

TAPPING SPEED GUIDE

MATERIALS			SPEED FEET PER MINUTE	MATERIALS			SPEED FEET PER MINUTE
Aluminum Alloys			90-100	(Steel, Cont.) Carbon Steel, Plain	Annealed	40-80	
Brass			60-100		Tempered	15-40	
Bronze			40-60	Cast, Carbon	Annealed	40-50	
Copper			40-60		Tempered	30	
High Temperature Alloys			Cobalt Base	Cast, Corrosion Resistant,	Annealed	20-30	
					Iron Base	as Cast	20-25
					Nickel Base	Low Alloy	Annealed
Iron	Ductile	Annealed	60	Precipitation Hardening, Stainless	Tempered	15-25	
		as Cast	30		Treated	10-15	
		Tempered	15-20		Annealed	15-45	
	Gray,	Annealed	80		Tempered	15-25	
		As Cast	35-60		Annealed	45-75	
	Malleable		60		Tool Steels, High Speed	Annealed	15-25
Magnesium Alloys		Heat Treated	25-50	Water Hardening	Annealed	50	
		Annealed	175	Ultra High Strength Steels	Annealed	35	
Manganese			20		Normalized	20	
Molybdenum Alloys		Stress Relieved	50		Tempered	3-7	
Monel		Annealed	20	Maraging Steels	Annealed	20-15	
Nickel Alloys		Annealed	25		Maraged	5-10	
Plastics,	Reinforced		25	Tantalum Alloys, Stress Relieved		3	
	Thermoplastics		50	Titanium Alloys, Commercial Pure,	Annealed	40-60	
	Thermosetting Plastics		50	Alpha & Alpha Beta Alloys,	Annealed	10-25	
Steels,	Alloys, Annealed or Cold Drawn		40-60	Tungsten Alloys, Pressed & Sintered		50	
	Quenched & Tempered		15-35	Zinc Alloys	Die Cast	150	
	Armor Plate		10				

CONVERSION TABLE, SURFACE FEET PER MINUTE TO REVOLUTIONS PER MINUTE

SPEED FEET PER MINUTE	20	25	30	40	50	60	70	80	90	100	110	120	130	140	150
TAP SIZE	REVOLUTIONS PER MINUTE														
0	1273	1592	1910	2546	3183	3820	4456	5093	5730	6366	7003	7639	8276	8913	9549
1	1047	1308	1570	2093	2617	3140	3663	4186	4710	5233	5756	6279	6808	7326	7849
2	888	1110	1333	1777	2221	2665	3109	3554	3999	4442	4886	5330	5774	6218	6662
3	772	964	1157	1543	1929	2315	2701	3086	3472	3858	4244	4629	5015	5401	5787
4	682	853	1023	1364	1705	2046	2387	2728	3069	3411	3751	4092	4434	4775	5116
5	611	764	917	1222	1528	1833	2139	2445	2750	3056	3361	3667	3973	4278	4584
6	553	691	829	1106	1382	1658	1934	2211	2487	2764	3040	3316	3592	3869	4145
8	466	583	699	932	1165	1398	1631	1864	2097	2330	2563	2796	3029	3262	3495
10	401	502	603	804	1005	1205	1406	1607	1808	2009	2210	2411	2612	2813	3014
12	354	442	531	707	884	1061	1238	1415	1592	1769	1945	2122	2300	2476	2653
1/4	306	382	458	611	764	917	1070	1222	1375	1528	1681	1833	1986	2139	2292
5/16	245	306	367	489	611	733	856	978	1100	1222	1345	1467	1589	1711	1833
3/8	204	255	306	407	509	611	713	815	917	1019	1120	1222	1324	1426	1528
7/16	175	219	262	349	437	524	611	698	786	873	960	1048	1135	1222	1310
1/2	153	191	229	306	382	458	535	611	688	764	840	917	993	1070	1146
9/16	137	172	206	275	344	412	481	550	619	687	756	825	893	963	1031
5/8	122	153	183	244	306	367	428	489	550	611	672	733	794	856	917
3/4	102	128	153	203	255	306	357	407	458	509	560	611	662	713	764
7/8	87	109	131	175	218	262	306	350	392	437	480	524	568	611	655
1	76	96	115	153	191	230	268	306	344	382	420	458	497	535	573

SMALL SHANK EXTENSION TAPS

**LIST 113P
EXTENSION**

Plug



TAP SIZE	SERIES DESIGN.	OVERALL LENGTH	NO. OF FLUTES	H LIMIT	SHANK DIAMETER	113P
						PLUG EDP NUMBER
6 - 32	NC	6"	3	H-3	.097	38332
8 - 32	NC	6"	3	H-3	.123	38331
10 - 24	NC	6"	3	H-3	.136	38342
10 - 32	NF	6"	3	H-3	.136	39014
1/4 - 20	NC	4"	4	H-3	.185	45612
1/4 - 20	NC	6"	4	H-3	.185	45681
1/4 - 28	NF	6"	4	H-3	.185	45719
5/16 - 18	NC	4"	4	H-3	.240	45614
5/16 - 18	NC	6"	4	H-3	.240	45683
5/16 - 24	NF	6"	4	H-3	.240	45631
3/8 - 16	NC	4"	4	H-3	.275	45779
3/8 - 16	NC	6"	4	H-3	.275	45685
3/8 - 16	NC	8"	4	H-3	.275	45686
3/8 - 24	NF	6"	4	H-3	.275	45641
1/2 - 13	NC	4"	4	H-3	.367	45748
1/2 - 13	NC	6"	4	H-3	.367	45687
1/2 - 13	NC	8"	4	H-3	.367	45668
1/2 - 20	NF	6"	4	H-3	.367	45661
5/8 - 11	NC	6"	4	H-3	.480	45689
5/8 - 11	NC	8"	4	H-3	.480	45952
5/8 - 18	NF	6"	4	H-3	.480	44956
3/4 - 10	NC	6"	4	H-3	.590	45831
3/4 - 10	NC	8"	4	H-3	.590	45832
3/4 - 10	NC	10"	4	H-3	.590	45834
3/4 - 16	NF	6"	4	H-3	.590	45789
7/8 - 9	NC	6"	4	H-4	.697	45741
7/8 - 9	NC	8"	4	H-4	.697	45761
7/8 - 9	NC	10"	4	H-4	.697	45771
7/8 - 9	NC	12"	4	H-4	.697	45772
1 - 8	NC	6"	4	H-4	.800	45839
1 - 8	NC	8"	4	H-4	.800	45841
1 - 8	NC	10"	4	H-4	.800	45851
1 - 8	NC	12"	4	H-4	.800	45859

*For larger quantity prices, consult factory.



TAP DRILL SIZES AND PERCENTAGE OF THREADS

TAP		TAP DRILL	DECIM. EQUIV.	THEOR. % OF THREAD	TAP		TAP DRILL	DECIM. EQUIV.	THEOR. % OF THREAD	TAP		TAP DRILL	DECIM. EQUIV.	THEOR. % OF THREAD
NOM. SIZE	TPI				NOM. SIZE	TPI				NOM. SIZE	TPI			
0	80	#56	.0465	83	1/4	20	13/64	.2031	72	5/8	18	9/16	.5625	87
		3/64	.0469	81			#6	.2040	71			0.5687	.5687	78
1	64	#54	.0550	89	1/4	28	#5	.2055	69	5/8	20	37/64	.5781	72
		#53	.0595	67			#3	.2130	80			37/64	.5781	87
1	72	#53	.0595	75	1/4	32	7/32	.2188	67	5/8	24	0.5828	.5828	78
		1/16	.0625	58			7/32	.2188	77			5/8	28	19/32
2	56	#51	.0670	82	1/4	36	#2	.2210	71	5/8	32	19/32	.5938	77
		#50	.0700	69			#2	.2210	80			19/32	.5938	87
2	64	#49	.0730	56	5/16	18	F	.2570	77	11/16	12	39/64	.6094	72
		#50	.0700	79			G	.2610	71			5/8	16	.6250
3	48	#48	.0760	85	5/16	20	F	.2570	85	11/16	20	41/64	.6406	72
		5/64	.0781	77			G	.2610	79			11/16	24	41/64
3	56	#47	.0785	76	5/16	24	H	.2660	72	11/16	28	21/32	.6562	67
		#46	.0810	67			H	.2660	86			11/16	32	21/32
3	40	#45	.0820	63	5/16	28	I	.2720	75	3/4	10	41/64	.6406	84
		#48	.0810	78			J	.2770	66			21/32	.6562	72
4	40	#44	.0860	80	5/16	32	J	.2770	77	3/4	12	21/32	.6562	87
		#43	.0890	71			K	.2810	68			43/64	.6719	72
4	48	#42	.0935	57	5/16	36	9/32	.2812	67	3/4	16	11/16	.6875	77
		3/32	.0938	56			K	.2810	78			3/4	20	45/64
4	48	#43	.0890	85	3/8	16	9/32	.2812	77	3/4	28	23/32	.7188	67
		#42	.0935	68			5/16	.3125	77			3/4	32	23/32
5	40	#41	.0960	59	3/8	20	O	.3160	73	13/16	12	47/64	.7344	72
		#40	.0980	83			P	.3230	80			13/16	16	3/4
5	44	#39	.0995	79	3/8	24	Q	.3320	66	13/16	20	49/64	.7656	72
		#38	.1015	72			Q	.3320	79			13/16	28	25/32
5	32	#37	.1040	65	3/8	28	R	.3390	67	13/16	32	25/32	.7812	77
		#38	.1015	80			11/32	.3438	67			7/8	9	49/64
6	40	#37	.1040	71	3/8	32	11/32	.3438	77	7/8	12	25/32	.7812	87
		#36	.1065	63			11/32	.3438	77			7/8	14	51/64
6	48	#37	.1040	84	3/8	36	S	.3480	75	7/8	14	51/64	.7969	84
		#36	.1065	78			T	.3580	86			0.8024	.8024	78
6	40	7/64	.1094	70	7/16	14	23/64	.3594	84	7/8	16	13/16	.8125	77
		#35	.1100	69			3/8	.3750	77			7/8	20	53/64
6	48	#34	.1110	67	7/16	16	V	.3770	75	7/8	28	27/32	.8438	67
		#33	.1130	77			W	.3860	79			7/8	32	27/32
8	32	#32	.1160	68	7/16	28	25/64	.3906	72	15/16	12	27/32	.8438	87
		#29	.1360	69			Y	.4040	72			55/64	.8594	72
8	36	#29	.1360	78	7/16	32	Y	.4040	83	15/16	16	7/8	.8750	77
		#28	.1405	65			13/32	.4062	77			15/16	20	57/64
10	24	9/64	.1406	65	1/2	12	Z	.4130	80	15/16	28	29/32	.9062	67
		#27	.1440	85			27/64	.4219	72			15/16	32	29/32
10	32	#26	.1470	79	1/2	13	27/64	.4219	78	1	8	55/64	.8594	87
		#25	.1495	75			7/16	.4375	77			7/8	8	.8750
10	40	#24	.1520	70	1/2	16	29/64	.4531	72	1	12	29/32	.9062	87
		#23	.1540	66			15/32	.4688	67			59/64	.9219	72
10	48	5/32	.1562	83	1/2	18	15/32	.4688	77	1	14	59/64	.9219	84
		#22	.1570	81			15/32	.4688	87			0.9274	.9274	78
12	24	#21	.1590	76	9/16	12	31/64	.4844	72	1	16	15/16	.9375	77
		#20	.1610	71			1/2	.5000	77			1	20	61/64
12	28	11/64	.1719	82	9/16	18	0.5062	.5062	69	1	28	31/32	.9688	67
		#17	.1730	79			1/2	.5000	87			1	32	31/32
12	32	#16	.1770	84	9/16	20	0.5062	.5062	78	1	8	59/64	.9219	87
		#15	.1800	67			33/64	.5156	72			0.9274	.9274	83
12	36	#16	.1770	84	9/16	24	0.5203	.5203	78	1 1/16	12	15/16	.9375	77
		#15	.1800	78			17/32	.5312	67			31/32	.9688	87
12	40	#14	.1820	73	9/16	28	0.5263	.5263	78	1 1/16	16	63/64	.9844	72
		#13	.1850	67			17/32	.5312	77			1	1.0000	77
1/4	20	#14	.1820	84	5/8	11	17/32	.5312	79	1 1/16	18	1	1.0000	87
		#13	.1850	76			5/8	12	35/64			.5469	72	1 1/16
1/4	20	3/16	.1875	70	5/8	16	9/16	.5625	77					
		#12	.1890	67			0.5687	.5687	69					