

Suggested Feed & Speeds for High Speed Steel Taps

Material	Brinell	Taps - SFM Threads per In.			
		3 – 7½	8 – 15	16 – 24	25 +
Aluminum	99 – 101	50	100	150	200
Aluminum Bronze	170 – 187	12	25	45	60
Bakelite	—	50	100	150	200
Brass	192 – 202	50	100	150	200
Bronze, Common	166 – 183	40	80	100	150
Bronze, Phosphor, ½ hard	187 – 202	25	40	50	80
Bronze, Phosphor, soft	149 – 163	40	80	100	150
Cast Iron, soft	126	30	60	90	140
Cast Iron, medium soft	196	25	40	50	80
Cast Iron, hard	293 – 302	10	20	30	40
Cast Iron, chilled	402	5	5	10	10
Cast Steel	286 – 302	20	30	40	50
Celluloid	—	50	100	150	200
Copper	80 – 85	40	80	100	150
Drop Forgings (steel)	170 – 196	12	25	45	60
Duralumin	90 – 104	50	100	150	200
Everdur	179 – 207	20	30	40	50
Machinery Steel	170 – 196	35	50	60	85
Magnet Steel, soft	241 – 302	20	40	50	75
Magnet Steel, hard	321 – 512	5	10	15	25
Manganese Steel, 7 – 13%	187 – 217	15	20	25	30
Manganese Copper, 30%Mn.	134	—	—	—	—
Malleable Iron	112 – 126	20	30	40	50
Mild Steel, .20 – .30C	170 – 202	40	55	70	90
Molybdenum Steel	196 – 235	20	30	35	45
Monel Metal	149 – 170	8	10	15	20
Nickel, Pure	187 – 202	25	40	50	80
Nickel Steel, 3½%	196 – 241	8	10	15	20
Rubber, hard	—	50	100	150	200
Screw Stock, C.R.	170 – 196	20	30	40	50
Spring Steel	402	10	10	15	15
Stainless Steel	146 – 149	8	10	15	20
Stainless Steel, C.R.	460 – 477	8	10	15	20
Steel, .40 to .50C	170 – 196	20	30	40	50
Tool, S.A.E., and Forging Steel	149	25	35	45	55
Tool, S.A.E., and Forging Steel	241	15	15	25	25
Tool, S.A.E., and Forging Steel	402	8	10	15	20
Zinc Alloy	112 – 126	50	100	150	200

- Spiral point taps may be run at speeds 15-20% faster than regular taps
- Thread forming taps: Double the SFM
- TiN Coated: Increase speed by 10-25%
- TiCN Coated: Increase speed by 25-50%
- TiAlN Coated: Increase speed by 50-75%

All recommendations should be considered only as a starting point, with possible variations to achieve optimum results.