



Speeds for HPT alum style taps. Spiral plug and bottoming.  
High Speed Steel bright finish or CrN coated. Taps are made in the USA.

Material	Bhn	SFM
Aluminum 2011,2024,6061,7075	--	<b>70-100</b>
Aluminum cast 208,213,360,A380.0,705.707	*	<b>60-80</b>
All types of plastics,delrin	*	<b>40-100</b>
Medium Carbon Steel 4140, 8620	*	*
Tool Steel, H.S.S A2,D2,M2,M42	*	*
Cast Iron	*	*
Stainless Steel 300 Series	*	*
Stainless Steel 400 Series	*	*
Stainless Steel 15-5, 17-4	*	*
Titanium 6AL-4V	*	*
Inconel 625, 718	*	*
Copper, Bronze	120-160	<b>30-50</b>
Brass (360 half hard)	--	<b>50-60</b>

\* use a different style tap

**Speeds are based on bright finish.** Increase speeds by 20-40% for CrN coated taps.  
Your machine's ability to synchronize rpms and required feedrate must be considered first before using recommended speeds in this chart.

#### 6 guidelines for best cutting results

Chamfer hole before tapping	keep tool concentricity low	Use proper drill size
Use plenty of coolant	avoid hitting bottom of blind hole	Use floating tap holder

**Note:** Cutting speeds, feeds, and lubrication data are given as starting values only. Parameters should be varied to suite your particular conditions. MariTool is constantly improving products, tolerances, and reliability. As such, these speeds and feeds are subject to change without prior notice. Cutting tools may shatter and or produce dangerous fumes when being used. Appropriate protection is advised.