List 26250/26255/26260/26350/26355/26360 - A Brand A-XPF

Work Material		Cutting Speed (SFM)		
		Tap Size		
		<1/2, M13	1/2, M14>	Bottom Chamfer
Low Carbon Steel	1010, 1018	50-115	25-55	25-55
Medium Carbon Steel	1035, 1045	50-115	25-55	25-55
High Carbon Steel	1065	50-85	25-40	25-40
Alloy Steel	4140	50-85	25-40	25-40
Tool Steel	D2, H13	20-65	10-30	10-30
300 Stainless	304	15-40	15-30	15-30
400 Stainless	420	15-35	15-30	15-30
17-4 PH		10-30	10-25	10-25
Aluminum	6061, 7075	65-115	35-60	35-50
Aluminum	Casting	65-90	35-60	35-50
Copper Alloy		30-100	15-65	15-60
Inconel	718	8-12	8-12	8-12
Titanium	Ti-6Al-4V	8-15	8-15	8-15
Hardened Steel	<35 HRC	50-100	40-65	40-65
Hardened Steel	35-45 HRC	8-25	8-12	8-12

1. Speeds given are assuming the use of water-soluble coolant
2. We recommend using non-water-soluble coolant or highly lubricated water-soluble coolant for tapping stainless steel.