

Knowing the hardness of the work material to be tapped is essential in selecting the best tap for the job.

| 10 mm/min<br>ball<br>3000 kg | 120°<br>cone<br>150 kg | 1/16"<br>ball<br>100 kg | model C              | 1000 lb<br>per<br>sq. in. | 10 mm/min<br>ball<br>3000 kg | 120°<br>cone<br>150 kg | 1/16"<br>ball<br>100 kg | model C              | 1000 lb<br>per<br>sq. in. |
|------------------------------|------------------------|-------------------------|----------------------|---------------------------|------------------------------|------------------------|-------------------------|----------------------|---------------------------|
| Brinell                      | Rockwell C             | Rockwell B              | Shore<br>Scleroscope | tensile<br>strength       | Brinell                      | Rockwell C             | Rockwell B              | Shore<br>Scleroscope | tensile<br>strength       |
| 800                          | 72                     | –                       | 100                  | –                         | 276                          | 30                     | 105                     | 42                   | 136                       |
| 780                          | 71                     | –                       | 99                   | –                         | 269                          | 29                     | 104                     | 41                   | 132                       |
| 760                          | 70                     | –                       | 98                   | –                         | 261                          | 28                     | 103                     | 40                   | 129                       |
| 745                          | 68                     | –                       | 97                   | 367                       | 258                          | 27                     | 102                     | 39                   | 127                       |
| 725                          | 67                     | –                       | 96                   | 357                       | 255                          | 26                     | 102                     | 39                   | 125                       |
| 712                          | 66                     | –                       | 95                   | 350                       | 249                          | 25                     | 101                     | 38                   | 123                       |
| 682                          | 65                     | –                       | 93                   | 337                       | 245                          | 24                     | 100                     | 37                   | 119                       |
| 668                          | 64                     | –                       | 91                   | 326                       | 240                          | 23                     | 99                      | 36                   | 117                       |
| 652                          | 63                     | –                       | 89                   | 318                       | 237                          | 23                     | 99                      | 35                   | 115                       |
| 626                          | 62                     | –                       | 87                   | 306                       | 229                          | 22                     | 98                      | 34                   | 113                       |
| 614                          | 61                     | –                       | 85                   | 299                       | 224                          | 21                     | 97                      | 33                   | 110                       |
| 601                          | 60                     | –                       | 83                   | 292                       | 217                          | 20                     | 96                      | 33                   | 107                       |
| 590                          | 59                     | –                       | 81                   | 290                       | 211                          | 19                     | 95                      | 32                   | 104                       |
| 576                          | 57                     | –                       | 79                   | 281                       | 206                          | 18                     | 94                      | 32                   | 102                       |
| 552                          | 56                     | –                       | 76                   | 270                       | 203                          | 17                     | 94                      | 31                   | 100                       |
| 545                          | 55                     | –                       | 75                   | 268                       | 200                          | 16                     | 93                      | 31                   | 98                        |
| 529                          | 54                     | –                       | 74                   | 259                       | 196                          | 15                     | 92                      | 30                   | 96                        |
| 514                          | 53                     | 120                     | 72                   | 254                       | 191                          | 14                     | 92                      | 30                   | 94                        |
| 502                          | 52                     | 119                     | 70                   | 247                       | 187                          | 13                     | 91                      | 29                   | 92                        |
| 495                          | 51                     | 119                     | 69                   | 244                       | 185                          | 12                     | 91                      | 29                   | 91                        |
| 477                          | 49                     | 118                     | 67                   | 233                       | 183                          | 11                     | 90                      | 28                   | 90                        |
| 461                          | 48                     | 117                     | 66                   | 227                       | 180                          | 10                     | 89                      | 28                   | 89                        |
| 451                          | 47                     | 117                     | 65                   | 223                       | 175                          | 9                      | 88                      | 27                   | 86                        |
| 444                          | 46                     | 116                     | 64                   | 219                       | 170                          | 7                      | 87                      | 27                   | 84                        |
| 427                          | 46                     | 115                     | 62                   | 209                       | 167                          | 6                      | 87                      | 27                   | 82                        |
| 415                          | 44                     | 115                     | 60                   | 204                       | 165                          | 5                      | 86                      | 26                   | 81                        |
| 401                          | 43                     | 114                     | 58                   | 196                       | 163                          | 4                      | 85                      | 26                   | 80                        |
| 388                          | 42                     | 114                     | 57                   | 191                       | 160                          | 3                      | 84                      | 25                   | 78                        |
| 375                          | 41                     | 113                     | 55                   | 184                       | 156                          | 2                      | 83                      | 25                   | 76                        |
| 370                          | 40                     | 112                     | 54                   | 182                       | 154                          | 1                      | 82                      | 25                   | 75                        |
| 362                          | 39                     | 111                     | 53                   | 179                       | 152                          | –                      | 82                      | 24                   | 74                        |
| 351                          | 38                     | 111                     | 51                   | 173                       | 150                          | –                      | 81                      | 24                   | 74                        |
| 346                          | 37                     | 110                     | 50                   | 170                       | 147                          | –                      | 80                      | 24                   | 72                        |
| 341                          | 37                     | 110                     | 49                   | 168                       | 145                          | –                      | 79                      | 23                   | 71                        |
| 331                          | 36                     | 109                     | 47                   | 163                       | 143                          | –                      | 79                      | 23                   | 70                        |
| 323                          | 35                     | 109                     | 46                   | 158                       | 141                          | –                      | 78                      | 23                   | 69                        |
| 311                          | 34                     | 108                     | 46                   | 153                       | 140                          | –                      | 77                      | 22                   | 69                        |
| 301                          | 33                     | 107                     | 45                   | 148                       | 135                          | –                      | 75                      | 22                   | 67                        |
| 293                          | 32                     | 106                     | 44                   | 144                       | 130                          | –                      | 72                      | 22                   | 65                        |
| 285                          | 31                     | 105                     | 43                   | 140                       | –                            | –                      | –                       | –                    | –                         |