

Material Group	Through Holes					Blind Holes					
	Tap Style	Grade	Range – m/min			Tap Style	Grade	Range – m/min			
			min	Starting Value	max			min	Starting Value	max	
P	1	T620	KP6525	20	30	45	T630,T632,T650	KP6525	14	21	32
		T622	KSP21	18	30	50	T622	KSP21	13	21	35
	2	T620	KP6525	17	25	38	T630,T632,T650	KP6525	12	18	26
		T622	KSP21	15	25	42	T622	KSP21	10	18	29
	3	T620	KP6525	12	15	20	T630,T632,T650	KP6525	8	11	14
	4	T600	KSP21	5	6	8	T602, T604	KSP21	3	4	5
5	T620	KP6525	12	15	20	T630,T632,T650	KP6525	8	11	14	
6	T600	KSP21	6	8	10	T602, T604	KSP21	4	6	7	
M	1	T620	KM6515	12	15	20	T630,T632,T650	KM6515	8	11	14
	2	T620	KM6515	9	12	16	T630,T632,T650	KM6515	6	8	11
	3	T620	KM6515	8	10	13	T630,T632,T650	KM6515	5	7	9
K	1	T640	KP6525	35	45	59	T640, T642	KP6525	24	32	41
	2	T640	KP6525	31	40	52	T640, T642	KP6525	22	28	36
	3	T640	KP6525	23	30	39	T640, T642	KP6525	16	21	27
N	1	T670	KSN38	42	55	72	T680	KSN38	30	39	50
		T622	KSN28	37	55	83	T622	KSN28	26	39	58
	2	T640	KP6525	38	50	65	T640, T642	KP6525	27	35	46
		T622	KSN28	33	50	75	T622	KSN28	23	35	53
4	T640	KP6525	4	6	9	T640, T642	KP6525	3	4	5	
S	1	T620	KP6525	8	12	18	T630, T632	KP6525	6	8	11
	2	T610	KSSH22	3	5	8	T612	KSSH22	3	4	5
	3	T610	KSSH22	3	4	6	T612	KSSH22	2	3	4
	4	T614	KSN25	3	4	6	T616	KSN25	2	3	4
H	1	T606	KSSH22	1,3	2,0	3,0	T606	KSSH22	1,1	1,4	1,8
	2	T606	KSSH22	1,0	1,5	2,3	T606	KSSH22	0,8	1,1	1,4

Holemaking

NOTE: Increase speed by up to 25% when using coolant taps (T621, T623, T631, T633, T641, T643, T651).
Use grade KP6505™ in steels. Use 50% of the recommended speed listed for grade KP6525™.



Material Group	Through Holes					Blind Holes					
	Tap Style	Grade	Range – SFM			Tap Style	Grade	Range – SFM			
			min	Starting Value	max			min	Starting Value	max	
P	1	T620	KP6525	70	100	150	T630,T632,T650	KP6525	50	70	100
		T622	KSP21	60	100	160	T622	KSP21	40	70	120
	2	T620	KP6525	50	80	120	T630,T632,T650	KP6525	40	60	90
		T622	KSP21	50	80	140	T622	KSP21	30	60	100
	3	T620	KP6525	40	50	60	T630,T632,T650	KP6525	30	30	40
		T600	KSP21	15	20	26	T602, T604	KSP21	11	14	18
M	1	T620	KM6515	40	50	60	T630,T632,T650	KM6515	30	30	40
	2	T620	KM6515	30	40	50	T630,T632,T650	KM6515	20	30	40
	3	T620	KM6515	30	30	40	T630,T632,T650	KM6515	20	20	30
K	1	T640	KP6525	110	150	190	T640, T642	KP6525	80	100	130
	2	T640	KP6525	100	130	170	T640, T642	KP6525	70	90	120
	3	T640	KP6525	80	100	130	T640, T642	KP6525	50	70	90
N	1	T670	KSN38	140	180	230	T680	KSN38	100	130	160
		T622	KSN28	120	180	270	T622	KSN28	80	130	190
	2	T640	KP6525	130	160	210	T640, T642	KP6525	90	110	150
		T622	KSN28	110	160	250	T622	KSN28	80	110	170
4	T640	KP6525	13	20	30	T640, T642	KP6525	11	14	18	
S	1	T620	KP6525	30	40	60	T630, T632	KP6525	21	28	36
	2	T610	KSSH22	11	16	25	T612	KSSH22	9	11	15
	3	T610	KSSH22	9	13	20	T612	KSSH22	7	9	12
	4	T614	KSN25	9	13	20	T616	KSN25	7	9	12
H	1	T606	KSSH22	4	7	10	T606	KSSH22	4	5	6
	2	T606	KSSH22	3	5	7	T606	KSSH22	3	3	4

NOTE: Increase speed by up to 25% when using coolant taps (T621, T623, T631, T633, T641, T643, T651).
Use grade KP6505™ in steels. Use 50% of the recommended speed listed for grade KP6525™.

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The complete Beyond™ High-Performance Taps Portfolio can be found in section L.

