

Machine Parameters



Thread	Flowdrill Diameter	Flowdrill [RPM]	Flowdrill [KW]	Cycle Time [Seconds]	Flowtap [RPM]
M2	1,8	3200	0,5	2	1600
M3	2,7	3000	0,6	2	1350
M4	3,7	2600	0,7	2	1000
M5	4,5	2500	0,8	2	800
M6	5,4	2400	1,0	2	650
M8	7,3	2200	1,3	2	500
M10	9,2	2000	1,5	3	400
M12	10,9	1800	1,7	3	330
M16	14,8	1400	2,2	4	250
M20	18,7	1200	2,7	5	200
G 1/8"	9,2	2000	1,5	3	400
G 1/4"	12,4	1600	2,0	3	360
G 3/8"	15,9	1400	2,3	4	300
G 1/2"	19,9	1200	3,0	5	270
G 3/4"	25,4	1000	3,5	6	200

Parameters on this table apply to mild steel with a 2mm thickness.

Add 1 second to the cycle time per each additional millimeter of material thickness.

Stainless steel requires 15% less RPM speed and a 0.1mm diameter Flowdrill increase when using threads M6 or larger.

Aluminum and other non-ferrous materials require approximately 50% higher RPM speeds.