

No.013 Improvements in tapping through holes with Spiral Pointed Taps Cutting

【Question】



I occasionally have a chip packing problem when I'm tapping through holes with a spiral fluted (SP) tap. Can you recommend a solution?

【Answer】

OH, it's easy!
You can solve your problem by using spiral pointed (PO) taps for cutting through holes.



【Guide】

Spiral fluted (SP) taps have a helical flute that pulls the chips backwards out of the hole towards the shank of the tap much like a twist drill. Spiral flute (SP) taps are ideally suited for tapping blind holes but tend to cause chip packing when used on tapping through holes in stringy materials. Spiral pointed (PO) taps offer a special advantage when tapping through holes because they push the chips forward ahead of the tap and out of the hole. Spiral point (PO) taps are designed to handle the long continuous chips that form and rarely have chip packing problems.

PULLS CHIPS OUT!

Chip ejection when tapping with a spiral fluted tap



Select and use spiral pointed (PO) taps for tapping through holes.



PUSHES CHIPS OUT!

Chip ejection when tapping with a spiral pointed (PO) tap



Select the best tap that suits the threading conditions and work piece material from the lineup below.

【Spiral pointed (PO) taps for tapping through holes】

PO (N-PO)



LS-PO (LS-N-PO) , long shanked



PO-V (N-PO-V) , titanium coated



AU+SL, titanium coated



SU+PO (SU-PO) for stainless steel



SU+SL for stainless steel



*Please refer to the product catalogs for details.