



【Question】



How I can distinguish between when to use a SP tap or a +SP tap? Which one can be used for general purpose?


【Answer】

Both can be used in a general purpose application. Here is the main difference. The SP taps are for low to middle tapping speed in radial arm drilling machines and machining centers using a floating tap holder or one with a tension/compression mechanism. The +SP taps are for middle to high tapping speed in machining centers but a ridged holder with synchronous feed is recommended.

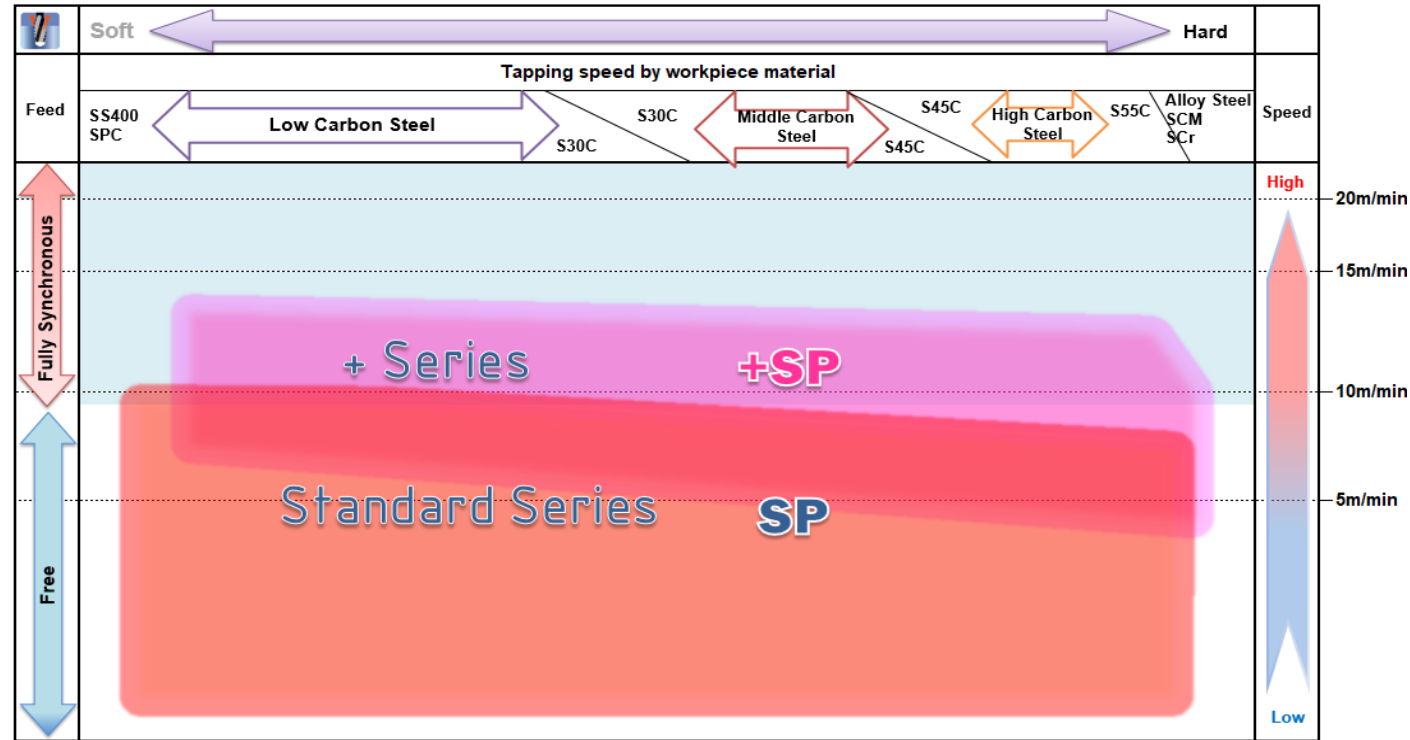


【Guide】


See the following "New System Table" to find the type of tap that the best suit your tapping conditions.



New System Table of Taps for Steels



An image of recommendable applications



You can refer to the above table to choose which tap is appropriate for your tapping conditions. Please also see the same formatted tables in our GENERAL CATALOG for your best selection of taps for "Steels, blind hole use", "Stainless Steels", "Non-ferrous Materials", and "Roll Taps".