

【Consultation】



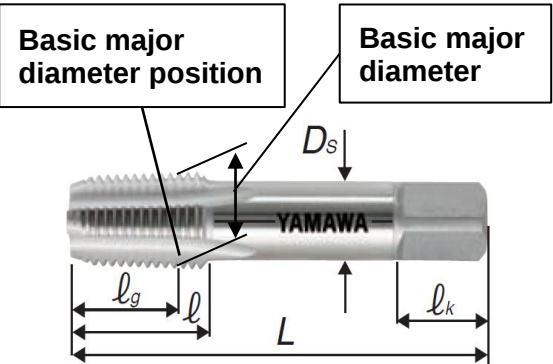
I am hand tapping a PT 1/4-19.  
Unlike machining, I am unable to set the tap insertion  
depth by using a scale setting.  
I am not sure how deep I should insert the taps into the  
workpiece. Is there any simple way for me to know how  
deep I should insert the tap?

【Answer】

PT taps have specific lengths from the tip to the basic  
major diameter, but they do not have a mark on the tap for  
this. Regarding PT1/4 (long thread type), you can make  
the standard-compliant PT internal taper pipe threads by  
driving the tap 21mm from the tip of the tap into the bored  
hole. Please put a mark on the position before tapping.  
Please refer the common usages below.



【Advice】



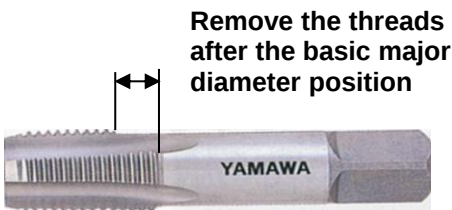
- Taps for taper pipe threads can be broadly  
classified into the three types below.
  1. Taper pipe taps for long thread type: PT
  2. Taper pipe taps for short thread type: S-PT
  3. Taper pipe taps for ISO type: Rc
- The length (distance) from the tip to the basic  
major diameter differs by the type of taps.  
The length from the tip to the basic major  
diameter is " $l_g$ " shown in the figure to the left.  
Also known as the projection. Please refer to  
the catalog for " $l_g$ " values.
- The most common ways are to wrap " $l_g$ "  
position with copper wire or to paint it in red.



Copper wire



Red paint



Remove the threads  
after the basic major  
diameter position

Copper wire may break and paint may come off.  
If you want a permanent marker, simply grind the  
threads off after the basic major diameter position as  
shown in the picture to the left.  
However, you need to be very careful as PT threads  
cannot be made correctly if you insert the tap  
beyond the position.

I will try it out by marking the position of the basic major diameter with a  
clear marker!

