

**【Consultation】**



Even though I ordered coated spiral pointed taps to tap through holes, a distributor told me, "Can I offer AU+SL spiral fluted taps"? Can I use AU+SL to tap through holes? I always thought spiral fluted taps were for blind holes.

**【Answer】**

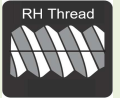





Our AU+SL is a spiral fluted tap with a plug chamfer and is designed for through holes. A spiral fluted tap is a generic term for taps with spiral flutes. However, most spiral fluted taps are for blind hole tapping, so the general idea is that "spiral tap = blind hole use" is common. However, our AU+SL uses a Right Hand threads with a Left Hand spiral design which ejects the chips forward the same as spiral pointed taps. Please refer to the explanation below for more details.



**【Explanation】**

I will explain the relationship between the direction of the spiral flutes and the direction of chip ejection by "AU+SP" (right-hand threads/right-hand spiral flutes) and "AU+SL" (right-hand threads/left-hand spiral flutes) below.



<b>AU+SP</b> Spiral Fluted taps for blind hole use	 	
<b>AU+SL</b> Spiral Fluted taps for through hole use	 	

Direction of chip ejection

**Spiral Fluted taps (For blind holes)**  
**"SP" and "AU+SP" taps with right-hand threads and right-hand spiral flutes eject the chips backward.**  
 ● Taps with left-hand threads and left-hand spiral flutes also eject chips backward.



**Spiral Pointed taps or Spiral Fluted taps for through holes**  
**"PO" and "AU+SL" with right-hand threads and left-hand spiral flutes eject the chips forward.**  
 ● Taps with left-hand threads and right-hand spiral flutes also eject the chips forward.



There are two types of spiral fluted taps, some for blind holes and some for through holes. Please remember that taps with the "SP" symbol are for blind holes and taps with the "SL" symbol are for through holes. An easy way to remember is SL= lefthand=through hole.

**【Advice】**

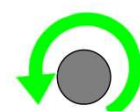
**【About the direction of the spiral flutes】**

When looking at the front tip of the tap, if the flutes twist in a clockwise direction this is a right hand spiral. If they rotate counterclockwise they are left hand spiral.



Clockwise

Counterclockwise



**Right-hand**

**Left-hand**