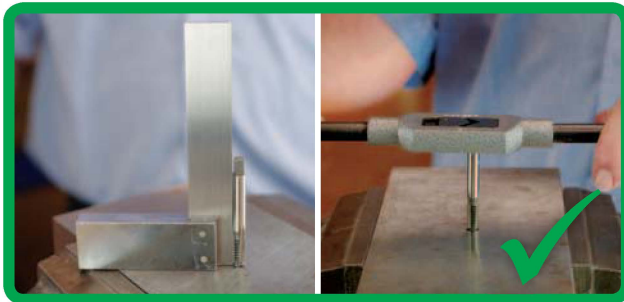
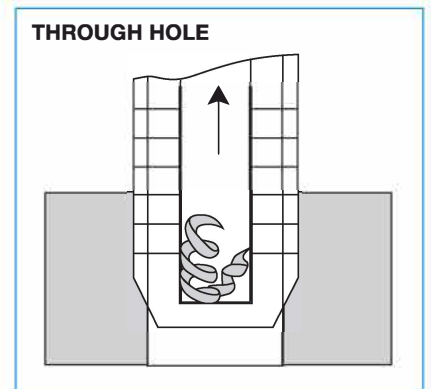


How to Use

Tapping a Through Hole

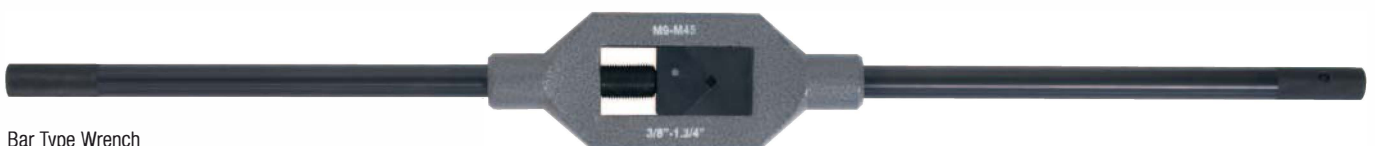
The following procedure should be followed when tapping a through hole.

- i. Clamp work firmly.
- ii. Drill a hole using correct size drill (tapping drill sizes are provided along with the product dimensions in Sutton Tools catalogues or use Sutton Tools pocket charts).
- iii. Place the taper tap or intermediate tap (depending on application) into a Sutton bar type tap wrench or Sutton T-Type tap wrench and apply Sutton lubricant to the tap. Lower the tap into the hole and position it so that it is at right angles to the hole.
- iv. With both hands on the tap wrench, apply steady downward pressure and complete two full turns keeping the tap at right angles to the work. Check that the tap is square to the hole.
- v. If the tap is not square, apply slight pressure in the direction required and make one further turn of the tap. Check that the tap is square again and repeat if correction is necessary. This prevents the tap from digging into one side of the hole and breaking.



- vi. Once the tap has started it will draw itself into the workpiece.
- vii. For Carbon Tools reverse to break the chip. Screw the tap slowly into the hole, backing off occasionally when tap becomes difficult to turn. Never force the tap as breakage could result.
- viii. For HSS Tools remember **not to back the tap off** as this may chip the teeth.
- ix. Continue tapping until you have tapped right through the hole. If this is not possible, you will have to use the intermediate and bottoming taps.

Hint: Do not use in a power drill. We recommend Sutton Tools bar type wrench for more controlled cutting (Catalogue Code M904, M905).



Bar Type Wrench