

The cutting work done by a set of hand taps (Partner A)

During the tapping of a hole, shavings are produced. These shavings cannot be processed by a single tap. That is why internal threads are often cut by a set of hand taps. Usually a set of hand taps consists of three tools with differently designed cutting parts.

The first tap has got one ring around the top of its shank. It is called the entering tap or taper tap. It is used to start tapping and also to tap through holes or to tap blind holes. It has the longest chamfer of the three taps to distribute action over a maximum number of teeth. The taper tap does half of the cutting work.




The second tap has got two rings around the top of its shank. It is called the plug tap.

Shavings – Späne

*to process -
verarbeiten*

Partner A

Put the information from your text into the table. Ask your partner for the missing information.

Serial taps	Tap 1	Tap 2	Tap 3
Sketch			
Name of the tap
Usage of the tap	<ul style="list-style-type: none"> • • • 	<ul style="list-style-type: none"> • • 	<ul style="list-style-type: none"> • •
Characteristic features	<ul style="list-style-type: none"> • • 	<ul style="list-style-type: none"> • • • 	<ul style="list-style-type: none"> • • •
Cutting work done by this tap




The cutting work done by a set of taps (Partner B)

It is commonly used in through holes and in blind holes with enough room at the bottom. The plug tap has got a relatively short chamfer and cutting edges which are deeper than those of the first tap. With these cutting edges it does about 30 percent of the cutting work.

The rest of the cutting work is done by the bottoming or finishing tap. Around the top of its shank, three rings may be cut or there may be no ring at all. This tap has a very short chamfer. It is designed to thread blind holes to the bottom. Its sharp cutting edges create the final nominal size of the thread.

Partner B

Put the information from your text into the table. Ask your partner for the missing information.

Serial taps	Tap 1	Tap 2	Tap 3
Sketch			
Name of the tap
Usage of the tap	<ul style="list-style-type: none"> • • • 	<ul style="list-style-type: none"> • • 	<ul style="list-style-type: none"> • •
Characteristic features	<ul style="list-style-type: none"> • • 	<ul style="list-style-type: none"> • • • 	<ul style="list-style-type: none"> • • •
Cutting work done by this tap