

Cutting internal threads and cutting external threads

Oops, here two texts about cutting internal and external threads have been mixed up. Sort out the two texts on how to cut internal and external threads and put the instructions for each activity into the table in the correct order.

At first, select the correct taps and the tap wrench. Next apply a suitable cutting fluid to the tap. Keep in mind that you do not need any cutting fluid if you want to tap brass or cast iron. At the beginning, chamfer the end of your workpiece with a file or on the disc sander. Then fasten the chamfered workpiece securely in a vice. Next, select the correct die and the die holder. When beginning to tap, place the tap in the hole as vertically as possible. Then press down equally on both handles of the tap holder. Before you start threading, do not forget to apply cutting fluid to the tapered end of the die. Place the lubricated tapered end of the die squarely on the workpiece. Then press down equally on both handles of the die holder and turn it clockwise for several turns. After turning clockwise for two turns, remove the tap holder and check if the tap is square. If the tap did not enter the hole squarely, remove it from the hole and restart tapping. When doing so, apply slightly more pressure in the direction away from which the tap leans. After several turns, check whether the die has worked squarely. If not, remove the die and restart threading. Now turn the tap clockwise one-quarter turn, then turn it back again about half a turn to break the chip. Now turn the die forward one turn and turn it back again about one and a half turns to break the chip. Do not forget to apply cutting fluid regularly during the threading process. Repeat this process steadily until you have finished tapping. When you have finished cutting the thread, check the thread with a thread ring gage or an appropriate nut. Finally, clean the tapped hole and check it with a thread gage or an appropriate bolt.

How to cut internal threads	How to cut external threads
1)	1)
2)	2)
3)	3)
4)	4)
5)	5)
6)	6)
7)	7)
8)	8)
9)	9)
	10)