

WORKSHOP PRACTICES

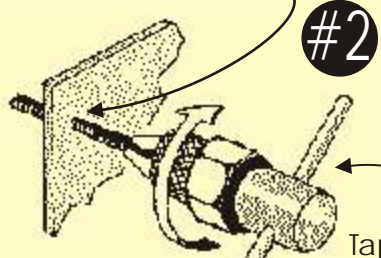
Tapping Holes

Buying a couple of tap drills, taps and a tap driver can greatly enhance your metal-working capabilities. The most common sizes for electronic work are 4-40 and 6-32. Drills are \$1, taps \$2

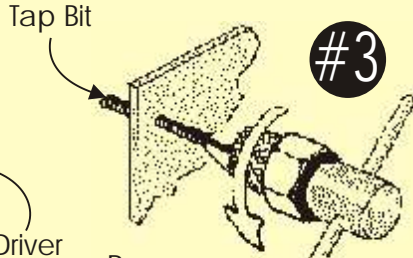
HINT: Use drop of oil to lubricate tap bit



Drill pilot hole using the **TAP DRILL**



#2

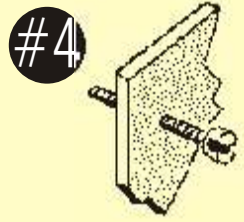


#3

Insert tap into hole and slowly turn clockwise. Tap will thread the hole. Use proper tap drill ... a smaller sized drill can cause tap to jam and snap-off.

Tap Driver (or Tap Chuck)

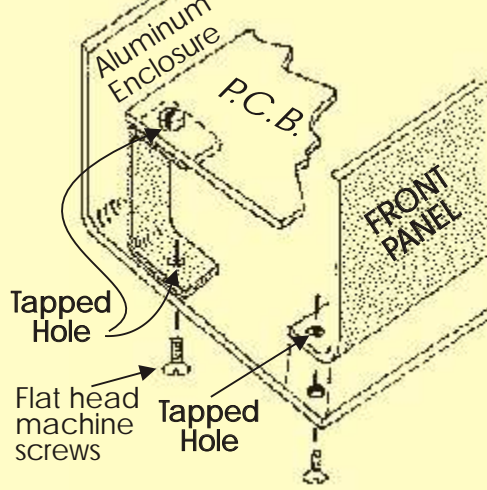
Remove tap by turning CCW. Remove any burrs on far side that might jam tap.



Machine screw can now be inserted

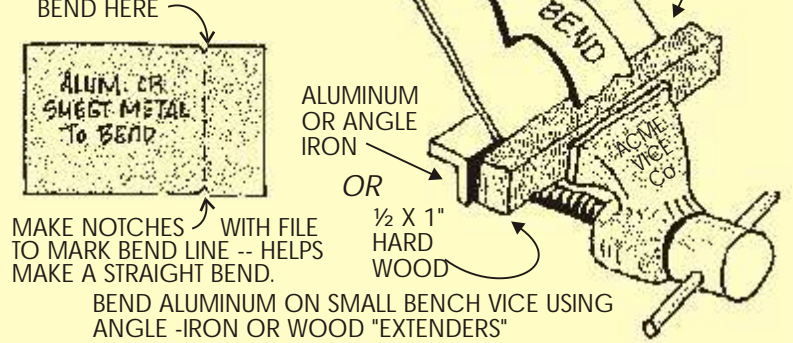
DRILL SIZES		
Size	Tap Drill	Thru Drill
2-56	.070" #50	.086" #44
4-40	.089" #43	.116" #32
6-32	.107" #36	.144" #27

A couple of applications for tapped holes

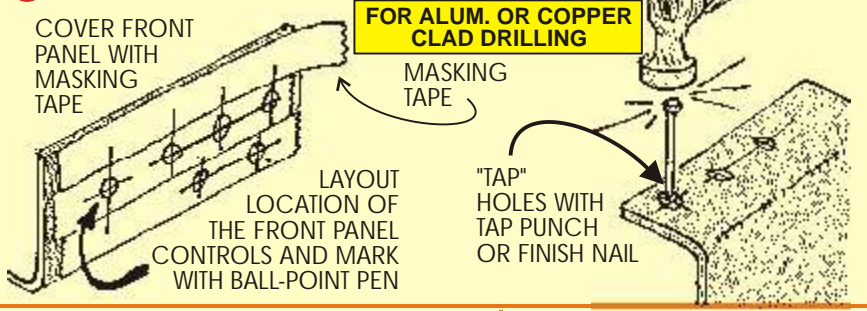


DOING THE METAL WORK --

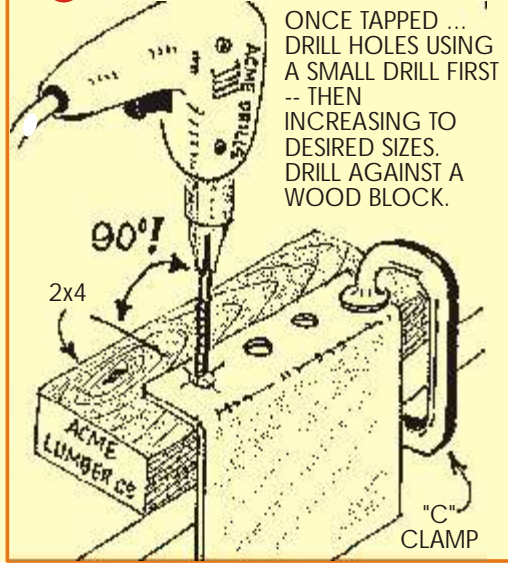
1 BENDING THE METAL



2 PREPARING TO DRILL



3 THE DRILLING



4 FINISHING TOUCHES

