HSS TAPS

TroUble	Possible Cause	Correction
Oversize Pitch Diameter	Incorrect tap Chip Packing Galling	Use correct H limit Use longer chamfered tap Use spiral pointed tap Use larger drill size Shorten length of thread in blind holes Reduce tapping speed Use lubricants
Torn or Rough Threads	Dull tap Chamfer too short Galling	Resharpen or replace Increase chamfer length Use lubricant Reduce speed Use larger drill
Breakage	Incorrect tap selection Excessive tapping torque Operating conditions	Increase chamfer length Use spiral pointed taps in through holes Tapping too deep Increase hole size Shorten thread length Increase chamfer length Reduce tapping speed Avoid bottoming out the tap
Chipping	Incorrect tap selection Operating conditions	Increase chamfer length Avoid chip packing in flutes Reduce tapping speed Use larger drill Ensure adequate lubricant
Excessive Wear	Incorrect tap selection Operating conditions	Increase chamfer length Reduce tapping speed Ensure adequate lubricant Use larger drill