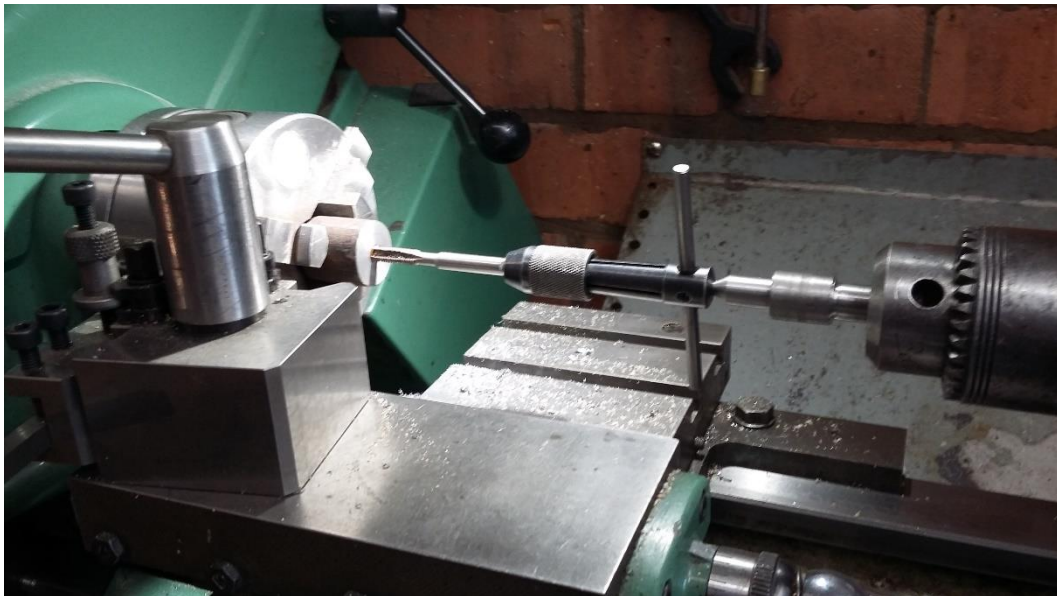


Tap Follower

My contribution by comparison is a bit rough and ready. It is a sprung tap follower. For years I have clamped a tap in the drill chuck in the tailstock and pulled the chuck round while juggling the tailstock feed to suit. To be honest that is still probably the easiest way for the smaller sizes, but as soon as you get up in size the tendency for the tap to slip increases and the use of a tap wrench is preferred. However, ensuring the tapped hole stays concentric to the mandrel is not so easy.

This simple tool locates in the dimple at the end of the tap, or in the dimple in the end of the tap wrench and is sprung loaded to keep everything in line. The spring means you can back off the tap with no fiddling with the tailstock, and the travel provides sufficient guidance to get the thread started true.

Again this tool can be resized to suit your requirements, or as in my case, to suit the spring I had available!



Drawings in Stone Age Units are attached below, but nothing is critical.

Well, I hope these items are of interest. As I said at the beginning all I need is a photo or two and some chat, so don't be shy, let us see what you have been up to.

Nick

NOTE: Chamfer all corners 0.030 - 45°

HARDWARE: 1. Spring L=1.500, diam. 0.370, wire diam. 0.055
2. Set Screw #8-32 3/16"

Tap Follower		
Body	By TUBALCAIN	Sheet # 3
Steel	mrpate222/youtube	-10/1 1-1-2017

NOTE: Harden and Temper (per your alloy heat requirements)

HARDWARE: 1. Spring L=1.500, diam. 0.370, wire diam. 0.055
2. Set Screw #8-32 3/16"

Tap Follower		
Pointer, opt. 1	By TUBALCAIN	Sheet # 3
Tool Steel	mrpate222/youtube	-10/1 1-1-2017

https://youtu.be/5O7Ts_dyHS0 - Really irritating video that includes use of a tap follower at about the 26 minute mark.