General Information

Models Offered

Three standard models of collapsible style taps offered – ALT, LL, and LLSR. All have a mechanism which collapses the chasers into the tap head upon thread completion allowing direct withdraw of tap from workpiece.

ALT – Primarily for straight thread tapping, but can be used to "jam cut" NPT and BSTP pipe threads.

LL – A "receding chaser" type tap which by virtue of its receding design, is expressly intended to produce the longer length, more precise American Petroleum Institute (API) threads used on oil tubular goods products. Can also be used to produce NPT and BSTP pipe threads.

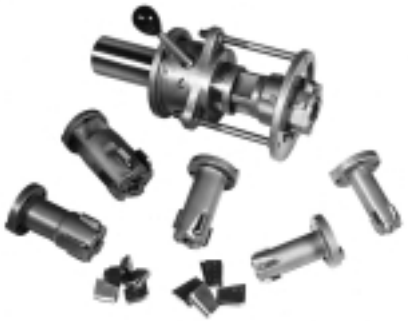
LLSR – A shorter length "receding chaser" tap which can be substituted when the application prevents the use of the longer LL style tap.

Range Characteristics

When equipped with a full complement of detachable tap heads, ALT and LL Taps are capable of tapping a wide size range of thread diameter and pitch combinations. The LLSR is for more specific tapping uses. Refer to the appropriate sections on each tap for more detailed information on the design and application characteristics of each.

Detachable Tap Heads

ALT, LL, and LLSR Taps use a "tap body" to which are affixed a series of detachable and interchangeable tap heads, each of which has a thread size range. This allows a particular body to be used to tap a variety of thread diameter and pitch combinations. For example, the 3 ALT body can be equipped with six different size heads giving it a 1-1/4" to 3-1/4" total diametrical range.



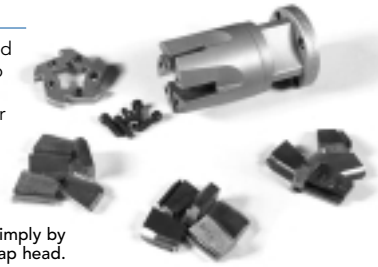
All Landis taps offer interchangeable tap heads with a common body—taps can be used to tap any thread form just by installing the proper chaser set in the tap head.

Rotary or Stationary Application

All taps can be furnished for revolving applications where the workpiece is stationary and the tool turns, or, as a stationary non-revolving tool used to tap a revolving workpiece. Some models can be converted and used as a stationary or revolving tool, others must be furnished from the factory equipped for one or the other type of application. See the individual section on each type of tap for details.

Size Adjustment

The thread form, pitch, and diameter is obtained by installing the proper set of chasers in the tap head. An adjusting screw in the nose of the tap head allows the chasers to be adjusted 1/32" or 1/16" over or under nominal diameter to bring the chasers to final size.



Inch, metric, or pipe threads can be tapped simply by installing the proper chaser set in the tap head.

Opening and Closing Action

Depending upon the type and model of machine and/or type of application for which the tool is being supplied, Landis taps can be opened and closed by yoke, opened by trip ring and closed by yoke, or, opened by trip ring and manually closed by a lever.

Thread Length

Thread length is adjustable. When the tap is equipped with trip ring and trip rods, thread length is regulated by positioning the trip ring through rod length adjustment. On yoke operated taps, thread length is set by locating the yoke.

Standard Chaser

"Overhang" Chaser

Chasers

Two types of chasers are supplied, standard and overhang. Standard chasers are used where the hole is through or of sufficient depth where chip clearance is not a problem. Overhang chasers extend beyond the front face of the chaser retaining cap and provide chip clearance when tapping into a blind hole.

Right- and Left-Hand Tapping

ALT and LL Taps can be used to tap right- and left-hand. However, left-hand tap heads and chasers are required. The LLSR Tap is furnished only to tap right-hand.