ALT Collapsible Taps

- Long Life Tap Chasers
- Positive Collapsing Action
- Five standard tap bodies and thirty-three standard tap heads allow ALT Taps to produce 1-1/4" to 13-1/4" I.D. and 1-1/4" to 12" nominal NPT and BSTP pipethreads.
- Leadscrew feed is recommended for best thread results, however, it is possible to hand feed under certain conditions.
- Recommended where wide range of work requires the versatility and wide range coverage offered by detachable tap heads.
- Can be used, when supplied with suitable tooling, to produce right- or left-hand threads.
- Can be supplied for revolving or stationary applications.
- Extension links, extension adapters, and special long tap heads allow deep hole tapping.

Stationary models can be converted in service to a rotary model by simply removing the expanding lever, installing a lever hole plug and providing an expanding means.

Here, collapsing action is accomplished by the trip ring contacting the workpiece. Set-up shoes attached to machine.

This illustrates a tap used on bar automatic machines or in other tapping applications where the workpiece location is constant. Available in the No. 2, 3, 4, 5 and 6 ALT models, this particular tap is both expanded and collapsed by means of the operating yoke. Information on tap applications for use on chucking machines should be referred to the Landis tap engineering department.

NOTE: All orders or inquiries for operating yokes must include the diameter of the yoke operating rod and the distance between the center line of the yoke operating rod and the center line of the spindle.

Deep Hole Tapping Options

Landis-Solutions.com
## SPECIFICATIONS

<table>
<thead>
<tr>
<th>Tap Size</th>
<th>Standard Capacity</th>
<th>Coarsest丝 Size</th>
<th><strong>Thread Length</strong></th>
<th><strong>Thread Length</strong></th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 ALT</td>
<td>4</td>
<td>1-1/4 to 1-3/8</td>
<td>2.0</td>
<td>2.1/16</td>
<td>1.3/8</td>
</tr>
<tr>
<td>3 ALT</td>
<td>6</td>
<td>1-1/4 to 1-3/8</td>
<td>2.0</td>
<td>2.1/16</td>
<td>1.3/8</td>
</tr>
<tr>
<td>4 ALT</td>
<td>8</td>
<td>1-1/4 to 1-3/8</td>
<td>2.0</td>
<td>2.1/16</td>
<td>1.3/8</td>
</tr>
<tr>
<td>5 ALT</td>
<td>10</td>
<td>1-1/4 to 1-3/8</td>
<td>2.0</td>
<td>2.1/16</td>
<td>1.3/8</td>
</tr>
<tr>
<td>6 ALT</td>
<td>12</td>
<td>1-1/4 to 1-3/8</td>
<td>2.0</td>
<td>2.1/16</td>
<td>1.3/8</td>
</tr>
</tbody>
</table>

**Weight of tap body. Additional weights shown pertain to individual tap heads.**

**The coarsest pitch limitations given pertain to tapping steel and are subject to change when tapping other materials.**

**Separate heads are required for tapping right- and left-hand threads. As shown by the "Thread Length" columns, thread lengths can vary between comparable sizes of right- and left-hand tap heads. Special, extra length, tap heads can be supplied to produce longer lengths.**

1 Total thread marking which can be produced including the chaser thread (thread run-out) section.

11 This column represents the total thread marking that can be produced by tap heads incorporating trip rings.

111 Regular chasers are used to thread the pipe sizes listed except those followed by O.H. which require overhang chasers. Pipe sizes listed are full threads (L1 plus L3) as per "H28 Handbook-Screw Standards for Federal Services," using chasers with 30° throats starting 1/64" below the thread root.

---

**Tap Size**

- 2 ALT
- 3 ALT
- 4 ALT
- 5 ALT
- 6 ALT

**Standard Capacity**

- 4
- 6
- 8
- 10
- 12

**Coarsest Size**

- 1-1/4 to 1-3/8
- 1-1/4 to 1-3/8
- 1-1/4 to 1-3/8
- 1-1/4 to 1-3/8
- 1-1/4 to 1-3/8

**Thread Length**

- 2.0
- 2.0
- 2.0
- 2.0
- 2.0

**Weight**

- 1.0
- 1.0
- 1.0
- 1.0
- 1.0

---

**Landis Solutions LLC**

360 South Church Street

Waynesboro, PA 17268

Toll Free: +1.800.358.3500

Fax: +1.888.718.2922

e-mail: info@Landis-Solutions.com

Landis-Solutions.com
### DIMENSIONS

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>2 ALT</td>
<td>1-3/8&quot;</td>
<td>1.375&quot;</td>
<td>1.125&quot;</td>
<td>1.4375&quot;</td>
<td>1.539&quot;</td>
<td>4.375&quot;</td>
<td>6-1/16&quot;</td>
<td>2.516&quot;</td>
<td>2.750&quot;</td>
<td>2.516&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
</tr>
<tr>
<td>3 ALT</td>
<td>1-3/4&quot;</td>
<td>1.375&quot;</td>
<td>1.125&quot;</td>
<td>1.4375&quot;</td>
<td>1.539&quot;</td>
<td>4.375&quot;</td>
<td>6-1/16&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td></td>
</tr>
<tr>
<td>4 ALT</td>
<td>1-7/8&quot;</td>
<td>1.375&quot;</td>
<td>1.125&quot;</td>
<td>1.4375&quot;</td>
<td>1.539&quot;</td>
<td>4.375&quot;</td>
<td>6-1/16&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td></td>
</tr>
<tr>
<td>5 ALT</td>
<td>2&quot;</td>
<td>1.375&quot;</td>
<td>1.125&quot;</td>
<td>1.4375&quot;</td>
<td>1.539&quot;</td>
<td>4.375&quot;</td>
<td>6-1/16&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td></td>
</tr>
<tr>
<td>6 ALT</td>
<td>2-1/4&quot;</td>
<td>1.375&quot;</td>
<td>1.125&quot;</td>
<td>1.4375&quot;</td>
<td>1.539&quot;</td>
<td>4.375&quot;</td>
<td>6-1/16&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td>2.750&quot;</td>
<td></td>
</tr>
</tbody>
</table>

* Special size tap head for this body. Price different from standard.

** Length of R.H. heads only—consult factory for L.H. head lengths.

### Ordering Instructions

All orders or inquiries should specify the style of tap required, whether stationary or rotary type, and the size and style of shank. Complete thread specifications, material specifications and whenever possible, the workpiece drawing should be submitted. If a drawing is not available, complete information as to whether standard chasers for “open hole” work or overhang chasers for “bottoming” work are required. If overhang chasers are ordered state amount of relief at the bottom end of the thread. Also specify if tap will be fed manually or by leadscrew.