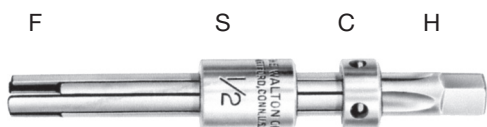


# HOW TO USE THE WALTON TAP EXTRACTOR



F - Fingers                      C - Collar  
S - Sleeve                      H - Holder

FIG. 1

WALTON TAP EXTRACTORS are precision made tools and should be treated and used as such. They are designed for the quick and easy removal of broken taps, and they are a great help to the mechanic when properly used. Unless you have had experience with WALTON TAP EXTRACTORS, do not attempt to use them until all instructions and suggestions, below and on reverse side, have been read. The few minutes spent reading these instructions will be time well spent.



FIG. 2

## INSTRUCTIONS FOR USE

### Before using the Tap Extractor:

**WARNING:** Proper use of eye protection is necessary when using Tap Extractors and all cutting tools.

*Thoroughly remove all loose chips from the holes around the broken tap before attempting to use the WALTON TAP EXTRACTOR. Be careful not to damage threads in so doing. Use compressed air if available.*

Try to knock off sharp, projecting points of the broken tap so that the holder will slide down close to the main portion of the broken part. Place a few drops of cutting oil on the broken tap before inserting the fingers of the tap extractor.

### Using the Tap Extractor:

*First:* Adjust the tap extractor so that the fingers (F) project beyond the left end of the holder (H) as shown in Fig. 1. *Then:* Grasp the extractor at the right end of the holder (H) and slide the fingers (F) down into the flutes of the broken tap - as far as they will go easily without forcing. Push the holder (H) down until it touches the broken tap (this is important). See Fig. 2.

The fingers must be supported their entire length, either in the flutes of the holder, or in the flutes of the broken tap. A shearing strain will then be exerted, and not a bending strain, thus greatly increasing the effectiveness of the tool.

*Now:* Slide the sleeve (S) down until it touches the work (See Fig. 2), and apply a tap wrench to the squared outer end of the holder (H); *twist forward and back a few times to loosen, and back out the broken tap.*

# KEEP THIS FOLDER WITH TOOLS FOR REFERENCE

---

---

## **Do Not Hammer**

Never hammer the collar or force the fingers into the flutes of the broken tap. To do so only wedges the broken tap more securely in the piece of work. The fingers should slide down into the flutes of the broken tap without the application of great force.

## **Shallow Fluted Taps or Gun Taps**

When using the extractor on shallow or narrow fluted taps, grind off the edge of the fingers next to the cutting edge of the tap (but only for a short distance) to permit the fingers to enter the flutes of the broken tap.

## **Using Without Collar**

It is recommended that the extractor be used with the collar (C), but if one or two flutes of the broken tap are blocked so that the fingers will not slide down, disassemble the extractor and reassemble without the collar. Now the fingers can be inserted into the flutes of the broken tap at different depths so as to make full contact with the unblocked flutes. This would be impossible were the collar left on.

## **If Tap Resists Reasonable Strain**

After inserting the extractor apply a reasonable strain in alternate directions in attempting to remove the broken tap. But, after applying reasonable strain, if the broken tap refuses to loosen, it is usually because the tap has shattered into two or more irregular pieces. Each piece then acts as a lock nut on the other. In this case it is wise to apply great strain on the extractor, even to the point of breaking the fingers of the extractor. The fingers can then be ground off even and used again in another effort to remove the obstinate tap.

## **Replacement Fingers**

When fingers become bent or broken, or are too short for further use, extra fingers may be obtained from your local dealer. We will be glad to suggest names in your area. All holders, collars, and sleeves will be replaced without charge if damaged parts are returned to Walton Company.

## **DIRECTIONS FOR ASSEMBLING THE TOOL**

The finger tang holes in the collar are nearer one edge of the collar than the other; therefore to assemble: Place the collar on the holder -- being sure that the edge with the greatest distance to the holes faces the squared end of the holder. Then one by one hook the fingers directly into the cross-holes in the collar, and slide on the sleeve. The tool is now complete.

If you have any difficulty either in operating or assembling the tool, write, FAX or phone us and we will endeavor to render further assistance.

### **WALTON COMPANY West Hartford CT 06133**

Tel: (860) 523-5231

FAX: (860) 236-9968  
[www.waltontools.com](http://www.waltontools.com)



### ***Other Walton tools include:***

*"Walton" Tap Extensions - for machine & hand tapping*

*"Walton-REPS" Pipe, Stud & Screw Extractors*



**CALIFORNIA PROPOSITION  
65 WARNING**



**Warning:** This product contains lead, a chemical known to the state of California to cause cancer, and birth defects or other reproductive harm.

For more information: [WWW.P65Warnings.ca.gov](http://WWW.P65Warnings.ca.gov)