

*Thank you for purchasing the OMW Tapping Guide Block. I hope you enjoy using it as much as I enjoyed making it. With a little care, this tool should give you many years of service. Please read the instructions below to take full advantage of your new Tapping Block. And let me know if you have comments or questions. I can be reached via email at [JHKO@AOL.COM](mailto:JHKO@AOL.COM), or at OMW Corporation (21 Pamaron Way, Ste. G., Novato, CA 94949).*

*Best Regards,*

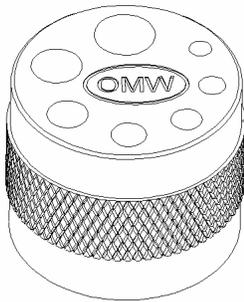
*Joe Osborn  
President, OMW Corporation.*

---

---

## **Instructions for Using the OMW Tapping Guide Block**

### *Background*



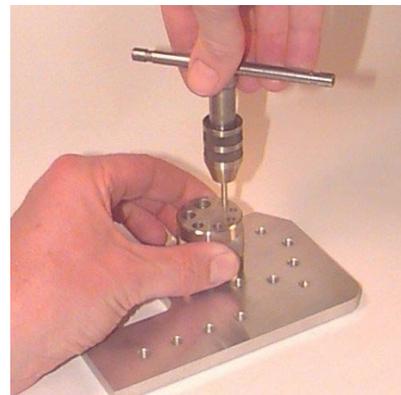
*The OMW Tapping Guide Block*

The OMW Tapping Guide block was inspired by a guide block used by a fine toolmaker I've had the pleasure to work with. This expert craftsman had made his block as an apprentice, and would use it whenever he tapped a hole. I never saw him break a tap. I took his design, and made it smaller and handier, and in the process moved the hole positions out near the edge to allow the block to be used in tight clearance spaces. I retained the feature of the counterbores on the bottom of the block for chip clearance, as well as

a band of knurling around the edge for easy gripping. I also tried to make the block aesthetically pleasing- a tool that would have a rightful place in a cherished oak toolchest.

### *Using the Tapping Block*

Probably over 90% of broken taps result because the taps are not started straight to the hole. The OMW Tapping Guide Block is designed to solve this problem by guiding taps straight to the surface when tapping. Make sure that the block is resting flat against your work surface, put your tap in your tap wrench, and guide it through the appropriate hole in the block and into the tap-drilled hole in your work. After the tap is started straight, you may remove the block and finish the hole without it, if desired.



Using the OMW Tapping Guide Block

The block has seven holes. The smallest hole will

(OVER)

guide all small taps from 0-80 to 6-32 threads. Note that the block indexes against the shank of the tap, not against the threads themselves. All these smaller taps have the same shank size. The next six holes handle #8, #10, #12, 1/4, 5/16, and 3/8 taps respectively.

**IMPORTANT NOTE:** The tapping block is purposely designed with fairly close clearance between the tap shank and the hole. Tap shank diameters are strictly defined and shanks are virtually always ground to size. I've measured many taps, and have always found the shanks to be very close to specified size. The informational lettering on the shank of most fine taps is chemically etched and does not affect shank diameter. However, I have seen some cheaper taps where this lettering on the shank of the tap was stamped into the metal, raising a sizable burr on the tap shank. These taps **MAY NOT FIT INTO THE APPROPRIATE HOLE**. In this case, grind or sand this burr down slightly, and the problem should be solved. If you are in a hurry, you can always use the next sized hole for the tap, although you should make sure the fit is not too loose to keep the tap straight to the work.

### Care of the Tool

The OMW Tapping Block is made of highest quality heat-treated 4140 steel and requires little care. However, when storing the block, spread a coat of light oil on the surface to prevent cosmetic rust from developing.