



***Adding and Editing
Tap Files***

Editing A Tap File

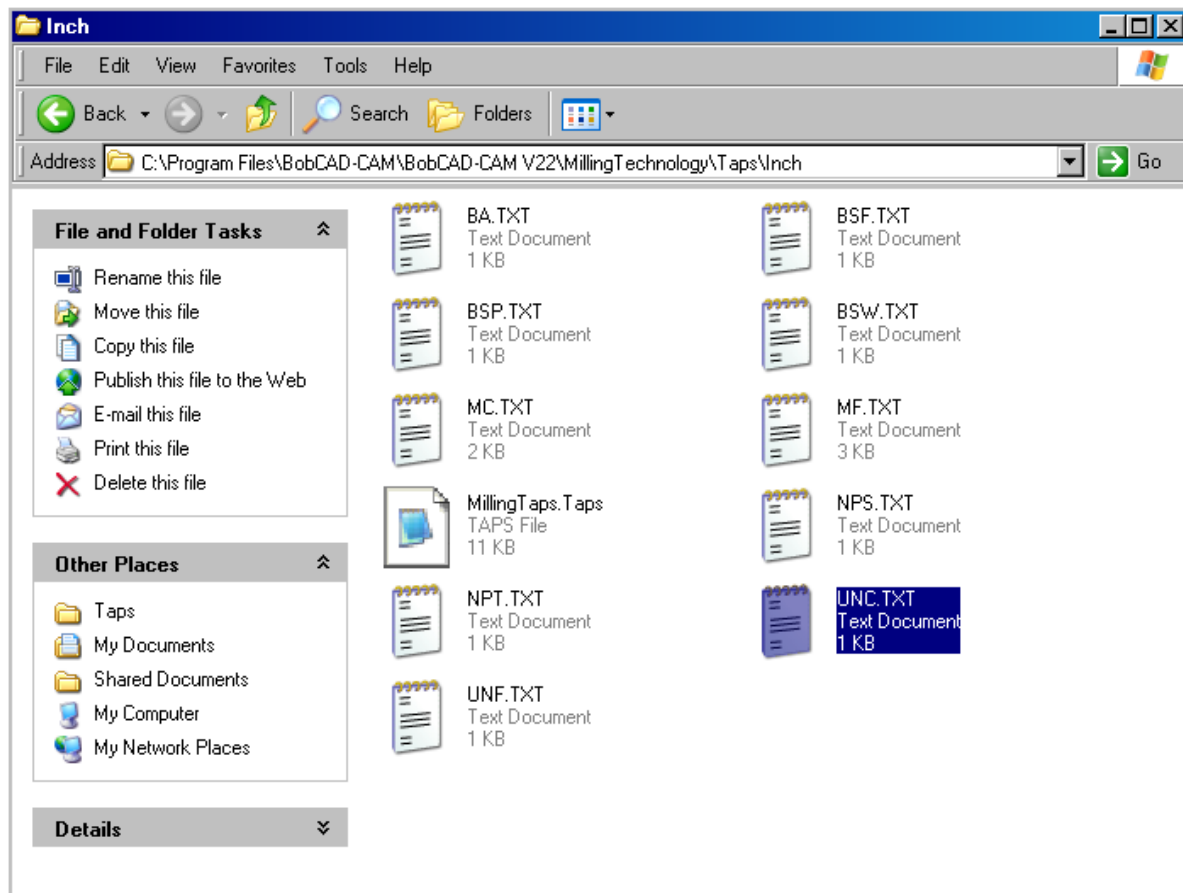
Different size and type taps may be added to Tap folder for selection within the BobCAD-CAM Version 22 software. They are simple text (.txt) files which may be edited using NotePad, NotePad++ or the Predator CNC Editor. The files reside in the following location:

C:\Program Files\BobCAD-CAM\BobCAD-CAM V22\MillingTechnology\Taps

With the BobCAD-CAM Version 22 software closed; navigate to, and open the taps folder. Delete the MillingTaps.Taps file. It will automatically be regenerated upon software launch. Open the desired text file (.txt) for the corresponding style of tap.

***** NOTE: It may prove best to make a copy of the file in the event of any errors while editing. *****

The example below will reflect the addition or editing of taps to the **UNC** file in the Inch folder.



```

UNC.TXT - Notepad
File Edit Format View Help
|%
16
UNC 1-64 ,0.0730,0.015625,0.061,0.067,0.0000,1,1,0,1,
UNC 2-56 ,0.0860,0.017857,0.072,0.079,0.0000,1,1,0,2,
UNC 3-48 ,0.0990,0.028333,0.082,0.091,0.0000,1,1,0,3,
UNC 4-40 ,0.1120,0.025000,0.090,0.102,0.0000,1,1,0,4,
UNC 5-40 ,0.1250,0.025000,0.102,0.115,0.0000,1,1,0,5,
UNC 6-32 ,0.1380,0.031250,0.110,0.124,0.0000,1,1,0,6,
UNC 8-32 ,0.1640,0.031250,0.137,0.150,0.0000,1,1,0,7,
UNC 10-24 ,0.1900,0.041667,0.153,0.171,0.0000,1,1,0,8,
UNC 12-24 ,0.2100,0.041667,0.177,0.196,0.0000,1,1,0,9,
UNC 1/4-20 ,0.2500,0.050000,0.201,0.227,0.0000,1,1,0,10,
UNC 5/16-18 ,0.3125,0.055556,0.263,0.285,0.0000,1,1,0,11,
UNC 3/8-16 ,0.3750,0.062500,0.318,0.343,0.0000,1,1,0,12,
UNC 7/16-14 ,0.4375,0.071429,0.374,0.401,0.0000,1,1,0,13,
UNC 1/2-13 ,0.5000,0.076923,0.433,0.459,0.0000,1,1,0,14,
UNC 9/16-12 ,0.4737,0.083334,0.484,0.521,0.0000,1,1,0,15,
UNC 5/8-11 ,0.6250,0.090909,0.543,0.577,0.0000,1,1,0,16,

```

The first line may ONLY contain the percent symbols. The second line will reflect the total number of taps within the file. This value will be Index Number of the last sequentially listed tap.

```

UNC.TXT - Notepad
File Edit Format View Help
|%
19
UNC 1-64 ,0.0730,0.015625,0.0595,0.067,0.0000,1,1,0,1,
UNC 2-56 ,0.0860,0.017857,0.0700,0.079,0.0000,1,1,0,2,
UNC 3-48 ,0.0990,0.028333,0.0785,0.091,0.0000,1,1,0,3,
UNC 4-40 ,0.1120,0.025000,0.0890,0.102,0.0000,1,1,0,4,
UNC 5-40 ,0.1250,0.025000,0.1015,0.115,0.0000,1,1,0,5,
UNC 6-32 ,0.1380,0.031250,0.1065,0.124,0.0000,1,1,0,6,
UNC 8-32 ,0.1640,0.031250,0.1360,0.150,0.0000,1,1,0,7,
UNC 10-24 ,0.1900,0.041667,0.1495,0.171,0.0000,1,1,0,8,
UNC 12-24 ,0.2100,0.041667,0.1770,0.196,0.0000,1,1,0,9,
UNC 1/4"-20 ,0.2500,0.050000,0.2010,0.227,0.0000,1,1,0,10,
UNC 5/16"-18 ,0.3125,0.055556,0.2570,0.285,0.0000,1,1,0,11,
UNC 3/8"-16 ,0.3750,0.062500,0.3125,0.343,0.0000,1,1,0,12,
UNC 7/16"-14 ,0.4375,0.071429,0.3680,0.401,0.0000,1,1,0,13,
UNC 1/2"-13 ,0.5000,0.076923,0.4219,0.459,0.0000,1,1,0,14,
UNC 9/16"-12 ,0.4737,0.083334,0.4844,0.521,0.0000,1,1,0,15,
UNC 5/8"-11 ,0.6250,0.090909,0.5313,0.577,0.0000,1,1,0,16,
UNC 3/4"-10 ,0.7500,0.100000,0.6663,0.0000,0.0000,1,1,0,17,
UNC 7/8"-9 ,0.8750,0.111111,0.7656,0.0000,0.0000,1,1,0,18,
UNC 1"-8 ,1.0000,0.125000,0.8750,0.0000,0.0000,1,1,0,19,

```

Please follow the format EXACTLY and list taps according to Nominal Diameter for ease of selection. After the changes have been made, Save the file. Once saved, open the BobCAD-CAM Version 22 software. The program will automatically regenerate a new MillingTaps.Taps file for the software operation.

The next page contains the line format and description of each variable.

UNC 1/4-20 ,0.2500,0.050000,0.201,0.227,0.0000,1,1,0,10,

