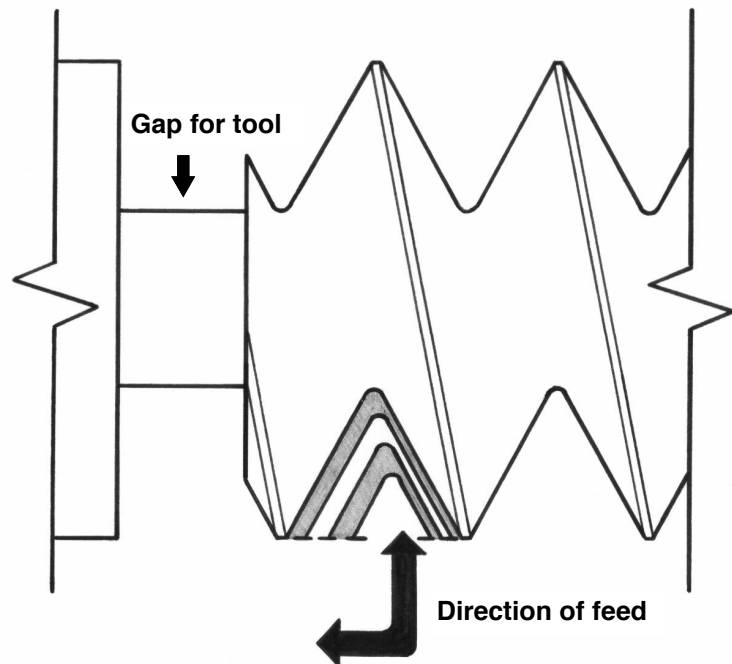


## Thread Cutting Procedure

1. Fit correct change wheels or gears required for the pitch to be cut.
2. If you are a beginner, it is much easier if you machine a gap for the tool equal in depth to the depth of the thread or equal in diameter to the “root” diameter of the thread. The gap is cut where the thread is to finish.
3. Mount the thread cutting tool in the tool post at right angles to the job. You can use a Screw Cutting Gauge to correctly align the thread cutting tool.
4. Choose a slow spindle speed so that you have enough time to turn back or withdraw the cross slide and switch off the machine at the end of the thread.

5. Each thread has to be cut in several steps. The cutting depth must not be large otherwise it may overload the motor or the tip may break off the tool. Turn back or withdraw the cross slide at the end of each cut, reverse



the motor to bring the tool to the start position. Adjust the tool to a new cutting depth by using the reading on the cross slide handwheel.

The top slide is recommended for thread cutting so that the tool can be adjusted sideways as shown in the illustration. By using this method, the tool is cutting on one side of the tool and there is less load on the point. On the final cut, The tool is not adjusted sideways so that full profile of the tool is cutting/ cleaning the thread to the full profile.