



Hand thread cutting

Te whakakōaka ā-ringā

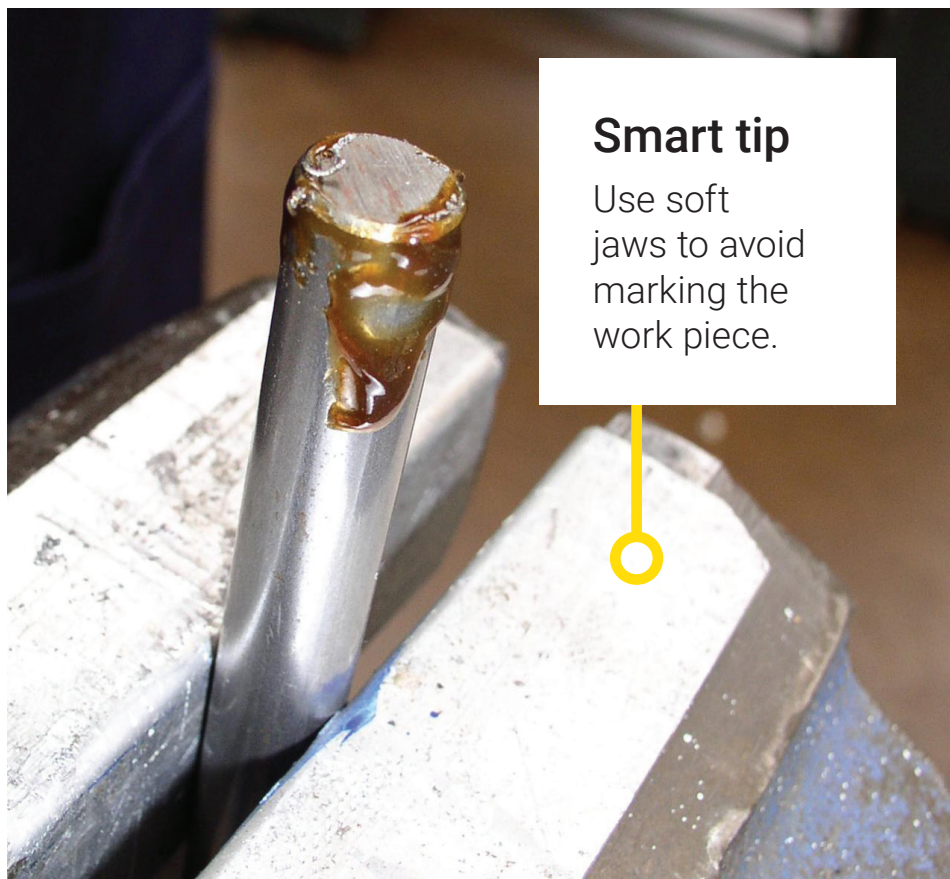


Using a micrometer or vernier calipers, select the correct size bar for the thread to be cut e.g;

Ø6 = M6

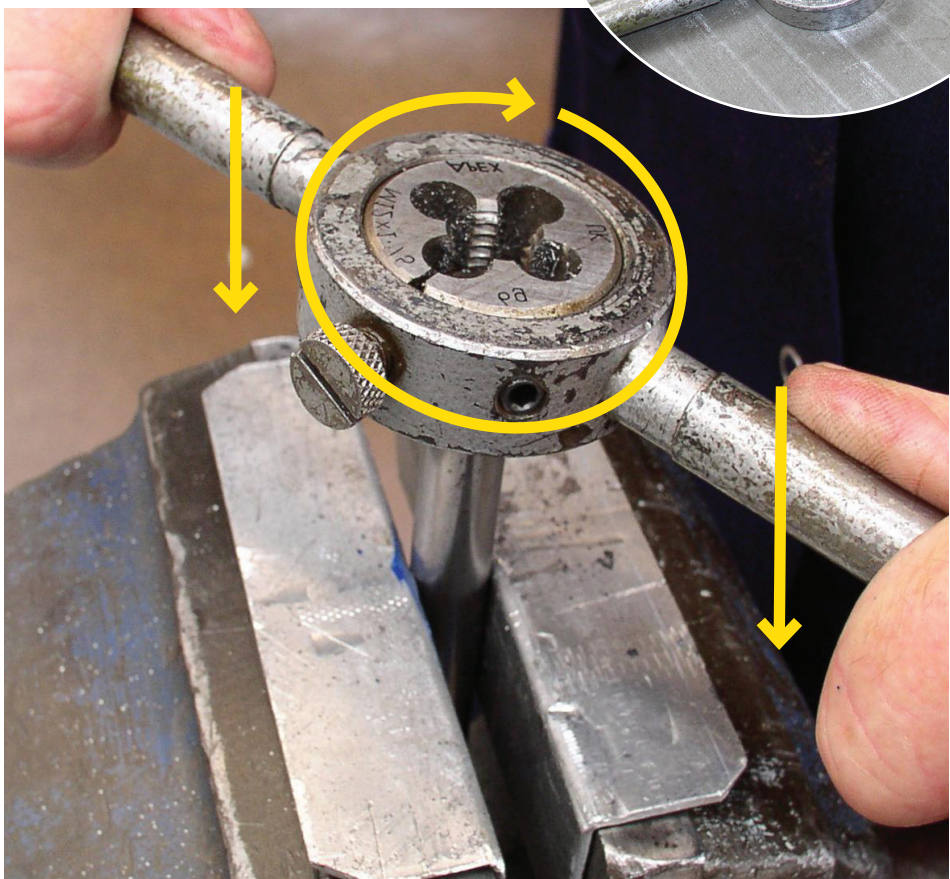
Ø8 = M8

Ø10 = M10



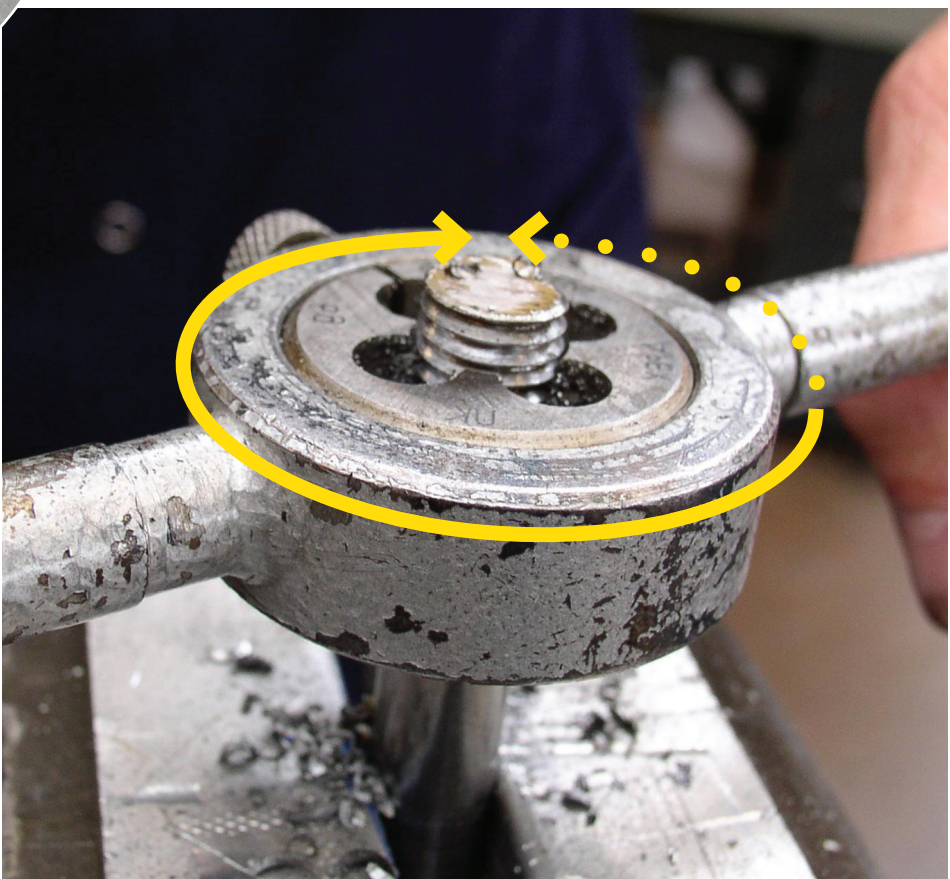
Smart tip

Use soft jaws to avoid marking the work piece.



Typically it takes **two** cuts to form an external thread, a rough followed by a finishing cut. To start the first cut, hold the bar vertical in a vice with the chamfered end up.

Hold the stock (handles) horizontal i.e. parallel to the ground press firmly down and turn clockwise until you can feel the die start to cut.

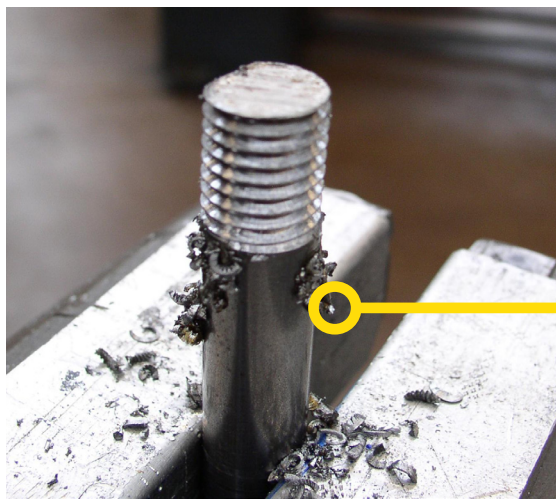


Once the cut is started, cut the thread by turning the stock clockwise 3/4 of a turn. Then turn in the opposite direction (anti-clockwise) 1/4 of a turn to break the 'chip' off.

If the chip isn't broken, the threads will become ragged or stripped. Once the rough cut is to the correct depth, remove the rough die anti-clockwise. Fit the finishing die onto the stock and perform the finishing cut.

WARNING KIA TŪPATO

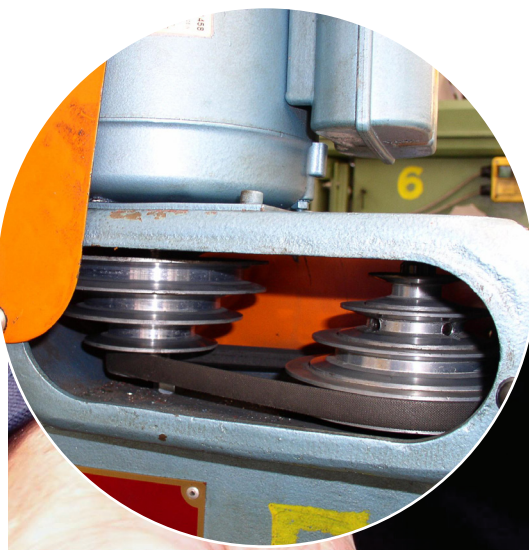
Be careful of sharp edges.
Kia tūpato ki ngā tapa koi.



The last step is to clean the swarf off the threads with a wire brush. Use a file to take the sharp edges off the head and form a clean start for the thread.

Drilling and drill press

Te wiri me te perehi wiri



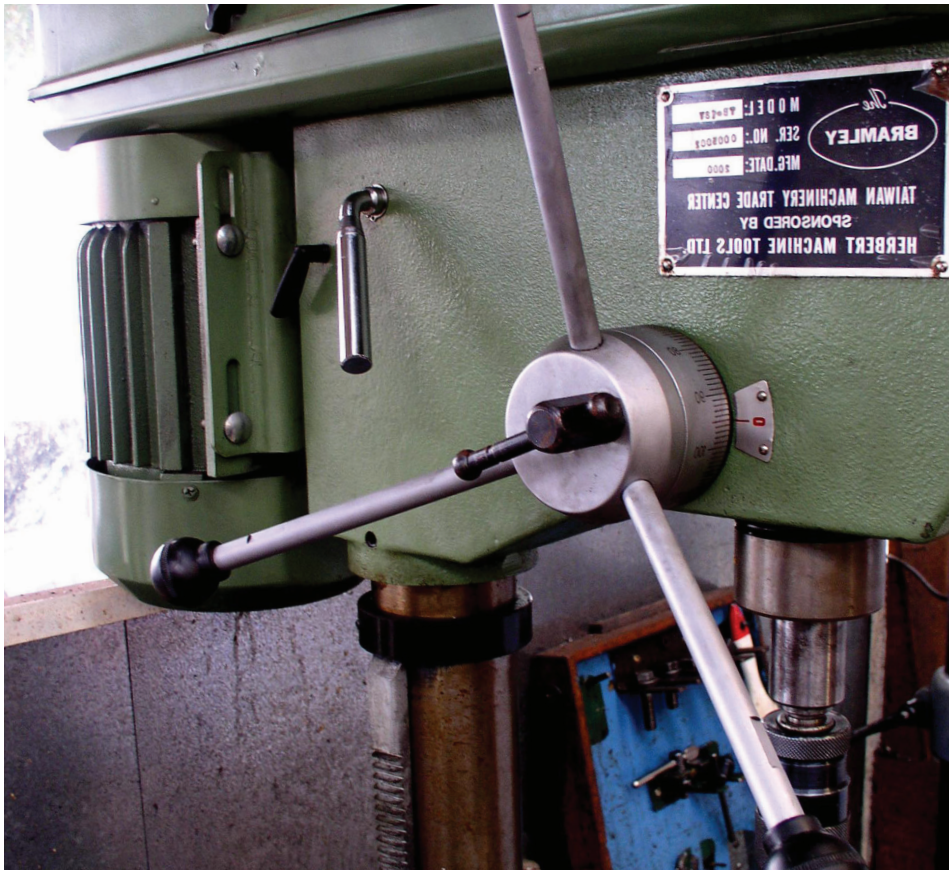
- Always use marking-out dye, a rule and then centre punch your work before you drill it.
- The accuracy of the finished job is worth the extra effort.
- Select the speed of the drill, using the type of material and size of the drill as a guide.



Ensure there is at least 25 mm of shank in the chuck and it is firmly tightened.

Smart tip

Before drilling use marking-out dye, a rule and then centre-punch your work piece.



As the Hand Feed Lever is turned the chuck is moved up or down.



When ready, pull down steadily and lightly on the feed handle.

WARNING KIA TŪPATO

Keep your fingers, clothes and hair clear.
Kia tika te mahi kia wātea ō matimati, kākahu, makawe hoki.