

Thread Chasing Precepts and other pertinent information: this file shows some important areas to be aware of for successful thread chasing.

1. **Tools** Start with thread chasers—only.....16 TPI -*my recommendation*. Add tools below as you gain skills.

- Thread chasers (3-40 TPI)
- Recess tool
- Point tool
- Armrest tool
- Inside tool (90 degree tool)

Chasing speed

- Speed: 250/300 low end----**300-350 ideal**-----350/450 high end

5 things necessary...

- Tool rest height
 - Tool rest position/distance from wood
 - Sharp tools
 - Proper chasing speed
 - Correct Traverse
2. Add: Point tool, inside tool, recess tool, arm rest tool Later
 3. 20 TPI thread chasers are best in very dense woods or acrylics
 4. Coarse thread chasers (10/12—TPI) are more difficult to start a thread, but will chase threads in softer woods.
 5. **Traverse:** a faster traverse is required for coarser thread chasers: (10/12 TPI)
 6. A slower traverse for finer thread chasers: (16/18/20 TPI)
 7. Understanding Wood
 - a. Dense, straight/Close-grained, (diffuse-porous), woods
 - b. **Specific gravity** = 1.0 or more is best
 - c. Specific gravity: the weight of a cubic foot of water at sea level---62.4 LBS
 8. Cross-grain wood will take a thread—but asymmetrical shrinkage is a big consideration
 9. **Taper on threads:** Logic, reason, and reality. Many thread chasers, myself included, consider a tapered thread a benefit.
 10. Chamfer-Female Recess-Male Shoulder
 11. Recess or stop-gap
 12. Inserts? CA glue? Chase-able Woods?
 13. Influence on thread chasing
 - a. BILL JONES
 - b. ALLAN BATTY
 - c. JOHN BERKELEY
 - d. Bill Bowers
 - e. Fred Holder (article)
 - f. Mike Peace

*The outline above is a list of important factors in chasing threads by hand. Some items are self-explanatory, other items are notes for myself to cover topics in teaching or demonstrations.

Partially, the categories reflect my own impressions and what I have learned from others.

Thread Chasing Precepts (overview)

Traverse

Tools

Lathe speed

Wood

- **Specific Gravity 1.0 or above +/-**
- **Close-grained, dense, Diffuse Porous**

Taper = Logic-reason-reality

Recess/chamfer/male shoulder