

**Turning Hand Chased Male Threads.
With
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Boxes are turned endgrain We are turning facegrain. Because almost any dry facegrain blank works. However, facegrain can move and oval threads don't work.

Most people have more difficulty with male threads than female threads. So we start with the mechanics of the male thread on common woods before attempting to work in exotics.

Select a **Dry Facegrain piece of wood.** Here we are using a 3 inch cube of Sugar Maple (Fig 1)

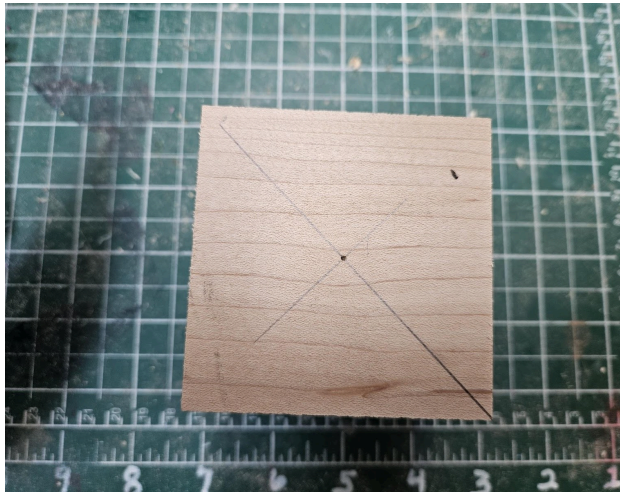


Fig 1
Using a bowl gouge turn the blank to a cylinder. We have changed the grain direction to facegrain so a spindle

roughing gouge is not the tool to use.



Fig 2
Round over the lead edge. We want to have a soft round corner. (Fig 3)



Fig 3

With your male thread chaser level on the rest, set the tool rest height so that the top of the cutter is at center. (Fig 4)



Fig 4

Set your lathe speed at 350 RPM using the second or third tooth on the chaser and the handle level allow the thread chaser to touch the radius corner. You should get what is best described as a “catch” that will appear as a spiral going from small to large diameter. (Fig 5)



Fig 5

Continue to extend the thread down the blank. **The lead tooth does not contact the blank until there is a thread. As you are extending the thread, lift the handle to get the desired cut.** (Fig 6 & 7)



Fig 6

As this is a practice piece you may wish to continue the threads down the blank. The threads are developed when they come to a peak. In the photo you can see the gap between the wood and the tooth. Also note that the threads are deeper at the beginning. (Fig 8)

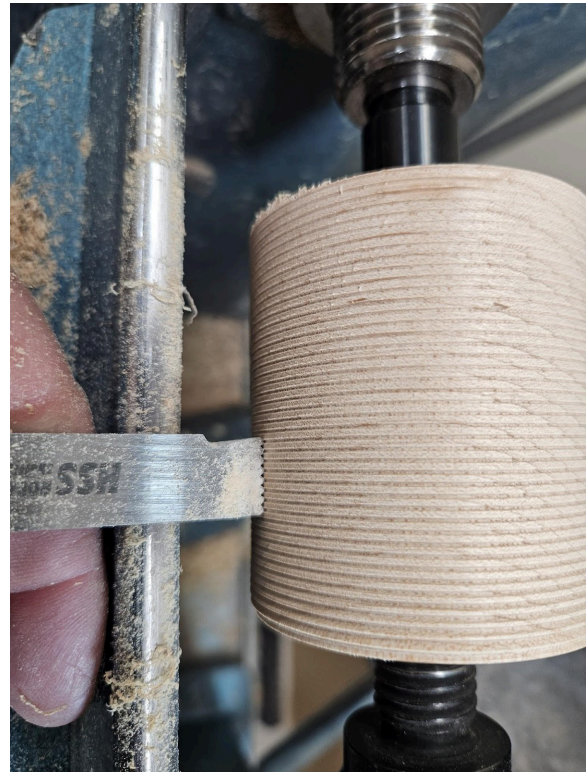


Fig 8

A small amount of wax helps to lubricate the threads and chaser. I find the best tool for applying the wax is somebody else's Toothbrush. You don't want to get wax in yours. (Fig 9)



Fig 7

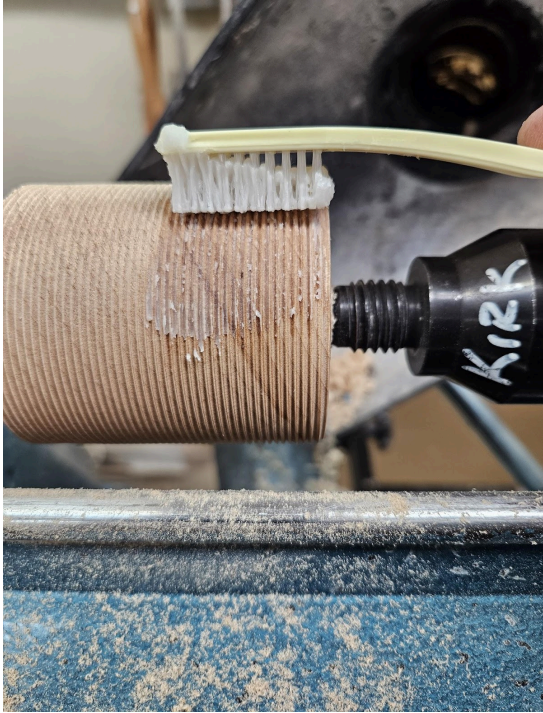


Fig 9
Keep practicing until you get the hang of chasing male threads. Once you have threads all down the surface of the blank, remove them and start over. (Fig 10)



Fig 10