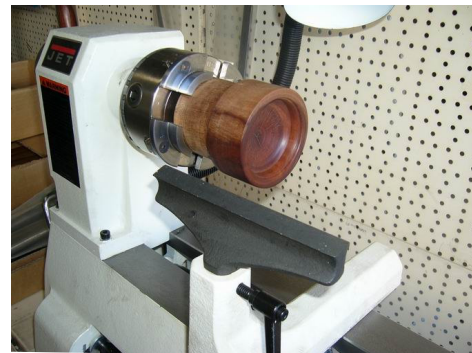


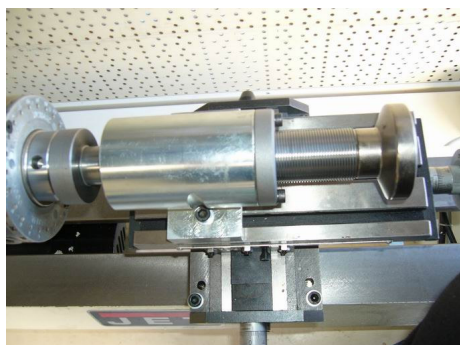
VERMEC THREAD CUTTING ATTACHMENT MAKING A BOX WITH A THREADED LID

CAUTION: Any tool is potentially dangerous - the user should take every precaution to avoid injury. The purchaser is responsible for ensuring that the product is suited to their needs.

1. Start with a cylinder of material
2. With the material in a 3 jaw chuck, true sides and face
3. Separate lid from base and identify parts
4. Mount the lid section with the tip towards headstock (Picture 1)
5. True face and shape the inside, cutting a straight, parallel area for inside threads
6. Cut a step for clearance and then a bevel where the threads are to begin
7. Sand and finish the inside
8. Flow thin super glue over the area to be threaded to strengthen



Picture 1

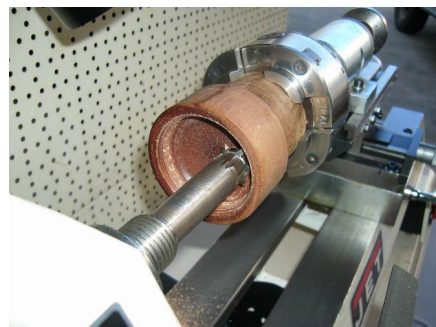


Picture 2

9. Align up Threading Jig parallel to bed (Picture 2)
10. Take the chuck and work piece from the lathe and screw it onto the threading jig
11. Arrange the threading jig and the cutter bit so the teeth on the cutter just brush the area to be threaded (Picture 3 and Picture 4)



Picture 3



Picture 4

12. Adjust the jig so that the cutter will cut a depth of approx. 30 to 35 thousandths for a 16tpi thread that will leave tiny flats remaining on the tips of the threads
13. You may have to re-adjust it deeper and make another cut
14. Cut four or five rows of threads, then lightly sand the threaded area
15. Only cut threads in one direction
16. Running speed when cutting threads—approx 3,000 revs
17. Remove the lid and mount the base with bottom towards the headstock
18. True sides and face and cut the approximated sized tenon

19. Turn out the inside, sand and finish (Picture 5)
20. Finish cutting a tenon larger in diameter (35 to 40 thousandths for 16tpi) than the threads in the lid—to allow for the mesh of the threads, and a little less in length than the width of 3 threads. Cut a bevel where the threads are to begin
21. Flow the thin super glue over the thread area



Picture 5

22. Take care when cutting the threads on the base as it is a climbing cut and it could unscrew the chuck (Picture 6 and Picture 7)



Picture 6



Picture 7



Picture 8

23. Take to the threading jig and cut the threads, testing the fit with the lid (Picture 8)
24. Return to the lathe, lightly sand the threads, and using the base to hold the lid, finish the shaping of the lid, blending with the base
25. Adjust the grain alignment by reducing the shoulder on the base (Picture 9)

26. Sand and finish the lid
27. Remove the base
28. On a waste block mounted on the chuck, cut a “jam-fit” tenon to hold the base
29. Shape the bottom of the box, sand and finish
30. When you cut the threads in the lid of the box, measure with a thread gauge (available from your Woodworking Supplier)—this will automatically give you the size of the tenon on the other side of the gauge to make the base of the box



Picture 9