

INSTRUCTIONS

WARNING! ALWAYS UNPLUG ROUTER BEFORE CHANGING INSERTS OR MAKING ADJUSTMENTS.

SUGGESTIONS FOR OBTAINING BEST RESULTS:

ROUTER . . . Use the smallest router you have since very little power is needed. A router with a micro depth adjustment is preferable since a few thousandths difference in depth determines the quality of your thread.

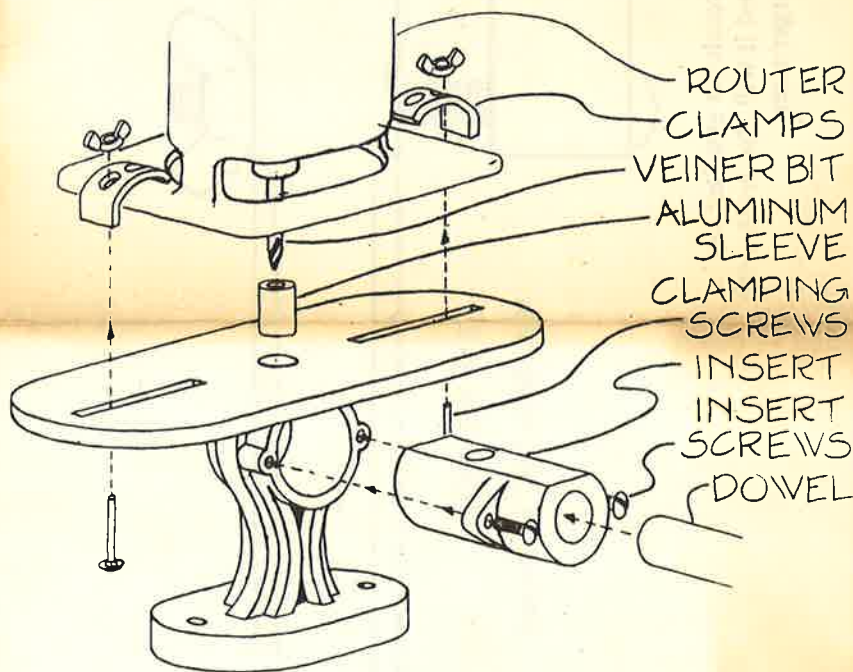
DOWELS . . . Select dowel stock with care. Dowels more than .015 oversize will not fit the inserts without sizing and dowels that are badly undersized will not make uniform threads. If you have a sizing plate, you will be able to use dowels that are quite a bit oversize but sizing is a nuisance and marks up the unthreaded surface of the dowel. Better to get accurate stock to start with. Beall Tool sells dowels in a variety of species that are generally closer to proper sizes than can be obtained from many suppliers.

MOUNTING . . . Attach the threader to a block that can be clamped to the workbench or held in a vise at a comfortable height. Make a crank handle like the one shown so that you will be able to advance the stock smoothly and avoid burn marks in your threads.

THREAD SHAPE . . . Wood structure will not allow the very sharp crests usually seen on metal threads. To obtain the strongest and cleanest threads, maintain the widest possible crest that will still fit freely in the nut. A sharp crest is more likely to chip out and ruin the appearance.

CHIPPING OUT . . . Severe chipping out is usually caused by misalignment of the router. If the router is not centered within .005, chipping will occur. It is vital to carefully center the router using the aluminum index sleeve and to make sure that the router is very securely clamped to the top of the housing. I suggest using pliers to tighten the wing nuts of the hold downs or better yet, to drill two very snug holes through the routers base and the top of the housing and securing with machine screws. This procedure will eliminate the necessity of having to align the router every time it is removed and reinstalled on the threader housing. Chipping can also be caused by a dull bit and by using poor dowel stock such as fir or ramin. Of course having the router set too deep will also give poor threading.

1. Install special bit in router.
2. Adjust router so that bit extends about 1 inch below base and tighten router in its own housing.
3. Place aluminum sleeve over router bit.
4. Place router on top of threader with sleeve in hole and clamp tightly in place with carriage bolts, wing nuts, washers and hold-downs provided.
5. Loosen router in its own housing and pull up sufficiently to clear hole in threader.
6. REMOVE ALUMINUM SLEEVE !!!
7. Place insert in threader and secure with two machine screws provided.
8. Adjust router depth so that the tip of the bit can just be seen when looking through the insert.
9. Turn on router and insert dowel as far as it will go. Turn dowels clockwise at about 1 rev. per second to cut thread. Some trial and error adjustment of depth will probably be necessary to get a proper thread. Never force the dowel when turning it into the insert, remove and lower the router a small amount and try again. Very small depth increments are called for when making final adjustments. A few thousandths of an inch will make the difference between a good thread and a poor one. GOOD LUCK



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** DRILL TAP HOLES 1/8" UNDER*

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These two little projects will save you time and money and improve the quality of your threads.

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