

Useful Hints On Chaser Care & Threading

TO AVOID CHASER CHIPPING AND BREAKAGE:

DON'T “hit the shoulder”

DON'T start tool on the work too hard.

DON'T use poor cutting oil.

DON'T use diehead with weak chaser springs, or clogged with chips - keep the tools clean and the chasers sharp.

DON'T let threading spindle and work spindle get out of alignment.

Threading machinery that is kept in alignment means more and better threads from the chasers.

AND IN GENERAL:

DON'T run chasers too long between grinds. Grinding more often increases chaser life and results in better threads.

DON'T use chasers with different throat angles in the same set.

DON'T use chasers with shorter throat angles than necessary.

DON'T burn the chasers. Take light fast cuts, using correct grinding wheel.

