

## Screw threading aide-memoir

1. Set top slide over to 29.5 degree (for whitworth) to bar.
2. Set change gears to relevant TPI.
3. Set threading tool at right position with small gauge.
4. Set cross slide to zero with tool kissing bar.
5. Run the lathe at slowest speed to check.
6. Move the top slide in/out a couple of thou per cut.
7. Stop motor at end of required travel
8. Reverse motor direction.
9. Clear tool for reverse direction by moving cross slide in/out.
10. Start motor and continue to clear position.
11. Move cross slide back to zero then go to number 6 again until last couple of thou when use cross slide for those couple of thou.