

5-3 Thread Chasing Dial

1. Thread chasing dial for Inch leadscrew

To cut even number threads the leadscrew can be engaged on any number or line. For odd number threads the leadscrew can be engaged on any number. Fractional threads (1/2, 1/4 etc.), leadscrew can only be engaged on the same number or line.

Note: When cutting metric threads on a lathe with an Inch leadscrew, be sure the half nut is engaged at all times. (If not, the thread will not repeat.)

2. Thread chasing dial for Metric leadscrew for cutting metric threads

There are two dials used for metric leadscrews, 2 & 7 divisions and 3 & 5 divisions. To cut threads with pitch of 1.25, 2.5 5.0, 2.25 and 4.5, please use the 3 & 5 dial. For the rest of threads, please use 2 & 7 division dial. Example 1: For cutting thread pitches of 0.5, 0.75, 1.0, 1.5, 2.0, 3.0, 4.0 and 6.0, please use the 14T worm gear and 2 & 7 division dial. The maximum number of divisions on the dial is 7. Example 2: For cutting thread pitches of 1.75, 3.5, 7.0, still use the same 14T worm gear and 2 & 7 division dial, but you can only engage the division dial (2 & 7) on 1 and 2 on two of the numbers.

Gear Teeth	Pitch		Dial Division	Half-nut Engaged Number
11T	2.75	5.5	2	1
13T	3.25	6.5	2	1
14T	1.75	3.5	2	1,2
	7			
	0.5	0.75	7	1,2,3,4,5,6,7
	1	1.5		
	2	3		
4	6			
15T	1.25	2.5	3	1,2,3
	5			
	2.25	4.5	5	1,2,3
18T	6.75		2	1,2