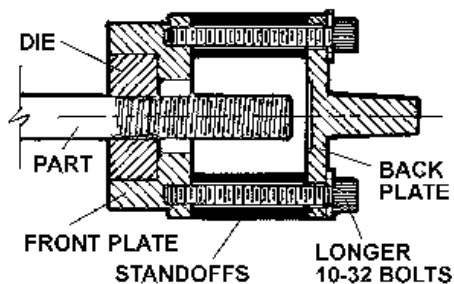


## SHERLINE Adjustable 1" Die Holder

P/N 1206

### Use of the Adjustable Die Holder

The adjustable die holder holds a 1" button die for tapping threads on a shaft. Also included is a bushing that allows a 13/16" die to be held. The depth of thread that can be cut is somewhat limited by the depth of the hole in the base. For smaller threads, a hole can be drilled in the center of the back plate to provide additional clearance. Just make sure you don't get so close to the outside of the #0 Morse taper that you weaken the holder. For larger and longer threads, a simple standoff can be made to hold the die and holder forward of the back plate. Two equal lengths of drilled stock that are square on each end are normally sufficient.



*A longer thread can be cut by using standoffs between the front and back plates.*

The best method of driving the spindle during this operation would be by hand using a hand crank from the thread cutting attachment (P/N 3100). Allow the tailstock and die to slide along the bed as the die feeds itself onto the part by leaving the tailstock loose enough to move easily. Be sure to get the chips to break clear of the part before backing the die off. A good thread can be ruined when backing the die off if you don't pay attention to this detail.

-Joe Martin, President and Owner  
SHERLINE Products