

TIP 11 — Thread Cutting with a Riser Block/Ron Lederer

Ron Lederer of Clearwater, Florida came up with a simple way to extend the range of the thread cutting attachment so it could be used to cut inch threads when the riser block is in place. (Because of the larger diameter of the 127-tooth gear, metric threads can already be cut with the riser block in place.) Just use two optional 150-tooth gears in place of the 100-tooth gears (A and B). These larger gears do not come with the thread cutting attachment, but can be purchased as [P/N 31510](#) at sherlinedirect.com. With this arrangement you will be able to cut threads from 40 TPI to 20 TPI, right or left hand. You can also cut right hand threads down to 10 TPI.

Another way by Douglas Swink

Douglas Swink of Arkansas says he was able to use his threading attachment with the riser blocks in place by purchasing a single extra 127 tooth gear. By using two 127 tooth gears in the A and B positions to drive the gear train instead of 100 and 100, the larger size gears accommodate the additional height of the riser block. The cost of a single extra 127-tooth gear is just \$15.40, which is much less than the cost of two 150-tooth gears.