

TIP 100 — A More Rigid Thread Cutting Attachment/Cary Millsap

I used to have problems keeping my thread cutting attachment (P/N 3100) rigid enough to complete a threading procedure. I had continual trouble keeping the primary support arm (P/N 31020) and secondary support arm (P/N 31030) from losing their grip with each other at the pivot point.

I've found a reliable solution, though. And it is very simple.

The Sherline instructions call for screwing the 10-32 × 1" SHCS (P/N 40330) through the secondary support arm into the threads on the primary support arm. However, I screwed in the SHCS with a washer, using Loctite® Blue, from the back of the primary support arm. (I swapped my 10-32 × 1" SHCS for a BHCS.)

The screw inserts through the unthreaded hole in the secondary support arm into a #10 washer and 10-32 nylon insert lock nut. Now I can torque down the nut on the front of the secondary support arm without having to worry about harming the threads in the primary support arm.

This modification is easy to make. It requires no changes to any stock part, and the only investment required is two #10 washers and a 10-32 nylon insert lock nut.

Cary Millsap

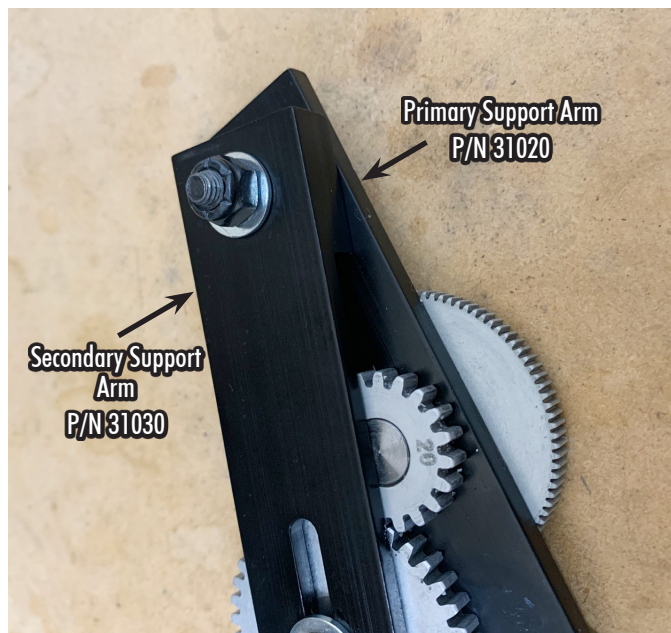


FIGURE 2—This photo shows the opposite side of the support arms.

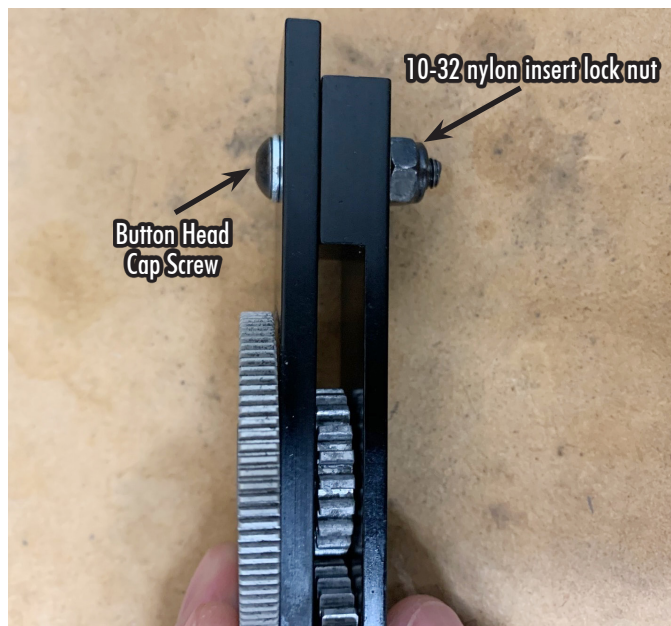


FIGURE 3



FIGURE 1