

I have written this to answer questions about using the Klein Jig on other lathes. Hopefully, I have answered your questions. If not, please let me know.

The Klein Threading Jig

Although this Jig was designed to be used on the Klein Lathe, it can actually be used on any lathe. Two things have to happen for it to work. The spindle thread pitch of the lathe and the jig need to match, and the jig needs to be mounted on the lathe at the same centerline height as the spindle of the lathe.

Since the spindle of the Jig is $\frac{3}{4}$ "-16, we offer a #2 taper with a $\frac{3}{4}$ "-16 spindle nose. This taper has been drilled for a "draw bar" for added security. When you put this into your lathe headstock, your lathe will then match the Klein Jig. This is important for a couple of reasons. The mandrel that holds the cutter is made to fit a $\frac{3}{4}$ "-16 spindle. The Klein faceplates also fit the $\frac{3}{4}$ "-16 spindle.

We have riser blocks to raise the jig to the correct height for most of the smaller lathes: Jet, Delta, General, Vicmark, Oneway 1018 and 1224, and Mercury. For other lathes (large or small) you will need to build your own riser block. We have a mounting plate for you to attach to the top of your riser block. The Jig attaches to the mounting plate. The riser block you build, could be as simple as a box made from $\frac{3}{4}$ " plywood. It must be able to slide along the ways of your lathe, remaining parallel to the lathe bed, and must be able to be clamped in place. The mounting plate comes with drawings for building a riser block.

These are the simplest solutions, but there are other ways. With the use of spindle adapters, you can use chucks or faceplates with other spindle sizes. You could hold the cutter in a collet or Jacobs chuck.

In all the classes I teach and all the demos I do, my preference is to use two 2" faceplates to make the threaded boxes. There are a couple of reasons for this. I can leave the lid and the base each attached to their own faceplate until I'm finished with the entire threading process. I don't have to worry about returning a piece to the chuck exactly like it was before. I prefer not to use chucks in a class or in demos for safety reasons. It is too easy to push the tool rest or your fingers into the chuck if you get distracted. I like to turn 2-3" diameter boxes between 2000-3000 rpm. I'm not comfortable spinning the mass of a chuck at those speeds.

Whenever I teach, since most lathes will accept a #2 taper, I equip all the lathes (large or small) with the special #2 taper and two faceplates, making it very convenient to turn threaded boxes using the Klein Threading Jig.

The Threading Jig comes with a HSS cutter, a mandrel to hold the cutter, one faceplate, and instructions for making a box with a threaded lid.

Also available is a video in VHS format and a DVD showing how to make threaded boxes.