



<http://www.corridorturners.org/>

## Next Meeting

The Next meeting of the Corridor Woodturners will be held at 6:30 PM on May 14th at Leisure Living Construction, 2700 Stone Gate Court in Hiawatha.

Last month we had a demonstration of thread making by hand and this month Byron Bohnen with the able assistance of Paul Rohrbacher will demonstrate thread cutting with the EZ thread cutting jig. Byron has included a summarization of the steps required and it is on page 6 of the newsletter. This URL will take you to a You-tube video of the jig in action(<https://www.youtube.com/watch?v=7ekwXFGzknc>)

## Airport Display

The display at the airport has been removed for the remodeling being done there. The items in the display will be at the meeting for members to pick up. Jeff Kromminga has graciously donated space at his shop for us to store the display cases until they can be returned to the airport.



## Last Meeting

Last month John Cox presented a program on hand thread chasing. Starting with a description of the best types of wood to use for chasing threads, the tools, a male and female chaser, an arm rest tool and a relief tool and what they look like, he explained how they are used and that only the chasers are really needed, however the arm rest tool makes things easier. The relief tool can be easily ground from an old allen wrench. The chasers are designated in threads per inch and are available in 16,20,24 TPI. The 20 TPI chasers are the best for beginning turners to use because the speed of the side travel of the chaser once the thread is begun is easy to follow. The project demonstrate was to be a box. The blank was turned between centers to a cylinder and a tenon was turned on each end. The blank was then parted in a 1/3-2/3 ratio with the 1/3 section to be the top. The top blank was put into a chuck, trued up and hollowed out. Hand chasing threads does not limit the turner to a specific size opening. The top section was hollowed out to a wall thickness of about one half inch. It is important that the first section, where the threads will be cut is parallel with the bed ways on the lathe so that the threads will not be tapered. A relief was cut just behind where the threads were to be chased so that the chaser can be removed before hitting the top of the box and ripping out the just formed threads. The tool rest was set so when the female chaser was placed on the arm rest the cutting edge of the tool was just a bit above center. A circular motion was started with the chaser and very slowly moved toward the wood at a 45 degree angle, just kissing the edge lightly with the center of the chaser with each pass. As the thread begins to form the chaser is brought around to continue the thread. The lead tooth of the chaser is not used until the thread has been fully formed. Continual passes are made until the thread is fully defined. Using a toothbrush to clean debris out of the threads and apply a good coat of wax the top threading was finished. In order to show how the male threads are determined John used a piece of hard maple, explaining that while it would take threads they wouldn't be very good but for demonstration purposed they would work well. A short tapered tenon was turned on the blank so that the top of the box would just fit onto it. The wax on the top section left a burnished line on the tenon. This

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Kevin Bierman

## From the President

I am very pleased to announce that after a lot of leg work, many e-mails and several meetings our club is set to host a two day demonstration with John Jordan. On October 3rd and 4th John will be our guest at Hawkeye Downs here in Cedar Rapids. John is a very well known turner from Tennessee and an honorary lifetime member of the AAW. He is famous for turned and carved hollow vessels. Please visit his web site ( <http://www.johnjordanwoodturning.com>) to see many examples of his fine work. The presentation will be broken down into two separate topics for those who can not attend both days.

### Saturday Demo: Bowl Turning

John will demonstrate bowl turning, starting with the basics. Wood selection, use of the deep fluted bowl gouge and shear scraper to make finished bowls from green wood, both regular and natural edge. There will be an in-depth discussion of sharpening, as well as the properties of wood, including how to deal with cracking and wood movement.

### Sunday Demo: Turned and Carved Hollow Vessel

John will show how to make an elegant and refined vessel, starting with fresh green wood. John will show how to shape the outside with the bowl gouge and shear scraper, then using hollowing tools that he makes, how to simply remove the wood working through a fairly small opening. Methods of controlling the wall thickness and smoothing as well as reversing to turn the bottom will be shown as well. After the turning, various carving and texturing techniques will be demonstrated. He will have many of his own special tools for sale both days.

We are looking at starting both days at 9 am and ending around 4. The club will provide lunch both days so we will not have to waste yours and John's time. A reduced room rate will be available at the near-by Holiday Inn Express and also RV camping can be arranged at the Downs. The cost to attend will be \$50.00 a day or \$90.00 for both days. We will of course sign up all club members first but plan to contact all surrounding area clubs. This will have to be prepaid so we can plan seating and meals. This is a major undertaking and believe me the board did not enter into this on a whim. Many of you were around the last time we did something like this and know how much of a team effort this takes. I say that as a lead into this, we are going to need the full club's help and participation. Aside from just attendance at the demos we are going to need help with many different things. Set-up, clean-up, camera work, meals and registration are just a few things that come to mind. October seems like quite a ways away but there are many things to do.

This promises to be a very good learning opportunity for what I think is a very reasonable cost close to home. Please bring any and all questions to the meeting on Thursday night.



**Trint Adams-Hackberry-Lacquer-S&T**



**Don Coleman-Bloodwood-WOP-POM**



**David Kesler -Acrylic & Afrilla Burl-CA**



**Kevin Bierman -Cherry-AO-POM**



**Brad Davis -Bloodwood-S&T**



**David Tegler**

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Code- S&T=show and tell, POM= Project of the Month, CA=CA glue, WOP= Wipe on Poly, AO= Antique Oil,



**Don Potter-?-Poly-S&T**



**Bob Smiley-S&T**



**Tom Mills-Red Gum-Salad Bowl-S&T**



**Glenn Hunt-POM**



**Harold Rosauer-Spalted Maple & Ebony  
Lacquer-S&T**



**Bruce Kruse-Cherry-Lacquer-POM**

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**Brad Davis-African Blackwood-S&T**



**Gary Nosek-Elm-S&T**



**Lisa Heitz-Rosewood- CA-POM**



**Kevin Bierman-Elm- AO-S&T**



**Paul Rohrbacher-Butternut-CA-S&T**



**Tom Nehl-Maple- WOP-POM**

## Byron's Directions for cutting threads with the EZ Threader

My EZ Threader came with the 16 TPI spindle but you can get different threading spindles for your jig at 20, 16, 12, 10 and 8 TPI for the additional spindle.

Some of the best hard woods for cutting threads are:

African Black Wood is probably the best.

Cocobolo (any) Hard Oily wood, Bubinga, Lignum Vitae, Boxwood, Osage Orange, Desert Iron Wood, Red Hart

Cheaper wood which work okay but work better if you soak the threaded area with thin CA glue are: Cherry, Hard Maple, Black Locust, Holly, Mesquite, Apple

Turn the wood into a cylinder between centers. Turn a cleat on both ends for chucking.

Use a parting tool separate the top from the bottom of the box. I do not use a parting tool I use the band saw since the band saw removed less wood. This helps the grain pattern to match better. When cutting round stock on a band saw it is safer to use a 90 degree jig to help stabilize the wood being cut.

Switch the top and bottom to self-centering 4 jaw chucks. The top and bottom will stay in the chucks until they are done.

Hollow the female portion of the box, sand and finish inside before threading.

Male section, don't hollow until all the threading is completed.

Female threads get cut first. This will be the top of the box. Male threads get cut to match the female threads.

The leading edge of both threaded area needs to be beveled so the cutting bit can take a gentle bite when it starts to cut.

If using a softer wood, apply CA glue to the threaded area to strengthen it.

Make the first pass about 50% of full depth. If tear out is starting to be seen, the thread cutter has started to open up the wood fibers. That is when to apply more Thin CA. Role the wood back and forth to allow the CA to fully soak in. Don't use any Kicker because it will turn the CA white. Weather you use kicker or not, make sure that the glue is hard before cutting.

Turn a relief groove at the end of the threads.

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4 to 5 threads is great plenty and probably too much. Cut 4 turns of the female thread then the cutter will be in the relief groove.

Cut thread DEEP enough so the top of the thread is a sharp "V" shaped. When the top is "Ved" the bottom or valley is at maximum depth. Now the top of the "V" can be sanded flat. Caution here, don't sand too much off, just until a flat is seen. The sanding can cause thread tear out so it may be advisable to apply a CA application and then without re setting the jig, recut the hardened threads, then sand.

Remove the lid and place the chuck holding the bottom on the lathe.

Hollow the bottom just enough so the threads can be cut. Make sure you have the relief grove where the threads will end. Male threads don't get hollowed first. You can hollow after the thread fitting is completed. The male threads are the hardest threads to cut. The Thread Cutter wants to grab the wood and run out of control. The thread tendon area is measured as follows. Measure the ID of the female threads, add 0.070" to the diameter for the size 16 threads and turn the tendon to that diameter. At the rear of the tendon cut a relief groove about 2/3 rds the width of the Thread Mill and 0.035" deep.

Line up the cutter with the bottom making sure everything is lined up with the ways of the lathe.

Bevel the leading edge of the bottom.

Cut the threads.

Sand the threads removing the sharp V edge.

Test fit the threads. When they are threaded correctly it is time to match the grain pattern of both top and bottom.

Shorten the shoulder where the top and bottom touch to get the grain to line up.

Lubricate the threads with something like of liquid wax. Butcher Block Finish works great as a lubricant.

Once the grain is matched and you like to fit of the threads it is time to hollow and finish the inside of the bottom.

Time to true up the outside of this box. Screw it together and shape the top of the box and the outside. Sand to your liking. The turning of the top and bottom together really tightens the threads making separation a real problem. The lid comes off very hard. A Strap Wrench to break the lid loose might be the best idea.

Burning 3 lines helps to camouflage the separation line, with the center line being the separation.

Apply finish to the outside of the project.

Using the parting tool remove the cleat on the bottom making sure the bottom has a slight concave.

Sign the bottom and apply finish.

### **Library Information**

Do you use the literature library? What items would you like to see added, what would make it easier to use? See Gary Nosek and make your wishes known.

### **For Sale**

Have something for sale? Let the club members know about it here. Get the info to John Cox to be added to the next newsletter

### **Dues Structure and Meeting Attendance Policy**

Club dues are:

\$25.00 per year for an General membership.

\$30.00 per year for a Family membership

\$100.00 per year for a Supporting membership.

Potential members may attend two meetings as a guest then must either join the club or pay 1/4 of the current general membership fee to attend a regular meeting.

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burnished mark was used as a guide to determine the diameter of the tenon onto which the male threads were cut. A chamfer was made on the end of the tenon and the tool rest adjusted to about a finger width away from the wood so that the male chaser was in a slight downward scraping position and a circular motion of the chaser was begun advancing into the wood at a 45 degree angle just kissing the wood with the center of the chaser and continuing the full width of the chaser. This motion was continued until a thread was formed and then the chaser was brought around to be perpendicular to the tenon in subsequent passes. A relief cut needed to be made at the end of the threads so the chaser could be removed before the back of the tenon was reached and the threads ripped out. In a great stroke of luck the top screwed onto the tenon almost perfectly the first time it was tried. This does not happen all the time, especially for beginners and the frustration of making the male threads too small is ever present. Plenty of practice, patience and perseverance are required with practice an essential.