

I developed this chart so I could remember how to set-up the lathe for cutting RH and LH internal threads. Harold Vordos was kind enough to provide all the information in this chart. Many thanks to Harold for generously sharing his knowledge. George Glines

Internal Threading Set-Up Chart

Spindle Direction	Position In Hole	Tool Faces	Direction of Cutter Travel	Compound Pointing 29.5°	Right/Left Hand Thread
				Using Clock Face as Reference	
Forward	Front	Up	Left	1:00 or 7:00	RH
Reverse	Back	Up	Right	1:00 or 7:00	RH
Forward	Back	Down	Right	1:00 or 7:00	LH
Reverse	Front	Down	Left	1:00 or 7:00	LH

Please note: This set-up chart assumes cutting with the compound rest at a 29.5 degree angle, and using the compound for the in-feed. The Compound Slide faces either 1:00 or 7:00 depending on operator preference and whether you wish to add or subtract dial readings.