



# “Handy-Thread”

## High Speed Threading Machine

(Cutting or Rolling)

A new concept in rod threading. *Handy-Thread* features standard rotating die heads, automatic air chucking, automatic die opening at precise thread length. Will cut a different thread length on opposite ends of each rod.

Designed for continuous duty high production rod threading of rods from 1/16" through 5/8" diameter. Approximate size: 23" x 37" x 26" high. Weighs approximately 300 lbs.

Request **AAA Bulletin A-139** for complete description and optional equipment, or online at:

[www.aaproducts.com](http://www.aaproducts.com).



### Handy-Thread – How It Works ...

The *Handy-Thread* has no chucking or feed levers, no foot switches and no clutches. The operator inserts the rod to be threaded through a short collet and against a stop; then pushes the carriage (with rod) forward until the rod engages the rotating threading die. At the proper thread length the die opens automatically. The operator then pulls the carriage (and rod) back and withdraws the threaded rod. Clamping and unclamping of the rod in the collet, and opening and re-cocking of the threading die are all done automatically as carriage movement actuates various limit switches.

### Features of the Standard HT-1P Model

The standard **HT-1P** model uses a 1½ HP, single phase, 120 VAC electric motor. It rotates the threading die at 400 RPM. Other speeds can be set at the factory, as ordered, or the pulleys can be changed in the field for faster or slower spindle speed.

**Rod Material.** Most materials for which the die is suited can be threaded, HP and RPM being the limiting factor.

**Thread Length.** This model will produce thread lengths up to 6" and can thread to within 1/2" of the end of the rod (a minimum of 1/2" is required for the collet to grip the rod). Rods as short as 1" long can be threaded. Longer threads or continuous threading of long rods requires a special *Handy-Thread* model.

**Alternate Threading.** Two thread length limit cams are provided which can be set to different thread lengths. The operator can cut threads of different lengths on opposite ends of the same rod, up to 3½" long on one end and up to 6" long on the opposite end. First thread one end, then insert the opposite end for a different thread length. After initially setting the two length stops the alternate threading operation is automatic. When the alternate threading feature is off, the same length is cut on both ends.

**Thread Cutting Dies.** The *Handy-Thread* machine can be ordered to use almost any brand of 5/8" capacity rotating die head of the quick opening type, but the machine must be fitted at the factory for the particular brand requested.

The *Handy-Thread* machine can be adjusted for very accurate thread lengths, and will repeat to an accuracy of plus or minus 0.018". The collet can be centered on the die head with sufficient accuracy to produce any class of thread of which the die head is capable. Thread length is held very accurately because of the low friction, free traveling ball bearings on which the chuck carriage travels.

Threading dies for the *Handy-Thread* machine must be of the quick opening, rotating type which have a yoke to open and close the die. Purchase dies locally.