

Thank you for purchasing the OMW Corporation Tailstock Die Holder. I hope you enjoy using it as much as I enjoyed making it. With a little care, this tool should give you many years of service. Please read the instructions below to take full advantage of your new Die Holder. And let me know if you have comments or questions. I can be reached via email at JHKO@AOL.COM, or at OMW Corporation (21 Pamaron Way, Ste. G., Novato, CA 94949).

Best Regards,

*Joe Osborn
President, OMW Corporation*

Instructions for Using the OMW Tailstock Die Holder

Die Holder Parts

The three main parts of the holder are the Body, the reducing insert and the tailstock plunger (Fig. 1).

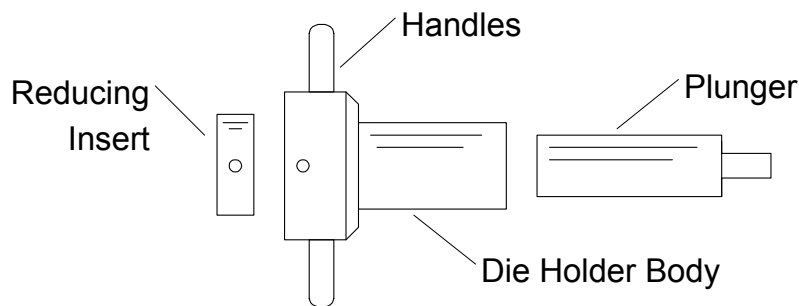


Fig. 1

Using the Die Holder

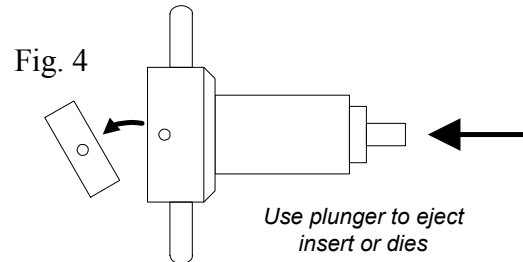
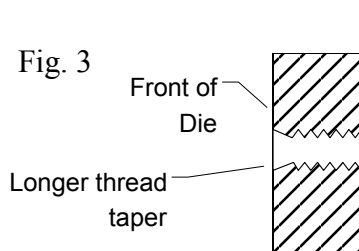
The OMW Die Holder is designed to hold 1" or 13/16th" diameter standard round dies. 13/16th" dies are held in a close fitting insert in the 1" die recess. The holder is designed so that round stock held in the three jaw chuck or collet of a lathe can be concentrically threaded easily and quickly.

To use the holder, mount a drill chuck in the tailstock of the lathe. Next, place the small end of the plunger in the tailstock drill chuck and tighten the chuck (Fig. 2). Place the desired die in the front recess of the die holder body, and tighten at least one set screw to hold the die securely. Make sure the die is seated securely and that the front face of the die is parallel to the front face of the die holder. Also, make



Fig. 2

sure the die is facing the correct direction. The die should have a longer inside taper on the side facing the work (Fig. 3). When using 13/16" dies, you will need to mount the die first in the reducing insert, then mount the insert into the die holder and tighten the set screw. The reducing insert or dies can be removed by pushing out with the plunger (Fig. 4).



Next, slide the die holder body over the plunger. Mount the work to be threaded securely in the lathe chuck or collet, with a small length protruding. Coat the work with cutting fluid. ***With the lathe power OFF,*** bring the tailstock toward the headstock of the lathe until the die engages with the work. (Fig. 5) Now, grasp handles of the die holder firmly and begin turning the holder clockwise while applying some pressure toward the work. Note that you will need to lock the lathe spindle so that the work does not turn as it is being threaded. Often, putting the lathe in its lowest gear will provide enough resistance to accomplish this. Or, on small lathes, you can hold the chuck or motor pulley steady with one hand while turning the die holder with the other. Every couple of turns, reverse the turning direction to break the chips, then continue threading to the desired depth.

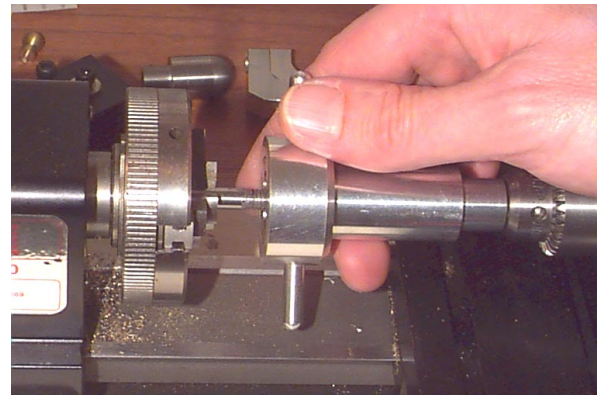


Fig. 5

A note about threading under power

The OMW Die Holder is designed for manual thread cutting, using the lathe for thread alignment, but without using the lathe power. Threading short lengths of thread under lathe power can be a tricky and potentially dangerous undertaking. You should NEVER turn on the lathe power while holding the die holder handles.