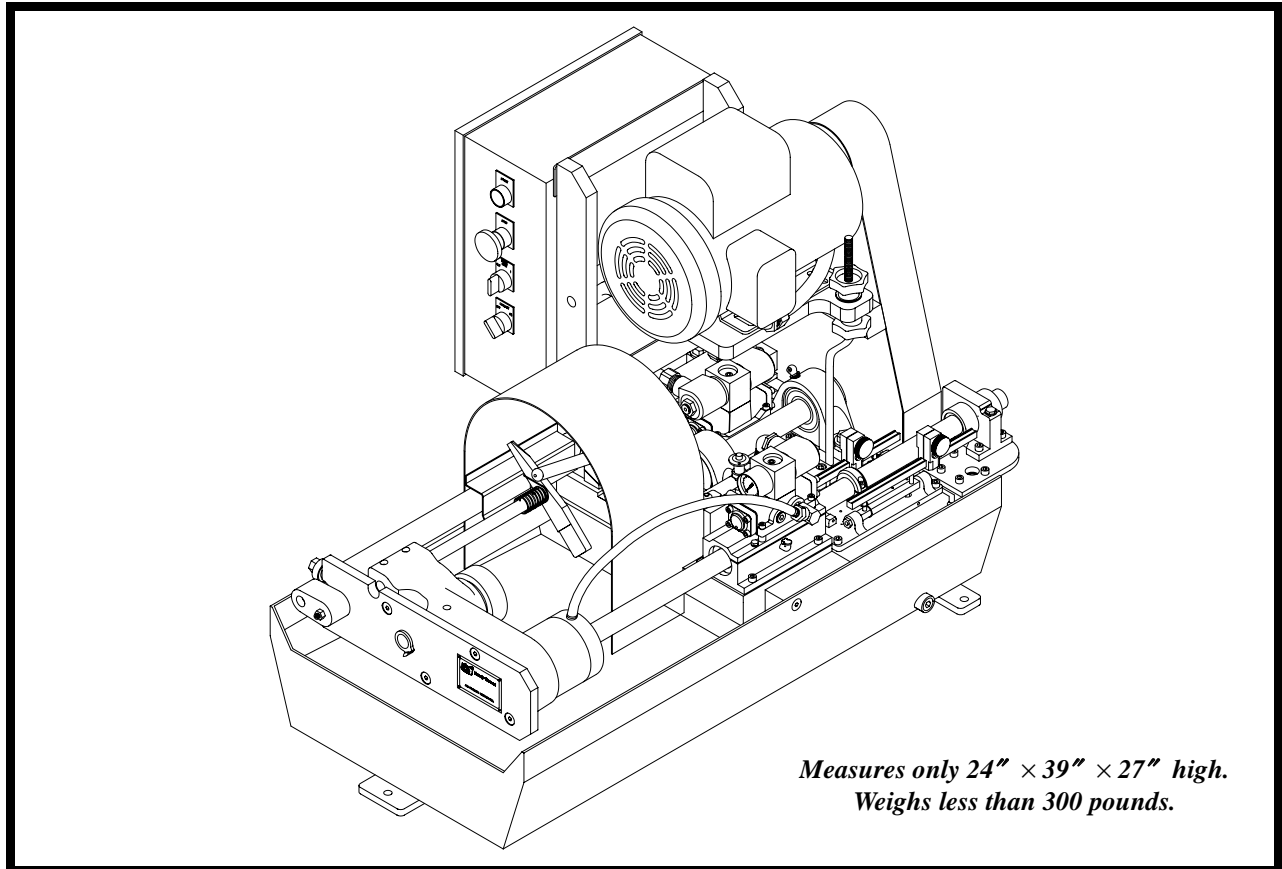


# “Handy-Thread”

(Patented)

## High Speed Threading Machine

FOR THREAD CUTTING OR ROLLING WITH ONE HAND



Measures only 24" × 39" × 27" high.  
Weighs less than 300 pounds.

### Standard No. 1 “Handy-Thread” machine

A completely new approach to threading. Table model for high production threading of rods through 5/8" diameter, NC, NF or through 16mm metric. “The best thing that’s happened to threading in years.”

Use only one hand, no foot operation. Change threading head in less than two minutes



Manufactured by *Jiffy* PRODUCTS DIVISION

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# ***“Handy-Thread” — A Unique and Proven Concept in Rod Threading***

*Featuring: Standard rotating threading heads, automatic air collet chucking;  
automatic threading head opening at precise thread length.*

***Will cut a different length of thread on each end automatically.***

**“Handy-Thread” is a quality, high production rod threading machine that is easy on the budget. It is a compact machine designed for continuous duty, high production threading of rods from 3/32” through 5/8” diameter. Approximate size: 24” × 39” × 27” high. Weighs less than 300 lbs. It can be moved easily to the job mounted on a rolling table or bench. Plug it into a standard 120-volt, 3-prong electrical outlet, connect it to the shop air supply, and it is ready to go to work. The machine can be operated with one hand. The carriage, mounted on ball bearings, rolls so easily that there is little operator fatigue. There are no foot switches to stumble over and even an unskilled operator can immediately learn to operate it with no special training. Thread quality will be as good as your threading head is capable of making. The quality of your thread is limited only by the quality of your threading head.**

## ***“HANDY-THREAD” – How it Works ...***

The patented **“Handy-Thread”** machine operates on a completely different principle than other threading machines on the market. It has no chucking or feed levers, no foot switches, and no clutches. All that is required of the operator is to insert the rod to be threaded through a short collet and against a stop, push the rod and carriage slightly forward (the chuck clamps the rod and the stop swings away), continue pushing the rod and its carriage forward until the rod engages the rotating threading head. At the proper thread length the threading head opens automatically. The operator then pulls the carriage (and rod) back to full retracted position and withdraws the threaded rod. Clamping and unclamping of the rod in its collet, and opening and re-cocking of the threading head are all done automatically as the movement of the carriage actuates various adjustable limit switches.

The machine can quickly be set up for a different threads. The operator removes the collet and threading head then installs the new collet and threading head and sets the desired thread length, using the built-in calibrated thread length quick set gauge. The machine is then ready for operation. It will produce any thread in its size range as fast as it is possible to run the threading head without damage to the head, or without exceeding the HP rating of the electric motor. A larger electric motor can be furnished to order.

## ***Features of The Standard No. 1 Model ...***

This is a non-reversing machine which will handle the majority of rod threading jobs. All concepts used in the **“Handy-Thread”** are practical, proven technology.

The standard model uses a 1-1/2 HP, 120-volt, 1725 RPM single-phase electric motor. As assembled at the factory it produces a spindle speed of 400 RPM which is satisfactory for most jobs. However, a different set of

pulleys will be installed at the factory before shipment when requested, or the pulleys and cog belt can readily be changed in the field for faster or slower spindle speed.

Since the motor never reverses during a threading operation, and never stops between threading operations, the motor will not overheat when the machine is used within the specified range of rod diameter, type of material and horse power.

**Rod Diameter.** This model will thread the equivalent of mild (cold rolled) steel in diameters up to 5/8” . For rods of larger diameter or harder material a model with a larger electric motor is recommended. (Consult factory)

**Rod Material.** Most materials for which the threading head is suited can be threaded, HP being the limiting factor.

**Thread Length.** This model will produce threads up to 6” long, and can thread to within 1/2” of the end of a 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 also can be done on a standard machine using continuous thread mode.

**Alternate Threading.** All models of the **“Handy-Thread”** have the *Alternate Threading* feature. Two thread length limit cams are provided which can be set to different thread lengths. The operator can cut threads to different lengths on opposite ends of the same rod, up to 3-1/2” long on one end and up to 6” long on the opposite end. The first threads one end, then inserts 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 turned off, the machine will cut the same length on each end up to 6” long.

**Threading Heads.** The **“Handy-Thread”** machine can be ordered to use almost any brand of 5/8” capacity rotating head. The threading head must be the quick-

opening, rotating type which has provisions for a yoke to open and close the head. Purchase heads from your local machinery house or contact factory. The machine must be fitted at the factory for the particular brand threading head which you will use.

The **“Handy-Thread”** machine can be adjusted for accurate thread lengths, and will repeat to an accuracy of plus or minus 0.015". The collet can be centered on the threading head with sufficient accuracy to produce any class thread of which the head is capable. Thread lead is held very accurate because of the low friction, free traveling ball bearings on which the rod chuck carriage travels.

**U-Bolt Threading.** U-bolts having a throat as small as 2" and a minimum overall length of 7" can be threaded even after the U-bolt has been bent.

**Power Requirements.** A standard **“Handy-Thread”** machine with 1-1/2 HP electric motor operates from 120 volts, single phase, 60 Hz, with 20 ampere draw (on 120 volts). A power cord with a 3-prong grounded plug which fits a standard 20-ampere 3-prong receptacle is furnished. A source of 85 PSI shop air is also required for operation of the collet and threading head closing cylinders. If shop air is not available, a small compressor of 1/2 HP which will deliver at least 85 PSI can be used.

**Equipment Furnished.** All single-phase **“Handy-Thread”** machines are furnished complete with 120-volt, 60 Hz motor; power cord and plug; electric control box; pressure regulator for the compressed air line; coolant pump; drive belt and two pulleys; and 5 sizes of rod guide bushings.

Collets, threading head are not furnished unless specified on your order. The machine will accept spring-type, No. 11 Hardinge or B & S collets. They can be included with your machine order or can be purchased locally from your machinery dealer.

Special collets to hold square or hex rods can be ordered with your **“Handy-Thread”** machine or can be obtained from your local machinery dealer. Special size collets for thread rolling are also available (for under size thread rolling rod).

**Special Electric Motors.** For threading rods 5/8" diameter, or material harder than mild steel, a slower spindle speed with greater torque will be needed. For these applications the machine can be ordered with 2 HP, 1725 RPM, 120/230-volt, 60 Hz, single-phase electric motor. The pulleys normally furnished with this motor give a spindle speed of 400 RPM. This larger motor and various pulley combinations to give spindle speeds in the range of 400 to 1700 RPM can be furnished on original order or can be installed in the field on existing **“Handy-Thread”** machines.

**Construction.** The **“Handy-Thread”** machine requires very little maintenance because all moving parts in the clamp cylinder and collet chuck are solid bronze or chrome plated to prevent rust from water base cutting fluids. The chuck body is made from alloy bronze and requires very little attention.

All solenoid valves are controlled by a PLC.

The traveling carriage on the **“Handy-Thread”** machine is all sealed ball bearing running on hard rods, and the work can be fed into the threading head with little effort.

The CNC machined base plate is made from a single heavy aluminum alloy casting, and is mounted to the cutting fluid tank with a 3-point mount to prevent distortion if the cutting fluid tank is bolted to an uneven surface.

This machine, in production for over 18 years, is truly a fine piece of production equipment, built by a company with over 40 years experience in special machine manufacturing and used in production by many major manufactures. Contact us for a list of satisfied owners.

# Model List & Options

## — THREAD CUTTING MODEL —

**MODEL HT-1P.** Standard No. 1 “**Handy-Thread**” machine with a 5/8” diameter thread capacity, non-reversing. Furnished with a 1-1/2 HP single-phase motor for 120 VAC, 60 Hz. This model has a standard air collet chuck to accept any No. 11 spring collet. Specify the brand and the model of the threading head to be used. Supplied with 5 rod guide bushings. The collet and threading head are priced separately. Consult factory for price and delivery.

**Larger Motor.** 2 HP, single-phase, 1725 RPM, 120/230 VAC. Add to the price of Model HT-1P. Consult factory for price and delivery.

**OPTION OC.** An oversized air collet chuck to hold collets for round rods from 1/8” through 1” diameter. Will accept any No. 21 spring collet. This option must be specified on your original order; it cannot be added to existing machines. Add suffix “-OC” to the model number of the “**Handy-Thread**” machine and add to the price of the selected model. Consult factory for price and delivery.

## — EXTRA ROD GUIDE BUSHINGS —

For helping the operator guide the rod into the collet. All “**Handy-Thread**” machines are supplied with 5 sizes of rod guide bushings for 1/4” , 5/16” , 3/8” , 1/2” , and 5/8” diameter rods. Other sizes may be ordered, but 1/4” is the smallest size. **Note:** Bushings are bored out to 1/32” greater than nominal rod diameter. Specify rod size when ordering. Consult factory for price and delivery.

## — ADAPTOR SLEEVE —

For adapting a small diameter threading head shank up to 1” in diameter. Specify shank diameter of your present head. Consult factory for price and delivery.

## — COLLETS FOR AIR CHUCK —

*No collets are furnished unless specified.  
For thread rolling, collet size must be  
undersize to fit roll stock rod.*

**No. 11 Spring Collet.** For any size round rod from 1/8” through 13/16” diameter in increments of 1/64” Specify choice of rod diameter. Consult factory for price and delivery.

**No. 21 Spring Collet.** For “**Handy-Thread**” machines with Option “-OC” (oversize collet chuck). Available for round rods from 1/8” through 1” diameter in increments of 1/64” . Can only be used on machines which were factory supplied with Option “-OC”. Consult factory for price and delivery.

**SPECIAL COLLETS** for square and hex rods. Consult factory for price and delivery.

**Many combinations of horsepower, speeds, voltage, left-hand threads, etc. within the machine limitations are available. Consult factory.**