



# Garrett Wade

## Technical Memo T77

Re: 98N11.01 98N11.02 98N11.03 98N11.04  
98N11.05

To Customers of the Complete Tap & Die Wood Threader Kit  
From The Garrett Wade Technical Department

Thank you for your purchase of the Complete Tap & Die Wood Threader Kit. Please follow these simple instructions to ensure efficient performance and quality results. Keep the V-shaped cutter sharp between uses with a small file or hone (12 Piece Mini File Set [www.garrettwade.com/05R01.05/](http://www.garrettwade.com/05R01.05/))

## Instructions for Use of the Wood Threader Tap & Die Kit

### Threading Operation

1. Check the dowel carefully. Straight grain hardwood dowels work the best. Check the dowel to ensure that it is round and not oval. Test fit the dowel in the threader to make sure it is not too snug or too loose.
2. With most dowels, you will have to use a lubricant. Linseed Oil or Tung Oil work best. These can be cleaned up with mineral spirits or turpentine if you want to stain or paint your finished project. Some hardwoods may require you to soak the part of the dowel you wish to thread. This soaking may take anywhere from a few minutes to a few days. The better the lubricated the dowel is, the easier it will be to cut and the cleaner the threads will be.
3. Before starting to cut the threads, you must chamfer the end of the dowel. This can be done by sanding the dowel or using a chamfer tool. This chamfer only needs to be approximately 1/8" down. This will make it easier to start your threads.
4. It is easier to cut the threads if you clamp the dowel in a vise or use some other way to hold the dowel firmly. But be careful not to damage your dowel. Insert the dowel into the large smooth end of the threading tool.
5. When you start the cut you may need to apply a slight downward pressure to help it get a clean bite. Once you have started cutting, always use a forward motion. If the cutter binds, back up no more than a quarter of a turn to clear any chips; continue cutting new threads. If you have to remove the threading tool and try to reinstall it, you **must** line up the threads you've already cut. If it is not properly lined up it will cut new threads, ruining the threads you have already done.
6. It is good to practice on a scrap piece of dowel. It won't take long before you'll be using your threader in more of your projects.

*For further assistance, call the Garrett Wade Technical Department at 800 221 2942, or email us at [mail@garrettwade.com](mailto:mail@garrettwade.com)*

## Tapping Operation

1. First drill a starter hole in the work piece. Use the chart below as reference for drill sizes.

1/2" Kit use a 3/8" Drill bit

1 1/4:" Kit use a 1 1/8" Drill bit

3/4" Kit use a 5/8" Drill bit

1 1/2" Kit use a 1 3/8" Drill bit

1" Kit use a 7/8" Drill bit

2. Lubricate the tap with Linseed Oil or Tung Oil. You can use any other type of Oil that you still can stain or paint over, depending on what your finished project requires.
3. It is important to start the Tap as straight as possible. Start slowly. This is important to get a clean cut at the top without tear out. It can be helpful on some types of wood to bevel the top edge to help the Tap start.
4. Turn the Tap in a couple of turns before turning it back out to allow the chips to clear. Continue in this forward-backward, cutting & clearing manner to carefully tap the hole to the desired depth.

Please call us at 800-221-2942 or email us at [mail@garrettwade.com](mailto:mail@garrettwade.com) if you have questions or need further assistance. Enjoy your Tap & Die Kit.

*Garrett Wade Customer Service*

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