



Contains March 2019 Minutes

April, 2019

NO MEMBERS OR VISITORS SHALL ENTER OR EXIT THE CAMP VIA THE CHRISTMAN ROAD ENTRANCE. MEMBERS MUST ENTER AND EXIT FROM MT.PLEASANT ROAD.

**BUCKEYE WOODWORKERS
AND WOODTURNERS
March 9, 2019**

Anyone wishing to submit pictures for the newsletter please send them to the editor within two days of the meeting

*******Note*******

**Buckeye Woodturners Meeting
Camp Y Noah
Mar. 9, 2019**

*Respectfully submitted,
Paul Crouse*

Tom Nellis opened the meeting by having two new members introduce themselves to the club. He then re-enforced the safety standards that all demonstrations will be done with a minimum of eye protection (whether that be protective glasses, safety goggles or face shield).

Tom announced that the club treadle lathe will either be sold or donated to the AAW based on the vote of the members at a later date.

Tom asked the members if the club was willing to consider buying new Rikon 70-220VSR lathes for the club to replace the Nova Comet II lathes we currently have. Bob Taylor made the motion to purchase the lathes and was seconded by Tom Pavlik. The motion carried, and the lathes will be purchased two at a time to slowly replace the Nova lathes. The current Nova lathes will be auctioned off to the members of the club

in order to help compensate for the cost of the new Rikon lathes being purchased.

Tom announced the induction of George Raeder and Bill Stone into the Buckeye Woodturner and Woodcrafter Hall of Fame as well as Larry McCardel as a posthumous inductee.

The winner of the Stranski challenge for both overall and most creative piece was Jack Boggio and runner-up winner was Benny Fix

Dirk Falter announced the current financial standings to the club.

Paul Crouse clarified the Hartville store discount policy and how the members are able to access and utilize it.

The following events were announced:

April 13, 2019- Jack Boggio and Richard Rohr will do an introduction into turning various toy tops.

May 11/12, 2019- Kevin Bedgood will be demonstrating box texturing/spiraling

June 8, 2019- Doll Lumber picnic

July 13, 2019- BWWT Auction

August 10, 2019- The BWWT meeting will be conducted at North Coast Woodturning club and Keith Gotchall will be conducting a demonstration with Hands on Turn-and-Learn at Camp Y-Noah the following day.

Sept-Oct- (open schedule - Tom Nellis opened the floor for members to do demos during those months)

November 9, 2019- Professional turner Jim Echter will be present for demonstrations.

Non-club Events:

April 6, 2019- Scott Gordon from Columbus club, invited BWWT members to attend demonstration from professional turner Mike Sorge

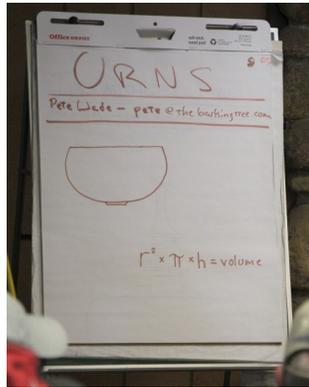
May 18, 2019- Canton Woodcraft and Arts fest.

Urns with Threaded Lids

Pete Wade
Mar. 9, 2019

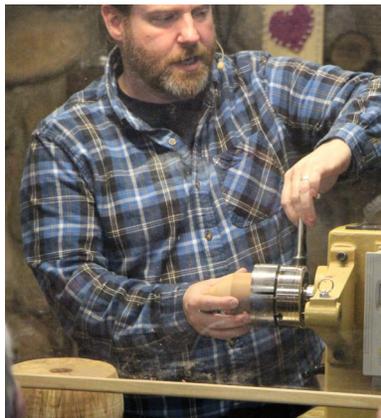
*Respectfully submitted,
 Paul Crouse*

Professional Woodturner, [Pete Wade](#) demonstrated the techniques he uses to create pet burial urns with threaded lids. He began by explaining how to calculate the size/volume of the urn required to hold all the ashes using the following equation; Radius squared x Pi x Height = Volume.



Pete put a rough turned hollow form between the centers and he used a homemade wooden drive center to prevent marring of the vessel opening. He re-turned the vessel to round as well as truing up the tenon at the base of the urn.

After remounting the vessel into large chuck jaws, he proceeded to demonstrate the use of a [laser guided hollowing system from Don Derry](#) (Derrytools.com).



Upon completion of the urn, Peter discussed the various types of wood you should and shouldn't use for threaded tops. He then demonstrated two separate methods of how to produce the threaded tops for the urn.



LIDDED URNS

Exquisite woods and craftsmanship

MIKE MAHONEY



MORE AND MORE PEOPLE ARE choosing cremation for their interment, as the world's population grows larger and less real estate is available for cemeteries. Some people have their ashes spread over their favorite places — the sea, a park, and recently even outer space. Others elect to be interred in a box or other container, ranging from a shoe box to a gold-trimmed marble vase to a wooden vessel.

Over the years I have turned many ash urns and have been surprised at the interest they have generated. People have purchased them for dogs, cats, even a horse. I once did one large enough to hold two people.

To make each urn unique, I felt I needed special pieces of wood and also a secure, visually distinctive way to fasten the lid to the body. Originally, I made snap-type, frictionfit, and even the o-ring lids. Finally, I settled on a threaded lid.

Why a threaded lid?

Adding a threaded lid increases the difficulty of the

piece. I find the threaded pieces of the urn — the lid and the neck — take more time to make than the hollow base. But the added craftsmanship enhances the piece immensely. It is also a nice feature to point out to prospective customers who may appreciate fine craft.

The lids are generally fashioned out of a non-competing timber, one that won't detract visually from the wood selected for the body of the vessel. Most of the lids I make are ebony and blackwood, but I've also used holly, olive and mountain mahogany.

Blackwood is especially good for lids because of its threading ability and its black color contrasts nicely with the base. I've turned bases from redwood burl, black locust, spalted maple, cherry and other hardwoods.

As you can see from the photos, I rely on fairly simple forms for the urn body; the key here is to let mother nature speak for herself through the beauty of the wood.

The capacity of my urns is between 100 and 300 cubic inches; federal regulations specify an urn for humans must have a capacity of at least 760 cc. The smallest urn should hold about 1/2-gallon of ashes.

Selecting stock for urns

For my average-size urn, I begin with a 10-x-10-x-7-in. block of wood. Special care should be taken when selecting the timber for the base. It must be first roughed out to the specific shape and then air-or-kiln

-dried. I air dry my urns about a year before they are re-turned. This is an essential part of the process. You don't want a vessel to crack once ashes are in it, nor do you want it to move so much that the threaded lid is locked in place.

After a vessel is stable enough to re-turn, it is re-mounted on the lathe and completely finished. You



The finial is turned while it is screwed into the boxwood insert, which is threaded before it is fit into the top of the urn. The hard dense boxwood insert makes it possible to use threaded lids with softer woods like redwood burl.

can hollow out the urn any way you like; I use the Stewart system.

The next step is to turn and fit the lid. Since most of my vessels are turned from wood that isn't dense enough to accept a hand-cut thread, I fit a boxwood insert into the neck of the piece. Boxwood is an excellent wood for threading, but it also must be very carefully cured. The insert is carved to fit the opening of the vessel with a slight flange so it seats evenly on the neck, as shown at the top of the next page.

After the boxwood insert has been fitted into the neck of the vessel, I cut the threads into the inside diameter with 16-tpi chasers. I like these chasers better than those with finer threads, say 18-or-20-tpi, because the coarser threads make it easier to open the vessel, when needed. Keep in mind that the finer your threads, the harder they will be to chase.

For details on how to chase threads, see Fred Holder's article in *American Woodturner*, PP 33-36, Summer 1999. He also lists companies that sell thread chasers.

I learned to cut threads from Bill Jones and Allan Batty in England. After learning their way and practicing for a while, I found that it was not as difficult as I expected. A good way to learn is to practice with plastic and Corian. Make sure the lathe speed is under 500 rpm for chasing threads.

Also, there are mechanical threading jigs on the market that would be great for this operation. These jigs will put a thread on most any timber, therefore eliminating the need for making the insert for the vessel.

The lid material, African Blackwood in this case, is also carefully dried. Since blackwood is a true rosewood, it is very important to monitor its drying. Rosewoods are generally very stable timbers, but it is very difficult to know when they are relatively dry. Remember, all these pieces are threaded together and any warping or shrinking will ruin the fit. I buy my blackwood in 3-x-3 in. squares, about 6-to-12 in. long.

Preparing lid material

To prep them for drying I round them into cylinders on the lathe and then part them into their finished length as lids. This step is crucial because if they are left in their square form when you later turn them as lids they will have a tendency to go oval after they are finished. I know this through experience. The rounded blocks should be left in this form for 8-to-12 months or longer in more humid conditions.



The author turned the funeral urn from redwood burl, then fitted it with a threaded lid turned from African Blackwood.

To make the lid, I first thread the part to fit the insert. I cut a 3/8 -in.- long tenon on the blackwood to the exact diameter and put a very small stop at the end. This is a very tricky threading operation. You must make sure you pull the thread chaser away from the work before you roll into the shoulder with your chaser. If you do not, you'll most likely strip the threads.

Then put the completed boxwood insert into the chuck to re-mount the piece and finish the finial. If I have done everything properly, the lid should screw nicely into the insert and you will be free to design the finial. Once the lid is completed, I glue the insert to the vessel with cyanoacrylate glue, making sure no glue shows. After the glue dries, the insert is ready to accept the lid. I finish the urns with a clear oil finish, then buff on a coat of wax.

You now have an ash urn, which is truly unique and can exemplify fine craft. If you don't have any ashes to put in it, they make nice display items.

Mike Mahoney is a professional woodturner and teacher in Utah. He will be a featured demonstrator at the 15th Annual AAW Symposium, July 6 - 8, in St. Paul, MN.

CHASING THREADS

Simple tools and a lot of practice makes perfect

FRED HOLDER



ONE OF THE ANCIENT TURNING techniques that has been gaining interest over the last few years is the art of hand chasing threads. I first became interested in this almost forgotten technique while reading Bill Jones' column in Woodturning magazine. I had never heard the term before. Thus, began a search, in fact, almost an obsession to learn how to do it. I've been making threads in metal with tap and die for many many years, but the thought of freehand threads on a lathe intrigued me. The road from hearing about thread chasing to actually chasing a successful thread was not an easy one, but the journey has been interesting.

The first stage of my journey was Jacob Holtzapffel's book, *Hand or Simple Turning*, where he discusses tools and techniques for chasing threads on hardwood and ivory. I made a chaser, but it didn't work. Finally, I found some used chasers for sale from G&M Tools in England. They sold them for \$6.00 each or \$12.00 per pair. I ordered several pairs and wound up with chasers for 11 tpi, 16 tpi, 19 tpi, and 24 tpi. They didn't work either. I decided it must be the speed, my lowest lathe speed was 500 rpm. I even tried using my Carba-Tec lathe and turning it by hand to get the speed down to a manageable level. Nothing seemed to work. I was almost to the point of giving up.

In re-reading Holtzapffel's book, I eventually noticed he described chasers cutting threads in hardwoods and ivory, and said a different technique was required for cutting threads in softwoods. I didn't see this at first, or at least it didn't register. I began to rethink my definition of hardwoods. I had been using maple and apple woods, considering them "hard wood." I had some cocobolo on hand, so I chucked up a piece onto my Carba-tec turning the lathe by hand. I tried the 11 tpi chaser, thinking that the coarser thread would be easier to cut. I was wrong about that, but it worked anyway.

I was elated and the journey continued with a search for more answers. I purchased one of Dennis White's videos that included thread chasing and James Lukin's book, *Turning Lathes*, which also has a good section on thread chasing. Anytime I had some spare time to play and a piece of suitable hardwood, I cut a few threads. Incidentally, that chaser I had made in the beginning now worked also. I'm afraid my main problem was in the definition of what is "hard" wood.

I was chasing threads on a Carba-Tec lathe by turning the lathe with my left hand while I held the chaser with my right hand. It worked very well and I've cut a lot of threads in that manner. Both Holtzapffel and Lukin used treadle lathes.

Before treadle lathes, turners had used springpole lathes. So, I graduated to my foot powered lathe, it is a spring pole type with a lathe spindle and a full three revolutions per downward stroke. Wow, this was even easier than turning the Carba-Tec by hand; I now had both hands to work the tool. I began to feel confident. Enough so that when I agreed to demonstrate my foot powered lathe at the January 1997 meeting of the Seattle AAW Chapter, I included thread chasing. Since then, I often demonstrate this technique at craft shows when people ask how I cut the threads in one of my threaded boxes. I have now progressed to chasing threads at 500 rpm. I will admit, however, that a speed of 100 or 200 rpm would make it a great deal easier.

I share the above with you to explain how I got from hearing about thread chasing to actually doing it successfully. I'm sure it would have been easier if I'd been able to watch Bill Jones or Allan Batty demonstrate the technique, but I didn't until after I had finally learned to chase threads on my own.

First, you have to have a pair of thread chasers, one for the inside and one for the outside, as shown below right. Incidentally, when it comes time to sharpen the chaser, hone or grind on the very top only, never ever on the face. I sometimes grind the top and sometimes use a diamond hone, either works well.

You also need a suitable supply of "hard wood." Wood that is hard enough for thread chasing is generally wood that will cut cleanly with a scraper: lignum vitae, boxwood, Osage Orange, desert Ironwood, redheart, African Blackwood (the best). I've also cut threads in oak, black locust and mesquite. I've even used a bit of thin hot stuff CA glue to harden apple wood enough to cut threads in it, but I don't recommend the softer woods. The key is a dense hard wood that will take and hold fine detail. This defined, let's get to making threads.

In all of the literature I read there was no definite answer as to which you should make first: the inside (female) thread or the outside (male) thread. Bill Jones didn't seem to think that it mattered, but Allan Batty

recommends making the inside thread first, because it is more difficult to make, because you can't see what's going on inside the hole. I agree with him. A lot of my thread chasing practice has been to take a 16 tpi chaser and make a thread to fit a 3/4 in.x16 tpi nut. This was always a trial-and-error situation until I watched Batty demonstrate at Provo in June 1997. He said to make your inside thread first and then on the end of the external thread to make a short tenon that just fits into the inside thread. This tenon is then the bottom of the external thread, when your chaser marks this area, your nut or box top will screw on. Therefore, we'll make the inside thread first.

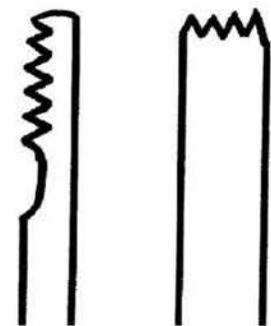
Prepare your hole for your internal thread like that shown in Fig 1 on the facing page. The only limiting factor for the diameter of the hole is that it must be large enough to enable your chaser to be properly entered into the hole. The sides of the hole must be parallel to the axis of rotation unless you want a tapered thread. Use a straight edge, pencil, or something to lay along the cylinder and compare this to the lathe bed. The entrance to the hole should be beveled or rounded to prevent the chaser teeth from catching on a sharp edge and the recess should be cut at the back of the hole to allow the chaser to cut clean before it hits the bottom of the hole. One nice thing about turning the lathe by hand, you can feel when you've hit the bottom of the hole; at 500 rpm this is not the case. When the chaser cuts into this recess, you must lift the chaser clear and return it to the beginning. Bill Jones refers to this as a sort of figure eight motion; I consider it sort of a loop.

Holtzapffel says to start cutting your thread on the beveled part as shown in his drawing, Figure 1. Your first cuts are along the curve a-b and then along the curve

Sources for Thread Chasers:

Craft Supplies USA; 1287 E.
1120 S.; Provo,
UT 84606 USA TEL: (800)
551-8876
Thread Chasers in sizes 16,
18, 20 TPI.
Woodcraft Supply; PO Box
1686;
Parkersburg, WV 26102 USA
TEL:(800) 225-
1153 Thread Chasers in 18,
20 TPI.
G&M Tools; The Mill, Mill
Lane; Ashington,
West Sussex; RH20 3BY
United Kingdom
Chasers in pairs in 4, 5, 6, 7,
8, 9, 10, 11, 14, 19,
22, 24 TPI; Contact: Tim
Muddle.

Tracy Tools Limited; 2 Mayors Avenue;
Dartmouth; South Devon; TQ6 9NF United
Kingdom, Chasers in 5, 6, 8, 9, 10, 11, 14, 16,



Cutting ends of the male, left, and female, right, tools.

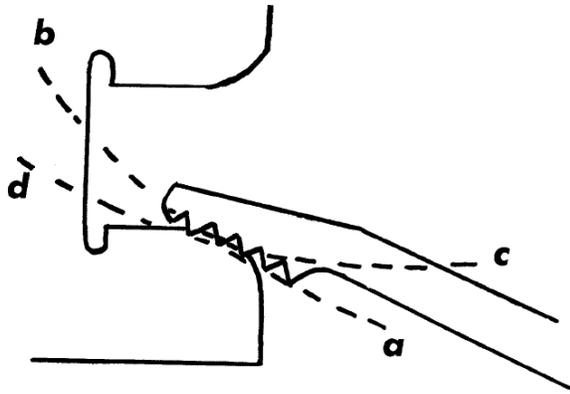


FIGURE 1: Holtzapffel's method of striking the thread. The first pass should be a to b and the next pass should be c to d and then you go down the parallel section. Note the hole for an inside thread must have sides that are parallel with the axis of rotation and a recess at the bottom of the hole to allow the chaser to fully cut the thread before hitting the bottom. A rounded or chamfered opening helps prevent a sharp edge from catching a tooth of the chaser and creating circles, not threads.

c-d, until you are cutting along the parallel of the cylinder. Lukin says, "I have found it quite easy to begin at once upon the end of the cylindrical part ...". I agree with Lukin and proceed as shown in Fig. 2, on the right.

First, I try to have the heel of the chaser ride on the cylinder. It doesn't cut but tends to move the tool along at the necessary rate of speed. A few practice motions like this allow you to get the feel for the speed. The more teeth to the inch the easier it is to handle the chaser, because you are progressing slower. Once you feel you have the speed down, allow it to cut lightly and move it evenly and smoothly (not faltering) at the desired speed. This is called "striking the thread." Once you have grooves cut deep enough to guide the chaser, you no longer have to move it, but you do have to lift it out of the grooves before it reaches the bottom of the hole. You must exert care to insert the tool into the grooves each time, miss and you may cut a double or triple thread, not good!

Until recently, I turned the "T" across the face of the area to be threaded, wrapped my fingers around the tool rest and hooked my index finger over the chaser to apply pressure against the cylinder during cutting. I recently acquired an "arm rest", Fig. 3, which considerably aids in cutting inside threads. You place the handle under your left arm, the arm rest on the "T" and the chaser on the arm rest with the hook (turned up part) touching the chaser. The arm rest is then tilted up and down as necessary to position the chaser and is pulled back to exert pressure during the cut. It makes cutting the inside thread much easier. Both Bill Jones and Allan Batty consider the arm rest indispensable for internal thread chasing. I say it is a lot easier; I was making threads without it.

Make additional passes until the thread is deep enough and clean. If you have a specific size that you are trying to achieve, you can measure the inside with calipers and, if necessary, shave off a little bit with a side cutting tool. Make sure the sides remain parallel to the axis of rotation and do not remove all of the thread; leave enough to guide the chaser for additional passes. Then make more passes until you have a good thread again. I do not hesitate to rotate the lathe by hand and make a few passes with the chaser at this very slow speed as final touch up. If you were to

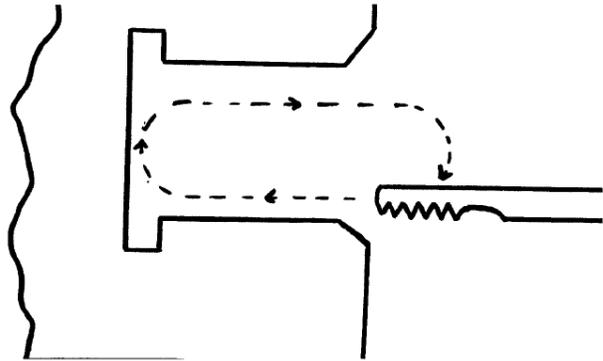


FIGURE 2: Holder recommends this motion with the inside chaser to cut the threads. The chaser should just cut clean into the recess and must be lifted clear before the chaser end hits the bottom of the hole. This is why it is more difficult to chase threads with fewer teeth per inch. The chaser is moving so much faster it is difficult to lift clear before touching the bottom.

slice the finished piece in half, you should have a thread that appears to be very similar to that shown on the first page of this article.

Now prepare the outside thread area similar to that shown in Fig. 4. The sides of the cylinder must be parallel to the axis of rotation, there must be a recess cut at the end of the threaded area, there must be a bevel or rounded area at the beginning of the threaded area, and there must be a little tenon (shaded area in the figure) that will just fit inside the female threaded area. The outside of the cylinder must be at least twice the depth of the threads larger than this area; i.e. if the thread depth is 0.025" then the diameter must be greater than 0.050" larger than the tenon as a very minimum. I recommend that it be a bit larger to allow for mistakes in getting started. This is especially important when learning this technique.

Before actually starting to move the chaser along the tool rest, it is important that the rest be dressed smooth, any nick or rough spot can stop or cause the chaser to falter and create problems with your thread. Again, with the area below the cutting edge rubbing on the wood get a feel for the rate feed that will be necessary. Make a few trial passes before allowing the tool to start cutting. Then move the tool along evenly at the determined speed allowing the edge to cut lightly as shown in Fig. 4.

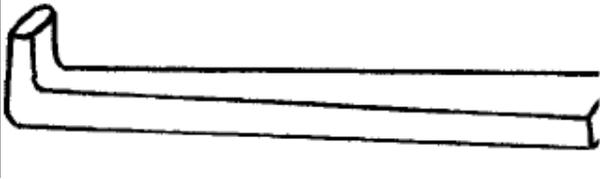


FIGURE 3: The armrest is a smooth steel shaft about 7- to 9-in. long. That can be fit into a handle. The left hand grasps the tool rest and the left thumb presses the tool down onto the armrest and the entire assembly down onto the tool rest. The tool rests against the hook on the armrest so side pressure can be applied as threads are cut.

As the cutter moves into the recess at the end of the threaded area pull it away from the wood and reapply at the beginning. Your chaser should be moving from right to left. Repeat this operation until the thread is well formed. If the chaser hasn't started to make scratches on the small tenon (shaded area on the illustration), use a square end scraper and take a light cut on top of the threads. Then cut the threads deeper until the chaser just cuts on the small tenon.

If everything was done properly, i.e., the threaded area was parallel to the axis of rotation and the threads are cut to the correct depth, the female thread should screw onto the threads you've just cut.

You may still have to relieve this a bit. I generally turn off the lathe and rotate it by hand while making some final passes with the chaser. Then try your nut or lid again. If it screws on fully, but is a little stiff, apply some soft wax and work it a bit. If that still doesn't free it up, then take another pass with the chaser while rotating by hand. When everything fits, your thread should look something like the thread shown on the first page of this article.

Clean the threads with a soft cloth and apply a light coat of soft wax as a finish. Work the threads a bit to burnish them.

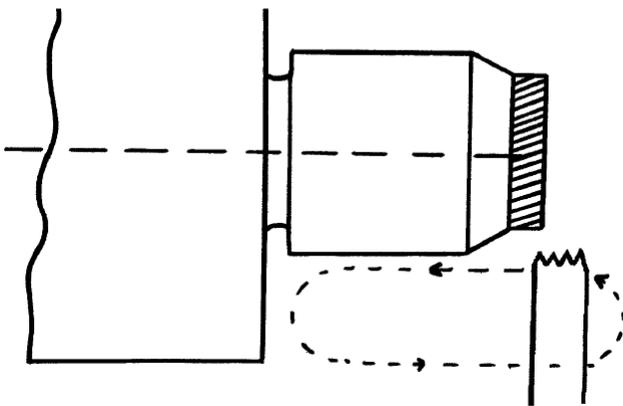


FIGURE 4: This drawing illustrates the movement of the chaser as it cuts the thread. The chaser should just cut into the recess and then be lifted clear of the wood before the chaser comes in contact with the shoulder. When the chaser just marks the shaded tenon, the thread should be ready to receive the inside threaded piece.

Well that is about all there is to it. As Bill Jones says, "start making little boxes with threaded lids, by the time you've made half a gross, you'll be a thread chaser." Once you have the tools and the inclination and a little bit of know how, all that remains is a lot of practice. Remember, a lathe with a speed of 100 to 200 rpm would be best. Lacking that, try chasing threads while hand turning the lathe. Start with a fine thread (16 to 24 tpi) in the beginning and use a good hard wood. One of the best that I've used is African Blackwood, it is a bit pricey, but it sure makes a nice thread.

One final note, all of the discussion here has been for cutting right hand threads. To cut left hand threads, move the chaser from left to right. Even though most chasers will be right hand chasers, you can still cut left hand threads by tilting the chaser down so that only the very cutting edge is contacting the wood. Move at the same speed, but from left to right. Have fun making threads!

Fred Holder is a turner and writer living in Camano Island, WA. Currently president of the Northwest Washington Woodturners and newsletter editor, he will be a demonstrator at the AAW Symposium in Tacoma, WA.

Calendar of Events

**PLEASE NOTE
BWWT MEETINGS ARE HELD ON
THE SECOND SATURDAY OF EACH
MONTH BEGINNING AT 9:00AM**

**NO MEMBERS OR VISITORS
SHALL ENTER OR EXIT THE
CAMP VIA THE CHRISTMAN
ROAD ENTRANCE. MEMBERS
MUST ENTER AND EXIT FROM
MT.PLEASANT ROAD.**

**BWWT Library Online Guide brought to
you by the BWWT Club Librarians, Dirk
Falther and Bob Hasenyager.
The online guide lists the books and videos that
are available in our club library along with de-
scriptions on the subject matter and other useful
information. Follow the link below to check it out.**

<http://uh.cx/uVS1S>

BWWT OFFICERS FOR 2019



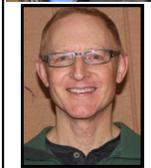
President
Tom Nellis
330-947-3441
brewmeister43@hotmail.com



Vice President
Brent Wells
330-606-6724
thegrumpywoodchuck@
gmail.com



Secretary
Paul Crouse
330-432-9659
paulecrouse@hotmail.com



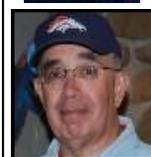
Treasurer
Dirk Falther
330-310-4570
dfalther3@att.net



Librarian
Bob Hasenyager
330-334-8314
bobhasenyager@gmail.com



Newsletter Editor
Keith Bellamy
330-221-2845
akbellamy@gmail.com



Membership Admin.
Phil Brower
330-688-7244
fbtoad@aol.com