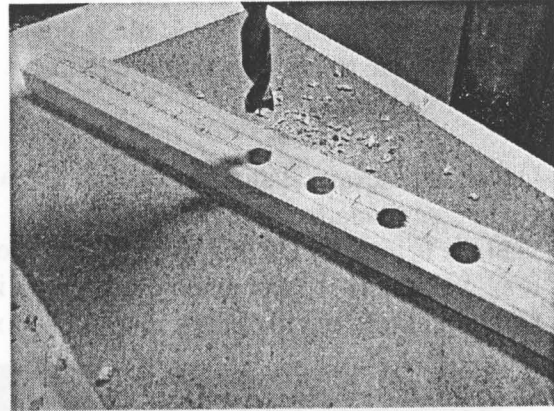


## Instructions for using The Hex Nut Fixture

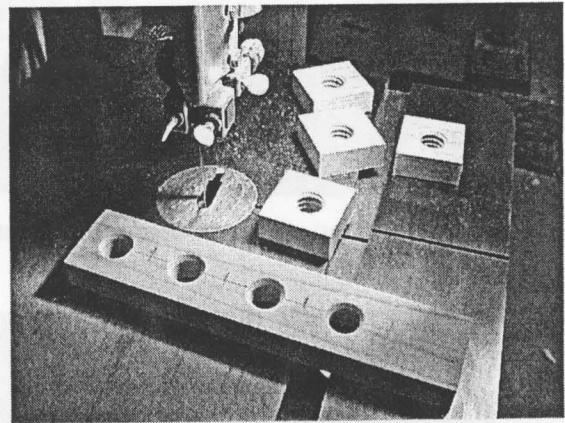
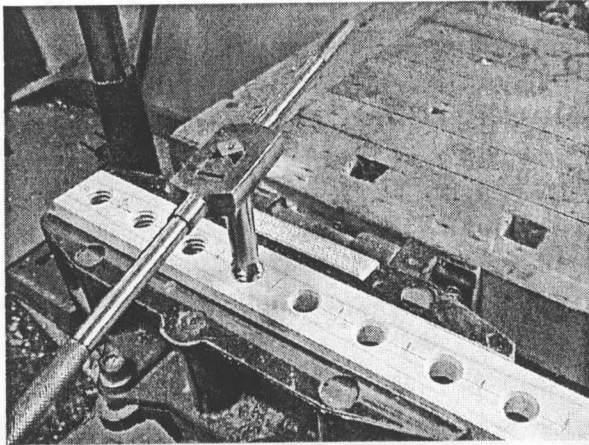
The Hex Nut Fixture is a simple device for making hexagonal nuts for use with the wood threader. Nuts of nearly any diameter and up to 1 1/8" in thickness can be made with this fixture.

First lay out several nuts on a piece of wood that has been ripped to approximate width. The piece used here is 1 3/4", for making 3/4" nuts. Mark the center and where the blanks will be cut, then bore the holes. These are 5/8".

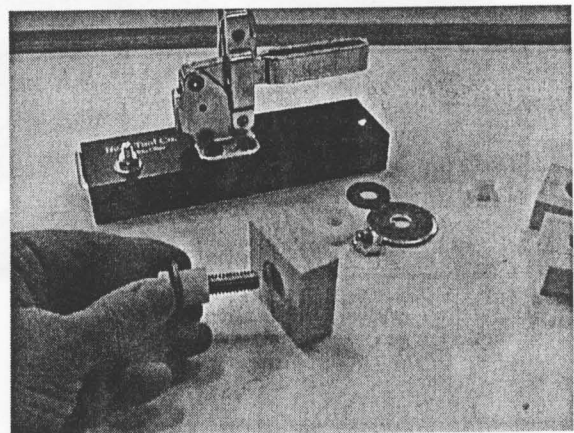
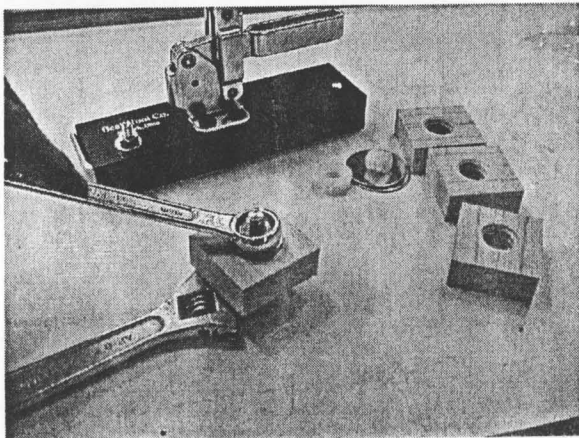
For a neater job, I always countersink the holes on both side before tapping. Next, tap the holes.



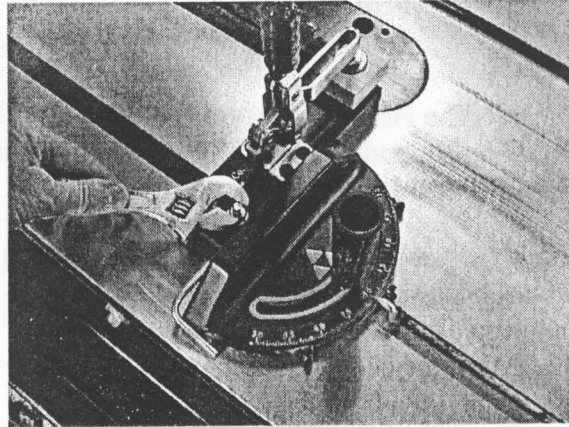
After tapping the holes, the nut blanks can be cut apart. Here I used a band saw.



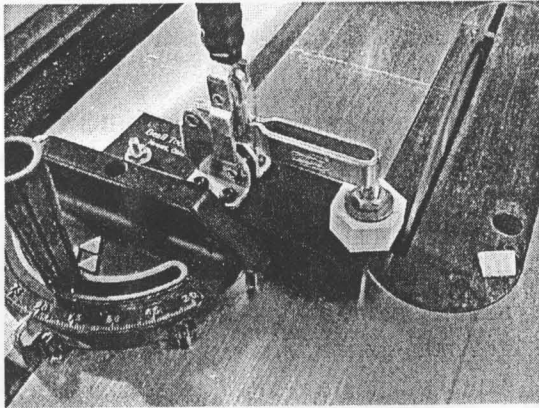
The nut blanks can now be readied for the fixture. The proper size washer and bushing is selected and slid over the bolt. The blank is then installed, followed by another washer and the nut. The whole assembly needs to be tightened with wrenches so that it is held firmly and won't spin when cut by the saw.



With the nut blank clamped firmly in the fixture, the whole unit is placed on the saw table against the miter gauge, and the gauge rod is set to achieve the desired distance from the blank to the blade. Care must be taken that the blade is not set so close to the fixture that it will cut into the washers.



Once the proper distance has been set, a cut can be made so that one side of the blank is trimmed. Having done this, the toggle clamp is loosened and the blank is turned 60 degrees and another cut is made. Continue turning and cutting until all six side of the nut have been trimmed.



Always be sure that the toggle clamp is tight before making a cut and pay attention to the blade height and the placement of your hands when using this fixture or any other fixture with your saw. Be sure that the gauge rod is tight so that it won't slip during operation use a guard and eye protection at all times.

This fixture may also be used with a chop saw or band saw, although bandsaw cuts will not be as smooth as those made with a circular saw.

