

Cross Threading

What Is Cross Threading?

Cross threading is caused when the Male AND Female threads are not correctly lined up.

It's usually caused when either the Male OR Female thread is slightly tilted when tightening occurs

Instead Of the threads lining up and sliding along one another, the threads cut across one another causing damage.

The more the threads are forced together the more damage occurs, to the point where THE Male OR Female thread becomes "Stripped" and so badly damaged the two parts will no longer screw together.

(Stripping can also occur when threads are tightened beyond their designed limits causing a thread to snap.

Elimination of this is to use a torque wrench together with the correct tightening torque for the thread in question.)

Cross threading can be detected due to the threads "Binding" when turning.

Threads should rotate freely until tightening is reached

If the threads start to "Bind" or give resistance gently back the Male OR Female thread out, re-line and try again.

How to prevent cross-threading

There is a method used to eliminate "Cross Threading" where by the Male OR Female thread is rotated

BACKWARD instead of forward (Anti clockwise instead of clockwise) until you hear / feel it click.

This is the end of the Male thread going past the end of the Female thread.

When you hear / feel this you will now know that the two threads are perfectly aligned and can be tightened together.

An illustration of this method can be viewed by clicking the following link on the PDF page.

https://www.youtube.com/watch?v=7U1yAeD_iU