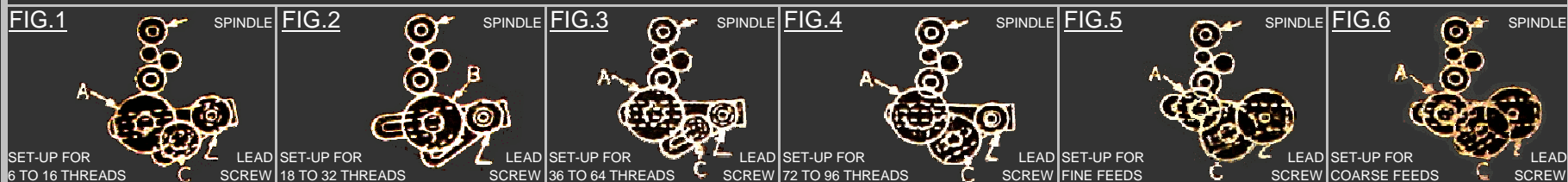


THREADING CHART

A - B - C ARE GEAR STUD POSITIONS
S = SPACER - = NO GEARS

R = REAR POSITION - TOWARD HEADSTOCK
F = FRONT POSITION - AWAY FROM HEADSTOCK



THREADS PER INCH	GEAR ON SCREW R F	POSITION						SPINDLE STUD GEAR	FIG.	THREADS PER INCH	GEAR ON SCREW R F	POSITION						SPINDLE STUD GEAR	FIG.
		A		B		C						A		B		C			
8	32	64	S	-	-	32	64	32	1	36	36	S	64	-	-	S	32	16	3
9	36	64	S	-	-	32	64	32	1	40	40	S	64	-	-	S	32	16	3
10	40	64	S	-	-	32	64	32	1	44	44	S	64	-	-	S	32	16	3
11	44	64	S	-	-	20	40	32	1	48	48	S	64	-	-	S	32	16	3
11.5	46	64	S	-	-	20	40	32	1	56	56	S	64	-	-	S	32	16	3
12	48	64	S	-	-	20	40	32	1	64	64	S	64	-	-	S	32	16	3
13	52	64	S	-	-	20	40	32	1	72	36	32	64	-	-	56	S	16	4
14	56	64	S	-	-	20	40	32	1	80	40	32	64	-	-	56	S	16	4
16	64	64	S	-	-	20	40	32	1	96	48	32	64	-	-	56	S	16	4
18	36	-	-	64	S	-	-	32	2	FEED PER REV. OF SPINDLE									
20	40	-	-	64	S	-	-	32	2	0.0024	64	24	48	-	-	64	20	16	5
22	44	-	-	64	S	-	-	32	2	0.0039	64	24	48	-	-	64	32	16	5
24	48	-	-	64	S	-	-	32	2	0.0049	64	48	24	-	-	20	64	32	6
27	54	-	-	64	S	-	-	32	2	0.0078	64	48	24	-	-	32	64	32	6
28	56	-	-	64	S	-	-	32	2	When two gears are used in combination, R, Rear indicates the position nearest the headstock. F, Front indicates the position away from headstock.									
32	64	-	-	64	S	-	-	32	2										

mm				error				mm				error					
0.5	54	46	44	0.0179%	20	36	32	6	1.25	20	56	48	0.0125%	64	54	16	5
0.6	36	54	44	0.0179%	24	46	32	6	1.5	64	56	20	0.0125%	40	54	16	5
0.7	36	56	46	0.0179%	54	44	16	5	1.75	48	52	20	0.0606%	44	56	16	5
0.75	54	46	44	0.0179%	40	48	32	6	2.0	40	56	32	0.0125%	20	36	16	5
0.8	46	36	32	0.0179%	44	54	32	6	2.5	20	56	24	0.0125%	64	54	16	5
0.9	46	44	20	0.0179%	54	40	16	5	3.0	20	56	32	0.0125%	40	54	16	5
1.0	40	36	20	0.0125%	64	56	16	5	4.0	20	56	24	0.0125%	40	54	16	5