

		TPI		1	2	3	4	5	6	7	8	1	2	3	4	5	6	7	8	1	2	3	4	5	6	7	8	1	2	3	4	5	6	7	8									
		Throat to thread in.		0.2150	0.2222	0.2105	0.2000	0.1818	0.1667	0.1518	0.1429	0.1250	0.1111	0.1053	0.1000	0.0909	0.0833	0.0761	0.0714	0.0625	0.0556	0.0526	0.0500	0.4455	0.0417	0.0385	0.0357	0.0313	0.0278	0.0263	0.0250	0.0227	0.0208	0.0192	0.0179	0.0156	0.0149	0.0104	0.0096	0.0089				
		Throat to thread mm		6.350	5.644	5.347	5.080	4.618	4.233	3.908	3.629	3.175	2.822	2.674	2.540	2.309	2.117	1.954	1.814	1.588	1.411	1.337	1.270	1.151	1.058	0.977	0.907	0.794	0.706	0.668	0.635	0.577	0.529	0.488	0.454	0.397	0.353	0.319	0.284	0.244	0.227			
Gear Ratios		40	127																																									
Revolutions		0.3150	1.0000																																									
Final Ratio																																												
Metric Ratios																																												
40	127	0.3150	TPI	3.780	4.252	4.488	4.724	5.197	5.669	6.142	6.614	7.559	<b>8.504</b>	8.976	9.449	10.394	11.339	12.283	13.228	15.118	<b>17.008</b>	17.953	18.898	20.787	22.677	24.567	26.457	30.236	34.016	35.906	37.795	41.575	45.354	49.134	52.913	60.472	68.031	71.811	75.591	83.150	90.709	98.268	105.827	
120	40	3.0000 <td>0.9449</td> <td>Throat to thread mm</td> <td>6.700</td> <td>5.333</td> <td>5.053</td> <td>4.800</td> <td>4.364</td> <td>4.000</td> <td>3.692</td> <td>3.429</td> <td>3.000</td> <td>2.667</td> <td>2.526</td> <td>2.400</td> <td>2.182</td> <td>2.004</td> <td>1.846</td> <td>1.714</td> <td>1.500</td> <td>1.333</td> <td>1.263</td> <td>1.200</td> <td>1.091</td> <td>1.000</td> <td>0.923</td> <td>0.867</td> <td><b>0.750</b></td> <td>0.667</td> <td>0.632</td> <td><b>0.600</b></td> <td>0.545</td> <td><b>0.500</b></td> <td>0.462</td> <td>0.429</td> <td>0.375</td> <td>0.333</td> <td>0.316</td> <td><b>0.300</b></td> <td>0.273</td> <td><b>0.250</b></td> <td>0.231</td> <td>0.214</td>	0.9449	Throat to thread mm	6.700	5.333	5.053	4.800	4.364	4.000	3.692	3.429	3.000	2.667	2.526	2.400	2.182	2.004	1.846	1.714	1.500	1.333	1.263	1.200	1.091	1.000	0.923	0.867	<b>0.750</b>	0.667	0.632	<b>0.600</b>	0.545	<b>0.500</b>	0.462	0.429	0.375	0.333	0.316	<b>0.300</b>	0.273	<b>0.250</b>	0.231	0.214
40	127	0.3150 <td>TPI</td> <td>4.724</td> <td>5.315</td> <td>5.616</td> <td>5.906</td> <td>6.946</td> <td>7.087</td> <td>7.677</td> <td>8.268</td> <td>9.449</td> <td>10.398</td> <td>11.220</td> <td>11.992</td> <td>12.943</td> <td>14.773</td> <td>15.354</td> <td>16.355</td> <td><b>18.888</b></td> <td>20.241</td> <td>22.441</td> <td>23.622</td> <td>25.984</td> <td>28.346</td> <td>30.701</td> <td>37.795</td> <td>42.682</td> <td>47.244</td> <td>51.969</td> <td>56.803</td> <td>61.647</td> <td>66.142</td> <td>74.591</td> <td>85.039</td> <td>89.764</td> <td>94.488</td> <td>103.937</td> <td>118.338</td> <td>122.835</td> <td>132.283</td>	TPI	4.724	5.315	5.616	5.906	6.946	7.087	7.677	8.268	9.449	10.398	11.220	11.992	12.943	14.773	15.354	16.355	<b>18.888</b>	20.241	22.441	23.622	25.984	28.346	30.701	37.795	42.682	47.244	51.969	56.803	61.647	66.142	74.591	85.039	89.764	94.488	103.937	118.338	122.835	132.283			
120	32	3.7500 <td>1.1811</td> <td>Throat to thread mm</td> <td><b>7.500</b></td> <td>6.667</td> <td>6.316</td> <td>6.066</td> <td><b>5.455</b></td> <td>5.000</td> <td>4.615</td> <td>4.286</td> <td>3.750</td> <td>3.333</td> <td>3.158</td> <td><b>3.000</b></td> <td>2.727</td> <td><b>2.500</b></td> <td>2.308</td> <td>2.143</td> <td>1.875</td> <td>1.667</td> <td>1.579</td> <td>1.500</td> <td>1.364</td> <td><b>1.250</b></td> <td>1.154</td> <td>1.071</td> <td>0.938</td> <td>0.833</td> <td>0.789</td> <td><b>0.750</b></td> <td>0.682</td> <td>0.625</td> <td>0.577</td> <td>0.536</td> <td>0.469</td> <td>0.417</td> <td>0.395</td> <td>0.374</td> <td>0.341</td> <td>0.313</td> <td>0.288</td> <td>0.268</td>	1.1811	Throat to thread mm	<b>7.500</b>	6.667	6.316	6.066	<b>5.455</b>	5.000	4.615	4.286	3.750	3.333	3.158	<b>3.000</b>	2.727	<b>2.500</b>	2.308	2.143	1.875	1.667	1.579	1.500	1.364	<b>1.250</b>	1.154	1.071	0.938	0.833	0.789	<b>0.750</b>	0.682	0.625	0.577	0.536	0.469	0.417	0.395	0.374	0.341	0.313	0.288	0.268
40	127	0.3150 <td>TPI</td> <td>5.039</td> <td>5.698</td> <td>6.929</td> <td>6.929</td> <td>7.559</td> <td>8.189</td> <td>8.819</td> <td>10.719</td> <td>13.339</td> <td>16.969</td> <td>13.988</td> <td>15.118</td> <td>16.378</td> <td>17.638</td> <td>20.177</td> <td>23.937</td> <td>23.937</td> <td>25.197</td> <td>27.717</td> <td>30.236</td> <td>32.756</td> <td>35.276</td> <td>40.315</td> <td>45.354</td> <td>47.874</td> <td>50.394</td> <td>55.433</td> <td>60.472</td> <td>65.512</td> <td>70.551</td> <td>80.630</td> <td>90.709</td> <td>95.748</td> <td>100.787</td> <td>110.866</td> <td>120.945</td> <td>131.024</td> <td>141.102</td>	TPI	5.039	5.698	6.929	6.929	7.559	8.189	8.819	10.719	13.339	16.969	13.988	15.118	16.378	17.638	20.177	23.937	23.937	25.197	27.717	30.236	32.756	35.276	40.315	45.354	47.874	50.394	55.433	60.472	65.512	70.551	80.630	90.709	95.748	100.787	110.866	120.945	131.024	141.102			
120	30	4.0000 <td>1.2598</td> <td>Throat to thread mm</td> <td><b>8.000</b></td> <td>7.111</td> <td>6.737</td> <td>6.400</td> <td>5.818</td> <td>5.333</td> <td>4.923</td> <td>4.571</td> <td><b>4.000</b></td> <td>3.556</td> <td>3.368</td> <td>3.200</td> <td>2.909</td> <td>2.667</td> <td>2.462</td> <td>2.286</td> <td>2.000</td> <td>1.778</td> <td>1.684</td> <td>1.600</td> <td>1.455</td> <td>1.333</td> <td>1.231</td> <td>1.143</td> <td><b>1.000</b></td> <td>0.889</td> <td><b>0.842</b></td> <td><b>0.800</b></td> <td>0.727</td> <td>0.667</td> <td>0.615</td> <td>0.571</td> <td>0.500</td> <td>0.444</td> <td>0.421</td> <td>0.400</td> <td>0.364</td> <td>0.333</td> <td>0.308</td> <td>0.286</td>	1.2598	Throat to thread mm	<b>8.000</b>	7.111	6.737	6.400	5.818	5.333	4.923	4.571	<b>4.000</b>	3.556	3.368	3.200	2.909	2.667	2.462	2.286	2.000	1.778	1.684	1.600	1.455	1.333	1.231	1.143	<b>1.000</b>	0.889	<b>0.842</b>	<b>0.800</b>	0.727	0.667	0.615	0.571	0.500	0.444	0.421	0.400	0.364	0.333	0.308	0.286
32	127	0.2520 <td>TPI</td> <td>3.024</td> <td>3.042</td> <td>3.591</td> <td>3.780</td> <td>4.157</td> <td>4.535</td> <td>4.913</td> <td>5.291</td> <td>6.047</td>	TPI	3.024	3.042	3.591	3.780	4.157	4.535	4.913	5.291	6.047																																

Size - Nominal Diameter	Pitch <sup>(1)</sup>	Clearance Drill	Tap Drill	Size - Nominal Diameter		Pitch <sup>(1)</sup>	Tap Drill	Size - Nominal Diameter		Pitch <sup>(1)</sup>	Tap Drill				
				Pitch <sup>(1)</sup>	Tap Drill			Pitch <sup>(1)</sup>	Tap Drill						
(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
M 1.60	0.35	1.8	1.25	M 1.0 x 0.2	0.2	0.8	M 12 x 1	1	11						
M 2.00	0.4	2.4	1.6	M 1.1 x 0.2	0.2	0.9	M 12 x 1.25	1.25	10.8						
M 2.50	0.45	2.9	2	M 1.2 x 0.2	0.2	1	M 12 x 1.5	1.5	10.5						
M 3.00	0.5	3.4	2.5	M 1.4 x 0.2	0.2	1.2	M 14 x 1.0	1	13						
M 3.50	0.6	3.9	2.9	M 1.6 x 0.2	0.2	1.4	M 14 x 1.25	1.25	12.8						
M 4.00	0.7	4.5	3.3	M 1.8 x 0.2	0.2	1.6	M 14 x 1.5	1.5	12.5						
M 5.00	0.8	5.5	4.2	M 2 x 0.25	0.25	1.75	M 15 x 1	1	14						
M 6.00	1	6.6	5	M 2.2 x 0.25	0.25	1.95	M 15 x 1.5	1.5	13.5						
M 8.00	1.25	9	6.8	M 2.5 x 0.35	0.35	2.1	M 16 x 1	1	15						
M 10.00	1.5	12	8.5	M 3 x 0.35	0.35	2.6	M 16 x 1.5	1.5	14.5						
M 12.00	1.75	14	10.2	M 3.5 x 0.35	0.35	3.1	M 17 x 1.0	1	16						
M 14.00	2	16	12	M 4 x 0.5	0.5	3.5	M 17 x 1.5	1.5	15.5						
M 16.00	2	18	14	M 4.5 x 0.5	0.5	4	M 18 x 1.0	1	17						
M 20.00	2.5	22	17.5	M 5 x 0.5	0.5	4.5	M 18 x 1.5	1.5	16.5						
M 22.00	2.5	25	19.5	M 5.5 x 0.5	0.5	5	M 18 x 2.0	2	16						
M 24.00	3	27	21	M 6 x 0.75	0.75	5.2	M 20 x 1.0	1	19						
M 27.00	3	30	24	M 7 x 0.75	0.75	6.2	M 20 x 1.5	1.5	18.5						
M 30.00	3.5	33	26.5	M 8 x 0.75	0.75	7.2	M 20 x 2.0	2	18						
M 36.00	4	40	32	M 8 x 1.0	1	7	M 22 x 1.0	1	21						
M 42.00	4.5	46	37.5	M 9 x 0.75	0.75	8.2	M 22 x 1.5	1.5	20.5						
M 48.00	5	53	43	M 9 x 1	1	8	M 22 x 2.0	2	20						
M 56.00	5.5	62	50.5	M 10 x 0.75	0.75	9.2	M 24 x 1.0	1	23						
M 64.00	6	70	58	M 10 x 1	1	9	M 24 x 1.5	1.5	22.5						
M 68.00	6	74	62	M 10 x 1.25	1.25	8.8	M 24 x 2.0	2	22						
				M 11 x 0.75	0.75	10.2	M 25 x 1.0	1	24						
				M 11 x 0.75	0.75	10.2	M 25 x 1.5	1.5	23.5						
				M 11 x 1	1	10	M 25 x 2.0	2	23						