PM1340 Metric Threading - as delivered with 120/127 tooth main gear, 30, 32 and 40 tooth smaller gears

David P. Best January 12, 2020

Metric Pitch	Where Used		Gear Configuration		Gear Box Settings		Metric Pitch
	Metric Coarse	Metric Fine	Upper Pair	Lower Pair	Letter	Number	
0.2		M1.0 to M1.8	30/127	120/32	E	8	0.2
0.25		M2.0 , M2.2	40/127	120/40	E	6	0.25
0.35	M1.6 x 0.35	M2.5 , M3 , 3.5	40/120 **	127/32	E	6	0.35
0.4	M2.0 x 0.4		32/127	120/40	D	6	0.4
0.45	M2.5 x 0.45		30/120 **	127/32	D	8	0.45
0.5	M3 x 0.5	M4 to M5.5	40/127	120/40	D	6	0.5
0.6	M3.5 x 0.6		32/127	120/40	D	1	0.6
0.7	M4 x 0.7		35/127 *	120/30	D	4	0.7
0.75		M6, M7, M8	40/127	120/40	D	1	0.75
0.8	M5 x 0.8		32/127	120/40	C	6	0.8
1	M6 x 1.0	M8 to M11 x 1.0	40/127	120/40	C	6	1
1.25	M8 x 1.25	M10 x 1.25	30/127	120/32	C	2	1.25
1.5	M10 x 1.5		40/127	120/40	C	1	1.5
1.75	M12 x 1.75		35/127 *	120/40	B	6	1.75
2	M14 & M16 x 2.0		40/127	120/40	B	6	2
2.5	M20 & M22 x 2.5		30/127	120/32	B	2	2.5
3	M24 & M 27 x 3		40/127	120/40	B	1	3
3.5	M30 x 3.5		35/127 *	120/40	A	6	3.5
4	M36 x 4		40/127	120/40	A	6	4
4.5	M42 x 4.5		30/127	120/32	A	4	4.5
5	M48 x 5		40/127	120/32	A	6	5
5.5	M56 x 5.5		Not available				5.5
6	M64 & M68 x 6		40/127	120/40	A	1	6

* These threads require a 35 tooth gear from Quality Machine Tools

** Requires inverting 120/127 Gear If which may require spacer or bushing to ensure clearence and proper alignment with smaller threading gears.