

Thread	Dial	Thread	Dial	Thread	Dial
4	1 - 4	13	1	44	1 - 4
4-1/2	1	14	1 or 3	46	1 or 3
4		16	1 - 8	48	1 - 8
5	1	18	1 or 3	62	1 - 4
5-1/2	1	19	1	56	1 - 8
6	1 or 3	20	1 - 4	64	1 - 8
6-1/2	1	22	1 or 3	72	1 - 8
7	1	23	1	76	1 - 4
8	1 - 8	24	1 - 8	80	1 - 8
9	1	26	1 or 3	88	1 - 8
9-1/2	1	28	1 - 4	92	1 - 4
10	1 or 3	32	1 - 8	96	1 - 8
11	1	36	1 - 4	104	1 - 8
11-1/2	1	38	1 or 3	112	1 - 8
12	1 - 4	40	1 - 8		

Table 1. Thread Indicator Table

- To cut inch threads, refer to the chart in Table 1. The half nut lever and the threading dial are used to thread in the conventional manner. The thread dial chart specifies at which point a thread can be entered using the threading dial.
- To cut metric threads, the half nuts must be left continually engaged once the start point has been selected and the half nut is initially engaged (thread dial cannot be used).

40T x 127T x 40T					8 T.P.I.			
Lever	1	2	3	4	5	6	7	8
A	.1005 .0345	.0893 .0318	.0804 .0276	.0731 .0251	.0699 .0240	.0670 .0230	.0618 .0213	.0574 .0197
B	.0502 .0172	.0447 .0154	.0402 .0138	.0365 .0126	.0349 .0120	.0335 .0115	.0309 .0106	.0287 .0098
C	.0251 .0086	.0223 .0077	.0201 .0089	.0183 .0063	.0175 .0061	.0167 .0058	.0155 .0053	.0143 .0049
D	.0126 .0043	.0112 .0038	.0100 .0035	.0091 .0031	.0088 .0030	.0084 .0029	.0077 .0027	.0072 .0025
E	.0063 .0022	.0056 .0019	.0050 .0017	.0046 .0016	.0044 .0015	.0042 .0014	.0039 .0013	.0036 .0012

Table 2. Inch Feed per Revolution of Spindle

Inch Thread Tables (8 T.P.I.) 23T 40T x 127T 40T								
Lever	1	2	3	4	5	6	7	88
A	4	4-1/2	5	5-1/2	5-3/4	6	6-1/2	7
B	8	9	10	11	11-1/2	12	13	14
C	16	18	20	22	23	24	26	28
D	32	36	40	44	46	48	52	56
E	64	72	80	88	92	96	104	112

Table 3. Metric Thread Chart Table

Metric Thread Chart

See step 5 in "Thread Cutting".

40T 127T x 40T					30T 127T x 40T (23T) 8 T.P.I.			
Lever	1	2	3	4	5	6	7	8
A	4.5 6	4 3				3 4		
B	2.25 3	2 2				1.5 2	1.3 1.7	
C	1.5 1.5	1.3 1.3	1.2 1.2	1.1 1.1		1.0 1.0	0.9 0.9	0.65 0.85
D	0.55 0.75	0.5 0.5	0.45 0.6	0.4 0.4		0.5 0.5	0.35 0.45	
E	0.3 0.3	0.25 0.25	0.3 0.3	0.2 0.2		0.25 0.25	0.2 0.2	

Table 4. Metric Thread Chart

The compound rest (Fig. 21-A) is located on top of the carriage and can be rotated 360°. There is a calibrated dial (in degrees - see Fig 21-B) below the rest to assist in placement of the compound to the desired angle.

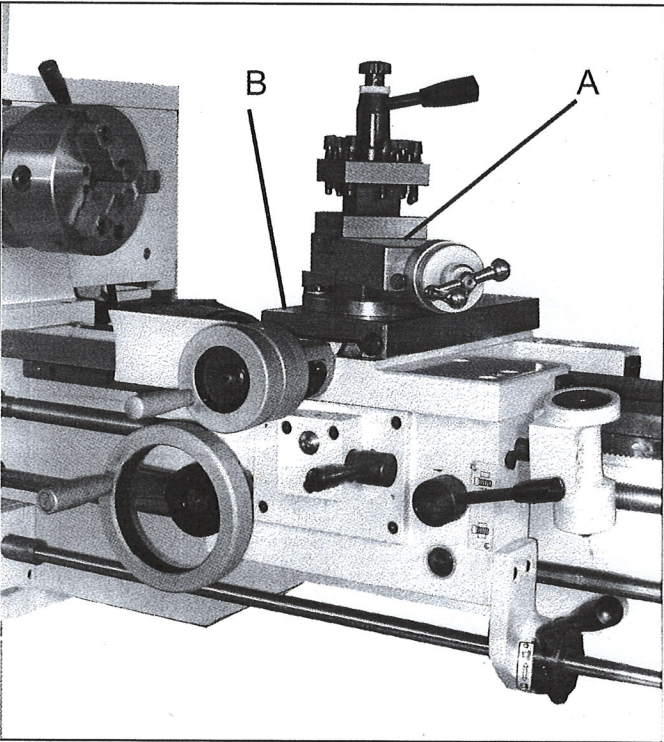


Fig. 21