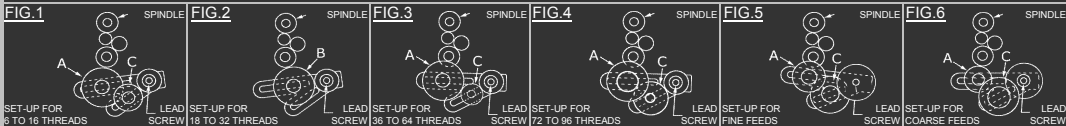


THREADING CHART

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		POSITION						SPINDLE STUD GEAR	FIG.
	R	F	R	A	F	R	B	F		
8	32		64	S	-	-	32	64	32	1
9	36		64	S	-	-	32	64	32	1
10	40		64	S	-	-	32	64	32	1
11	44		64	S	-	-	20	40	32	1
11.5	46		64	S	-	-	20	40	32	1
12	48		64	S	-	-	20	40	32	1
13	52		64	S	-	-	20	40	32	1
14	56		64	S	-	-	20	40	32	1
16	64		64	S	-	-	20	40	32	1
18	36		-	-	64	S	-	-	32	2
20	40		-	-	64	S	-	-	32	2
22	44		-	-	64	S	-	-	32	2
24	48		-	-	64	S	-	-	32	2
27	54		-	-	64	S	-	-	32	2
28	56		-	-	64	S	-	-	32	2
32	64		-	-	64	S	-	-	32	2
36	36		S	64	-	-	S	32	16	3
40	40		S	64	-	-	S	32	16	3
44	44		S	64	-	-	S	32	16	3
48	48		S	64	-	-	S	32	16	3
56	56		S	64	-	-	S	32	16	3
64	64		S	64	-	-	S	32	16	3
72	36		32	64	-	-	56	S	16	4
80	40		32	64	-	-	56	S	16	4
96	48		32	64	-	-	56	S	16	4
FEED PER REV. OF SPINDLE										
0.0024	64		24	48	-	-	64	20	16	5
0.0039	64		24	48	-	-	64	32	16	5
0.0049	64		48	24	-	-	20	64	32	6
0.0078	64		48	24	-	-	32	64	32	6

When two gears are used in combination, R, Rear indicates the position nearest the headstock. F, Front indicates the position away from headstock.