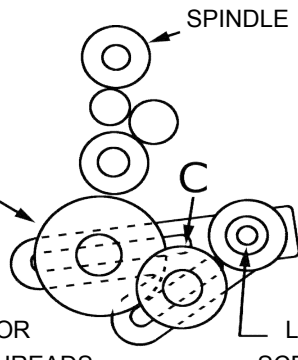
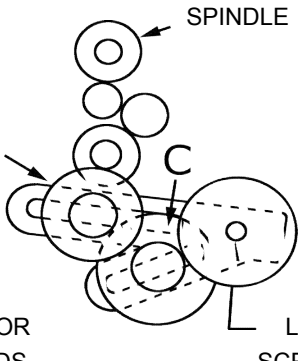
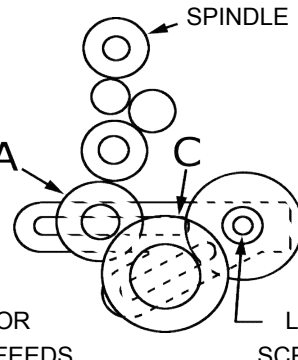


109 LATHE THREADING CHART

24 pitch 14.5° gears
1/2" bore with dual 1/8" slots

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

16 tpi Lead Screw

TPI Threading arrangements		THREADS PER INCH	SPINDLE STUD GEAR	POSITION						GEAR ON SCREW		FIG.
FIG.1  SET-UP FOR 6 TO 16 THREADS	A			B		C		R	F			
		R	F	R	F	R	F	R	F			
		8	32	64	S	-	-	32	64	32	1	
		9	32	64	S	-	-	32	64	36	1	
		10	32	64	S	-	-	32	64	40	1	
		11	32	64	S	-	-	20	40	44	1	
		11.5	32	64	S	-	-	20	40	46	1	
		12	32	64	S	-	-	20	40	48	1	
		13	32	64	S	-	-	20	40	52	1	
		14	32	64	S	-	-	20	40	56	1	
		16	32	64	S	-	-	20	40	64	1	
		18	32	-	-	64	S	-	-	36	2	
		20	32	-	-	64	S	-	-	40	2	
		22	32	-	-	64	S	-	-	44	2	
		24	32	-	-	64	S	-	-	48	2	
		26	32	-	-	64	S	-	-	52	2	
		27	32	-	-	64	S	-	-	54	2	
		28	32	-	-	64	S	-	-	56	2	
		32	32	-	-	64	S	-	-	64	2	
		36	16	S	64	-	-	S	32	36	3	
		40	16	S	64	-	-	S	32	40	3	
		44	16	S	64	-	-	S	32	44	3	
		48	16	S	64	-	-	S	32	48	3	
		56	16	S	64	-	-	S	32	56	3	
		64	16	S	64	-	-	S	32	64	3	
		72	16	32	64	-	-	56	S	36	4	
		80	16	32	64	-	-	56	S	40	4	
		96	16	32	64	-	-	56	S	48	4	
		FEED PER REV. OF SPINDLE										
		0.0024	16	24	48	-	-	64	20	64	5	
		0.0039	16	24	48	-	-	64	32	64	5	
		0.0049	32	48	24	-	-	20	64	64	6	
		0.0078	32	48	24	-	-	32	64	64	6	
		Gears positions: R (rear nearest headstock), F (front, away from headstock)										
Feeds and metric arrangements		METRIC mm PITCH	SPINDLE STUD GEAR	POSITION						GEAR ON SCREW		FIG.
FIG.5  SET-UP FOR FINE FEEDS	A			error		C		R	F			
		R	F			R	F	R	F			
		0.5	32	36	44	0.0089%		20	46	54	6	
		0.6	32	36	44	0.0107%		24	46	54	6	
		0.7	32	44	46	0.0169%		54	64	64	6	
		0.75	32	24	20	0.0134%		44	54	46	6	
		0.8	32	44	46	0.0193%		54	64	56	6	
		0.9	32	64	S	0.0161%		46	44	54	1	
		1.0	32	46	44	0.0179%		40	54	36	6	
		1.25	32	48	54	0.0156%		56	64	40	6	
		1.5	32	64	S	0.0909%		40	52	44	1	
		1.75	32	54	64	0.1553%		46	44	36	6	
		2.0	32	52	54	0.1748%		40	44	24	6	
		2.5	32	64	S	0.1515%		44	52	24	1	
		3.0	32	64	S	0.1818%		20	52	44	1	
		FIG.6  SET-UP FOR COARSE FEEDS										