109 LATHE THREADING CHART

24 pitch 14.5º 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

FIG.1

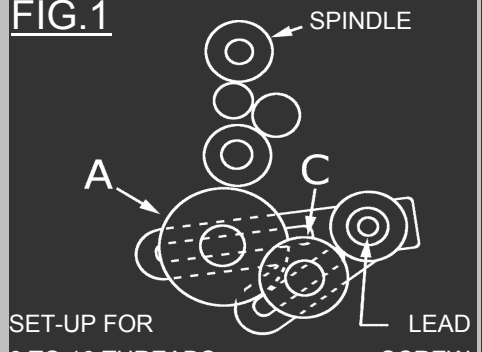


FIG.2

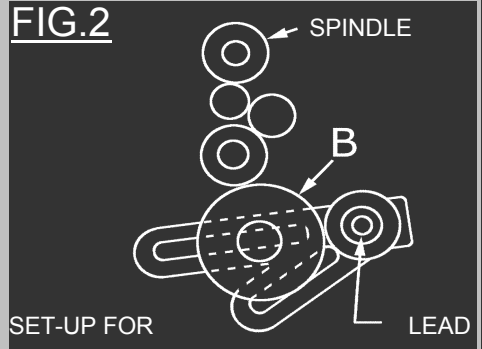


FIG.3

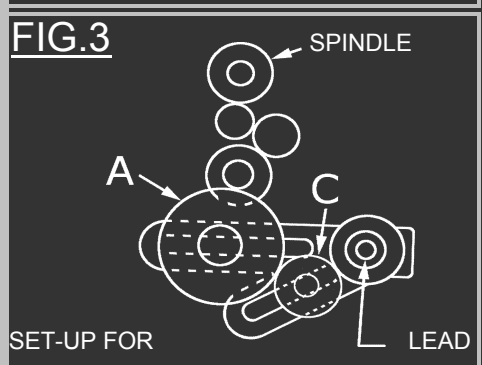
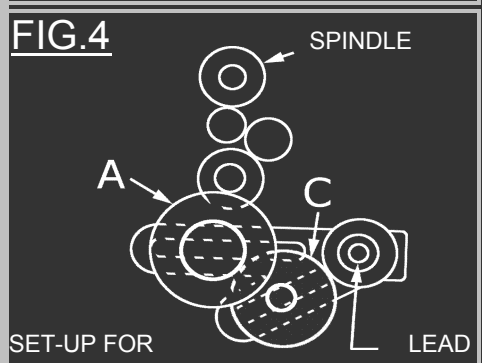


FIG.4



Feeds and metric arrangements

FIG.5

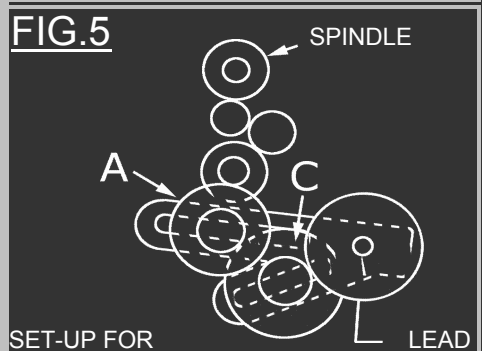
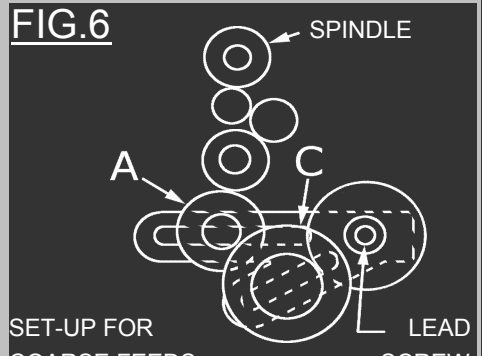


FIG.6



THREADS PER INCH	SPINDLE STUD GEAR	POSITION A R	A F	B R	B F	C R	C F	GEAR ON SCREW R	GEAR ON SCREW F	FIG.
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)										

METRIC mm PITCH	SPINDLE STUD GEAR	POSITION A R	A F	error	C R	C F	GEAR ON SCREW R	GEAR ON SCREW F	FIG.
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