

Catalog No. UKS-10



OPERATOR'S MANUAL

Tables of Leads

and Indexing Divisions

for



MILLING MACHINES

equipped with

Model K Universal Spiral Dividing Head and Conventional and Low Lead Attachments

(U. S. Standard Lead Screw)

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**Kearney & Trecker
Corporation**

Milwaukee 14, Wisconsin

U. S. A.

FOREWORD

This manual contains operating instructions for the Model K Universal Spiral Dividing Head and the Conventional and Low Lead Attachments. It also includes tables of leads and indexing divisions for use with these attachments on milling machines equipped with U.S. Standard lead screws.

This is an operator's manual only. For maintenance information refer to the Replacement Parts Manual for your milling machine.

In the purchase of these attachments you possess a guarantee of precision-built equipment — designed and manufactured so as to assure the greatest measure of long-life performance. The Kearney & Trecker policy of insisting on sound engineering principles and superior standards of workmanship — in practice now for more than fifty years — backs up each attachment and insures you of its high quality.

This manual has been prepared to familiarize you with these attachments and to help you operate them properly. Figures 1 and 2 call out the main units in consecutive order. The units are referred to by means of index numbers throughout the manual.

It is our intention to continually improve the service you receive from Kearney & Trecker - Milwaukee milling machine attachments and to make their operation as simple as possible. In accordance with this policy, we invite you to bring any questions and problems to the attention of the Service Department, Kearney & Trecker Corporation, Milwaukee 14, Wis. For service by telephone, call Greenfield 6-8300.

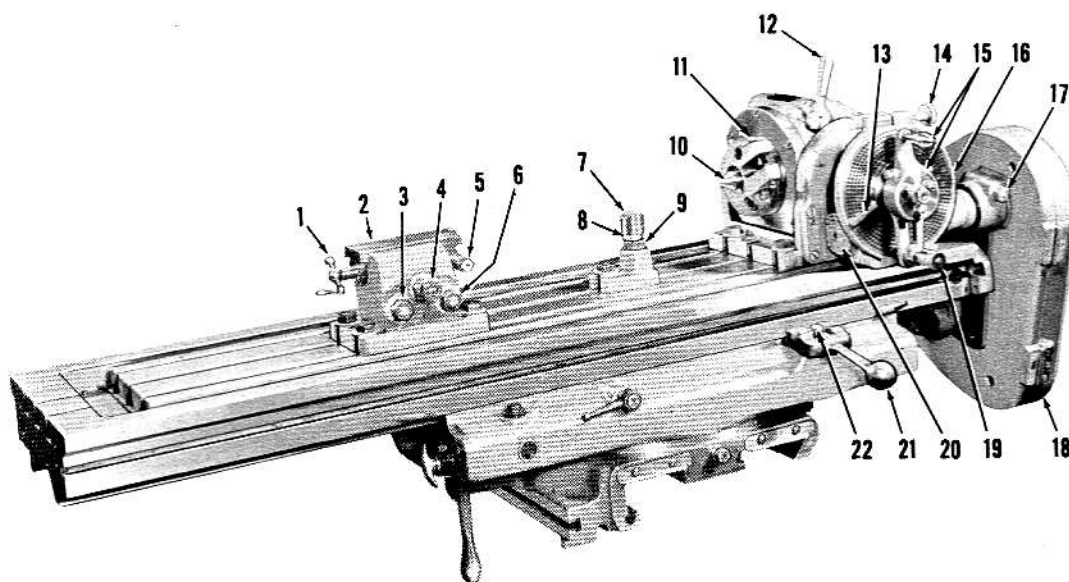
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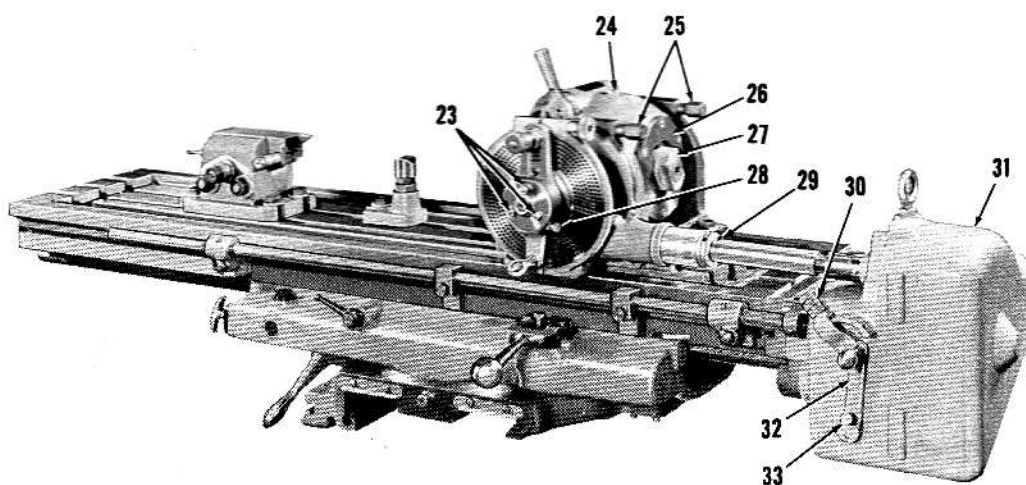
Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)



- | | | |
|------------------|--------------------------|----------------------------------|
| 1. Crank | 8. Lock Nut | 16. Index Plate |
| 2. Tail Stock | 9. Adjusting Screw | 17. Locking Screw |
| 3. Lock Nut | 10. Dividing Head Center | 18. Conventional Lead Attachment |
| 4. Adjusting Nut | 11. Work Driver | 19. Index Plunger Knob |
| 5. Locking Screw | 12. Spindle Clamp Lever | 20. Oil Level Screw Plug |
| 6. Lock Nut | 13. Index Fingers | 21. Table Control Lever |
| 7. Steady Rest | 14. Lock Nut | 22. Locking Screw |
| | 15. Index Crank | |

Fig. 1. Model K Universal Spiral Dividing Head and Conventional Lead Attachment



- | | | |
|-----------------------------|----------------------|-------------------------------|
| 23. Nuts | 27. Nut | 30. Selection Lever |
| 24. Oil Filler Screw | 28. *Adjusting Screw | 31. Low Lead Attachment |
| 25. Spindle Block Lock Nuts | 29. Graduated Dial | 32. Directional Control Lever |
| 26. Spindle Block | | 33. Lock Screw |

Fig. 2. Model K Universal Spiral Dividing Head and Low Lead Attachment

A dividing head is essentially a device for dividing a circle into any number of equal parts. This operation is commonly referred to as indexing. The dividing head is also used as an attachment to rotate the work piece at a certain rate in relation to the travel of the milling machine table. This operation is commonly called spiral milling. Indexing operations are performed by hand as explained in Section II. Spiral milling operations are accomplished by means of a lead attachment as explained in Sections III and IV.

The function of the lead attachment is to coordinate the rotation of the dividing head spindle with the travel of the milling machine table. The relationship between these two motions is termed "lead" and is defined as the distance traveled by the table while the dividing head spindle makes one revolution.

The gearing in a Model K Dividing Head consists of a worm and a worm wheel which drives the spindle through the index plate, the index plunger and a pair of hypoid bevel gears. The ratio between the worm and worm wheel is 8:1 and the ratio between the hypoid gears is 5:1. The total ratio, then, between the drive worm and spindle is 40:1, which is the standard milling machine ratio for dividing heads. Stated in other words, in order to rotate the dividing head spindle one revolution, the drive worm must be rotated 40 revolutions.

The lead of the table drive screw is .250 inch; that is, when the screw makes one revolution, the table advances .250 inch. If the drive screw were connected to the drive worm of the dividing head spindle through a gear ratio of 1:1, the dividing head spindle would rotate once for each 40 rotations of the

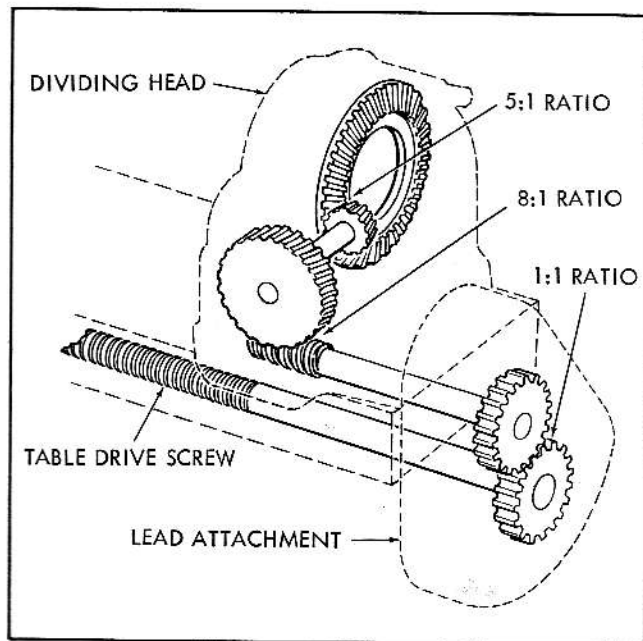


Fig. 3. Schematic Drawing

table drive screw. The milling machine table at the same time would advance 10 inches (40 x .250). This is the basis for the expression "the common lead of a milling machine is 10 inches". These relationships are shown in the schematic drawing in Figure 3.

It can be seen that a variety of leads are obtainable by changing the gear ratio in the lead attachment.

SECTION II

MODEL K UNIVERSAL SPIRAL DIVIDING HEAD

Used in conjunction with the Model K Dividing Head are one double index plate, an adjustable tailstock (2), a steady rest (7), a head center (10) with work driver (11) and a conventional (18) or low lead attachment (31).

SPINDLE

The dividing head is mounted on the milling ma-

chine table and secured with T-bolts. The dividing head center (10) is mounted in a centering plug which fits into the spindle. The centering plug is secured to the spindle by means of the nut (27). The spindle itself is mounted on pre-loaded precision ball bearings and is provided with a clamp which is controlled by the lever (12). The spindle should be clamped for all operations except when spiral milling and indexing.

An adjustable drive key provides for the elimination of all free play between the key and the driving flange of arbors, chucks or the work driver (11). The adjustment is made by means of a square head screw which controls the position of a hardened button in the key.

The entire spindle block (26) can be swiveled 100 degrees from 5 degrees below the horizontal to 5 degrees past the vertical. Graduations on the spindle block just behind the index plate indicate the position of the spindle. However, a bar and indicator should be used when accurate positioning of the spindle is required. The spindle block is clamped in position by means of the two nuts (25).

INDEX CRANK AND PLUNGER

The index crank (15) is keyed to the shaft of the hypoid pinion and is secured with a nut at the end of the shaft. The plunger on the knob (19) is hardened and ground to fit the holes of the index plate (16) accurately and is spring-loaded to insure that it remains in an index plate hole. The plunger will remain withdrawn if it is rotated slightly after being withdrawn. A slot in the index crank permits the plunger to be located for the desired circle of holes in the index plate. If the workpiece has been accurately positioned and the plunger can not be inserted in a hole, loosen the three nuts (23), turn the screw (28) until the plunger pin can be located in a hole and then tighten the three nuts.

The index crank drives the spindle through the 5:1 ratio hypoid bevel gear. Each turn of the crank, then, rotates the spindle 72 degrees and five turns of the crank are required to rotate the spindle 360 degrees. It has been found that the majority of indexing operations encountered in practice require from 10 to 60 degrees rotation of the spindle or 6 to 36 divisions on the workpiece - all of which can be accomplished with less than one complete turn of the index crank. The two index fingers (13) can be rotated on the face of the index plate and adjusted to the number of holes required for each division. Since most indexing can be accomplished with less than one turn of the crank, the possibility of human error is reduced because the plunger will remain within the arc between the two fingers.

HAND DRIVE

When it is necessary to circular-mill only a short distance a manually operated double-handle crank can be installed on the end of the worm shaft. Since the ratio between this shaft and the spindle is 40:1, one turn of the crank will rotate the spindle 9 degrees. Forty turns of the crank will rotate the spindle one complete revolution. A dial (29), graduated in degrees and five minute increments, is used to measure the movement of the spindle.

TAIL STOCK

The tail stock (2) is used to support the workpiece and to align it horizontally with the dividing

head spindle. The tail stock center is dovetailed to the tail stock block and can be moved horizontally by loosening the screw (5) and turning the crank (1). The center can be swiveled 15 degrees downward from the horizontal position. This is done by loosening the two locking nuts (3 and 6) and then turning the nut (4) until the center is at the desired angle.

Note Be sure to tighten the locking nuts before milling to maintain the setting.

STEADY REST

It is recommended that the steady rest (7) be used to give additional support when milling long and slender workpieces. The steady rest is adjusted vertically by loosening the nut (8) and turning the adjusting screw (9) in or out of the base.

RIGHT ANGLE DRIVE BRACKET

The right angle drive bracket shown in Figure 4 is used in such operations as milling face circles, scrolls, cams, etc., when the dividing head must be mounted so that its spindle is at right angles to the long dimension of the milling machine table. This bracket has a 1:1 gear ratio and is mounted on the worm shaft casting of the dividing head as shown in Figure 4.

INDEX PLATES

The two index plates are fitted and doweled together to form a single unit. The plates have seven concentric circles of holes which are drilled and finish bored to a tolerance of plus or minus .0001 inch between adjacent holes. The number of holes in each circle is indicated on the circle and every tenth hole in each circle is scribe-circled to simplify identification. When mounting plates on the dividing head, draw the screws up evenly before tightening them. The index plates are clamped by means of the

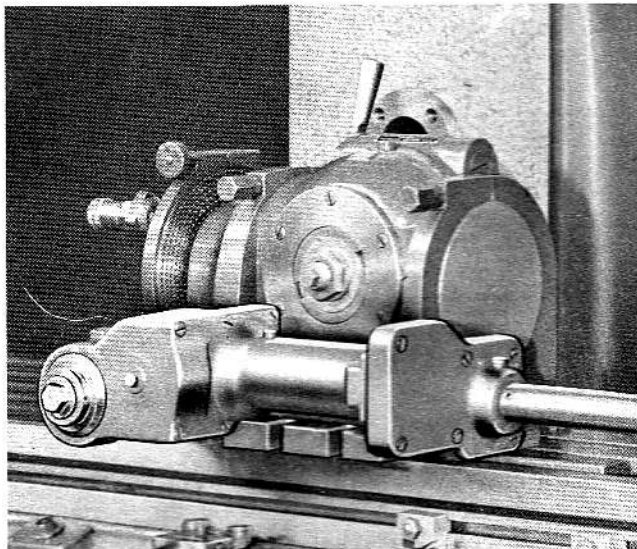


Fig. 4. Right Angle Drive Bracket

nut (14). The plates must be clamped when indexing and released when spiral milling.

There are two standard and four high number index plates. The two standard plates are fitted and doweled to form a double plate - one side being called plate #1 and the other side being called plate #2. The four high number plates consist of two double plates, each side being called #3, #4, #5 and #6 respectively.

The number of holes in each circle of holes in each of the six plates is listed in the following table.

| Plate No. | Number of index holes per circle (Largest number on outside diameter of plate) | | | | | | |
|-----------|---|----|----|----|----|----|----|
| | 1 | 98 | 88 | 78 | 76 | 68 | 58 |
| 2 | 100 | 96 | 92 | 84 | 72 | 66 | 60 |
| 3 | 93 | 86 | 79 | 71 | 63 | 57 | 51 |
| 4 | 94 | 87 | 81 | 73 | 64 | 59 | 52 |
| 5 | 97 | 89 | 82 | 74 | 67 | 61 | 53 |
| 6 | 99 | 91 | 83 | 77 | 69 | 62 | 56 |

To determine the number of holes to be taken for a given indexing, use the formula $n = \frac{5H}{N}$

Where n = number of holes to be taken
 H = number of holes in the index plate circle
 N = number of divisions required

The set of six plates can be used for all divisions of a circle from 2 to 100 and all those divisible by 5 up to 500 except 175, 200, 225, 275, 325, 350, 375, 400, 425, 450 and 475. The index plate, the particular circle of holes and the number of holes to index for each of these divisions is listed in Table 1 at the rear of this book. All other indexing divisions must be performed with the lead attachment or a differential attachment.

LUBRICATION

Two reservoirs supply oil to the spindle and the worm and hypoid gearing. The reservoirs are filled through screw plug openings, one (24) on top and in the center of the dividing head and one on the top but near the index plate. The oil level in each reservoir should be checked periodically. This is done by removing two screw plugs, one (20) near the index plate and the other shown in Figure 7 on the opposite side of the dividing head, and adding oil until the level is

even with the screw plug opening. In addition, the two reservoirs should be drained and refilled once each year. Use the highest quality of rust-proof oil obtainable (Standard Oil Company Stan-O-Rust No. 95 or equivalent).

ASTRONOMICAL DIVIDER

The Model K dividing head can be equipped with the astronomical divider as shown in Figure 5. With this divider it is possible to divide a circle into 360 degrees, 21,600 minutes or 1,296,000 seconds. The astronomical divider is easily mounted on the dividing head by removing the index crank and index plate. The divider has three plates and three plungers, one of each for degrees, minutes and seconds. The degree plate has 72 holes, each hole representing one degree of spindle rotation. Both the minute and second plates have 60 holes, each hole representing a minute or second of spindle rotation.

When more than one plunger is required to move the spindle through a given arc, the plunger controlling the smallest increment is moved first. For example, to move the spindle through an arc of 5 degrees, 17 minutes and 44 seconds, first move the small (second) plunger 44 holes, the middle (minute) plunger 17 holes and the large (degree) plunger 5 holes.

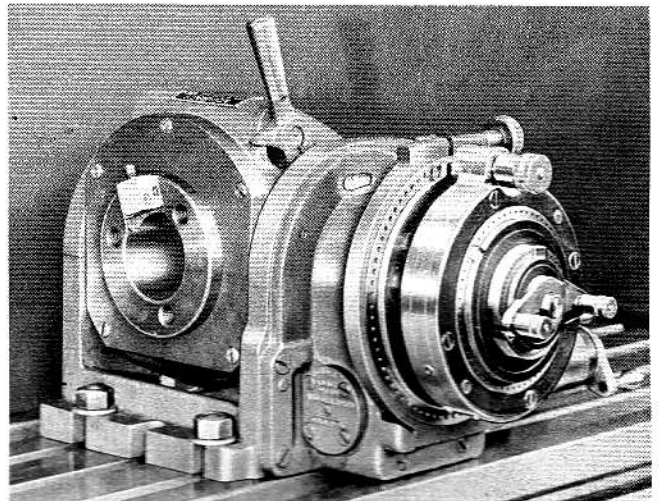


Fig. 5. Astronomical Divider

SECTION III

CONVENTIONAL LEAD ATTACHMENT

The Conventional Lead Attachment (18) is supplied with 13 change gears for cutting more than 1,300 leads ranging from .670 inches to 149 inches. The gears are driven directly by the table drive screw. To mount the attachment, proceed as follows:

1. Remove the bracket cover at the right end of the table and the nut and washer on the table screw.
2. Remove the hex head plug screw near the center and top of the table bracket.
3. Screw the bracket stud (see Figure 6) supplied

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Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

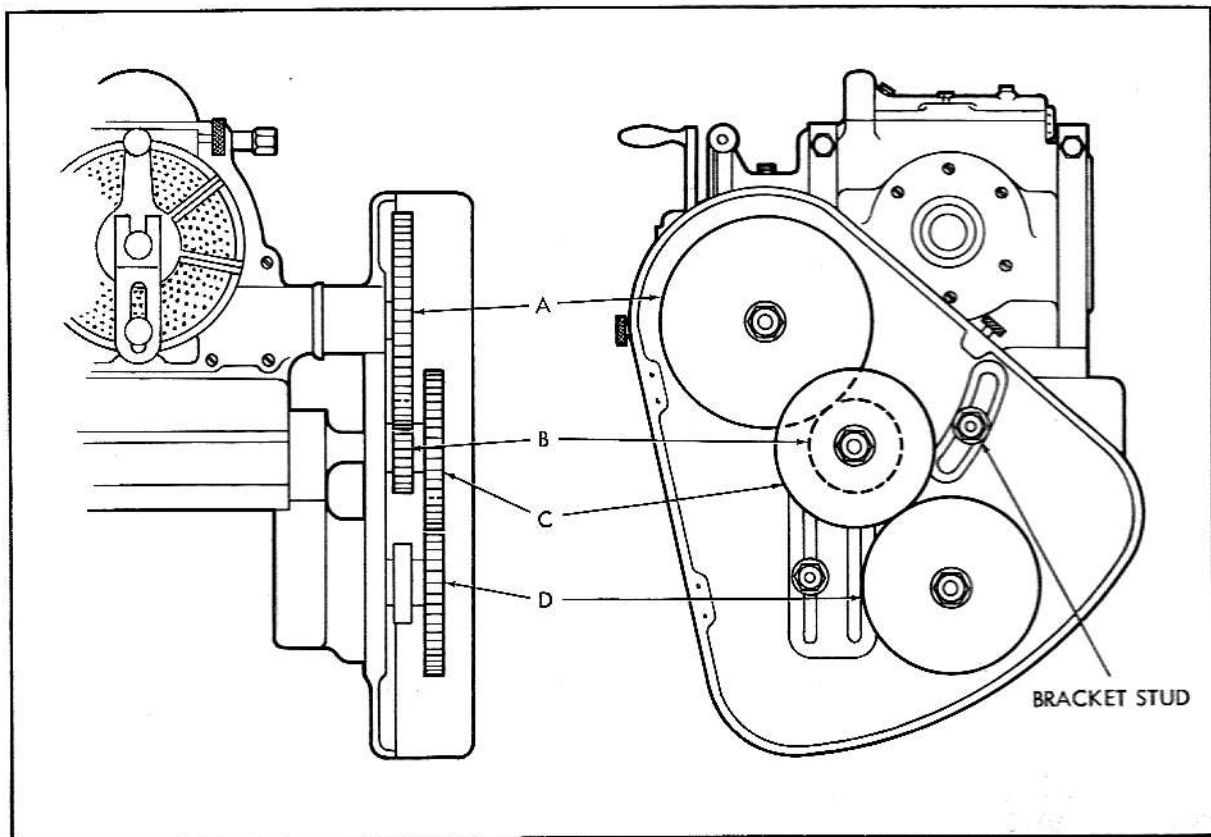


Fig. 6. Gearing in Conventional Lead Attachment

with the lead attachment into the hole in the table bracket.

4. Mount the lead attachment so that the worm housing of the dividing head fits into the boss on the change gear bracket. Secure the bracket by tightening locking screw (17) and the nut on the bracket stud.

The gears supplied with the Conventional Lead Attachment consist of two 48-tooth and two 24-tooth gears and nine gears with the following number of teeth: 100, 86, 72, 64, 56, 44, 40, 32, and 28.

The various leads are obtained by mounting the gears as explained in the following paragraphs.

Figure 6 illustrates the position of the gears in the lead attachment and identifies each by a letter. B and D are driver gears and A and C are driven gears. The particular gears to use in each of the positions for a desired lead are listed in Table 2 at the rear of this book. If the gears do not mesh when placed in the positions shown, the two driver gears (B and D) or the two driven gears (A and C) may be interchanged to give a total of four combinations for the desired lead.

Caution Do not interchange gears A and B, or gears C and D. Use power feed only for leads of 3 inches or higher. Use hand feed for all other leads. Do not use rapid traverse on leads lower than 10 inches.

When milling spirals, it may be necessary to use idler gears as shown in Figure 7. One idler is required for left hand spirals and two or none, depending on the space available, for right hand spirals.

Periodically fill the hand oilers on the lead attachment and oil the gears and studs in the change gear bracket with a good grade machine oil.

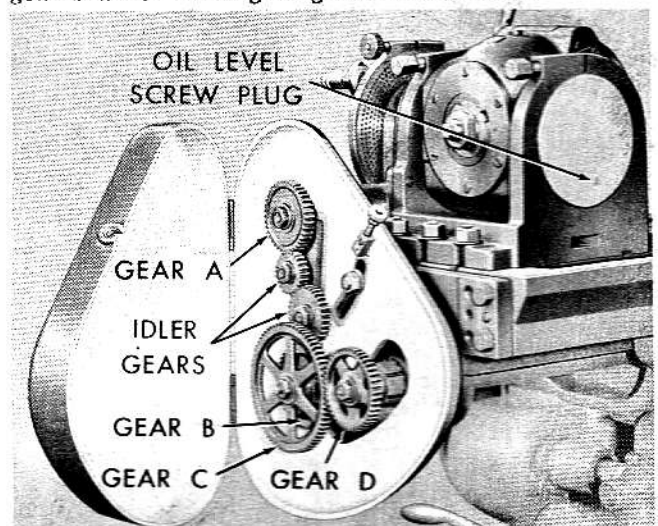


Fig. 7. Idler Gears in Conventional Lead Attachment

SECTION IV

LOW LEAD ATTACHMENT

The Low Lead Attachment (31) can be used with the Model K Dividing Head to provide 42,362 different leads ranging from .0219 inches to 2918.4 inches. To mount the Low Lead Attachment, proceed as follows:

1. Remove the bracket cover at the right end of the table and remove the nut and washer on the table screw.
2. Insert the auxiliary drive shaft supplied with the lead attachment through the hole indicated in Figure 8 and into the splined hub of the drive gear in the saddle. Push the shaft in as far as it will go.
3. Remove the cover (K) and the table screw extension (L) from the lead attachment.
4. Lift the lead attachment into position on the table screw and auxiliary drive shaft so that the two dowels (H) enter the two "H" dowel holes.
5. Insert the four screws (J) to secure the attachment in position.
6. Position the worm and worm wheel (F and G, Figure 9) according to the lead selected, then replace the table screw extension and the cover.

The positions of the worm and wheel (F and G) will depend on the lead selected. For leads up to 8.000 inches a worm is used in position (F) and a worm wheel in position (G). For leads from 8.000 inches and up a worm wheel is used in position (F) and a worm in position (G). For leads up to 8.000 inches table feed is controlled by the lever (32); for leads from 8.000 inches and up table feed is controlled by the lever (21). Both power feed and rapid traverse can be used for all leads.

Caution Be sure the lever (21) is locked in the neutral position by means of the screw (22) when table feed is controlled with the lever (32). Be sure the lever (32) is locked in the neutral position by means of the screw (33) when table feed is controlled with the lever (21).

The gears supplied with the Low Lead Attachment consist of two 20-tooth gears and fifteen with the following number of teeth: 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 32, 34, 36, 38 and 40. Three worm gear sets in the ratios of 1:96, 1:24 and 1:3 are also supplied.

Figure 9 illustrates the position of the worm and gears in the lead attachment and identifies each by means of a letter. The particular worm, worm wheel and gear to use in each position for a desired lead are listed in Table 3 at the rear of this book.

The lead for a particular combination of gears can be computed by means of the formulae on the next page.

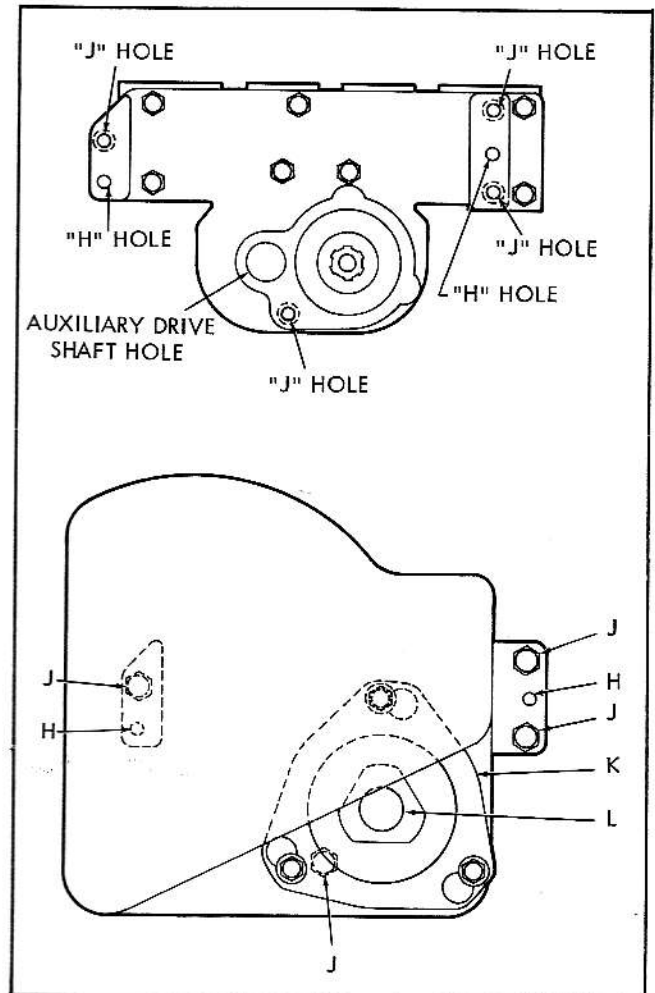


Fig. 8. Mounting Low Lead Attachment

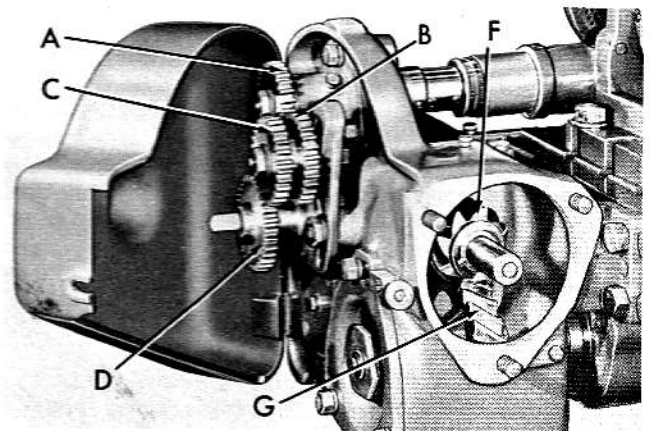


Fig. 9. Gearing in Low Lead Attachment

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Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

For leads up to 8.000 inches when a worm is used in position F and a worm wheel in position G:

- a) If F = 1 and G = 96, the lead = $\frac{1}{12} \times \frac{A}{B} \times \frac{C}{D}$
- b) If F = 1 and G = 24, the lead = $\frac{1}{3} \times \frac{A}{B} \times \frac{C}{D}$
- c) If F = 8 and G = 24, the lead = $\frac{8}{3} \times \frac{A}{B} \times \frac{C}{D}$

For leads from 8.000 inches up when a worm wheel is used in position F and a worm in position G:

- a) If F = 24 and G = 8, the lead = $\frac{24}{1} \times \frac{A}{B} \times \frac{C}{D}$
- b) If F = 24 and G = 1, the lead = $\frac{192}{1} \times \frac{A}{B} \times \frac{C}{D}$
- c) If F = 96 and G = 1, the lead = $\frac{768}{1} \times \frac{A}{B} \times \frac{C}{D}$

The values of A, B, C and D are the number of teeth in the gears A, B, C and D in Figure 9.

Of the 42,362 leads available, 2,258 have been selected for inclusion in Table 3. A master table listing the gears to use for all leads is on file in the Engineering Department of Kearney & Trecker Corporation. If the desired lead can not be obtained closely enough from Table 3, write or wire Kearney & Trecker Corporation giving the exact lead desired. The arrangement of change gears for the closest lead to that desired will be forwarded.

Table 4 lists the gears for milling single, double, triple, quadruple and metric threads. The thread milling attachment must be used with standard thread cutters or hobs when milling threads. Left and right hand threads are milled by setting the lever (30) to the appropriate position.

Periodically fill the hand oilers on the lead attachment and oil the gears and studs in the change gear bracket with a good grade machine oil.

The tables of indexing divisions and leads referred to in the foregoing text appear on the following pages.

TABLE 1 — PLAIN INDEXING

Model K Universal Spiral Dividing Head Using Standard or High Number Index Plates.

| No. of Div. | Standard Double Plate | | | | High Number Double Plates | | | | | | | |
|-------------|-----------------------|--------|-------------|--------|---------------------------|--------|-------------|--------|-------------|--------|-------------|--------|
| | Plate No. 1 | | Plate No. 2 | | Plate No. 3 | | Plate No. 4 | | Plate No. 5 | | Plate No. 6 | |
| | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes |
| 1 | Any | 5 Turn | Any | 5 Turn | Any | 5 Turn | Any | 5 Turn | Any | 5 Turn | Any | 5 Turn |
| 2 | 98 | 245 | 100 | 250 | 86 | 215 | 64 | 160 | 82 | 205 | 62 | 155 |
| 3 | 78 | 130 | 96 | 160 | 93 | 155 | 87 | 145 | — | — | 69 | 115 |
| 4 | 88 | 110 | 96 | 120 | — | — | 64 | 80 | — | — | 56 | 70 |
| 5 | Any | 1 Turn | Any | 1 Turn | Any | 1 Turn | Any | 1 Turn | Any | 1 Turn | Any | 1 Turn |
| 6 | 78 | 65 | 96 | 90 | — | — | — | — | — | — | — | — |
| 7 | 98 | 70 | 84 | 60 | 63 | 45 | — | — | — | — | 91 | 65 |
| 8 | 88 | 55 | 96 | 60 | — | — | 64 | 40 | — | — | 56 | 35 |
| 9 | 54 | 30 | 72 | 40 | 63 | 35 | — | — | — | — | 99 | 55 |
| 10 | 98 | 49 | 100 | 50 | 86 | 43 | 94 | 47 | 82 | 41 | 62 | 31 |
| 11 | 88 | 40 | 66 | 30 | — | — | — | — | — | — | 99 | 45 |
| 12 | — | — | 96 | 40 | — | — | — | — | — | — | — | — |
| 13 | 78 | 30 | — | — | — | — | 52 | 20 | — | — | 91 | 35 |
| 14 | 98 | 35 | 84 | 30 | — | — | — | — | — | — | 56 | 20 |
| 15 | 78 | 26 | 96 | 32 | 93 | 31 | 81 | 27 | — | — | 99 | 33 |
| 16 | — | — | 96 | 30 | — | — | 64 | 20 | — | — | — | — |
| 17 | 68 | 20 | — | — | 51 | 15 | — | — | — | — | — | — |
| 18 | 54 | 15 | 72 | 20 | — | — | — | — | — | — | — | — |
| 19 | 76 | 20 | — | — | 57 | 15 | — | — | — | — | — | — |
| 20 | 88 | 22 | 100 | 25 | — | — | 64 | 16 | — | — | 56 | 14 |
| 21 | — | — | 84 | 20 | 63 | 15 | — | — | — | — | — | — |
| 22 | 88 | 20 | 66 | 15 | — | — | — | — | — | — | — | — |
| 23 | — | — | 92 | 20 | — | — | — | — | — | — | 69 | 15 |
| 24 | — | — | 96 | 20 | — | — | — | — | — | — | — | — |
| 25 | — | — | 100 | 20 | — | — | — | — | — | — | — | — |
| 26 | 78 | 15 | — | — | — | — | 52 | 10 | — | — | — | — |
| 27 | 54 | 10 | — | — | — | — | 81 | 15 | — | — | — | — |
| 28 | — | — | 84 | 15 | — | — | — | — | — | — | 56 | 10 |
| 29 | 58 | 10 | — | — | — | — | — | — | — | — | — | — |
| 30 | 78 | 13 | 96 | 16 | — | — | — | — | — | — | — | — |
| 31 | — | — | — | — | 95 | 15 | — | — | — | — | 62 | 10 |
| 32 | — | — | 96 | 15 | — | — | 64 | 10 | — | — | — | — |
| 33 | — | — | 66 | 10 | — | — | — | — | — | — | 99 | 15 |
| 34 | 68 | 10 | — | — | — | — | — | — | — | — | — | — |
| 35 | 98 | 14 | 84 | 12 | 63 | 9 | — | — | — | — | 77 | 11 |
| 36 | — | — | 72 | 10 | — | — | — | — | — | — | — | — |
| 37 | — | — | — | — | — | — | — | — | 74 | 10 | — | — |
| 38 | 76 | 10 | — | — | — | — | — | — | — | — | — | — |
| 39 | 78 | 10 | — | — | — | — | — | — | — | — | — | — |
| 40 | 88 | 11 | 96 | 12 | — | — | 64 | 8 | — | — | 56 | 7 |
| 41 | — | — | — | — | — | — | — | — | 82 | 10 | — | — |
| 42 | — | — | 84 | 10 | — | — | — | — | — | — | — | — |
| 43 | — | — | — | — | 86 | 10 | — | — | — | — | — | — |
| 44 | 88 | 10 | — | — | — | — | — | — | — | — | — | — |
| 45 | 54 | 6 | 72 | 8 | 63 | 7 | 81 | 9 | — | — | 99 | 11 |
| 46 | — | — | 92 | 10 | — | — | — | — | — | — | — | — |
| 47 | — | — | — | — | — | — | 94 | 10 | — | — | — | — |
| 48 | — | — | 96 | 10 | — | — | — | — | — | — | — | — |
| 49 | 98 | 10 | — | — | — | — | — | — | — | — | — | — |
| 50 | — | — | 100 | 10 | — | — | — | — | — | — | — | — |

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Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 1 (continued)—PLAIN INDEXING

Model K Universal Spiral Dividing Head Using Standard or High Number Index Plates.

| No. of Div. | Standard Double Plate | | | | High Number Double Plates | | | | | | | |
|-------------------|-----------------------|-------|-------------|-------|---------------------------|-------|-------------|-------|-------------|-------|-------------|-------|
| | Plate No. 1 | | Plate No. 2 | | Plate No. 3 | | Plate No. 4 | | Plate No. 5 | | Plate No. 6 | |
| | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes |
| 51 | — | — | — | — | 51 | 5 | — | — | — | — | — | — |
| 52 | — | — | — | — | — | — | 52 | 5 | — | — | — | — |
| 53 | — | — | — | — | — | — | — | — | 53 | 5 | — | — |
| 54 | 54 | 5 | — | — | — | — | — | — | — | — | — | — |
| 55 | 88 | 8 | 66 | 6 | — | — | — | — | — | — | 99 | 9 |
| 56 | — | — | — | — | — | — | — | — | — | — | 56 | 5 |
| 57 | — | — | — | — | 57 | 5 | — | — | — | — | — | — |
| 58 | 58 | 5 | — | — | — | — | — | — | — | — | — | — |
| 59 | — | — | — | — | — | — | 59 | 5 | — | — | — | — |
| 60 | — | — | 96 | 8 | — | — | — | — | — | — | — | — |
| 61 | — | — | — | — | — | — | — | — | 61 | 5 | — | — |
| 62 | — | — | — | — | — | — | — | — | — | — | 62 | 5 |
| 63 | — | — | — | — | 63 | 5 | — | — | — | — | — | — |
| 64 | — | — | — | — | — | — | 64 | 5 | — | — | — | — |
| 65 | 78 | 6 | — | — | — | — | 52 | 4 | — | — | 91 | 7 |
| 66 | — | — | 66 | 5 | — | — | — | — | — | — | — | — |
| 67 | — | — | — | — | — | — | — | — | 67 | 5 | — | — |
| 68 | 68 | 5 | — | — | — | — | — | — | — | — | — | — |
| 69 | — | — | — | — | — | — | — | — | — | — | 69 | 5 |
| 70 | 98 | 7 | 84 | 6 | — | — | — | — | — | — | 56 | 4 |
| 71 | — | — | — | — | 71 | 5 | — | — | — | — | — | — |
| 72 | — | — | 72 | 5 | — | — | — | — | — | — | — | — |
| 73 | — | — | — | — | — | — | 73 | 5 | — | — | — | — |
| 74 | — | — | — | — | — | — | — | — | 74 | 5 | — | — |
| 75 | — | — | 60 | 4 | — | — | — | — | — | — | — | — |
| 76 | 76 | 5 | — | — | — | — | — | — | — | — | — | — |
| 77 | — | — | — | — | — | — | — | — | — | — | 77 | 5 |
| 78 | 78 | 5 | — | — | — | — | — | — | — | — | — | — |
| 79 | — | — | — | — | 79 | 5 | — | — | — | — | — | — |
| 80 | — | — | 96 | 6 | — | — | 64 | 4 | — | — | — | — |
| 81 | — | — | — | — | — | — | 81 | 5 | — | — | — | — |
| 82 | — | — | — | — | — | — | — | — | 82 | 5 | — | — |
| 83 | — | — | — | — | — | — | — | — | — | — | 83 | 5 |
| 84 | — | — | 84 | 5 | — | — | — | — | — | — | — | — |
| 85 | 68 | 4 | — | — | 51 | 3 | — | — | — | — | — | — |
| 86 | — | — | — | — | 86 | 5 | — | — | — | — | — | — |
| 87 | — | — | — | — | — | — | 87 | 5 | — | — | — | — |
| 88 | 88 | 5 | — | — | — | — | — | — | — | — | — | — |
| 89 | — | — | — | — | — | — | — | — | 89 | 5 | — | — |
| 90 | 54 | 3 | 72 | 4 | — | — | — | — | — | — | — | — |
| 91 | — | — | — | — | — | — | — | — | — | — | 91 | 5 |
| 92 | — | — | 92 | 5 | — | — | — | — | — | — | — | — |
| 93 | — | — | — | — | 93 | 5 | — | — | — | — | — | — |
| 94 | — | — | — | — | — | — | 94 | 5 | — | — | — | — |
| 95 | 76 | 4 | — | — | 57 | 3 | — | — | — | — | — | — |
| 96 | — | — | 96 | 5 | — | — | — | — | — | — | — | — |
| 97 | — | — | — | — | — | — | — | — | 97 | 5 | — | — |
| 98 | 98 | 5 | — | — | — | — | — | — | — | — | — | — |
| 99 | — | — | — | — | — | — | — | — | — | — | 99 | 5 |
| 100 | — | — | 100 | 5 | — | — | — | — | — | — | — | — |

TABLE 1 (continued) — PLAIN INDEXING

Model K Universal Spiral Dividing Head Using Standard or High Number Index Plates.

| No. of Div. | Standard Double Plate | | | | High Number Double Plates | | | | | | | |
|-------------|-----------------------|-------|-------------|-------|---------------------------|-------|-------------|-------|-------------|-------|-------------|-------|
| | Plate No. 1 | | Plate No. 2 | | Plate No. 3 | | Plate No. 4 | | Plate No. 5 | | Plate No. 6 | |
| | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes | Circle | Holes |
| 105 | — | — | 84 | 4 | 63 | 3 | — | — | — | — | — | — |
| 110 | 88 | 4 | 66 | 3 | — | — | — | — | — | — | — | — |
| 115 | — | — | 92 | 4 | — | — | — | — | — | — | 69 | 3 |
| 120 | — | — | 96 | 4 | — | — | — | — | — | — | — | — |
| 125 | — | — | 100 | 4 | — | — | — | — | — | — | — | — |
| 130 | 78 | 3 | — | — | — | — | 52 | 2 | — | — | — | — |
| 135 | 54 | 2 | — | — | — | — | 81 | 3 | — | — | — | — |
| 140 | — | — | 84 | 3 | — | — | — | — | — | — | 56 | 2 |
| 145 | 58 | 2 | — | — | — | — | 87 | 3 | — | — | — | — |
| 150 | — | — | 60 | 2 | — | — | — | — | — | — | — | — |
| 155 | — | — | — | — | 93 | 3 | — | — | — | — | 62 | 2 |
| 160 | — | — | 96 | 3 | — | — | 64 | 2 | — | — | — | — |
| 165 | — | — | 66 | 2 | — | — | — | — | — | — | — | — |
| 170 | 68 | 2 | — | — | — | — | — | — | — | — | — | — |
| 175 | — | — | — | — | — | — | — | — | — | — | — | — |
| 180 | — | — | 72 | 2 | — | — | — | — | — | — | — | — |
| 185 | — | — | — | — | — | — | — | — | 74 | 2 | — | — |
| 190 | 76 | 2 | — | — | — | — | — | — | — | — | — | — |
| 195 | 78 | 2 | — | — | — | — | — | — | — | — | — | — |
| 200 | — | — | — | — | — | — | — | — | — | — | — | — |
| 205 | — | — | — | — | — | — | — | — | 82 | 2 | — | — |
| 210 | — | — | 84 | 2 | — | — | — | — | — | — | — | — |
| 215 | — | — | — | — | 86 | 2 | — | — | — | — | — | — |
| 220 | 88 | 2 | — | — | — | — | — | — | — | — | — | — |
| 225 | — | — | — | — | — | — | — | — | — | — | — | — |
| 230 | — | — | 92 | 2 | — | — | — | — | — | — | — | — |
| 235 | — | — | — | — | — | — | 94 | 2 | — | — | — | — |
| 240 | — | — | 96 | 2 | — | — | — | — | — | — | — | — |
| 245 | 98 | 2 | — | — | — | — | — | — | — | — | — | — |
| 250 | — | — | 100 | 2 | — | — | — | — | — | — | — | — |
| 255 | — | — | — | — | 51 | 1 | — | — | — | — | — | — |
| 260 | — | — | — | — | — | — | 52 | 1 | — | — | — | — |
| 265 | — | — | — | — | — | — | — | — | 53 | 1 | — | — |
| 270 | 54 | 1 | — | — | — | — | — | — | — | — | — | — |
| 275 | — | — | — | — | — | — | — | — | — | — | — | — |
| 280 | — | — | — | — | — | — | — | — | — | — | 56 | 1 |
| 285 | — | — | — | — | 57 | 1 | — | — | — | — | — | — |
| 290 | 58 | 1 | — | — | — | — | — | — | — | — | — | — |
| 295 | — | — | — | — | — | — | 59 | 1 | — | — | — | — |
| 300 | — | — | 60 | 1 | — | — | — | — | — | — | — | — |
| 305 | — | — | — | — | — | — | — | — | 61 | 1 | — | — |
| 310 | — | — | — | — | — | — | — | — | — | — | 62 | 1 |
| 315 | — | — | — | — | 63 | 1 | — | — | — | — | — | — |
| 320 | — | — | — | — | — | — | 64 | 1 | — | — | — | — |
| 325 | — | — | — | — | — | — | — | — | — | — | — | — |
| 330 | — | — | 66 | 1 | — | — | — | — | — | — | — | — |
| 335 | — | — | — | — | — | — | — | — | 67 | 1 | — | — |
| 340 | 68 | 1 | — | — | — | — | — | — | — | — | — | — |
| 345 | — | — | — | — | — | — | — | — | — | — | 69 | 1 |
| 350 | — | — | — | — | — | — | — | — | — | — | — | — |

BUILDERS OF PRECISION AND PRODUCTION



MACHINE TOOLS FOR MILLING AND BORING

TABLE 2 — LEADS — CONVENTIONAL LEAD ATTACHMENT

CAUTION Hand Feed Only. Do Not use Power Feed or Rapid Traverse with Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|-------|----|-----|----|-----|-------|----|-----|----|-----|-------|----|-----|----|-----|
| .670 | 24 | 86 | 24 | 100 | 1.637 | 32 | 100 | 44 | 86 | 2.121 | 24 | 44 | 28 | 72 |
| .781 | 24 | 86 | 28 | 100 | 1.650 | 24 | 64 | 44 | 100 | 2.133 | 24 | 100 | 64 | 72 |
| .800 | 24 | 72 | 24 | 100 | 1.667 | 24 | 64 | 32 | 72 | 2.143 | 24 | 56 | 32 | 64 |
| .893 | 24 | 86 | 32 | 100 | 1.674 | 24 | 40 | 24 | 86 | 2.171 | 24 | 72 | 56 | 86 |
| .900 | 24 | 64 | 24 | 100 | 1.680 | 24 | 40 | 28 | 100 | 2.178 | 28 | 100 | 56 | 72 |
| .930 | 24 | 72 | 24 | 86 | 1.706 | 24 | 72 | 44 | 86 | 2.182 | 24 | 44 | 40 | 100 |
| .933 | 24 | 72 | 28 | 100 | 1.711 | 28 | 72 | 44 | 100 | 2.188 | 24 | 48 | 28 | 64 |
| 1.029 | 24 | 56 | 24 | 100 | 1.714 | 24 | 56 | 40 | 100 | 2.193 | 24 | 56 | 44 | 86 |
| 1.042 | 28 | 86 | 32 | 100 | 1.744 | 24 | 64 | 40 | 86 | 2.200 | 32 | 64 | 44 | 100 |
| 1.047 | 24 | 64 | 24 | 86 | 1.745 | 24 | 44 | 32 | 100 | 2.222 | 28 | 56 | 32 | 72 |
| 1.050 | 24 | 64 | 28 | 100 | 1.750 | 28 | 64 | 40 | 100 | 2.233 | 24 | 40 | 32 | 86 |
| 1.067 | 24 | 72 | 32 | 100 | 1.776 | 24 | 44 | 28 | 86 | 2.238 | 28 | 64 | 44 | 86 |
| 1.085 | 24 | 72 | 28 | 86 | 1.778 | 32 | 72 | 40 | 100 | 2.240 | 28 | 40 | 32 | 100 |
| 1.116 | 24 | 100 | 40 | 86 | 1.786 | 24 | 100 | 64 | 86 | 2.250 | 24 | 40 | 24 | 64 |
| 1.196 | 24 | 56 | 24 | 86 | 1.800 | 24 | 64 | 48 | 100 | 2.274 | 32 | 72 | 44 | 86 |
| 1.200 | 24 | 64 | 32 | 100 | 1.809 | 28 | 72 | 40 | 86 | 2.286 | 32 | 56 | 40 | 100 |
| 1.221 | 24 | 64 | 28 | 86 | 1.818 | 24 | 44 | 24 | 72 | 2.292 | 24 | 64 | 44 | 72 |
| 1.228 | 24 | 100 | 44 | 86 | 1.823 | 28 | 100 | 56 | 86 | 2.326 | 32 | 64 | 40 | 86 |
| 1.240 | 24 | 72 | 32 | 86 | 1.860 | 28 | 56 | 32 | 86 | 2.333 | 24 | 40 | 28 | 72 |
| 1.244 | 28 | 72 | 32 | 100 | 1.861 | 24 | 72 | 48 | 86 | 2.338 | 24 | 44 | 24 | 56 |
| 1.250 | 24 | 64 | 24 | 72 | 1.867 | 24 | 72 | 56 | 100 | 2.344 | 28 | 100 | 72 | 86 |
| 1.302 | 28 | 100 | 40 | 86 | 1.875 | 24 | 56 | 28 | 64 | 2.368 | 28 | 44 | 32 | 86 |
| 1.309 | 24 | 44 | 24 | 100 | 1.886 | 24 | 56 | 44 | 100 | 2.381 | 32 | 100 | 64 | 86 |
| 1.333 | 24 | 72 | 40 | 100 | 1.905 | 24 | 56 | 32 | 72 | 2.386 | 24 | 44 | 28 | 64 |
| 1.340 | 24 | 100 | 48 | 86 | 1.919 | 24 | 64 | 44 | 86 | 2.392 | 24 | 56 | 48 | 86 |
| 1.371 | 24 | 56 | 32 | 100 | 1.920 | 24 | 40 | 32 | 100 | 2.400 | 32 | 64 | 48 | 100 |
| 1.395 | 24 | 64 | 32 | 86 | 1.925 | 28 | 64 | 44 | 100 | 2.424 | 24 | 44 | 32 | 72 |
| 1.400 | 28 | 64 | 32 | 100 | 1.944 | 28 | 64 | 32 | 72 | 2.431 | 28 | 64 | 40 | 72 |
| 1.429 | 24 | 56 | 24 | 72 | 1.954 | 24 | 40 | 28 | 86 | 2.442 | 24 | 64 | 56 | 86 |
| 1.433 | 28 | 100 | 44 | 86 | 1.956 | 32 | 72 | 44 | 100 | 2.445 | 40 | 72 | 44 | 100 |
| 1.440 | 24 | 40 | 24 | 100 | 1.990 | 28 | 72 | 44 | 86 | 2.450 | 28 | 64 | 56 | 100 |
| 1.447 | 28 | 72 | 32 | 86 | 1.993 | 24 | 56 | 40 | 86 | 2.456 | 44 | 100 | 48 | 86 |
| 1.458 | 24 | 64 | 28 | 72 | 2.000 | 24 | 40 | 24 | 72 | 2.481 | 24 | 72 | 64 | 86 |
| 1.467 | 24 | 72 | 44 | 100 | 2.009 | 24 | 100 | 72 | 86 | 2.489 | 28 | 100 | 64 | 72 |
| 1.488 | 32 | 100 | 40 | 86 | 2.030 | 24 | 44 | 32 | 86 | 2.500 | 24 | 64 | 48 | 72 |
| 1.500 | 24 | 64 | 40 | 100 | 2.035 | 28 | 64 | 40 | 86 | 2.514 | 32 | 56 | 44 | 100 |
| 1.522 | 24 | 44 | 24 | 86 | 2.036 | 28 | 44 | 32 | 100 | 2.532 | 28 | 72 | 56 | 86 |
| 1.527 | 24 | 44 | 28 | 100 | 2.045 | 24 | 44 | 24 | 64 | 2.537 | 24 | 44 | 40 | 86 |
| 1.550 | 24 | 72 | 40 | 86 | 2.047 | 40 | 100 | 44 | 86 | 2.546 | 28 | 44 | 40 | 100 |
| 1.556 | 28 | 72 | 40 | 100 | 2.057 | 24 | 56 | 48 | 100 | 2.558 | 32 | 64 | 44 | 86 |
| 1.563 | 24 | 100 | 56 | 86 | 2.067 | 32 | 72 | 40 | 86 | 2.567 | 28 | 48 | 44 | 100 |
| 1.595 | 24 | 56 | 32 | 86 | 2.083 | 24 | 64 | 40 | 72 | 2.571 | 24 | 40 | 24 | 56 |
| 1.600 | 24 | 72 | 48 | 100 | 2.084 | 28 | 100 | 64 | 86 | 2.593 | 28 | 48 | 32 | 72 |
| 1.607 | 24 | 56 | 24 | 64 | 2.093 | 24 | 86 | 48 | 64 | 2.605 | 40 | 100 | 56 | 86 |
| 1.628 | 28 | 64 | 32 | 86 | 2.100 | 24 | 64 | 56 | 100 | 2.618 | 24 | 44 | 48 | 100 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 2 (continued) — LEADS — CONVENTIONAL LEAD ATTACHMENT

CAUTION Do Not Use Power Feed for any Lead below 3.000 inches.
Do Not Use Rapid Traverse with Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|-------|----|-----|----|-----|-------|----|-----|----|-----|-------|-----|-----|----|-----|
| 2.619 | 24 | 56 | 44 | 72 | 3.117 | 24 | 44 | 32 | 56 | 3.582 | 44 | 40 | 28 | 86 |
| 2.625 | 24 | 40 | 28 | 64 | 3.125 | 28 | 56 | 40 | 64 | 3.588 | 24 | 86 | 72 | 56 |
| 2.640 | 24 | 40 | 44 | 100 | 3.126 | 48 | 100 | 56 | 86 | 3.600 | 32 | 100 | 72 | 64 |
| 2.658 | 32 | 56 | 40 | 86 | 3.140 | 24 | 86 | 72 | 64 | 3.618 | 56 | 72 | 40 | 86 |
| 2.667 | 24 | 40 | 32 | 72 | 3.143 | 40 | 56 | 44 | 100 | 3.636 | 24 | 44 | 32 | 48 |
| 2.674 | 28 | 64 | 44 | 72 | 3.150 | 28 | 100 | 72 | 64 | 3.637 | 48 | 44 | 24 | 72 |
| 2.678 | 24 | 56 | 40 | 64 | 3.175 | 32 | 56 | 40 | 72 | 3.646 | 40 | 48 | 28 | 64 |
| 2.679 | 32 | 100 | 72 | 86 | 3.182 | 28 | 44 | 32 | 64 | 3.655 | 40 | 56 | 44 | 86 |
| 2.700 | 24 | 100 | 72 | 64 | 3.189 | 32 | 56 | 48 | 86 | 3.657 | 32 | 56 | 64 | 100 |
| 2.713 | 28 | 48 | 40 | 86 | 3.198 | 40 | 64 | 44 | 86 | 3.663 | 72 | 64 | 28 | 86 |
| 2.727 | 24 | 44 | 32 | 64 | 3.200 | 28 | 100 | 64 | 56 | 3.667 | 44 | 40 | 24 | 72 |
| 2.743 | 24 | 56 | 64 | 100 | 3.214 | 24 | 56 | 48 | 64 | 3.673 | 24 | 28 | 24 | 56 |
| 2.750 | 40 | 64 | 44 | 100 | 3.225 | 24 | 100 | 86 | 64 | 3.684 | 44 | 100 | 72 | 86 |
| 2.778 | 32 | 64 | 40 | 72 | 3.241 | 28 | 48 | 40 | 72 | 3.686 | 24 | 100 | 86 | 56 |
| 2.791 | 32 | 64 | 48 | 86 | 3.256 | 24 | 86 | 56 | 48 | 3.704 | 32 | 48 | 40 | 72 |
| 2.800 | 32 | 64 | 56 | 100 | 3.267 | 28 | 48 | 56 | 100 | 3.721 | 28 | 86 | 64 | 56 |
| 2.812 | 24 | 32 | 24 | 64 | 3.273 | 24 | 40 | 24 | 44 | 3.733 | 48 | 100 | 56 | 72 |
| 2.828 | 28 | 44 | 32 | 72 | 3.275 | 44 | 100 | 64 | 86 | 3.750 | 28 | 56 | 48 | 64 |
| 2.843 | 40 | 72 | 44 | 86 | 3.281 | 24 | 32 | 28 | 64 | 3.763 | 28 | 100 | 86 | 64 |
| 2.845 | 32 | 100 | 64 | 72 | 3.300 | 44 | 64 | 48 | 100 | 3.771 | 44 | 56 | 48 | 100 |
| 2.849 | 28 | 64 | 56 | 86 | 3.308 | 32 | 72 | 64 | 86 | 3.799 | 28 | 86 | 56 | 48 |
| 2.857 | 24 | 48 | 32 | 56 | 3.333 | 28 | 48 | 32 | 56 | 3.809 | 24 | 56 | 64 | 72 |
| 2.865 | 44 | 100 | 56 | 86 | 3.345 | 28 | 100 | 86 | 72 | 3.810 | 32 | 72 | 48 | 56 |
| 2.867 | 24 | 100 | 86 | 72 | 3.349 | 40 | 100 | 72 | 86 | 3.818 | 24 | 40 | 28 | 44 |
| 2.880 | 24 | 40 | 48 | 100 | 3.360 | 48 | 40 | 28 | 100 | 3.819 | 40 | 72 | 44 | 64 |
| 2.894 | 28 | 72 | 64 | 86 | 3.383 | 32 | 44 | 40 | 86 | 3.822 | 32 | 100 | 86 | 72 |
| 2.909 | 32 | 44 | 40 | 100 | 3.403 | 28 | 64 | 56 | 72 | 3.837 | 44 | 86 | 48 | 64 |
| 2.917 | 28 | 48 | 32 | 64 | 3.409 | 24 | 44 | 40 | 64 | 3.840 | 64 | 40 | 24 | 100 |
| 2.924 | 32 | 56 | 44 | 86 | 3.411 | 44 | 72 | 48 | 86 | 3.850 | 44 | 64 | 56 | 100 |
| 2.933 | 44 | 72 | 48 | 100 | 3.422 | 44 | 100 | 56 | 72 | 3.876 | 100 | 72 | 24 | 86 |
| 2.934 | 32 | 48 | 44 | 100 | 3.428 | 24 | 40 | 32 | 56 | 3.889 | 32 | 72 | 56 | 64 |
| 2.946 | 24 | 56 | 44 | 64 | 3.429 | 40 | 56 | 48 | 100 | 3.896 | 24 | 44 | 40 | 56 |
| 2.950 | 28 | 44 | 40 | 86 | 3.438 | 28 | 56 | 44 | 64 | 3.907 | 28 | 40 | 48 | 86 |
| 2.977 | 40 | 100 | 64 | 86 | 3.488 | 40 | 64 | 48 | 86 | 3.911 | 44 | 100 | 64 | 72 |
| 2.984 | 28 | 48 | 44 | 86 | 3.491 | 64 | 44 | 24 | 100 | 3.920 | 28 | 40 | 56 | 100 |
| 3.000 | 24 | 40 | 28 | 56 | 3.492 | 32 | 56 | 44 | 72 | 3.927 | 72 | 44 | 24 | 100 |
| 3.030 | 24 | 44 | 40 | 72 | 3.500 | 28 | 40 | 32 | 64 | 3.929 | 32 | 56 | 44 | 64 |
| 3.044 | 24 | 44 | 48 | 86 | 3.520 | 32 | 40 | 44 | 100 | 3.977 | 28 | 44 | 40 | 64 |
| 3.055 | 24 | 44 | 56 | 100 | 3.535 | 28 | 44 | 40 | 72 | 3.979 | 44 | 86 | 56 | 72 |
| 3.056 | 32 | 64 | 44 | 72 | 3.552 | 48 | 44 | 28 | 86 | 3.987 | 40 | 56 | 48 | 86 |
| 3.070 | 24 | 40 | 44 | 86 | 3.556 | 40 | 100 | 64 | 72 | 4.000 | 24 | 40 | 32 | 48 |
| 3.080 | 28 | 40 | 44 | 100 | 3.564 | 56 | 44 | 28 | 100 | 4.011 | 28 | 48 | 44 | 64 |
| 3.086 | 24 | 100 | 72 | 56 | 3.565 | 28 | 48 | 44 | 72 | 4.019 | 72 | 100 | 48 | 86 |
| 3.101 | 40 | 72 | 48 | 86 | 3.571 | 32 | 56 | 40 | 64 | 4.040 | 32 | 44 | 40 | 72 |
| 3.111 | 40 | 100 | 56 | 72 | 3.572 | 48 | 100 | 64 | 86 | 4.059 | 32 | 44 | 48 | 86 |

TABLE 2 (continued) — LEADS — CONVENTIONAL LEAD ATTACHMENT

CAUTION Do Not Use Rapid Traverse With Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|-------|-----|-----|----|-----|-------|-----|-----|----|-----|-------|-----|-----|----|-----|
| 4.070 | 40 | 86 | 56 | 64 | 4.584 | 32 | 48 | 44 | 64 | 5.142 | 40 | 100 | 72 | 56 |
| 4.073 | 64 | 44 | 28 | 100 | 4.651 | 40 | 48 | 48 | 86 | 5.143 | 24 | 40 | 48 | 56 |
| 4.074 | 32 | 48 | 44 | 72 | 4.655 | 64 | 44 | 32 | 100 | 5.156 | 44 | 32 | 24 | 64 |
| 4.091 | 48 | 64 | 24 | 44 | 4.667 | 28 | 40 | 32 | 48 | 5.160 | 86 | 40 | 24 | 100 |
| 4.093 | 32 | 40 | 44 | 86 | 4.675 | 48 | 44 | 24 | 56 | 5.168 | 100 | 72 | 32 | 86 |
| 4.114 | 32 | 100 | 72 | 56 | 4.687 | 40 | 32 | 24 | 64 | 5.185 | 56 | 48 | 32 | 72 |
| 4.125 | 24 | 40 | 44 | 64 | 4.688 | 56 | 100 | 72 | 86 | 5.195 | 32 | 44 | 40 | 56 |
| 4.135 | 40 | 86 | 64 | 72 | 4.691 | 24 | 100 | 86 | 44 | 5.209 | 100 | 64 | 24 | 72 |
| 4.144 | 56 | 44 | 28 | 86 | 4.714 | 44 | 40 | 24 | 56 | 5.210 | 64 | 40 | 28 | 86 |
| 4.167 | 64 | 100 | 56 | 86 | 4.736 | 56 | 44 | 32 | 86 | 5.226 | 86 | 64 | 28 | 72 |
| 4.186 | 72 | 64 | 32 | 86 | 4.762 | 40 | 48 | 32 | 56 | 5.233 | 72 | 64 | 40 | 86 |
| 4.200 | 48 | 64 | 56 | 100 | 4.773 | 56 | 44 | 24 | 64 | 5.236 | 72 | 44 | 32 | 100 |
| 4.242 | 28 | 44 | 32 | 48 | 4.778 | 40 | 100 | 86 | 72 | 5.238 | 32 | 48 | 44 | 56 |
| 4.253 | 32 | 86 | 64 | 56 | 4.784 | 32 | 86 | 72 | 56 | 5.250 | 24 | 64 | 56 | 40 |
| 4.264 | 40 | 48 | 44 | 86 | 4.785 | 48 | 28 | 24 | 86 | 5.256 | 44 | 100 | 86 | 72 |
| 4.267 | 48 | 100 | 64 | 72 | 4.800 | 72 | 48 | 32 | 100 | 5.280 | 48 | 40 | 44 | 100 |
| 4.278 | 28 | 40 | 44 | 72 | 4.813 | 44 | 40 | 28 | 64 | 5.303 | 28 | 44 | 40 | 48 |
| 4.286 | 32 | 56 | 48 | 64 | 4.821 | 72 | 56 | 24 | 64 | 5.316 | 40 | 86 | 64 | 56 |
| 4.300 | 28 | 100 | 86 | 56 | 4.849 | 64 | 44 | 24 | 72 | 5.328 | 28 | 86 | 72 | 44 |
| 4.320 | 72 | 40 | 24 | 100 | 4.861 | 40 | 72 | 56 | 64 | 5.333 | 32 | 40 | 48 | 72 |
| 4.341 | 56 | 86 | 48 | 72 | 4.884 | 28 | 86 | 72 | 48 | 5.347 | 44 | 72 | 56 | 64 |
| 4.342 | 28 | 86 | 64 | 48 | 4.889 | 32 | 40 | 44 | 72 | 5.357 | 40 | 64 | 48 | 56 |
| 4.361 | 100 | 64 | 24 | 86 | 4.898 | 24 | 28 | 32 | 56 | 5.358 | 64 | 100 | 72 | 86 |
| 4.363 | 24 | 40 | 32 | 44 | 4.900 | 28 | 32 | 56 | 100 | 5.375 | 40 | 100 | 86 | 64 |
| 4.364 | 40 | 44 | 48 | 100 | 4.911 | 40 | 56 | 44 | 64 | 5.400 | 48 | 100 | 72 | 64 |
| 4.365 | 40 | 56 | 44 | 72 | 4.914 | 32 | 100 | 86 | 56 | 5.413 | 64 | 44 | 32 | 86 |
| 4.375 | 56 | 48 | 24 | 64 | 4.950 | 44 | 100 | 72 | 64 | 5.426 | 40 | 48 | 56 | 86 |
| 4.386 | 44 | 56 | 48 | 86 | 4.961 | 48 | 86 | 64 | 72 | 5.444 | 56 | 40 | 28 | 72 |
| 4.400 | 48 | 48 | 44 | 100 | 4.978 | 56 | 100 | 64 | 72 | 5.455 | 48 | 44 | 28 | 56 |
| 4.444 | 28 | 72 | 64 | 56 | 4.984 | 100 | 56 | 24 | 86 | 5.469 | 40 | 32 | 28 | 64 |
| 4.465 | 64 | 40 | 24 | 86 | 5.000 | 48 | 64 | 48 | 72 | 5.473 | 28 | 100 | 86 | 44 |
| 4.477 | 44 | 86 | 56 | 64 | 5.017 | 28 | 100 | 86 | 48 | 5.486 | 64 | 56 | 48 | 100 |
| 4.479 | 86 | 64 | 24 | 72 | 5.023 | 24 | 86 | 72 | 40 | 5.500 | 44 | 40 | 24 | 48 |
| 4.480 | 64 | 40 | 28 | 100 | 5.029 | 64 | 56 | 44 | 100 | 5.556 | 40 | 48 | 48 | 72 |
| 4.500 | 40 | 100 | 72 | 64 | 5.040 | 72 | 40 | 28 | 100 | 5.568 | 56 | 44 | 28 | 64 |
| 4.522 | 100 | 72 | 28 | 86 | 5.074 | 40 | 44 | 48 | 86 | 5.581 | 32 | 86 | 72 | 48 |
| 4.537 | 56 | 48 | 28 | 72 | 5.080 | 32 | 72 | 64 | 56 | 5.582 | 48 | 24 | 24 | 86 |
| 4.545 | 24 | 44 | 40 | 48 | 5.088 | 100 | 64 | 28 | 86 | 5.600 | 56 | 48 | 48 | 100 |
| 4.546 | 28 | 44 | 40 | 56 | 5.091 | 28 | 40 | 32 | 44 | 5.625 | 72 | 56 | 28 | 64 |
| 4.548 | 44 | 72 | 64 | 86 | 5.093 | 40 | 48 | 44 | 72 | 5.657 | 64 | 44 | 28 | 72 |
| 4.558 | 56 | 40 | 28 | 86 | 5.105 | 28 | 64 | 56 | 48 | 5.698 | 56 | 32 | 28 | 86 |
| 4.567 | 72 | 44 | 24 | 86 | 5.116 | 44 | 48 | 48 | 86 | 5.714 | 64 | 48 | 24 | 56 |
| 4.572 | 40 | 56 | 64 | 100 | 5.119 | 86 | 56 | 24 | 72 | 5.730 | 40 | 64 | 44 | 48 |
| 4.582 | 72 | 44 | 28 | 100 | 5.120 | 64 | 40 | 32 | 100 | 5.733 | 48 | 100 | 86 | 72 |
| 4.583 | 44 | 72 | 48 | 64 | 5.133 | 56 | 48 | 44 | 100 | 5.756 | 44 | 86 | 72 | 64 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 2 (continued) — LEADS — CONVENTIONAL LEAD ATTACHMENT

CAUTION Do Not Use Rapid Traverse With Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|-------|-----|-----|----|-----|-------|-----|-----|----|-----|-------|-----|-----|----|-----|
| 5.759 | 86 | 56 | 24 | 64 | 6.396 | 44 | 32 | 40 | 86 | 7.104 | 56 | 44 | 48 | 86 |
| 5.760 | 72 | 40 | 32 | 100 | 6.400 | 64 | 48 | 48 | 100 | 7.106 | 100 | 72 | 44 | 86 |
| 5.788 | 56 | 86 | 64 | 72 | 6.417 | 44 | 40 | 28 | 48 | 7.111 | 64 | 40 | 32 | 72 |
| 5.814 | 100 | 64 | 32 | 86 | 6.429 | 48 | 56 | 48 | 64 | 7.130 | 56 | 48 | 44 | 72 |
| 5.818 | 64 | 44 | 40 | 100 | 6.450 | 48 | 100 | 86 | 64 | 7.143 | 40 | 48 | 48 | 56 |
| 5.833 | 56 | 72 | 48 | 64 | 6.460 | 100 | 72 | 40 | 86 | 7.159 | 72 | 44 | 28 | 64 |
| 5.847 | 64 | 56 | 44 | 86 | 6.465 | 64 | 44 | 32 | 72 | 7.163 | 56 | 40 | 44 | 86 |
| 5.861 | 72 | 40 | 28 | 86 | 6.482 | 40 | 72 | 56 | 48 | 7.167 | 86 | 40 | 24 | 72 |
| 5.867 | 64 | 48 | 44 | 100 | 6.512 | 56 | 48 | 48 | 86 | 7.176 | 72 | 56 | 48 | 86 |
| 5.893 | 48 | 56 | 44 | 64 | 6.515 | 86 | 44 | 24 | 72 | 7.200 | 72 | 48 | 48 | 100 |
| 5.912 | 44 | 100 | 86 | 64 | 6.533 | 56 | 24 | 28 | 100 | 7.268 | 100 | 64 | 40 | 86 |
| 5.920 | 56 | 44 | 40 | 86 | 6.545 | 48 | 40 | 24 | 44 | 7.272 | 64 | 44 | 28 | 56 |
| 5.926 | 64 | 48 | 32 | 72 | 6.548 | 40 | 56 | 44 | 48 | 7.273 | 32 | 48 | 48 | 44 |
| 5.952 | 100 | 56 | 24 | 72 | 6.563 | 72 | 48 | 28 | 64 | 7.292 | 56 | 48 | 40 | 64 |
| 5.954 | 64 | 40 | 32 | 86 | 6.578 | 72 | 56 | 44 | 86 | 7.310 | 44 | 28 | 40 | 86 |
| 5.969 | 56 | 48 | 44 | 86 | 6.600 | 72 | 48 | 44 | 100 | 7.314 | 64 | 28 | 32 | 100 |
| 5.972 | 86 | 64 | 32 | 72 | 6.645 | 100 | 56 | 32 | 86 | 7.326 | 72 | 64 | 56 | 86 |
| 5.980 | 72 | 56 | 40 | 86 | 6.667 | 64 | 48 | 28 | 56 | 7.330 | 86 | 44 | 24 | 64 |
| 6.000 | 48 | 40 | 28 | 56 | 6.689 | 56 | 100 | 86 | 72 | 7.333 | 48 | 40 | 44 | 72 |
| 6.016 | 44 | 32 | 28 | 64 | 6.697 | 100 | 56 | 24 | 64 | 7.334 | 44 | 40 | 32 | 48 |
| 6.020 | 28 | 100 | 86 | 40 | 6.698 | 72 | 40 | 32 | 86 | 7.347 | 48 | 28 | 24 | 56 |
| 6.061 | 40 | 44 | 32 | 48 | 6.719 | 28 | 64 | 86 | 56 | 7.371 | 48 | 100 | 86 | 56 |
| 6.077 | 100 | 64 | 28 | 72 | 6.720 | 56 | 40 | 48 | 100 | 7.400 | 100 | 44 | 28 | 86 |
| 6.089 | 32 | 86 | 72 | 44 | 6.735 | 44 | 28 | 24 | 56 | 7.408 | 64 | 48 | 40 | 72 |
| 6.109 | 56 | 44 | 48 | 100 | 6.750 | 24 | 64 | 72 | 40 | 7.424 | 56 | 44 | 28 | 48 |
| 6.112 | 48 | 48 | 44 | 72 | 6.757 | 44 | 100 | 86 | 56 | 7.442 | 64 | 48 | 48 | 86 |
| 6.122 | 40 | 28 | 24 | 56 | 6.766 | 64 | 44 | 40 | 86 | 7.465 | 86 | 64 | 40 | 72 |
| 6.125 | 56 | 40 | 28 | 64 | 6.784 | 100 | 48 | 28 | 86 | 7.467 | 64 | 48 | 56 | 100 |
| 6.137 | 72 | 44 | 24 | 64 | 6.806 | 56 | 32 | 28 | 72 | 7.500 | 72 | 48 | 32 | 64 |
| 6.140 | 48 | 40 | 44 | 86 | 6.818 | 40 | 64 | 48 | 44 | 7.525 | 56 | 100 | 86 | 64 |
| 6.143 | 40 | 100 | 86 | 56 | 6.822 | 44 | 86 | 64 | 48 | 7.543 | 48 | 28 | 44 | 100 |
| 6.160 | 56 | 40 | 44 | 100 | 6.825 | 86 | 56 | 32 | 72 | 7.576 | 100 | 44 | 24 | 72 |
| 6.171 | 48 | 100 | 72 | 56 | 6.857 | 64 | 40 | 24 | 56 | 7.597 | 56 | 24 | 28 | 86 |
| 6.202 | 40 | 86 | 64 | 48 | 6.875 | 44 | 48 | 48 | 64 | 7.601 | 86 | 44 | 28 | 72 |
| 6.222 | 28 | 72 | 64 | 40 | 6.880 | 32 | 100 | 86 | 40 | 7.611 | 72 | 44 | 40 | 86 |
| 6.234 | 48 | 44 | 32 | 56 | 6.944 | 100 | 64 | 32 | 72 | 7.619 | 64 | 48 | 32 | 56 |
| 6.250 | 40 | 48 | 48 | 64 | 6.945 | 100 | 56 | 28 | 72 | 7.620 | 64 | 56 | 48 | 72 |
| 6.255 | 32 | 100 | 86 | 44 | 6.968 | 86 | 48 | 28 | 72 | 7.636 | 56 | 40 | 24 | 44 |
| 6.279 | 48 | 86 | 72 | 64 | 6.977 | 72 | 48 | 40 | 86 | 7.639 | 44 | 32 | 40 | 72 |
| 6.286 | 44 | 40 | 32 | 56 | 6.982 | 64 | 44 | 48 | 100 | 7.644 | 64 | 100 | 86 | 72 |
| 6.300 | 56 | 100 | 72 | 64 | 6.984 | 44 | 72 | 64 | 56 | 7.657 | 56 | 32 | 28 | 64 |
| 6.343 | 100 | 44 | 24 | 86 | 7.000 | 32 | 64 | 56 | 40 | 7.674 | 72 | 48 | 44 | 86 |
| 6.350 | 40 | 72 | 64 | 56 | 7.013 | 72 | 44 | 24 | 56 | 7.675 | 48 | 32 | 44 | 86 |
| 6.364 | 56 | 44 | 24 | 48 | 7.040 | 64 | 40 | 44 | 100 | 7.679 | 86 | 48 | 24 | 56 |
| 6.379 | 48 | 86 | 64 | 56 | 7.071 | 56 | 44 | 40 | 72 | 7.680 | 64 | 40 | 48 | 100 |

TABLE 2 (continued) - LEADS - CONVENTIONAL LEAD ATTACHMENT

CAUTION Do Not Use Rapid Traverse With Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|-------|-----|-----|----|-----|-------|-----|----|----|-----|-------|-----|-----|----|-----|
| 7.700 | 56 | 32 | 44 | 100 | 8.457 | 100 | 44 | 32 | 86 | 9.302 | 48 | 24 | 40 | 86 |
| 7.714 | 72 | 40 | 24 | 56 | 8.485 | 56 | 44 | 32 | 48 | 9.303 | 100 | 40 | 32 | 86 |
| 7.752 | 100 | 72 | 48 | 86 | 8.506 | 64 | 28 | 32 | 86 | 9.333 | 64 | 40 | 28 | 48 |
| 7.778 | 56 | 48 | 48 | 72 | 8.523 | 100 | 44 | 24 | 64 | 9.351 | 72 | 44 | 32 | 56 |
| 7.792 | 48 | 44 | 40 | 56 | 8.527 | 44 | 24 | 40 | 86 | 9.375 | 72 | 48 | 40 | 64 |
| 7.813 | 100 | 56 | 28 | 64 | 8.532 | 86 | 56 | 40 | 72 | 9.382 | 48 | 100 | 86 | 44 |
| 7.815 | 56 | 40 | 48 | 86 | 8.534 | 64 | 24 | 32 | 100 | 9.385 | 86 | 56 | 44 | 72 |
| 7.818 | 40 | 100 | 86 | 44 | 8.552 | 86 | 44 | 28 | 64 | 9.406 | 86 | 40 | 28 | 64 |
| 7.838 | 86 | 48 | 28 | 64 | 8.556 | 56 | 40 | 44 | 72 | 9.428 | 44 | 28 | 24 | 40 |
| 7.855 | 72 | 44 | 48 | 100 | 8.572 | 72 | 48 | 32 | 56 | 9.429 | 48 | 40 | 44 | 56 |
| 7.857 | 44 | 48 | 48 | 56 | 8.594 | 44 | 32 | 40 | 64 | 9.460 | 44 | 100 | 86 | 40 |
| 7.872 | 44 | 28 | 32 | 64 | 8.600 | 86 | 48 | 48 | 100 | 9.472 | 56 | 44 | 64 | 86 |
| 7.875 | 72 | 40 | 28 | 64 | 8.640 | 72 | 40 | 48 | 100 | 9.524 | 64 | 48 | 40 | 56 |
| 7.883 | 44 | 100 | 86 | 48 | 8.681 | 100 | 64 | 40 | 72 | 9.545 | 56 | 44 | 48 | 64 |
| 7.920 | 72 | 40 | 44 | 100 | 8.682 | 64 | 48 | 56 | 86 | 9.549 | 100 | 64 | 44 | 72 |
| 7.936 | 100 | 56 | 32 | 72 | 8.687 | 86 | 44 | 32 | 72 | 9.556 | 86 | 40 | 32 | 72 |
| 7.954 | 40 | 64 | 56 | 44 | 8.721 | 100 | 64 | 48 | 86 | 9.569 | 72 | 56 | 64 | 86 |
| 7.963 | 86 | 48 | 32 | 72 | 8.727 | 48 | 40 | 32 | 44 | 9.598 | 86 | 56 | 40 | 64 |
| 7.974 | 48 | 28 | 40 | 86 | 8.730 | 44 | 28 | 40 | 72 | 9.600 | 72 | 48 | 64 | 100 |
| 7.994 | 100 | 64 | 44 | 86 | 8.750 | 56 | 48 | 48 | 64 | 9.625 | 56 | 40 | 44 | 64 |
| 8.000 | 32 | 48 | 48 | 40 | 8.772 | 48 | 28 | 44 | 86 | 9.643 | 72 | 56 | 48 | 64 |
| 8.021 | 56 | 48 | 44 | 64 | 8.800 | 64 | 32 | 44 | 100 | 9.675 | 72 | 100 | 86 | 64 |
| 8.035 | 72 | 56 | 40 | 64 | 8.838 | 100 | 44 | 28 | 72 | 9.690 | 100 | 48 | 40 | 86 |
| 8.063 | 86 | 40 | 24 | 64 | 8.839 | 72 | 56 | 44 | 64 | 9.697 | 64 | 48 | 32 | 44 |
| 8.081 | 64 | 44 | 40 | 72 | 8.889 | 64 | 48 | 48 | 72 | 9.723 | 56 | 32 | 40 | 72 |
| 8.102 | 100 | 48 | 28 | 72 | 8.909 | 56 | 40 | 28 | 44 | 9.741 | 100 | 44 | 24 | 56 |
| 8.119 | 48 | 86 | 64 | 44 | 8.929 | 100 | 56 | 32 | 64 | 9.768 | 72 | 48 | 56 | 86 |
| 8.140 | 100 | 40 | 28 | 86 | 8.930 | 48 | 86 | 64 | 40 | 9.773 | 86 | 44 | 32 | 64 |
| 8.145 | 64 | 44 | 56 | 100 | 8.953 | 56 | 32 | 44 | 86 | 9.778 | 64 | 40 | 44 | 72 |
| 8.148 | 64 | 48 | 44 | 72 | 8.959 | 86 | 64 | 48 | 72 | 9.796 | 64 | 28 | 24 | 56 |
| 8.163 | 40 | 28 | 32 | 56 | 8.960 | 64 | 40 | 56 | 100 | 9.818 | 72 | 40 | 24 | 44 |
| 8.167 | 56 | 40 | 28 | 48 | 8.980 | 44 | 28 | 32 | 56 | 9.822 | 44 | 32 | 40 | 56 |
| 8.182 | 72 | 44 | 32 | 64 | 9.000 | 72 | 40 | 28 | 56 | 9.828 | 64 | 100 | 86 | 56 |
| 8.186 | 64 | 40 | 44 | 86 | 9.044 | 100 | 72 | 56 | 86 | 9.844 | 72 | 32 | 28 | 64 |
| 8.212 | 86 | 64 | 44 | 72 | 9.074 | 56 | 24 | 28 | 72 | 9.900 | 72 | 32 | 44 | 100 |
| 8.229 | 64 | 100 | 72 | 56 | 9.091 | 40 | 48 | 48 | 44 | 9.921 | 100 | 56 | 40 | 72 |
| 8.250 | 48 | 40 | 44 | 64 | 9.115 | 100 | 48 | 28 | 64 | 9.923 | 64 | 24 | 32 | 86 |
| 8.306 | 100 | 56 | 40 | 86 | 9.134 | 72 | 44 | 48 | 86 | 9.943 | 100 | 44 | 28 | 64 |
| 8.312 | 64 | 44 | 32 | 56 | 9.137 | 100 | 56 | 44 | 86 | 9.954 | 86 | 48 | 40 | 72 |
| 8.333 | 40 | 24 | 32 | 64 | 9.143 | 64 | 40 | 32 | 56 | 9.967 | 100 | 56 | 48 | 86 |
| 8.361 | 86 | 40 | 28 | 72 | 9.164 | 72 | 44 | 56 | 100 | | | | | |
| 8.372 | 72 | 48 | 48 | 86 | 9.167 | 44 | 24 | 24 | 48 | | | | | |
| 8.377 | 86 | 44 | 24 | 56 | 9.210 | 72 | 40 | 44 | 86 | | | | | |
| 8.400 | 72 | 48 | 56 | 100 | 9.214 | 86 | 40 | 24 | 56 | | | | | |
| 8.437 | 72 | 32 | 24 | 64 | 9.260 | 100 | 48 | 32 | 72 | | | | | |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 2 (continued) — LEADS — CONVENTIONAL LEAD ATTACHMENT

NOTE Power Feed and Rapid Traverse May Be Used with All Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|--------|-----|-----|----|-----|--------|-----|-----|----|-----|--------|-----|-----|----|-----|
| 10.000 | 64 | 32 | 28 | 56 | 10.913 | 100 | 56 | 44 | 72 | 11.944 | 86 | 48 | 48 | 72 |
| 10.033 | 56 | 100 | 86 | 48 | 10.937 | 100 | 40 | 28 | 64 | 11.960 | 72 | 28 | 40 | 86 |
| 10.046 | 72 | 40 | 48 | 86 | 10.945 | 56 | 100 | 86 | 44 | 12.000 | 72 | 40 | 32 | 48 |
| 10.057 | 64 | 28 | 44 | 100 | 10.949 | 86 | 48 | 44 | 72 | 12.031 | 56 | 32 | 44 | 64 |
| 10.078 | 86 | 32 | 24 | 64 | 10.972 | 64 | 28 | 48 | 100 | 12.040 | 56 | 100 | 86 | 40 |
| 10.080 | 72 | 40 | 56 | 100 | 11.000 | 44 | 48 | 48 | 40 | 12.121 | 64 | 44 | 40 | 48 |
| 10.101 | 100 | 44 | 32 | 72 | 11.021 | 72 | 28 | 24 | 56 | 12.153 | 100 | 64 | 56 | 72 |
| 10.159 | 64 | 28 | 32 | 72 | 11.057 | 72 | 100 | 86 | 56 | 12.178 | 72 | 44 | 64 | 86 |
| 10.175 | 100 | 64 | 56 | 86 | 11.111 | 64 | 32 | 40 | 72 | 12.216 | 86 | 44 | 40 | 64 |
| 10.182 | 64 | 40 | 28 | 44 | 11.137 | 56 | 32 | 28 | 44 | 12.222 | 64 | 32 | 44 | 72 |
| 10.186 | 44 | 24 | 40 | 72 | 11.160 | 100 | 56 | 40 | 64 | 12.245 | 48 | 28 | 40 | 56 |
| 10.209 | 56 | 32 | 28 | 48 | 11.163 | 72 | 48 | 64 | 86 | 12.250 | 56 | 32 | 28 | 40 |
| 10.228 | 72 | 44 | 40 | 64 | 11.169 | 86 | 44 | 32 | 56 | 12.272 | 72 | 64 | 48 | 44 |
| 10.233 | 64 | 32 | 44 | 86 | 11.198 | 86 | 48 | 40 | 64 | 12.277 | 100 | 56 | 44 | 64 |
| 10.238 | 48 | 72 | 86 | 56 | 11.200 | 64 | 32 | 56 | 100 | 12.286 | 86 | 40 | 32 | 56 |
| 10.267 | 56 | 24 | 44 | 100 | 11.225 | 44 | 28 | 40 | 56 | 12.318 | 86 | 48 | 44 | 64 |
| 10.286 | 72 | 40 | 32 | 56 | 11.250 | 72 | 48 | 48 | 64 | 12.343 | 72 | 28 | 48 | 100 |
| 10.312 | 48 | 32 | 44 | 64 | 11.313 | 64 | 44 | 56 | 72 | 12.375 | 72 | 40 | 44 | 64 |
| 10.313 | 72 | 48 | 44 | 64 | 11.314 | 72 | 28 | 44 | 100 | 12.403 | 64 | 24 | 40 | 86 |
| 10.320 | 48 | 100 | 86 | 40 | 11.363 | 100 | 44 | 32 | 64 | 12.444 | 64 | 40 | 56 | 72 |
| 10.336 | 100 | 72 | 64 | 86 | 11.401 | 86 | 44 | 28 | 48 | 12.468 | 64 | 44 | 48 | 56 |
| 10.370 | 64 | 48 | 56 | 72 | 11.429 | 64 | 48 | 48 | 56 | 12.500 | 100 | 40 | 32 | 64 |
| 10.390 | 64 | 44 | 40 | 56 | 11.454 | 72 | 40 | 28 | 44 | 12.509 | 64 | 100 | 86 | 44 |
| 10.417 | 100 | 64 | 48 | 72 | 11.459 | 44 | 32 | 40 | 48 | 12.542 | 86 | 40 | 28 | 48 |
| 10.419 | 64 | 40 | 56 | 86 | 11.467 | 64 | 100 | 86 | 48 | 12.558 | 72 | 32 | 48 | 86 |
| 10.451 | 86 | 64 | 56 | 72 | 11.512 | 72 | 32 | 44 | 86 | 12.571 | 64 | 40 | 44 | 56 |
| 10.467 | 72 | 32 | 40 | 86 | 11.518 | 86 | 56 | 48 | 64 | 12.572 | 44 | 56 | 64 | 40 |
| 10.473 | 72 | 44 | 64 | 100 | 11.520 | 72 | 40 | 64 | 100 | 12.600 | 72 | 32 | 56 | 100 |
| 10.476 | 64 | 48 | 44 | 56 | 11.574 | 100 | 48 | 40 | 72 | 12.627 | 100 | 44 | 40 | 72 |
| 10.500 | 56 | 40 | 48 | 64 | 11.629 | 100 | 48 | 48 | 86 | 12.686 | 100 | 44 | 48 | 86 |
| 10.558 | 86 | 56 | 44 | 64 | 11.638 | 64 | 40 | 32 | 44 | 12.698 | 64 | 28 | 40 | 72 |
| 10.571 | 100 | 44 | 40 | 86 | 11.667 | 56 | 24 | 32 | 64 | 12.727 | 64 | 32 | 28 | 44 |
| 10.606 | 56 | 44 | 40 | 48 | 11.688 | 72 | 44 | 40 | 56 | 12.728 | 56 | 48 | 48 | 44 |
| 10.631 | 64 | 28 | 40 | 86 | 11.695 | 64 | 28 | 44 | 86 | 12.732 | 100 | 48 | 44 | 72 |
| 10.655 | 72 | 44 | 56 | 86 | 11.719 | 100 | 32 | 24 | 64 | 12.758 | 64 | 28 | 48 | 86 |
| 10.659 | 100 | 48 | 44 | 86 | 11.721 | 72 | 40 | 56 | 86 | 12.791 | 100 | 40 | 44 | 86 |
| 10.667 | 64 | 40 | 48 | 72 | 11.728 | 86 | 40 | 24 | 44 | 12.798 | 86 | 48 | 40 | 56 |
| 10.694 | 44 | 48 | 56 | 48 | 11.733 | 64 | 24 | 44 | 100 | 12.800 | 64 | 28 | 56 | 100 |
| 10.713 | 40 | 28 | 48 | 64 | 11.757 | 86 | 32 | 28 | 64 | 12.834 | 44 | 48 | 56 | 40 |
| 10.714 | 72 | 48 | 40 | 56 | 11.785 | 72 | 48 | 44 | 56 | 12.857 | 72 | 28 | 32 | 64 |
| 10.750 | 86 | 40 | 32 | 64 | 11.786 | 48 | 32 | 44 | 56 | 12.858 | 48 | 56 | 48 | 32 |
| 10.800 | 72 | 32 | 48 | 100 | 11.825 | 86 | 32 | 44 | 100 | 12.900 | 72 | 100 | 86 | 48 |
| 10.853 | 56 | 24 | 40 | 86 | 11.852 | 64 | 24 | 32 | 72 | 12.963 | 56 | 24 | 40 | 72 |
| 10.859 | 86 | 44 | 40 | 72 | 11.905 | 100 | 56 | 48 | 72 | 12.987 | 100 | 44 | 32 | 56 |
| 10.909 | 64 | 32 | 24 | 44 | 11.938 | 56 | 24 | 44 | 86 | 13.020 | 100 | 48 | 40 | 64 |

TABLE 2 (continued) — LEADS — CONVENTIONAL LEAD ATTACHMENT

NOTE Power Feed and Rapid Traverse May Be Used with All Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|--------|-----|-----|----|-----|--------|-----|-----|----|-----|--------|-----|----|----|-----|
| 13.024 | 64 | 32 | 56 | 86 | 14.286 | 100 | 40 | 32 | 56 | 15.677 | 86 | 48 | 56 | 64 |
| 13.030 | 86 | 44 | 48 | 72 | 14.318 | 72 | 64 | 56 | 44 | 15.714 | 64 | 32 | 44 | 56 |
| 13.062 | 64 | 28 | 32 | 56 | 14.319 | 72 | 44 | 56 | 64 | 15.750 | 72 | 40 | 56 | 64 |
| 13.082 | 100 | 64 | 72 | 86 | 14.322 | 100 | 48 | 44 | 64 | 15.767 | 86 | 24 | 44 | 100 |
| 13.090 | 72 | 40 | 32 | 44 | 14.333 | 86 | 40 | 48 | 72 | 15.873 | 100 | 56 | 64 | 72 |
| 13.096 | 44 | 24 | 40 | 56 | 14.352 | 72 | 28 | 48 | 86 | 15.874 | 100 | 56 | 64 | 72 |
| 13.125 | 72 | 48 | 56 | 64 | 14.400 | 72 | 32 | 64 | 100 | 15.909 | 56 | 32 | 40 | 44 |
| 13.139 | 86 | 40 | 44 | 72 | 14.536 | 100 | 32 | 40 | 86 | 15.926 | 86 | 48 | 64 | 72 |
| 13.157 | 72 | 28 | 44 | 86 | 14.545 | 64 | 48 | 48 | 44 | 15.989 | 100 | 32 | 44 | 86 |
| 13.163 | 86 | 28 | 24 | 56 | 14.583 | 56 | 24 | 40 | 64 | 16.000 | 64 | 48 | 48 | 40 |
| 13.200 | 72 | 24 | 44 | 100 | 14.651 | 72 | 32 | 56 | 86 | 16.042 | 56 | 32 | 44 | 48 |
| 13.258 | 100 | 44 | 28 | 48 | 14.659 | 86 | 44 | 48 | 64 | 16.071 | 72 | 28 | 40 | 64 |
| 13.289 | 100 | 56 | 64 | 86 | 14.667 | 64 | 40 | 44 | 48 | 16.125 | 86 | 40 | 48 | 64 |
| 13.333 | 64 | 32 | 48 | 72 | 14.694 | 72 | 28 | 32 | 56 | 16.204 | 100 | 48 | 56 | 72 |
| 13.393 | 100 | 56 | 48 | 64 | 14.743 | 86 | 28 | 48 | 100 | 16.233 | 100 | 44 | 40 | 56 |
| 13.396 | 72 | 40 | 64 | 86 | 14.780 | 86 | 40 | 44 | 64 | 16.280 | 100 | 40 | 56 | 86 |
| 13.437 | 86 | 32 | 28 | 56 | 14.800 | 100 | 44 | 56 | 86 | 16.288 | 86 | 44 | 40 | 48 |
| 13.438 | 86 | 48 | 48 | 64 | 14.815 | 64 | 24 | 40 | 72 | 16.296 | 64 | 24 | 44 | 72 |
| 13.469 | 48 | 28 | 44 | 56 | 14.849 | 56 | 24 | 28 | 44 | 16.327 | 64 | 28 | 40 | 56 |
| 13.500 | 72 | 40 | 48 | 64 | 14.880 | 100 | 48 | 40 | 56 | 16.333 | 56 | 24 | 28 | 40 |
| 13.514 | 86 | 28 | 44 | 100 | 14.884 | 64 | 28 | 56 | 86 | 16.364 | 72 | 48 | 48 | 44 |
| 13.566 | 100 | 48 | 56 | 86 | 14.931 | 86 | 32 | 40 | 72 | 16.370 | 100 | 48 | 44 | 56 |
| 13.611 | 56 | 24 | 28 | 48 | 14.933 | 64 | 24 | 56 | 100 | 16.423 | 86 | 32 | 44 | 72 |
| 13.636 | 72 | 44 | 40 | 48 | 14.950 | 100 | 56 | 72 | 86 | 16.456 | 72 | 28 | 64 | 100 |
| 13.643 | 64 | 24 | 44 | 86 | 15.000 | 72 | 24 | 28 | 56 | 16.500 | 72 | 40 | 44 | 48 |
| 13.650 | 86 | 56 | 64 | 72 | 15.050 | 86 | 32 | 56 | 100 | 16.612 | 100 | 28 | 40 | 86 |
| 13.672 | 100 | 32 | 28 | 64 | 15.150 | 100 | 44 | 32 | 48 | 16.623 | 64 | 28 | 32 | 44 |
| 13.682 | 86 | 40 | 28 | 44 | 15.151 | 100 | 44 | 48 | 72 | 16.667 | 100 | 40 | 48 | 72 |
| 13.713 | 64 | 40 | 48 | 56 | 15.202 | 86 | 44 | 56 | 72 | 16.722 | 86 | 40 | 56 | 72 |
| 13.715 | 64 | 56 | 48 | 40 | 15.238 | 64 | 28 | 48 | 72 | 16.744 | 72 | 32 | 64 | 86 |
| 13.750 | 44 | 48 | 48 | 32 | 15.239 | 64 | 24 | 32 | 56 | 16.753 | 86 | 44 | 48 | 56 |
| 13.760 | 86 | 40 | 64 | 100 | 15.272 | 56 | 40 | 48 | 44 | 16.797 | 86 | 32 | 40 | 64 |
| 13.889 | 100 | 48 | 48 | 72 | 15.278 | 44 | 24 | 40 | 48 | 16.800 | 72 | 24 | 56 | 100 |
| 13.935 | 86 | 48 | 56 | 72 | 15.279 | 100 | 40 | 44 | 72 | 16.875 | 72 | 32 | 48 | 64 |
| 13.953 | 100 | 40 | 48 | 86 | 15.306 | 100 | 28 | 24 | 56 | 16.892 | 86 | 40 | 44 | 56 |
| 13.960 | 86 | 44 | 40 | 56 | 15.349 | 72 | 24 | 44 | 86 | 16.914 | 100 | 44 | 64 | 86 |
| 13.968 | 64 | 28 | 44 | 72 | 15.357 | 86 | 48 | 48 | 56 | 16.970 | 64 | 48 | 56 | 44 |
| 14.000 | 56 | 48 | 48 | 40 | 15.429 | 72 | 40 | 48 | 56 | 17.045 | 100 | 44 | 48 | 64 |
| 14.026 | 72 | 44 | 48 | 56 | 15.469 | 72 | 32 | 44 | 64 | 17.062 | 86 | 28 | 40 | 72 |
| 14.063 | 72 | 32 | 40 | 64 | 15.480 | 72 | 100 | 86 | 40 | 17.102 | 86 | 44 | 56 | 64 |
| 14.071 | 72 | 100 | 86 | 44 | 15.504 | 100 | 48 | 64 | 86 | 17.143 | 64 | 56 | 48 | 32 |
| 14.078 | 86 | 48 | 44 | 56 | 15.556 | 64 | 48 | 56 | 48 | 17.188 | 100 | 40 | 44 | 64 |
| 14.142 | 72 | 40 | 44 | 56 | 15.584 | 48 | 28 | 40 | 44 | 17.200 | 86 | 32 | 64 | 100 |
| 14.204 | 100 | 44 | 40 | 64 | 15.625 | 100 | 48 | 48 | 64 | 17.275 | 86 | 56 | 72 | 64 |
| 14.260 | 56 | 24 | 44 | 72 | 15.636 | 86 | 40 | 32 | 44 | 17.361 | 100 | 32 | 40 | 72 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 2 (continued) — LEADS — CONVENTIONAL LEAD ATTACHMENT

NOTE Power Feed and Rapid Traverse May Be Used with All Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|--------|-----|----|----|-----|--------|-----|----|----|-----|-------|-----|----|----|-----|
| 17.364 | 64 | 24 | 56 | 86 | 19.394 | 64 | 24 | 32 | 44 | 21.82 | 100 | 28 | 44 | 72 |
| 17.373 | 86 | 44 | 64 | 72 | 19.444 | 100 | 40 | 56 | 72 | 21.88 | 100 | 40 | 56 | 64 |
| 17.442 | 100 | 48 | 72 | 86 | 19.480 | 100 | 44 | 48 | 56 | 21.90 | 86 | 24 | 44 | 72 |
| 17.454 | 64 | 40 | 48 | 44 | 19.531 | 100 | 32 | 40 | 64 | 21.94 | 86 | 28 | 40 | 56 |
| 17.500 | 56 | 48 | 48 | 32 | 19.535 | 72 | 24 | 56 | 86 | 21.99 | 86 | 44 | 72 | 64 |
| 17.550 | 86 | 28 | 32 | 56 | 19.545 | 86 | 48 | 48 | 44 | 22.00 | 64 | 32 | 44 | 40 |
| 17.677 | 100 | 44 | 56 | 72 | 19.590 | 64 | 28 | 48 | 56 | 22.04 | 72 | 28 | 48 | 56 |
| 17.679 | 72 | 28 | 44 | 64 | 19.635 | 72 | 40 | 48 | 44 | 22.11 | 86 | 28 | 72 | 100 |
| 17.778 | 64 | 28 | 56 | 72 | 19.642 | 100 | 40 | 44 | 56 | 22.22 | 100 | 40 | 64 | 72 |
| 17.858 | 100 | 28 | 32 | 64 | 19.643 | 44 | 28 | 40 | 32 | 22.32 | 100 | 28 | 40 | 64 |
| 17.917 | 86 | 24 | 28 | 56 | 19.656 | 86 | 28 | 64 | 100 | 22.34 | 86 | 44 | 64 | 56 |
| 17.918 | 86 | 32 | 48 | 72 | 19.687 | 72 | 32 | 56 | 64 | 22.40 | 86 | 24 | 40 | 64 |
| 17.959 | 64 | 28 | 44 | 56 | 19.710 | 86 | 40 | 44 | 48 | 22.50 | 72 | 28 | 56 | 64 |
| 18.000 | 72 | 48 | 48 | 40 | 19.840 | 100 | 28 | 40 | 72 | 22.73 | 100 | 48 | 48 | 44 |
| 18.181 | 100 | 40 | 32 | 44 | 19.886 | 100 | 44 | 56 | 64 | 22.80 | 86 | 48 | 56 | 44 |
| 18.182 | 48 | 24 | 40 | 44 | 19.908 | 86 | 24 | 40 | 72 | 22.86 | 64 | 48 | 48 | 28 |
| 18.229 | 100 | 48 | 56 | 64 | 19.934 | 100 | 28 | 48 | 86 | 22.91 | 72 | 44 | 56 | 40 |
| 18.273 | 100 | 28 | 44 | 86 | 20.00 | 64 | 48 | 48 | 32 | 22.92 | 100 | 40 | 44 | 48 |
| 18.285 | 64 | 28 | 32 | 40 | 20.07 | 86 | 24 | 56 | 100 | 22.93 | 86 | 24 | 64 | 100 |
| 18.333 | 64 | 32 | 44 | 48 | 20.09 | 100 | 56 | 72 | 64 | 23.04 | 86 | 32 | 48 | 56 |
| 18.367 | 72 | 28 | 40 | 56 | 20.16 | 86 | 48 | 72 | 64 | 23.14 | 100 | 24 | 40 | 72 |
| 18.428 | 86 | 40 | 48 | 56 | 20.20 | 100 | 44 | 64 | 72 | 23.26 | 100 | 32 | 64 | 86 |
| 18.476 | 86 | 32 | 44 | 64 | 20.35 | 100 | 32 | 56 | 86 | 23.33 | 64 | 32 | 56 | 48 |
| 18.519 | 100 | 48 | 64 | 72 | 20.36 | 64 | 40 | 56 | 44 | 23.38 | 72 | 28 | 40 | 44 |
| 18.605 | 100 | 40 | 64 | 86 | 20.41 | 100 | 28 | 32 | 56 | 23.44 | 100 | 48 | 72 | 64 |
| 18.663 | 100 | 64 | 86 | 72 | 20.42 | 56 | 24 | 28 | 32 | 23.45 | 86 | 40 | 48 | 44 |
| 18.667 | 64 | 40 | 56 | 48 | 20.45 | 72 | 32 | 40 | 44 | 23.52 | 86 | 32 | 56 | 64 |
| 18.700 | 72 | 44 | 64 | 56 | 20.48 | 86 | 48 | 64 | 56 | 23.57 | 72 | 24 | 44 | 56 |
| 18.750 | 100 | 40 | 48 | 64 | 20.57 | 72 | 40 | 64 | 56 | 23.81 | 100 | 28 | 48 | 72 |
| 18.770 | 86 | 28 | 44 | 72 | 20.63 | 72 | 24 | 44 | 64 | 23.89 | 86 | 32 | 64 | 72 |
| 18.812 | 86 | 40 | 56 | 64 | 20.74 | 64 | 24 | 56 | 72 | 24.00 | 100 | 56 | 86 | 64 |
| 18.858 | 48 | 28 | 44 | 40 | 20.78 | 64 | 28 | 40 | 44 | 24.13 | 86 | 28 | 44 | 56 |
| 18.939 | 100 | 44 | 40 | 28 | 20.83 | 100 | 32 | 48 | 72 | 24.19 | 86 | 40 | 72 | 64 |
| 19.029 | 100 | 44 | 72 | 86 | 20.90 | 86 | 32 | 56 | 72 | 24.24 | 64 | 24 | 40 | 44 |
| 19.048 | 64 | 24 | 40 | 56 | 20.93 | 100 | 40 | 72 | 86 | 24.31 | 100 | 32 | 56 | 72 |
| 19.091 | 72 | 44 | 56 | 48 | 20.95 | 64 | 28 | 44 | 48 | 24.43 | 86 | 32 | 40 | 44 |
| 19.096 | 100 | 32 | 44 | 72 | 21.00 | 72 | 40 | 56 | 48 | 24.44 | 64 | 24 | 44 | 48 |
| 19.111 | 86 | 40 | 64 | 72 | 21.12 | 86 | 32 | 44 | 56 | 24.54 | 72 | 32 | 48 | 44 |
| 19.136 | 72 | 28 | 64 | 86 | 21.21 | 56 | 24 | 40 | 44 | 24.55 | 100 | 32 | 44 | 56 |
| 19.197 | 86 | 28 | 40 | 64 | 21.32 | 100 | 24 | 44 | 86 | 24.57 | 86 | 40 | 64 | 56 |
| 19.200 | 72 | 24 | 64 | 100 | 21.33 | 100 | 56 | 86 | 72 | 24.64 | 86 | 24 | 44 | 64 |
| 19.250 | 56 | 32 | 44 | 40 | 21.39 | 56 | 24 | 44 | 48 | 24.75 | 72 | 32 | 44 | 40 |
| 19.286 | 72 | 56 | 48 | 32 | 21.43 | 100 | 40 | 48 | 56 | 24.88 | 100 | 72 | 86 | 48 |
| 19.350 | 86 | 32 | 72 | 100 | 21.48 | 100 | 32 | 44 | 64 | 24.93 | 64 | 28 | 48 | 44 |
| 19.380 | 100 | 24 | 40 | 86 | 21.50 | 86 | 48 | 48 | 40 | 25.00 | 100 | 48 | 48 | 40 |

TABLE 2 (continued) — LEADS — CONVENTIONAL LEAD ATTACHMENT

NOTE Power Feed and Rapid Traverse May Be Used with All Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|-------|-----|----|----|-----|-------|-----|----|----|----|-------|-----|----|----|----|
| 25.08 | 86 | 40 | 56 | 48 | 28.57 | 100 | 56 | 64 | 40 | 33.33 | 100 | 48 | 64 | 40 |
| 25.13 | 86 | 44 | 72 | 56 | 28.64 | 72 | 44 | 56 | 32 | 33.51 | 86 | 28 | 48 | 44 |
| 25.14 | 64 | 28 | 44 | 40 | 28.65 | 100 | 24 | 44 | 64 | 33.59 | 100 | 64 | 86 | 40 |
| 25.45 | 56 | 24 | 48 | 44 | 28.67 | 86 | 40 | 64 | 48 | 33.79 | 86 | 28 | 44 | 40 |
| 25.46 | 100 | 24 | 44 | 72 | 29.09 | 64 | 28 | 56 | 44 | 33.94 | 64 | 24 | 56 | 44 |
| 25.51 | 100 | 28 | 40 | 56 | 29.17 | 100 | 48 | 56 | 40 | 34.09 | 100 | 48 | 72 | 44 |
| 25.57 | 100 | 64 | 72 | 44 | 29.22 | 100 | 56 | 72 | 44 | 34.20 | 86 | 44 | 56 | 32 |
| 25.60 | 86 | 24 | 40 | 56 | 29.32 | 86 | 48 | 72 | 44 | 34.29 | 72 | 48 | 64 | 28 |
| 25.67 | 56 | 24 | 44 | 40 | 29.34 | 64 | 24 | 44 | 40 | 34.38 | 100 | 32 | 44 | 40 |
| 25.71 | 72 | 24 | 48 | 56 | 29.39 | 72 | 28 | 64 | 56 | 34.55 | 86 | 28 | 72 | 64 |
| 25.80 | 86 | 24 | 72 | 100 | 29.56 | 86 | 32 | 44 | 40 | 34.72 | 100 | 24 | 40 | 48 |
| 25.97 | 100 | 44 | 64 | 56 | 29.76 | 100 | 28 | 40 | 48 | 34.88 | 100 | 24 | 72 | 86 |
| 26.04 | 100 | 24 | 40 | 64 | 29.86 | 86 | 24 | 40 | 48 | 34.90 | 100 | 56 | 86 | 44 |
| 26.06 | 86 | 44 | 64 | 48 | 29.90 | 100 | 28 | 72 | 86 | 35.00 | 72 | 24 | 56 | 48 |
| 26.16 | 100 | 32 | 72 | 86 | 30.00 | 72 | 32 | 64 | 48 | 35.10 | 86 | 28 | 64 | 56 |
| 26.18 | 72 | 40 | 64 | 44 | 30.23 | 86 | 32 | 72 | 64 | 35.16 | 100 | 32 | 72 | 64 |
| 26.19 | 44 | 24 | 40 | 28 | 30.30 | 100 | 48 | 64 | 44 | 35.18 | 86 | 44 | 72 | 40 |
| 26.25 | 72 | 32 | 56 | 48 | 30.48 | 64 | 24 | 32 | 28 | 35.36 | 72 | 32 | 44 | 28 |
| 26.33 | 86 | 28 | 48 | 56 | 30.54 | 100 | 44 | 86 | 64 | 35.56 | 64 | 24 | 32 | 24 |
| 26.52 | 100 | 44 | 56 | 48 | 30.56 | 44 | 24 | 40 | 24 | 35.71 | 100 | 32 | 64 | 56 |
| 26.58 | 100 | 28 | 64 | 86 | 30.61 | 100 | 28 | 48 | 56 | 35.83 | 86 | 32 | 64 | 48 |
| 26.67 | 64 | 28 | 56 | 48 | 30.71 | 86 | 24 | 48 | 56 | 36.00 | 72 | 32 | 64 | 40 |
| 26.79 | 100 | 48 | 72 | 56 | 30.86 | 72 | 28 | 48 | 40 | 36.36 | 100 | 44 | 64 | 40 |
| 26.88 | 86 | 28 | 56 | 64 | 31.01 | 100 | 24 | 64 | 86 | 36.46 | 100 | 48 | 56 | 32 |
| 27.00 | 72 | 32 | 48 | 40 | 31.11 | 64 | 24 | 56 | 48 | 36.67 | 48 | 24 | 44 | 24 |
| 27.13 | 100 | 24 | 56 | 86 | 31.25 | 100 | 28 | 56 | 64 | 36.86 | 86 | 28 | 48 | 40 |
| 27.15 | 100 | 44 | 86 | 72 | 31.27 | 86 | 40 | 64 | 44 | 37.04 | 100 | 24 | 64 | 72 |
| 27.22 | 56 | 24 | 28 | 24 | 31.35 | 86 | 24 | 56 | 64 | 37.33 | 64 | 24 | 56 | 40 |
| 27.27 | 72 | 24 | 40 | 44 | 31.43 | 64 | 28 | 44 | 32 | 37.40 | 72 | 28 | 64 | 44 |
| 27.30 | 86 | 28 | 64 | 72 | 31.50 | 72 | 32 | 56 | 40 | 37.50 | 72 | 24 | 40 | 32 |
| 27.34 | 100 | 32 | 56 | 64 | 31.75 | 100 | 72 | 64 | 28 | 37.63 | 86 | 32 | 56 | 40 |
| 27.36 | 86 | 40 | 56 | 44 | 31.82 | 100 | 44 | 56 | 40 | 37.88 | 100 | 24 | 40 | 44 |
| 27.43 | 64 | 28 | 48 | 40 | 31.85 | 86 | 24 | 64 | 72 | 38.10 | 64 | 24 | 40 | 28 |
| 27.50 | 56 | 32 | 44 | 28 | 31.99 | 100 | 56 | 86 | 48 | 38.18 | 72 | 24 | 56 | 44 |
| 27.64 | 86 | 40 | 72 | 56 | 32.00 | 64 | 28 | 56 | 40 | 38.20 | 100 | 24 | 44 | 48 |
| 27.78 | 100 | 32 | 64 | 72 | 32.09 | 56 | 24 | 44 | 32 | 38.39 | 86 | 28 | 40 | 32 |
| 27.87 | 86 | 24 | 56 | 72 | 32.14 | 100 | 56 | 72 | 40 | 38.57 | 72 | 28 | 48 | 32 |
| 27.92 | 86 | 28 | 40 | 44 | 32.25 | 86 | 48 | 72 | 40 | 38.89 | 56 | 24 | 40 | 24 |
| 28.00 | 100 | 64 | 86 | 48 | 32.41 | 100 | 24 | 56 | 72 | 38.96 | 100 | 28 | 48 | 44 |
| 28.05 | 72 | 28 | 48 | 44 | 32.47 | 100 | 28 | 40 | 44 | 39.09 | 86 | 32 | 64 | 44 |
| 28.06 | 100 | 28 | 44 | 56 | 32.58 | 86 | 24 | 40 | 44 | 39.29 | 100 | 28 | 44 | 40 |
| 28.13 | 100 | 40 | 72 | 64 | 32.73 | 72 | 32 | 64 | 44 | 39.42 | 86 | 24 | 44 | 40 |
| 28.15 | 86 | 28 | 44 | 48 | 32.74 | 100 | 28 | 44 | 48 | 39.49 | 86 | 28 | 72 | 56 |
| 28.29 | 72 | 28 | 44 | 40 | 32.85 | 86 | 24 | 44 | 48 | 39.77 | 100 | 32 | 56 | 44 |
| 28.41 | 100 | 32 | 40 | 44 | 33.00 | 72 | 24 | 44 | 40 | 40.00 | 72 | 24 | 64 | 48 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 2 (continued) — LEADS — CONVENTIONAL LEAD ATTACHMENT

NOTE Power Feed and Rapid Traverse May Be Used with All Leads Shown on This Page.

| Lead | A | B | C | D | Lead | A | B | C | D | Lead | A | B | C | D |
|-------|-----|----|----|----|-------|-----|----|----|----|--------|-----|----|----|----|
| 40.18 | 100 | 32 | 72 | 56 | 49.27 | 86 | 24 | 44 | 32 | 68.18 | 100 | 24 | 72 | 44 |
| 40.31 | 86 | 32 | 72 | 48 | 49.77 | 100 | 24 | 86 | 72 | 68.57 | 72 | 24 | 64 | 28 |
| 40.72 | 100 | 44 | 86 | 48 | 50.00 | 72 | 24 | 40 | 24 | 69.11 | 86 | 28 | 72 | 32 |
| 40.82 | 100 | 28 | 64 | 56 | 50.17 | 86 | 24 | 56 | 40 | 69.44 | 100 | 24 | 40 | 24 |
| 40.91 | 100 | 40 | 72 | 44 | 50.26 | 86 | 28 | 72 | 44 | 69.80 | 100 | 28 | 86 | 44 |
| 40.95 | 86 | 28 | 64 | 48 | 51.14 | 100 | 32 | 72 | 44 | 70.00 | 72 | 24 | 56 | 24 |
| 41.14 | 72 | 28 | 64 | 40 | 51.19 | 86 | 24 | 40 | 28 | 71.43 | 100 | 28 | 64 | 32 |
| 41.25 | 72 | 24 | 44 | 32 | 51.43 | 72 | 24 | 48 | 28 | 71.67 | 86 | 24 | 48 | 24 |
| 41.67 | 100 | 32 | 64 | 48 | 51.95 | 100 | 28 | 64 | 44 | 72.92 | 100 | 24 | 56 | 32 |
| 41.81 | 86 | 24 | 56 | 48 | 52.08 | 100 | 24 | 40 | 32 | 74.65 | 100 | 24 | 86 | 48 |
| 41.91 | 64 | 24 | 44 | 28 | 52.12 | 86 | 24 | 64 | 44 | 75.00 | 100 | 24 | 72 | 40 |
| 41.99 | 100 | 32 | 86 | 64 | 52.50 | 72 | 24 | 56 | 32 | 76.39 | 100 | 24 | 44 | 24 |
| 42.00 | 72 | 24 | 56 | 40 | 53.03 | 100 | 24 | 56 | 44 | 76.79 | 100 | 28 | 86 | 40 |
| 42.23 | 86 | 28 | 44 | 32 | 53.33 | 64 | 24 | 56 | 28 | 80.00 | 72 | 24 | 64 | 24 |
| 42.66 | 100 | 28 | 86 | 72 | 53.57 | 100 | 24 | 72 | 56 | 80.36 | 100 | 28 | 72 | 32 |
| 42.78 | 56 | 24 | 44 | 24 | 53.75 | 86 | 24 | 48 | 32 | 80.65 | 86 | 24 | 72 | 32 |
| 42.86 | 100 | 28 | 48 | 40 | 54.85 | 100 | 28 | 86 | 56 | 81.44 | 100 | 24 | 86 | 44 |
| 43.00 | 86 | 24 | 48 | 40 | 55.00 | 72 | 24 | 44 | 24 | 81.90 | 86 | 24 | 64 | 28 |
| 43.64 | 72 | 24 | 64 | 44 | 55.28 | 86 | 28 | 72 | 40 | 83.33 | 100 | 24 | 48 | 24 |
| 43.75 | 100 | 32 | 56 | 40 | 55.56 | 100 | 24 | 64 | 48 | 83.61 | 86 | 24 | 56 | 24 |
| 43.98 | 86 | 32 | 72 | 44 | 55.99 | 100 | 24 | 86 | 64 | 89.59 | 100 | 24 | 86 | 40 |
| 44.44 | 64 | 24 | 40 | 24 | 56.25 | 100 | 32 | 72 | 40 | 92.14 | 86 | 24 | 72 | 28 |
| 44.64 | 100 | 28 | 40 | 32 | 56.31 | 86 | 24 | 44 | 28 | 93.75 | 100 | 24 | 72 | 32 |
| 44.68 | 86 | 28 | 64 | 44 | 57.14 | 100 | 28 | 64 | 40 | 95.24 | 100 | 24 | 64 | 28 |
| 44.79 | 86 | 24 | 40 | 32 | 57.30 | 100 | 24 | 44 | 32 | 95.56 | 86 | 24 | 64 | 24 |
| 45.00 | 72 | 24 | 48 | 32 | 57.33 | 86 | 24 | 64 | 40 | 95.98 | 100 | 28 | 86 | 32 |
| 45.45 | 100 | 24 | 48 | 44 | 58.33 | 100 | 24 | 56 | 40 | 97.22 | 100 | 24 | 56 | 24 |
| 45.61 | 86 | 24 | 56 | 44 | 58.44 | 100 | 28 | 72 | 44 | 107.14 | 100 | 24 | 72 | 24 |
| 45.72 | 64 | 24 | 48 | 28 | 58.64 | 86 | 24 | 72 | 44 | 107.50 | 86 | 24 | 72 | 24 |
| 45.84 | 100 | 24 | 44 | 40 | 59.53 | 100 | 24 | 40 | 28 | 111.11 | 100 | 24 | 64 | 24 |
| 45.92 | 100 | 28 | 72 | 56 | 59.72 | 86 | 24 | 40 | 24 | 111.98 | 100 | 24 | 86 | 32 |
| 46.07 | 86 | 28 | 48 | 32 | 60.00 | 72 | 24 | 64 | 32 | 125.00 | 100 | 24 | 72 | 24 |
| 46.67 | 64 | 24 | 56 | 32 | 60.61 | 100 | 24 | 64 | 44 | 127.98 | 100 | 24 | 86 | 28 |
| 46.88 | 100 | 24 | 72 | 64 | 61.08 | 100 | 32 | 86 | 44 | 149.31 | 100 | 24 | 86 | 24 |
| 47.15 | 72 | 24 | 44 | 28 | 61.43 | 86 | 24 | 48 | 28 | | | | | |
| 47.62 | 100 | 24 | 64 | 56 | 62.22 | 64 | 24 | 56 | 24 | | | | | |
| 47.78 | 86 | 24 | 64 | 48 | 62.50 | 100 | 23 | 56 | 32 | | | | | |
| 47.99 | 100 | 28 | 86 | 64 | 62.71 | 86 | 24 | 56 | 32 | | | | | |
| 48.00 | 72 | 24 | 64 | 40 | 63.99 | 100 | 24 | 86 | 56 | | | | | |
| 48.38 | 86 | 32 | 72 | 40 | 64.29 | 100 | 28 | 72 | 40 | | | | | |
| 48.61 | 100 | 24 | 56 | 48 | 64.50 | 86 | 24 | 72 | 40 | | | | | |
| 48.86 | 100 | 40 | 86 | 44 | 65.48 | 100 | 24 | 44 | 28 | | | | | |
| 48.89 | 64 | 24 | 44 | 24 | 65.70 | 86 | 24 | 44 | 24 | | | | | |
| 49.11 | 100 | 28 | 44 | 32 | 66.67 | 100 | 24 | 64 | 40 | | | | | |
| 49.14 | 86 | 28 | 64 | 40 | 67.19 | 100 | 32 | 86 | 40 | | | | | |

TABLE 3 — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Table Trip Lever is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|
| .0219 | 20 | 38 | 20 | 40 | 1 | 96 | .0301 | 20 | 36 | 26 | 40 | 1 | 96 | .0382 | 20 | 30 | 22 | 32 | 1 | 96 |
| .0230 | 20 | 38 | 21 | 40 | 1 | 96 | .0302 | 20 | 29 | 21 | 40 | 1 | 96 | .0384 | 25 | 38 | 28 | 40 | 1 | 96 |
| .0232 | 20 | 36 | 20 | 40 | 1 | 96 | .0303 | 23 | 38 | 24 | 40 | 1 | 96 | .0386 | 20 | 25 | 22 | 38 | 1 | 96 |
| .0241 | 20 | 38 | 22 | 40 | 1 | 96 | .0304 | 20 | 32 | 21 | 36 | 1 | 96 | .0388 | 20 | 26 | 23 | 38 | 1 | 96 |
| .0243 | 20 | 36 | 21 | 40 | 1 | 96 | .0305 | 20 | 36 | 25 | 38 | 1 | 96 | .0390 | 20 | 27 | 24 | 38 | 1 | 96 |
| .0244 | 20 | 36 | 20 | 38 | 1 | 96 | .0306 | 22 | 36 | 24 | 40 | 1 | 96 | .0392 | 22 | 32 | 26 | 38 | 1 | 96 |
| .0245 | 20 | 34 | 20 | 40 | 1 | 96 | .0307 | 20 | 30 | 21 | 38 | 1 | 96 | .0394 | 23 | 32 | 25 | 38 | 1 | 96 |
| .0252 | 20 | 38 | 23 | 40 | 1 | 96 | .0308 | 22 | 36 | 23 | 38 | 1 | 96 | .0396 | 25 | 36 | 26 | 38 | 1 | 96 |
| .0253 | 21 | 38 | 22 | 40 | 1 | 96 | .0309 | 21 | 34 | 24 | 40 | 1 | 96 | .0398 | 22 | 32 | 25 | 36 | 1 | 96 |
| .0255 | 20 | 36 | 22 | 40 | 1 | 96 | .0310 | 22 | 34 | 23 | 40 | 1 | 96 | .0400 | 20 | 25 | 24 | 40 | 1 | 96 |
| .0256 | 20 | 36 | 21 | 38 | 1 | 96 | .0311 | 21 | 38 | 27 | 40 | 1 | 96 | .0402 | 20 | 24 | 22 | 38 | 1 | 96 |
| .0257 | 20 | 34 | 21 | 40 | 1 | 96 | .0312 | 21 | 34 | 23 | 38 | 1 | 96 | .0404 | 22 | 29 | 23 | 36 | 1 | 96 |
| .0258 | 20 | 34 | 20 | 38 | 1 | 96 | .0314 | 22 | 38 | 26 | 40 | 1 | 96 | .0406 | 20 | 27 | 25 | 38 | 1 | 96 |
| .0260 | 20 | 32 | 20 | 40 | 1 | 96 | .0316 | 21 | 36 | 26 | 40 | 1 | 96 | .0408 | 21 | 29 | 23 | 34 | 1 | 96 |
| .0263 | 20 | 38 | 24 | 40 | 1 | 96 | .0318 | 20 | 38 | 29 | 40 | 1 | 96 | .0410 | 22 | 38 | 34 | 40 | 1 | 96 |
| .0265 | 21 | 38 | 23 | 40 | 1 | 96 | .0320 | 21 | 36 | 25 | 38 | 1 | 96 | .0412 | 24 | 34 | 28 | 40 | 1 | 96 |
| .0266 | 20 | 36 | 23 | 40 | 1 | 96 | .0322 | 21 | 34 | 25 | 40 | 1 | 96 | .0414 | 21 | 27 | 23 | 36 | 1 | 96 |
| .0267 | 21 | 36 | 22 | 40 | 1 | 96 | .0324 | 20 | 30 | 21 | 36 | 1 | 96 | .0416 | 23 | 32 | 25 | 36 | 1 | 96 |
| .0268 | 20 | 36 | 22 | 38 | 1 | 96 | .0326 | 22 | 38 | 27 | 40 | 1 | 96 | .0418 | 24 | 34 | 27 | 38 | 1 | 96 |
| .0270 | 20 | 34 | 22 | 40 | 1 | 96 | .0328 | 21 | 32 | 24 | 40 | 1 | 96 | .0420 | 21 | 25 | 24 | 40 | 1 | 96 |
| .0271 | 20 | 34 | 21 | 38 | 1 | 96 | .0330 | 20 | 29 | 23 | 40 | 1 | 96 | .0422 | 21 | 24 | 22 | 38 | 1 | 96 |
| .0272 | 20 | 34 | 20 | 36 | 1 | 96 | .0332 | 21 | 29 | 22 | 40 | 1 | 96 | .0424 | 20 | 30 | 29 | 38 | 1 | 96 |
| .0273 | 20 | 32 | 21 | 40 | 1 | 96 | .0334 | 21 | 38 | 29 | 40 | 1 | 96 | .0426 | 21 | 29 | 24 | 34 | 1 | 96 |
| .0274 | 20 | 32 | 20 | 38 | 1 | 96 | .0336 | 20 | 30 | 23 | 38 | 1 | 96 | .0428 | 23 | 28 | 25 | 40 | 1 | 96 |
| .0276 | 21 | 38 | 24 | 40 | 1 | 96 | .0338 | 20 | 29 | 20 | 34 | 1 | 96 | .0430 | 21 | 26 | 23 | 36 | 1 | 96 |
| .0277 | 22 | 38 | 23 | 40 | 1 | 96 | .0340 | 21 | 36 | 28 | 40 | 1 | 96 | .0432 | 20 | 27 | 21 | 30 | 1 | 96 |
| .0278 | 20 | 30 | 20 | 40 | 1 | 96 | .0342 | 24 | 38 | 26 | 40 | 1 | 96 | .0434 | 25 | 36 | 30 | 40 | 1 | 96 |
| .0280 | 20 | 36 | 23 | 38 | 1 | 96 | .0344 | 22 | 32 | 24 | 40 | 1 | 96 | .0436 | 21 | 29 | 26 | 36 | 1 | 96 |
| .0281 | 21 | 36 | 22 | 38 | 1 | 96 | .0346 | 23 | 36 | 26 | 40 | 1 | 96 | .0438 | 22 | 32 | 26 | 34 | 1 | 96 |
| .0282 | 20 | 34 | 23 | 40 | 1 | 96 | .0348 | 20 | 29 | 23 | 38 | 1 | 96 | .0440 | 22 | 25 | 24 | 40 | 1 | 96 |
| .0283 | 21 | 34 | 22 | 40 | 1 | 96 | .0350 | 21 | 30 | 24 | 40 | 1 | 96 | .0442 | 22 | 28 | 27 | 40 | 1 | 96 |
| .0284 | 20 | 34 | 22 | 38 | 1 | 96 | .0352 | 21 | 34 | 26 | 38 | 1 | 96 | .0444 | 21 | 28 | 27 | 38 | 1 | 96 |
| .0285 | 20 | 38 | 26 | 40 | 1 | 96 | .0354 | 20 | 34 | 26 | 36 | 1 | 96 | .0446 | 21 | 30 | 26 | 34 | 1 | 96 |
| .0286 | 20 | 34 | 21 | 36 | 1 | 96 | .0356 | 23 | 34 | 24 | 38 | 1 | 96 | .0448 | 22 | 28 | 26 | 38 | 1 | 96 |
| .0287 | 20 | 29 | 20 | 40 | 1 | 96 | .0358 | 22 | 32 | 25 | 40 | 1 | 96 | .0450 | 20 | 25 | 27 | 40 | 1 | 96 |
| .0288 | 20 | 32 | 21 | 38 | 1 | 96 | .0360 | 20 | 27 | 21 | 36 | 1 | 96 | .0452 | 23 | 29 | 26 | 38 | 1 | 96 |
| .0289 | 20 | 32 | 20 | 36 | 1 | 96 | .0362 | 21 | 29 | 24 | 40 | 1 | 96 | .0454 | 22 | 34 | 32 | 38 | 1 | 96 |
| .0290 | 22 | 38 | 24 | 40 | 1 | 96 | .0364 | 22 | 34 | 27 | 40 | 1 | 96 | .0456 | 26 | 25 | 20 | 38 | 1 | 96 |
| .0292 | 20 | 30 | 21 | 40 | 1 | 96 | .0366 | 22 | 32 | 23 | 36 | 1 | 96 | .0458 | 23 | 32 | 26 | 34 | 1 | 96 |
| .0293 | 22 | 36 | 23 | 40 | 1 | 96 | .0368 | 24 | 34 | 25 | 40 | 1 | 96 | .0460 | 23 | 24 | 24 | 40 | 1 | 96 |
| .0294 | 20 | 34 | 24 | 40 | 1 | 96 | .0370 | 20 | 32 | 27 | 38 | 1 | 96 | .0462 | 26 | 34 | 29 | 40 | 1 | 96 |
| .0296 | 21 | 34 | 23 | 40 | 1 | 96 | .0372 | 20 | 28 | 20 | 32 | 1 | 96 | .0464 | 22 | 26 | 25 | 38 | 1 | 96 |
| .0297 | 20 | 34 | 23 | 38 | 1 | 96 | .0374 | 20 | 34 | 29 | 38 | 1 | 96 | .0466 | 20 | 38 | 34 | 32 | 1 | 96 |
| .0298 | 21 | 34 | 22 | 38 | 1 | 96 | .0376 | 20 | 28 | 24 | 38 | 1 | 96 | .0468 | 21 | 27 | 26 | 36 | 1 | 96 |
| .0299 | 21 | 38 | 26 | 40 | 1 | 96 | .0378 | 20 | 29 | 25 | 38 | 1 | 96 | .0470 | 20 | 26 | 22 | 30 | 1 | 96 |
| .0300 | 20 | 34 | 22 | 36 | 1 | 96 | .0380 | 20 | 30 | 26 | 38 | 1 | 96 | .0472 | 25 | 32 | 29 | 40 | 1 | 96 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Table Trip Lever is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|
| .0474 | 26 | 24 | 21 | 40 | 1 | 96 | .0566 | 20 | 23 | 25 | 32 | 1 | 96 | .0705 | 23 | 29 | 32 | 30 | 1 | 96 |
| .0476 | 22 | 26 | 27 | 40 | 1 | 96 | .0568 | 21 | 29 | 32 | 34 | 1 | 96 | .0710 | 34 | 21 | 20 | 38 | 1 | 96 |
| .0478 | 26 | 34 | 30 | 40 | 1 | 96 | .0570 | 34 | 29 | 21 | 36 | 1 | 96 | .0715 | 30 | 23 | 25 | 38 | 1 | 96 |
| .0480 | 20 | 27 | 28 | 36 | 1 | 96 | .0572 | 24 | 23 | 25 | 38 | 1 | 96 | .0720 | 36 | 25 | 24 | 40 | 1 | 96 |
| .0482 | 24 | 28 | 27 | 40 | 1 | 96 | .0574 | 29 | 26 | 21 | 34 | 1 | 96 | .0725 | 29 | 25 | 21 | 28 | 1 | 96 |
| .0484 | 20 | 29 | 32 | 38 | 1 | 96 | .0576 | 28 | 27 | 20 | 30 | 1 | 96 | .0730 | 24 | 21 | 23 | 30 | 1 | 96 |
| .0486 | 23 | 29 | 25 | 34 | 1 | 96 | .0578 | 28 | 34 | 32 | 38 | 1 | 96 | .0735 | 36 | 29 | 27 | 38 | 1 | 96 |
| .0488 | 29 | 26 | 21 | 40 | 1 | 96 | .0580 | 24 | 25 | 29 | 40 | 1 | 96 | .0740 | 30 | 24 | 27 | 38 | 1 | 96 |
| .0490 | 21 | 25 | 28 | 40 | 1 | 96 | .0582 | 30 | 26 | 23 | 38 | 1 | 96 | .0745 | 25 | 27 | 28 | 29 | 1 | 96 |
| .0492 | 25 | 36 | 34 | 40 | 1 | 96 | .0584 | 23 | 28 | 29 | 34 | 1 | 96 | .0750 | 32 | 24 | 27 | 40 | 1 | 96 |
| .0494 | 22 | 29 | 25 | 32 | 1 | 96 | .0586 | 22 | 23 | 25 | 34 | 1 | 96 | .0755 | 26 | 22 | 23 | 30 | 1 | 96 |
| .0496 | 28 | 26 | 21 | 38 | 1 | 96 | .0588 | 27 | 22 | 23 | 40 | 1 | 96 | .0760 | 38 | 25 | 24 | 40 | 1 | 96 |
| .0498 | 20 | 29 | 26 | 30 | 1 | 96 | .0590 | 22 | 29 | 28 | 30 | 1 | 96 | .0765 | 34 | 25 | 27 | 40 | 1 | 96 |
| .0500 | 20 | 25 | 21 | 28 | 1 | 96 | .0592 | 27 | 20 | 20 | 38 | 1 | 96 | .0770 | 22 | 20 | 21 | 25 | 1 | 96 |
| .0502 | 22 | 21 | 23 | 40 | 1 | 96 | .0594 | 21 | 24 | 22 | 27 | 1 | 96 | .0775 | 28 | 27 | 26 | 29 | 1 | 96 |
| .0504 | 28 | 27 | 21 | 36 | 1 | 96 | .0596 | 28 | 27 | 20 | 29 | 1 | 96 | .0780 | 38 | 28 | 20 | 29 | 1 | 96 |
| .0506 | 20 | 40 | 34 | 28 | 1 | 96 | .0598 | 25 | 22 | 24 | 38 | 1 | 96 | .0785 | 25 | 23 | 26 | 30 | 1 | 96 |
| .0508 | 24 | 29 | 28 | 38 | 1 | 96 | .0600 | 20 | 40 | 36 | 25 | 1 | 96 | .0790 | 34 | 26 | 29 | 40 | 1 | 96 |
| .0510 | 26 | 34 | 32 | 40 | 1 | 96 | .0602 | 20 | 21 | 22 | 29 | 1 | 96 | .0795 | 30 | 24 | 29 | 38 | 1 | 96 |
| .0512 | 23 | 26 | 25 | 36 | 1 | 96 | .0604 | 23 | 28 | 30 | 34 | 1 | 96 | .0800 | 32 | 20 | 24 | 40 | 1 | 96 |
| .0514 | 25 | 32 | 30 | 38 | 1 | 96 | .0606 | 20 | 22 | 20 | 25 | 1 | 96 | .0805 | 23 | 20 | 21 | 25 | 1 | 96 |
| .0516 | 40 | 34 | 20 | 38 | 1 | 96 | .0608 | 22 | 26 | 25 | 29 | 1 | 96 | .0810 | 36 | 25 | 27 | 40 | 1 | 96 |
| .0518 | 21 | 24 | 27 | 38 | 1 | 96 | .0610 | 29 | 26 | 21 | 32 | 1 | 96 | .0815 | 38 | 24 | 21 | 34 | 1 | 96 |
| .0520 | 24 | 25 | 26 | 40 | 1 | 96 | .0612 | 23 | 27 | 25 | 29 | 1 | 96 | .0820 | 32 | 22 | 23 | 34 | 1 | 96 |
| .0522 | 23 | 27 | 25 | 34 | 1 | 96 | .0614 | 28 | 20 | 20 | 38 | 1 | 96 | .0825 | 27 | 20 | 22 | 30 | 1 | 96 |
| .0524 | 21 | 24 | 23 | 32 | 1 | 96 | .0616 | 26 | 30 | 29 | 34 | 1 | 96 | .0830 | 24 | 22 | 21 | 23 | 1 | 96 |
| .0526 | 25 | 22 | 20 | 36 | 1 | 96 | .0618 | 29 | 23 | 20 | 34 | 1 | 96 | .0835 | 38 | 29 | 26 | 34 | 1 | 96 |
| .0528 | 21 | 29 | 28 | 32 | 1 | 96 | .0620 | 28 | 23 | 22 | 36 | 1 | 96 | .0840 | 38 | 26 | 20 | 29 | 1 | 96 |
| .0530 | 25 | 30 | 29 | 38 | 1 | 96 | .0622 | 26 | 22 | 24 | 38 | 1 | 96 | .0845 | 29 | 22 | 20 | 26 | 1 | 96 |
| .0532 | 22 | 28 | 26 | 32 | 1 | 96 | .0624 | 26 | 27 | 28 | 36 | 1 | 96 | .0850 | 34 | 25 | 24 | 32 | 1 | 96 |
| .0534 | 23 | 34 | 36 | 38 | 1 | 96 | .0625 | 21 | 20 | 20 | 28 | 1 | 96 | .0855 | 38 | 25 | 27 | 40 | 1 | 96 |
| .0536 | 22 | 27 | 30 | 38 | 1 | 96 | .0630 | 36 | 25 | 21 | 40 | 1 | 96 | .0860 | 28 | 24 | 23 | 26 | 1 | 96 |
| .0538 | 23 | 30 | 32 | 38 | 1 | 96 | .0635 | 34 | 29 | 26 | 40 | 1 | 96 | .0865 | 29 | 25 | 34 | 38 | 1 | 96 |
| .0540 | 24 | 25 | 27 | 40 | 1 | 96 | .0640 | 32 | 25 | 24 | 40 | 1 | 96 | .0870 | 38 | 26 | 20 | 28 | 1 | 96 |
| .0542 | 23 | 26 | 25 | 34 | 1 | 96 | .0645 | 40 | 34 | 25 | 38 | 1 | 96 | .0875 | 30 | 20 | 28 | 40 | 1 | 96 |
| .0544 | 26 | 22 | 21 | 38 | 1 | 96 | .0650 | 26 | 25 | 27 | 36 | 1 | 96 | .0880 | 24 | 20 | 22 | 25 | 1 | 96 |
| .0546 | 38 | 29 | 20 | 40 | 1 | 96 | .0655 | 28 | 30 | 32 | 38 | 1 | 96 | .0885 | 28 | 20 | 22 | 29 | 1 | 96 |
| .0548 | 22 | 29 | 26 | 30 | 1 | 96 | .0660 | 22 | 25 | 27 | 30 | 1 | 96 | .0890 | 26 | 20 | 23 | 28 | 1 | 96 |
| .0550 | 21 | 25 | 22 | 28 | 1 | 96 | .0665 | 24 | 23 | 26 | 34 | 1 | 96 | .0895 | 29 | 21 | 28 | 36 | 1 | 96 |
| .0552 | 23 | 27 | 28 | 36 | 1 | 96 | .0670 | 38 | 26 | 22 | 40 | 1 | 96 | .0900 | 36 | 20 | 24 | 40 | 1 | 96 |
| .0554 | 21 | 26 | 23 | 28 | 1 | 96 | .0675 | 24 | 25 | 27 | 32 | 1 | 96 | .0905 | 40 | 26 | 24 | 34 | 1 | 96 |
| .0556 | 27 | 25 | 21 | 34 | 1 | 96 | .0680 | 34 | 25 | 24 | 40 | 1 | 96 | .0910 | 38 | 24 | 20 | 29 | 1 | 96 |
| .0558 | 21 | 23 | 22 | 30 | 1 | 96 | .0685 | 28 | 26 | 29 | 38 | 1 | 96 | .0915 | 36 | 27 | 28 | 34 | 1 | 96 |
| .0560 | 22 | 26 | 27 | 34 | 1 | 96 | .0690 | 23 | 25 | 27 | 30 | 1 | 96 | .0920 | 24 | 20 | 23 | 25 | 1 | 96 |
| .0562 | 32 | 29 | 22 | 36 | 1 | 96 | .0695 | 27 | 20 | 21 | 34 | 1 | 96 | .0925 | 32 | 22 | 29 | 38 | 1 | 96 |
| .0564 | 36 | 28 | 20 | 38 | 1 | 96 | .0700 | 24 | 20 | 21 | 30 | 1 | 96 | .0930 | 28 | 23 | 22 | 24 | 1 | 96 |

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Table Trip Lever is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|
| .0935 | 26 | 24 | 29 | 28 | 1 | 96 | .1165 | 38 | 23 | 22 | 26 | 1 | 96 | .1540 | 34 | 23 | 30 | 24 | 1 | 96 |
| .0940 | 34 | 23 | 29 | 38 | 1 | 96 | .1170 | 30 | 28 | 38 | 29 | 1 | 96 | .1550 | 38 | 22 | 28 | 26 | 1 | 96 |
| .0945 | 27 | 20 | 21 | 25 | 1 | 96 | .1175 | 40 | 24 | 22 | 26 | 1 | 96 | .1560 | 36 | 20 | 26 | 25 | 1 | 96 |
| .0950 | 38 | 25 | 24 | 32 | 1 | 96 | .1180 | 30 | 22 | 27 | 26 | 1 | 96 | .1570 | 40 | 24 | 26 | 23 | 1 | 96 |
| .0955 | 36 | 26 | 24 | 29 | 1 | 96 | .1185 | 40 | 25 | 24 | 27 | 1 | 96 | .1580 | 34 | 26 | 29 | 20 | 1 | 96 |
| .0960 | 27 | 25 | 32 | 30 | 1 | 96 | .1190 | 34 | 20 | 21 | 25 | 1 | 96 | .1590 | 40 | 20 | 21 | 22 | 1 | 96 |
| .0965 | 40 | 20 | 22 | 38 | 1 | 96 | .1195 | 29 | 21 | 27 | 26 | 1 | 96 | .1600 | 36 | 21 | 28 | 25 | 1 | 96 |
| .0970 | 40 | 27 | 22 | 28 | 1 | 96 | .1200 | 27 | 21 | 28 | 25 | 1 | 96 | .1610 | 34 | 20 | 25 | 22 | 1 | 96 |
| .0975 | 26 | 24 | 27 | 25 | 1 | 96 | .1205 | 38 | 23 | 21 | 24 | 1 | 96 | .1620 | 36 | 25 | 27 | 20 | 1 | 96 |
| .0980 | 21 | 20 | 28 | 25 | 1 | 96 | .1210 | 34 | 21 | 26 | 29 | 1 | 96 | .1630 | 34 | 24 | 29 | 21 | 1 | 96 |
| .0985 | 29 | 23 | 30 | 32 | 1 | 96 | .1215 | 38 | 23 | 30 | 34 | 1 | 96 | .1640 | 38 | 28 | 29 | 20 | 1 | 96 |
| .0990 | 27 | 20 | 22 | 25 | 1 | 96 | .1220 | 36 | 22 | 34 | 38 | 1 | 96 | .1650 | 36 | 20 | 22 | 20 | 1 | 96 |
| .0995 | 34 | 23 | 21 | 26 | 1 | 96 | .1225 | 28 | 20 | 21 | 20 | 1 | 96 | .1660 | 36 | 22 | 28 | 23 | 1 | 96 |
| .1000 | 36 | 24 | 20 | 25 | 1 | 96 | .1230 | 28 | 22 | 29 | 25 | 1 | 96 | .1670 | 38 | 25 | 29 | 22 | 1 | 96 |
| .1005 | 30 | 22 | 23 | 26 | 1 | 96 | .1235 | 30 | 22 | 25 | 23 | 1 | 96 | .1680 | 36 | 20 | 28 | 25 | 1 | 96 |
| .1010 | 32 | 22 | 25 | 30 | 1 | 96 | .1240 | 40 | 21 | 25 | 32 | 1 | 96 | .1690 | 40 | 26 | 29 | 22 | 1 | 96 |
| .1015 | 38 | 26 | 25 | 30 | 1 | 96 | .1245 | 36 | 22 | 21 | 23 | 1 | 96 | .1700 | 34 | 25 | 30 | 20 | 1 | 96 |
| .1020 | 29 | 22 | 26 | 28 | 1 | 96 | .1250 | 36 | 20 | 25 | 30 | 1 | 96 | .1710 | 38 | 25 | 27 | 20 | 1 | 96 |
| .1025 | 40 | 22 | 23 | 34 | 1 | 96 | .1260 | 36 | 20 | 21 | 25 | 1 | 96 | .1720 | 40 | 24 | 26 | 21 | 1 | 96 |
| .1030 | 28 | 25 | 32 | 29 | 1 | 96 | .1270 | 38 | 22 | 30 | 34 | 1 | 96 | .1730 | 40 | 26 | 27 | 20 | 1 | 96 |
| .1035 | 27 | 20 | 23 | 25 | 1 | 96 | .1280 | 32 | 20 | 24 | 25 | 1 | 96 | .1740 | 36 | 25 | 29 | 20 | 1 | 96 |
| .1040 | 26 | 20 | 24 | 25 | 1 | 96 | .1290 | 38 | 20 | 22 | 27 | 1 | 96 | .1750 | 21 | 30 | 27 | 36 | 1 | 24 |
| .1045 | 40 | 22 | 20 | 29 | 1 | 96 | .1300 | 30 | 20 | 26 | 25 | 1 | 96 | .1760 | 22 | 25 | 24 | 40 | 1 | 24 |
| .1050 | 36 | 20 | 21 | 30 | 1 | 96 | .1310 | 38 | 25 | 30 | 29 | 1 | 96 | .1770 | 21 | 29 | 22 | 30 | 1 | 24 |
| .1055 | 26 | 23 | 28 | 25 | 1 | 96 | .1320 | 36 | 20 | 22 | 25 | 1 | 96 | .1780 | 23 | 34 | 30 | 38 | 1 | 24 |
| .1060 | 34 | 21 | 22 | 28 | 1 | 96 | .1330 | 38 | 20 | 21 | 25 | 1 | 96 | .1790 | 20 | 30 | 29 | 36 | 1 | 24 |
| .1065 | 34 | 28 | 40 | 38 | 1 | 96 | .1340 | 38 | 22 | 27 | 29 | 1 | 96 | .1800 | 20 | 25 | 27 | 40 | 1 | 24 |
| .1070 | 32 | 24 | 26 | 27 | 1 | 96 | .1350 | 30 | 20 | 27 | 25 | 1 | 96 | .1810 | 20 | 26 | 24 | 34 | 1 | 24 |
| .1075 | 38 | 24 | 22 | 27 | 1 | 96 | .1360 | 34 | 20 | 24 | 25 | 1 | 96 | .1820 | 21 | 25 | 26 | 40 | 1 | 24 |
| .1080 | 27 | 20 | 24 | 25 | 1 | 96 | .1370 | 38 | 24 | 27 | 26 | 1 | 96 | .1830 | 21 | 27 | 24 | 34 | 1 | 24 |
| .1085 | 40 | 24 | 25 | 32 | 1 | 96 | .1380 | 36 | 20 | 23 | 25 | 1 | 96 | .1840 | 23 | 25 | 24 | 40 | 1 | 24 |
| .1090 | 36 | 21 | 29 | 38 | 1 | 96 | .1390 | 38 | 22 | 38 | 29 | 1 | 96 | .1850 | 25 | 32 | 27 | 38 | 1 | 24 |
| .1095 | 32 | 23 | 34 | 36 | 1 | 96 | .1400 | 40 | 20 | 21 | 25 | 1 | 96 | .1860 | 20 | 28 | 25 | 32 | 1 | 24 |
| .1100 | 30 | 20 | 22 | 25 | 1 | 96 | .1410 | 40 | 20 | 22 | 26 | 1 | 96 | .1870 | 21 | 26 | 25 | 36 | 1 | 24 |
| .1105 | 40 | 26 | 25 | 29 | 1 | 96 | .1420 | 40 | 21 | 34 | 38 | 1 | 96 | .1880 | 20 | 38 | 30 | 28 | 1 | 24 |
| .1110 | 34 | 22 | 25 | 29 | 1 | 96 | .1430 | 38 | 23 | 27 | 26 | 1 | 96 | .1890 | 27 | 25 | 21 | 40 | 1 | 24 |
| .1115 | 40 | 23 | 20 | 26 | 1 | 96 | .1440 | 36 | 20 | 24 | 25 | 1 | 96 | .1901 | 24 | 26 | 21 | 34 | 1 | 24 |
| .1120 | 28 | 20 | 24 | 25 | 1 | 96 | .1450 | 36 | 20 | 29 | 30 | 1 | 96 | .1910 | 21 | 27 | 28 | 38 | 1 | 24 |
| .1125 | 27 | 24 | 30 | 25 | 1 | 96 | .1460 | 34 | 23 | 32 | 27 | 1 | 96 | .1920 | 28 | 27 | 20 | 36 | 1 | 24 |
| .1130 | 28 | 26 | 34 | 27 | 1 | 96 | .1470 | 38 | 20 | 26 | 28 | 1 | 96 | .1930 | 23 | 32 | 29 | 36 | 1 | 24 |
| .1135 | 34 | 24 | 25 | 26 | 1 | 96 | .1480 | 36 | 28 | 29 | 21 | 1 | 96 | .1940 | 22 | 21 | 20 | 36 | 1 | 24 |
| .1140 | 36 | 25 | 38 | 40 | 1 | 96 | .1490 | 32 | 34 | 38 | 20 | 1 | 96 | .1950 | 26 | 30 | 27 | 40 | 1 | 24 |
| .1145 | 34 | 22 | 24 | 27 | 1 | 96 | .1500 | 32 | 20 | 27 | 24 | 1 | 96 | .1960 | 28 | 25 | 21 | 40 | 1 | 24 |
| .1150 | 36 | 20 | 23 | 30 | 1 | 96 | .1510 | 40 | 23 | 25 | 24 | 1 | 96 | .1970 | 26 | 22 | 20 | 40 | 1 | 24 |
| .1155 | 34 | 23 | 30 | 32 | 1 | 96 | .1520 | 38 | 20 | 24 | 25 | 1 | 96 | .1980 | 27 | 25 | 22 | 40 | 1 | 24 |
| .1160 | 29 | 20 | 24 | 25 | 1 | 96 | .1530 | 34 | 20 | 27 | 25 | 1 | 96 | .1990 | 21 | 30 | 29 | 34 | 1 | 24 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Table Trip Lever is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|
| .2000 | 20 | 25 | 21 | 28 | 1 | 24 | .2460 | 23 | 22 | 24 | 34 | 1 | 24 | .3340 | 26 | 34 | 38 | 29 | 1 | 24 |
| .2010 | 22 | 24 | 25 | 38 | 1 | 24 | .2470 | 32 | 25 | 22 | 38 | 1 | 24 | .3360 | 24 | 20 | 21 | 25 | 1 | 24 |
| .2020 | 27 | 34 | 29 | 38 | 1 | 24 | .2480 | 28 | 23 | 22 | 36 | 1 | 24 | .3380 | 29 | 22 | 20 | 26 | 1 | 24 |
| .2030 | 29 | 25 | 21 | 40 | 1 | 24 | .2490 | 26 | 24 | 20 | 29 | 1 | 24 | .3400 | 24 | 32 | 34 | 25 | 1 | 24 |
| .2039 | 26 | 34 | 32 | 40 | 1 | 24 | .2500 | 21 | 20 | 20 | 28 | 1 | 24 | .3420 | 27 | 40 | 38 | 25 | 1 | 24 |
| .2050 | 23 | 22 | 20 | 34 | 1 | 24 | .2520 | 36 | 25 | 21 | 40 | 1 | 24 | .3440 | 23 | 26 | 28 | 24 | 1 | 24 |
| .2060 | 27 | 23 | 20 | 38 | 1 | 24 | .2540 | 34 | 29 | 26 | 40 | 1 | 24 | .3460 | 29 | 38 | 34 | 25 | 1 | 24 |
| .2070 | 23 | 25 | 27 | 40 | 1 | 24 | .2560 | 32 | 25 | 24 | 40 | 1 | 24 | .3480 | 29 | 40 | 36 | 25 | 1 | 24 |
| .2080 | 24 | 25 | 26 | 40 | 1 | 24 | .2580 | 40 | 34 | 25 | 38 | 1 | 24 | .3500 | 30 | 20 | 28 | 40 | 1 | 24 |
| .2090 | 20 | 22 | 20 | 29 | 1 | 24 | .2600 | 24 | 25 | 26 | 32 | 1 | 24 | .3520 | 24 | 20 | 22 | 25 | 1 | 24 |
| .2100 | 30 | 25 | 21 | 40 | 1 | 24 | .2620 | 28 | 30 | 32 | 38 | 1 | 24 | .3540 | 28 | 20 | 22 | 29 | 1 | 24 |
| .2110 | 22 | 28 | 29 | 36 | 1 | 24 | .2640 | 22 | 25 | 27 | 30 | 1 | 24 | .3560 | 26 | 20 | 23 | 28 | 1 | 24 |
| .2120 | 29 | 36 | 30 | 38 | 1 | 24 | .2660 | 38 | 25 | 21 | 40 | 1 | 24 | .3580 | 29 | 20 | 20 | 27 | 1 | 24 |
| .2130 | 21 | 29 | 30 | 34 | 1 | 24 | .2680 | 38 | 26 | 22 | 40 | 1 | 24 | .3600 | 36 | 20 | 24 | 40 | 1 | 24 |
| .2140 | 24 | 27 | 26 | 36 | 1 | 24 | .2700 | 24 | 25 | 27 | 32 | 1 | 24 | .3620 | 40 | 26 | 24 | 34 | 1 | 24 |
| .2150 | 25 | 28 | 26 | 36 | 1 | 24 | .2720 | 34 | 25 | 24 | 40 | 1 | 24 | .3640 | 26 | 20 | 21 | 25 | 1 | 24 |
| .2160 | 24 | 25 | 27 | 40 | 1 | 24 | .2740 | 28 | 26 | 29 | 38 | 1 | 24 | .3660 | 36 | 27 | 28 | 34 | 1 | 24 |
| .2170 | 25 | 32 | 30 | 36 | 1 | 24 | .2760 | 23 | 25 | 27 | 30 | 1 | 24 | .3680 | 24 | 20 | 23 | 25 | 1 | 24 |
| .2180 | 23 | 30 | 29 | 34 | 1 | 24 | .2779 | 27 | 20 | 21 | 34 | 1 | 24 | .3700 | 32 | 22 | 29 | 38 | 1 | 24 |
| .2191 | 20 | 25 | 23 | 28 | 1 | 24 | .2800 | 24 | 20 | 21 | 30 | 1 | 24 | .3720 | 28 | 23 | 22 | 24 | 1 | 24 |
| .2200 | 21 | 25 | 22 | 28 | 1 | 24 | .2820 | 23 | 29 | 32 | 30 | 1 | 24 | .3740 | 29 | 24 | 26 | 28 | 1 | 24 |
| .2210 | 22 | 28 | 27 | 32 | 1 | 24 | .2840 | 28 | 29 | 30 | 34 | 1 | 24 | .3761 | 34 | 23 | 29 | 38 | 1 | 24 |
| .2220 | 27 | 32 | 30 | 38 | 1 | 24 | .2860 | 30 | 23 | 25 | 38 | 1 | 24 | .3780 | 27 | 20 | 21 | 25 | 1 | 24 |
| .2230 | 20 | 23 | 20 | 26 | 1 | 24 | .2880 | 36 | 25 | 24 | 40 | 1 | 24 | .3800 | 27 | 36 | 38 | 25 | 1 | 24 |
| .2240 | 21 | 25 | 24 | 30 | 1 | 24 | .2900 | 29 | 25 | 21 | 28 | 1 | 24 | .3820 | 36 | 26 | 24 | 29 | 1 | 24 |
| .2250 | 27 | 20 | 20 | 40 | 1 | 24 | .2921 | 32 | 21 | 23 | 40 | 1 | 24 | .3840 | 36 | 25 | 24 | 30 | 1 | 24 |
| .2260 | 28 | 25 | 23 | 38 | 1 | 24 | .2940 | 27 | 29 | 36 | 38 | 1 | 24 | .3860 | 40 | 20 | 22 | 38 | 1 | 24 |
| .2270 | 22 | 28 | 26 | 30 | 1 | 24 | .2961 | 27 | 24 | 30 | 38 | 1 | 24 | .3880 | 30 | 21 | 22 | 27 | 1 | 24 |
| .2280 | 34 | 29 | 21 | 36 | 1 | 24 | .2980 | 25 | 27 | 28 | 29 | 1 | 24 | .3900 | 27 | 20 | 26 | 30 | 1 | 24 |
| .2290 | 29 | 38 | 36 | 40 | 1 | 24 | .3000 | 32 | 24 | 27 | 40 | 1 | 24 | .3920 | 28 | 20 | 21 | 25 | 1 | 24 |
| .2300 | 21 | 25 | 23 | 23 | 1 | 24 | .3020 | 26 | 22 | 23 | 30 | 1 | 24 | .3940 | 29 | 32 | 30 | 23 | 1 | 24 |
| .2310 | 26 | 32 | 29 | 34 | 1 | 24 | .3040 | 38 | 25 | 24 | 40 | 1 | 24 | .3960 | 27 | 20 | 22 | 25 | 1 | 24 |
| .2320 | 24 | 25 | 29 | 40 | 1 | 24 | .3060 | 34 | 25 | 27 | 40 | 1 | 24 | .3980 | 34 | 23 | 21 | 26 | 1 | 24 |
| .2330 | 25 | 32 | 34 | 38 | 1 | 24 | .3080 | 21 | 20 | 22 | 25 | 1 | 24 | .4000 | 30 | 20 | 20 | 25 | 1 | 24 |
| .2340 | 26 | 25 | 27 | 40 | 1 | 24 | .3099 | 26 | 27 | 28 | 29 | 1 | 24 | .4019 | 26 | 30 | 32 | 23 | 1 | 24 |
| .2350 | 23 | 29 | 32 | 36 | 1 | 24 | .3120 | 36 | 25 | 26 | 40 | 1 | 24 | .4040 | 28 | 21 | 20 | 22 | 1 | 24 |
| .2360 | 25 | 27 | 26 | 34 | 1 | 24 | .3140 | 25 | 23 | 26 | 30 | 1 | 24 | .4060 | 29 | 20 | 21 | 25 | 1 | 24 |
| .2370 | 26 | 24 | 21 | 32 | 1 | 24 | .3160 | 29 | 26 | 34 | 40 | 1 | 24 | .4080 | 27 | 30 | 34 | 25 | 1 | 24 |
| .2380 | 32 | 29 | 22 | 34 | 1 | 24 | .3180 | 23 | 25 | 28 | 27 | 1 | 24 | .4100 | 40 | 22 | 23 | 34 | 1 | 24 |
| .2390 | 26 | 32 | 30 | 34 | 1 | 24 | .3200 | 32 | 20 | 24 | 40 | 1 | 24 | .4120 | 28 | 29 | 32 | 25 | 1 | 24 |
| .2400 | 36 | 25 | 20 | 40 | 1 | 24 | .3220 | 23 | 20 | 21 | 25 | 1 | 24 | .4140 | 23 | 25 | 27 | 20 | 1 | 24 |
| .2410 | 22 | 25 | 23 | 28 | 1 | 24 | .3240 | 36 | 25 | 27 | 40 | 1 | 24 | .4160 | 24 | 25 | 26 | 20 | 1 | 24 |
| .2420 | 23 | 22 | 25 | 36 | 1 | 24 | .3260 | 28 | 32 | 38 | 34 | 1 | 24 | .4180 | 40 | 22 | 20 | 29 | 1 | 24 |
| .2430 | 34 | 27 | 22 | 38 | 1 | 24 | .3280 | 23 | 34 | 32 | 22 | 1 | 24 | .4200 | 24 | 20 | 21 | 20 | 1 | 24 |
| .2440 | 32 | 27 | 21 | 34 | 1 | 24 | .3300 | 27 | 20 | 22 | 30 | 1 | 24 | .4220 | 26 | 25 | 28 | 23 | 1 | 24 |
| .2450 | 28 | 20 | 21 | 40 | 1 | 24 | .3320 | 24 | 22 | 21 | 23 | 1 | 24 | .4240 | 29 | 38 | 40 | 24 | 1 | 24 |

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Table Trip Lever is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|-------|----|----|----|----|---|----|
| .4261 | 34 | 38 | 40 | 28 | 1 | 24 | .5361 | 38 | 22 | 27 | 29 | 1 | 24 | .7200 | 36 | 20 | 24 | 20 | 1 | 24 |
| .4280 | 28 | 21 | 26 | 27 | 1 | 24 | .5400 | 27 | 20 | 24 | 20 | 1 | 24 | .7238 | 38 | 20 | 24 | 21 | 1 | 24 |
| .4300 | 38 | 24 | 22 | 27 | 1 | 24 | .5440 | 34 | 20 | 24 | 25 | 1 | 24 | .7280 | 38 | 24 | 40 | 29 | 1 | 24 |
| .4320 | 27 | 20 | 24 | 25 | 1 | 24 | .5481 | 38 | 24 | 27 | 26 | 1 | 24 | .7323 | 40 | 22 | 29 | 24 | 1 | 24 |
| .4340 | 40 | 24 | 25 | 32 | 1 | 24 | .5520 | 36 | 20 | 23 | 25 | 1 | 24 | .7359 | 34 | 21 | 30 | 22 | 1 | 24 |
| .4361 | 36 | 21 | 29 | 38 | 1 | 24 | .5559 | 38 | 22 | 28 | 29 | 1 | 24 | .7403 | 38 | 21 | 27 | 22 | 1 | 24 |
| .4380 | 32 | 23 | 34 | 36 | 1 | 24 | .5600 | 32 | 20 | 21 | 20 | 1 | 24 | .7444 | 40 | 21 | 34 | 29 | 1 | 24 |
| .4400 | 24 | 20 | 22 | 20 | 1 | 24 | .5641 | 40 | 20 | 22 | 26 | 1 | 24 | .7485 | 38 | 20 | 26 | 22 | 1 | 24 |
| .4419 | 28 | 22 | 25 | 24 | 1 | 24 | .5681 | 40 | 21 | 34 | 38 | 1 | 24 | .7523 | 40 | 22 | 36 | 29 | 1 | 24 |
| .4439 | 29 | 21 | 27 | 28 | 1 | 24 | .5719 | 38 | 23 | 27 | 26 | 1 | 24 | .7556 | 34 | 21 | 28 | 20 | 1 | 24 |
| .4461 | 32 | 22 | 23 | 25 | 1 | 24 | .5760 | 36 | 20 | 24 | 25 | 1 | 24 | .7600 | 38 | 20 | 24 | 20 | 1 | 24 |
| .4480 | 28 | 20 | 24 | 25 | 1 | 24 | .5800 | 29 | 20 | 24 | 20 | 1 | 24 | .7642 | 40 | 22 | 29 | 23 | 1 | 24 |
| .4500 | 36 | 20 | 21 | 28 | 1 | 24 | .5840 | 32 | 23 | 34 | 27 | 1 | 24 | .7680 | 36 | 20 | 32 | 25 | 1 | 24 |
| .4520 | 28 | 26 | 34 | 27 | 1 | 24 | .5881 | 38 | 20 | 26 | 28 | 1 | 24 | .7721 | 38 | 21 | 32 | 25 | 1 | 24 |
| .4540 | 26 | 20 | 22 | 21 | 1 | 24 | .5918 | 36 | 21 | 29 | 28 | 1 | 24 | .7758 | 40 | 22 | 32 | 25 | 1 | 24 |
| .4560 | 36 | 25 | 38 | 40 | 1 | 24 | .5961 | 38 | 20 | 32 | 34 | 1 | 24 | .7800 | 36 | 20 | 26 | 20 | 1 | 24 |
| .4579 | 34 | 22 | 24 | 27 | 1 | 24 | .6000 | 30 | 20 | 24 | 20 | 1 | 24 | .7841 | 38 | 20 | 26 | 21 | 1 | 24 |
| .4600 | 30 | 20 | 23 | 25 | 1 | 24 | .6042 | 40 | 20 | 29 | 32 | 1 | 24 | .7879 | 40 | 20 | 26 | 22 | 1 | 24 |
| .4620 | 34 | 23 | 30 | 32 | 1 | 24 | .6080 | 36 | 25 | 38 | 30 | 1 | 24 | .7917 | 38 | 20 | 25 | 20 | 1 | 24 |
| .4640 | 29 | 20 | 24 | 25 | 1 | 24 | .6120 | 34 | 20 | 27 | 25 | 1 | 24 | .7951 | 38 | 21 | 29 | 22 | 1 | 24 |
| .4660 | 38 | 23 | 22 | 26 | 1 | 24 | .6159 | 34 | 23 | 30 | 24 | 1 | 24 | .8000 | 40 | 20 | 24 | 20 | 1 | 24 |
| .4680 | 27 | 20 | 26 | 25 | 1 | 24 | .6201 | 38 | 22 | 28 | 26 | 1 | 24 | .8042 | 40 | 21 | 38 | 30 | 1 | 24 |
| .4701 | 40 | 24 | 22 | 26 | 1 | 24 | .6240 | 36 | 20 | 26 | 25 | 1 | 24 | .8081 | 40 | 21 | 28 | 22 | 1 | 24 |
| .4720 | 30 | 22 | 27 | 26 | 1 | 24 | .6280 | 40 | 23 | 26 | 24 | 1 | 24 | .8127 | 40 | 21 | 32 | 25 | 1 | 24 |
| .4739 | 34 | 22 | 23 | 25 | 1 | 24 | .6321 | 34 | 20 | 29 | 26 | 1 | 24 | .8160 | 36 | 20 | 34 | 25 | 1 | 24 |
| .4760 | 34 | 20 | 21 | 25 | 1 | 24 | .6364 | 40 | 20 | 21 | 22 | 1 | 24 | .8203 | 38 | 21 | 34 | 25 | 1 | 24 |
| .4780 | 29 | 21 | 27 | 26 | 1 | 24 | .6400 | 32 | 20 | 24 | 20 | 1 | 24 | .8242 | 34 | 20 | 32 | 22 | 1 | 24 |
| .4800 | 36 | 20 | 20 | 25 | 1 | 24 | .6439 | 34 | 20 | 25 | 22 | 1 | 24 | .8282 | 40 | 21 | 30 | 23 | 1 | 24 |
| .4819 | 38 | 23 | 21 | 24 | 1 | 24 | .6480 | 36 | 20 | 27 | 25 | 1 | 24 | .8320 | 40 | 21 | 38 | 29 | 1 | 24 |
| .4839 | 34 | 21 | 26 | 29 | 1 | 24 | .6521 | 34 | 21 | 29 | 24 | 1 | 24 | .8352 | 38 | 21 | 36 | 26 | 1 | 24 |
| .4859 | 38 | 23 | 30 | 34 | 1 | 24 | .6560 | 38 | 20 | 29 | 28 | 1 | 24 | .8400 | 36 | 20 | 28 | 20 | 1 | 24 |
| .4880 | 34 | 22 | 36 | 38 | 1 | 24 | .6600 | 36 | 20 | 22 | 20 | 1 | 24 | .8444 | 38 | 20 | 28 | 21 | 1 | 24 |
| .4900 | 28 | 20 | 21 | 20 | 1 | 24 | .6640 | 36 | 22 | 28 | 23 | 1 | 24 | .8485 | 40 | 20 | 28 | 22 | 1 | 24 |
| .4921 | 28 | 22 | 29 | 25 | 1 | 24 | .6679 | 38 | 22 | 29 | 25 | 1 | 24 | .8511 | 38 | 22 | 34 | 23 | 1 | 24 |
| .4941 | 30 | 22 | 25 | 23 | 1 | 24 | .6720 | 36 | 20 | 28 | 25 | 1 | 24 | .8550 | 38 | 20 | 27 | 20 | 1 | 24 |
| .4960 | 30 | 21 | 25 | 24 | 1 | 24 | .6760 | 40 | 22 | 29 | 26 | 1 | 24 | .8613 | 38 | 20 | 34 | 25 | 1 | 24 |
| .4980 | 36 | 22 | 21 | 23 | 1 | 24 | .6800 | 34 | 20 | 24 | 20 | 1 | 24 | .8636 | 38 | 22 | 36 | 24 | 1 | 24 |
| .5000 | 25 | 20 | 24 | 20 | 1 | 24 | .6840 | 38 | 20 | 27 | 25 | 1 | 24 | .8686 | 38 | 21 | 36 | 25 | 1 | 24 |
| .5040 | 36 | 20 | 21 | 25 | 1 | 24 | .6878 | 40 | 21 | 26 | 24 | 1 | 24 | .8718 | 40 | 20 | 34 | 26 | 1 | 24 |
| .5080 | 38 | 22 | 30 | 34 | 1 | 24 | .6923 | 40 | 20 | 27 | 26 | 1 | 24 | .8769 | 38 | 20 | 36 | 26 | 1 | 24 |
| .5120 | 32 | 20 | 24 | 25 | 1 | 24 | .6960 | 36 | 20 | 29 | 25 | 1 | 24 | .8791 | 40 | 21 | 36 | 26 | 1 | 24 |
| .5160 | 38 | 20 | 22 | 27 | 1 | 24 | .7000 | 30 | 20 | 28 | 20 | 1 | 24 | .8834 | 40 | 21 | 32 | 23 | 1 | 24 |
| .5200 | 26 | 20 | 24 | 20 | 1 | 24 | .7039 | 34 | 21 | 30 | 23 | 1 | 24 | .8889 | 40 | 20 | 28 | 21 | 1 | 24 |
| .5241 | 38 | 20 | 24 | 29 | 1 | 24 | .7081 | 38 | 21 | 27 | 23 | 1 | 24 | .8917 | 38 | 21 | 34 | 23 | 1 | 24 |
| .5280 | 36 | 20 | 22 | 25 | 1 | 24 | .7125 | 38 | 20 | 27 | 24 | 1 | 24 | .8959 | 40 | 22 | 34 | 23 | 1 | 24 |
| .5320 | 38 | 20 | 21 | 25 | 1 | 24 | .7161 | 40 | 20 | 29 | 27 | 1 | 24 | .9000 | 40 | 20 | 27 | 20 | 1 | 24 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Table Trip Lever is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|---|----|--------|----|----|----|----|---|----|--------|----|----|----|----|---|----|
| .9048 | 40 | 20 | 38 | 28 | 1 | 24 | 1.1765 | 20 | 32 | 24 | 34 | 8 | 24 | 1.5440 | 23 | 32 | 29 | 36 | 8 | 24 |
| .9091 | 40 | 22 | 36 | 24 | 1 | 24 | 1.1842 | 20 | 32 | 27 | 38 | 8 | 24 | 1.5520 | 22 | 21 | 20 | 36 | 8 | 24 |
| .9120 | 38 | 20 | 36 | 25 | 1 | 24 | 1.1917 | 22 | 32 | 26 | 40 | 8 | 24 | 1.5600 | 26 | 30 | 27 | 40 | 8 | 24 |
| .9143 | 36 | 20 | 32 | 21 | 1 | 24 | 1.2000 | 21 | 28 | 24 | 40 | 8 | 24 | 1.5680 | 28 | 25 | 21 | 40 | 8 | 24 |
| .9206 | 40 | 20 | 29 | 21 | 1 | 24 | 1.2078 | 22 | 34 | 28 | 40 | 8 | 24 | 1.5758 | 26 | 22 | 20 | 40 | 8 | 24 |
| .9235 | 40 | 21 | 32 | 22 | 1 | 24 | 1.2164 | 20 | 30 | 26 | 38 | 8 | 24 | 1.5840 | 22 | 25 | 27 | 40 | 8 | 24 |
| .9280 | 40 | 21 | 38 | 26 | 1 | 24 | 1.2244 | 22 | 29 | 23 | 38 | 8 | 24 | 1.5922 | 21 | 30 | 29 | 34 | 8 | 24 |
| .9322 | 38 | 21 | 34 | 22 | 1 | 24 | 1.2320 | 21 | 25 | 22 | 40 | 8 | 24 | 1.6000 | 20 | 25 | 21 | 28 | 8 | 24 |
| .9362 | 38 | 20 | 34 | 23 | 1 | 24 | 1.2402 | 22 | 32 | 23 | 34 | 8 | 24 | 1.6082 | 22 | 24 | 25 | 38 | 8 | 24 |
| .9366 | 40 | 21 | 34 | 23 | 1 | 24 | 1.2476 | 20 | 36 | 32 | 38 | 8 | 24 | 1.6161 | 27 | 34 | 29 | 38 | 8 | 24 |
| .9441 | 38 | 21 | 36 | 23 | 1 | 24 | 1.2554 | 23 | 36 | 28 | 38 | 8 | 24 | 1.6240 | 29 | 25 | 21 | 40 | 8 | 24 |
| .9486 | 40 | 22 | 36 | 23 | 1 | 24 | 1.2639 | 21 | 32 | 26 | 36 | 8 | 24 | 1.6314 | 26 | 34 | 32 | 40 | 8 | 24 |
| .9524 | 40 | 20 | 30 | 21 | 1 | 24 | 1.2719 | 25 | 38 | 29 | 40 | 8 | 24 | 1.6399 | 23 | 22 | 20 | 34 | 8 | 24 |
| .9596 | 40 | 22 | 38 | 24 | 1 | 24 | 1.2800 | 20 | 25 | 24 | 40 | 8 | 24 | 1.6476 | 27 | 23 | 20 | 38 | 8 | 24 |
| .9600 | 36 | 20 | 32 | 20 | 1 | 24 | 1.2880 | 21 | 25 | 23 | 40 | 8 | 24 | 1.6560 | 23 | 25 | 27 | 40 | 8 | 24 |
| .9651 | 38 | 20 | 32 | 21 | 1 | 24 | 1.2963 | 20 | 24 | 21 | 36 | 8 | 24 | 1.6640 | 24 | 25 | 26 | 40 | 8 | 24 |
| .9667 | 29 | 20 | 40 | 20 | 1 | 24 | 1.3037 | 22 | 36 | 32 | 40 | 8 | 24 | 1.6719 | 20 | 22 | 20 | 29 | 8 | 24 |
| .9714 | 36 | 20 | 34 | 21 | 1 | 24 | 1.3123 | 22 | 38 | 34 | 40 | 8 | 24 | 1.6800 | 30 | 25 | 21 | 40 | 8 | 24 |
| .9744 | 40 | 20 | 38 | 26 | 1 | 24 | 1.3200 | 22 | 30 | 27 | 40 | 8 | 24 | 1.6878 | 22 | 28 | 29 | 36 | 8 | 24 |
| .9812 | 40 | 21 | 34 | 22 | 1 | 24 | 1.3282 | 20 | 29 | 26 | 36 | 8 | 24 | 1.6959 | 29 | 36 | 30 | 38 | 8 | 24 |
| .9825 | 20 | 38 | 28 | 40 | 8 | 24 | 1.3362 | 20 | 27 | 23 | 34 | 8 | 24 | 1.7039 | 21 | 29 | 30 | 34 | 8 | 24 |
| .9882 | 21 | 34 | 24 | 40 | 8 | 24 | 1.3440 | 21 | 25 | 24 | 40 | 8 | 24 | 1.7119 | 24 | 27 | 26 | 36 | 8 | 24 |
| .9922 | 22 | 34 | 23 | 40 | 8 | 24 | 1.3523 | 20 | 29 | 25 | 34 | 8 | 24 | 1.7196 | 25 | 28 | 26 | 36 | 8 | 24 |
| .9969 | 21 | 34 | 23 | 38 | 8 | 24 | 1.3603 | 21 | 26 | 24 | 38 | 8 | 24 | 1.7280 | 24 | 25 | 27 | 40 | 8 | 24 |
| 1.0000 | 20 | 28 | 21 | 40 | 8 | 24 | 1.3684 | 21 | 28 | 26 | 38 | 8 | 24 | 1.7361 | 25 | 32 | 30 | 36 | 8 | 24 |
| 1.0088 | 20 | 32 | 23 | 38 | 8 | 24 | 1.3761 | 21 | 26 | 23 | 36 | 8 | 24 | 1.7438 | 23 | 30 | 29 | 34 | 8 | 24 |
| 1.0163 | 20 | 29 | 21 | 38 | 8 | 24 | 1.3841 | 22 | 29 | 26 | 38 | 8 | 24 | 1.7524 | 20 | 25 | 23 | 28 | 8 | 24 |
| 1.0234 | 21 | 36 | 25 | 38 | 8 | 24 | 1.3918 | 21 | 36 | 34 | 38 | 8 | 24 | 1.7600 | 21 | 25 | 22 | 28 | 8 | 24 |
| 1.0320 | 20 | 34 | 25 | 38 | 8 | 24 | 1.4000 | 20 | 25 | 21 | 32 | 8 | 24 | 1.7679 | 22 | 28 | 27 | 32 | 8 | 24 |
| 1.0402 | 21 | 34 | 24 | 38 | 8 | 24 | 1.4080 | 22 | 25 | 24 | 40 | 8 | 24 | 1.7763 | 27 | 32 | 30 | 38 | 8 | 24 |
| 1.0476 | 20 | 28 | 22 | 40 | 8 | 24 | 1.4161 | 21 | 29 | 22 | 30 | 8 | 24 | 1.7837 | 20 | 23 | 20 | 26 | 8 | 24 |
| 1.0575 | 20 | 29 | 23 | 40 | 8 | 24 | 1.4241 | 23 | 34 | 30 | 38 | 8 | 24 | 1.7920 | 21 | 25 | 24 | 30 | 8 | 24 |
| 1.0643 | 21 | 36 | 26 | 38 | 8 | 24 | 1.4321 | 20 | 30 | 29 | 36 | 8 | 24 | 1.8000 | 20 | 20 | 27 | 40 | 8 | 24 |
| 1.0721 | 22 | 36 | 25 | 38 | 8 | 24 | 1.4400 | 20 | 25 | 27 | 40 | 8 | 24 | 1.8077 | 28 | 25 | 23 | 38 | 8 | 24 |
| 1.0796 | 20 | 26 | 20 | 38 | 8 | 24 | 1.4481 | 23 | 36 | 34 | 40 | 8 | 24 | 1.8159 | 22 | 28 | 26 | 30 | 8 | 24 |
| 1.0889 | 21 | 36 | 28 | 40 | 8 | 24 | 1.4560 | 21 | 25 | 26 | 40 | 8 | 24 | 1.8238 | 34 | 29 | 21 | 36 | 8 | 24 |
| 1.0965 | 20 | 32 | 25 | 38 | 8 | 24 | 1.4641 | 21 | 27 | 24 | 34 | 8 | 24 | 1.8316 | 29 | 38 | 36 | 40 | 8 | 24 |
| 1.1034 | 20 | 29 | 24 | 40 | 8 | 24 | 1.4720 | 23 | 25 | 24 | 40 | 8 | 24 | 1.8400 | 21 | 25 | 23 | 28 | 8 | 24 |
| 1.1118 | 21 | 34 | 27 | 40 | 8 | 24 | 1.4803 | 25 | 32 | 27 | 38 | 8 | 24 | 1.8480 | 26 | 32 | 29 | 34 | 8 | 24 |
| 1.1200 | 21 | 30 | 24 | 40 | 8 | 24 | 1.4881 | 20 | 28 | 25 | 32 | 8 | 24 | 1.8560 | 24 | 25 | 29 | 40 | 8 | 24 |
| 1.1282 | 20 | 26 | 22 | 40 | 8 | 24 | 1.4957 | 21 | 26 | 25 | 36 | 8 | 24 | 1.8640 | 25 | 32 | 34 | 38 | 8 | 24 |
| 1.1359 | 20 | 29 | 21 | 34 | 8 | 24 | 1.5038 | 30 | 28 | 20 | 38 | 8 | 24 | 1.8720 | 26 | 25 | 27 | 40 | 8 | 24 |
| 1.1438 | 21 | 34 | 25 | 36 | 8 | 24 | 1.5120 | 27 | 25 | 21 | 40 | 8 | 24 | 1.8799 | 23 | 29 | 32 | 36 | 8 | 24 |
| 1.1523 | 20 | 27 | 21 | 36 | 8 | 24 | 1.5204 | 24 | 26 | 21 | 34 | 8 | 24 | 1.8882 | 25 | 27 | 26 | 34 | 8 | 24 |
| 1.1594 | 20 | 23 | 20 | 40 | 8 | 24 | 1.5278 | 22 | 32 | 30 | 36 | 8 | 24 | 1.8958 | 26 | 24 | 21 | 32 | 8 | 24 |
| 1.1688 | 21 | 29 | 23 | 38 | 8 | 24 | 1.5364 | 28 | 27 | 20 | 36 | 8 | 24 | 1.9040 | 32 | 29 | 22 | 34 | 8 | 24 |

TABLE 3 (continued) - LEADS - LOW LEAD ATTACHMENT

CAUTION Be Sure Table Trip Lever is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|---|----|--------|----|----|----|----|---|----|--------|----|----|----|----|---|----|
| 1.9118 | 26 | 32 | 30 | 34 | 8 | 24 | 2.5464 | 36 | 26 | 20 | 29 | 8 | 24 | 3.2653 | 36 | 21 | 20 | 28 | 8 | 24 |
| 1.9200 | 21 | 25 | 24 | 28 | 8 | 24 | 2.5625 | 38 | 29 | 22 | 30 | 8 | 24 | 3.2808 | 28 | 30 | 29 | 22 | 8 | 24 |
| 1.9276 | 22 | 25 | 23 | 28 | 8 | 24 | 2.5780 | 36 | 23 | 21 | 34 | 8 | 24 | 3.2970 | 34 | 22 | 20 | 25 | 8 | 24 |
| 1.9360 | 23 | 22 | 25 | 36 | 8 | 24 | 2.5941 | 26 | 21 | 22 | 28 | 8 | 24 | 3.3126 | 24 | 21 | 25 | 23 | 8 | 24 |
| 1.9441 | 22 | 38 | 34 | 27 | 8 | 24 | 2.6087 | 27 | 23 | 20 | 24 | 8 | 24 | 3.3280 | 26 | 20 | 24 | 25 | 8 | 24 |
| 1.9521 | 21 | 34 | 32 | 27 | 8 | 24 | 2.6250 | 30 | 20 | 21 | 32 | 8 | 24 | 3.3438 | 40 | 22 | 20 | 29 | 8 | 24 |
| 1.9600 | 28 | 20 | 21 | 40 | 8 | 24 | 2.6411 | 36 | 22 | 23 | 38 | 8 | 24 | 3.3599 | 38 | 26 | 25 | 29 | 8 | 24 |
| 1.9679 | 23 | 22 | 24 | 34 | 8 | 24 | 2.6564 | 40 | 29 | 26 | 36 | 8 | 24 | 3.3750 | 30 | 20 | 27 | 32 | 8 | 24 |
| 1.9761 | 32 | 25 | 22 | 38 | 8 | 24 | 2.6721 | 38 | 29 | 26 | 34 | 8 | 24 | 3.3913 | 36 | 23 | 26 | 32 | 8 | 24 |
| 1.9839 | 28 | 23 | 22 | 36 | 8 | 24 | 2.6879 | 38 | 26 | 20 | 29 | 8 | 24 | 3.4062 | 32 | 28 | 38 | 34 | 8 | 24 |
| 1.9923 | 20 | 29 | 26 | 24 | 8 | 24 | 2.7031 | 40 | 27 | 26 | 38 | 8 | 24 | 3.4222 | 28 | 20 | 22 | 24 | 8 | 24 |
| 2.0000 | 21 | 20 | 20 | 28 | 8 | 24 | 2.7187 | 29 | 24 | 27 | 32 | 8 | 24 | 3.4373 | 36 | 23 | 28 | 34 | 8 | 24 |
| 2.0160 | 21 | 30 | 27 | 25 | 8 | 24 | 2.7340 | 28 | 22 | 29 | 36 | 8 | 24 | 3.4528 | 38 | 25 | 23 | 27 | 8 | 24 |
| 2.0317 | 20 | 21 | 20 | 25 | 8 | 24 | 2.7500 | 30 | 20 | 22 | 32 | 8 | 24 | 3.4690 | 34 | 23 | 22 | 25 | 8 | 24 |
| 2.0468 | 25 | 24 | 28 | 38 | 8 | 24 | 2.7657 | 34 | 26 | 23 | 29 | 8 | 24 | 3.4846 | 36 | 29 | 40 | 38 | 8 | 24 |
| 2.0625 | 27 | 24 | 22 | 32 | 8 | 24 | 2.7812 | 32 | 25 | 22 | 27 | 8 | 24 | 3.5000 | 25 | 20 | 21 | 20 | 8 | 24 |
| 2.0779 | 24 | 22 | 20 | 28 | 8 | 24 | 2.7972 | 24 | 22 | 25 | 26 | 8 | 24 | 3.5152 | 29 | 20 | 20 | 22 | 8 | 24 |
| 2.0934 | 25 | 23 | 26 | 36 | 8 | 24 | 2.8125 | 26 | 21 | 23 | 27 | 8 | 24 | 3.5313 | 38 | 22 | 23 | 30 | 8 | 24 |
| 2.1093 | 23 | 27 | 26 | 28 | 8 | 24 | 2.8283 | 30 | 22 | 28 | 36 | 8 | 24 | 3.5468 | 30 | 21 | 27 | 29 | 8 | 24 |
| 2.1250 | 34 | 28 | 21 | 32 | 8 | 24 | 2.8444 | 28 | 21 | 20 | 25 | 8 | 24 | 3.5625 | 38 | 24 | 27 | 32 | 8 | 24 |
| 2.1405 | 24 | 23 | 20 | 26 | 8 | 24 | 2.8608 | 40 | 27 | 21 | 29 | 8 | 24 | 3.5778 | 28 | 20 | 23 | 24 | 8 | 24 |
| 2.1562 | 23 | 24 | 27 | 32 | 8 | 24 | 2.8750 | 30 | 20 | 23 | 32 | 8 | 24 | 3.5936 | 36 | 22 | 28 | 34 | 8 | 24 |
| 2.1719 | 36 | 26 | 20 | 34 | 8 | 24 | 2.8908 | 34 | 23 | 22 | 30 | 8 | 24 | 3.6090 | 40 | 21 | 27 | 38 | 8 | 24 |
| 2.1875 | 30 | 24 | 21 | 32 | 8 | 24 | 2.9060 | 34 | 24 | 20 | 26 | 8 | 24 | 3.6250 | 30 | 20 | 29 | 32 | 8 | 24 |
| 2.2031 | 23 | 24 | 25 | 29 | 8 | 24 | 2.9217 | 24 | 20 | 21 | 23 | 8 | 24 | 3.6400 | 26 | 20 | 21 | 20 | 8 | 24 |
| 2.2187 | 24 | 25 | 26 | 30 | 8 | 24 | 2.9372 | 38 | 23 | 24 | 36 | 8 | 24 | 3.6558 | 29 | 22 | 26 | 25 | 8 | 24 |
| 2.2341 | 26 | 25 | 29 | 36 | 8 | 24 | 2.9531 | 26 | 20 | 23 | 27 | 8 | 24 | 3.6715 | 38 | 23 | 25 | 30 | 8 | 24 |
| 2.2500 | 27 | 24 | 21 | 28 | 8 | 24 | 2.9683 | 34 | 21 | 22 | 32 | 8 | 24 | 3.6872 | 32 | 24 | 28 | 27 | 8 | 24 |
| 2.2657 | 28 | 25 | 22 | 29 | 8 | 24 | 2.9843 | 34 | 22 | 21 | 29 | 8 | 24 | 3.7029 | 36 | 25 | 27 | 28 | 8 | 24 |
| 2.2815 | 22 | 20 | 21 | 27 | 8 | 24 | 3.0000 | 27 | 20 | 20 | 24 | 8 | 24 | 3.7182 | 40 | 27 | 32 | 34 | 8 | 24 |
| 2.2967 | 36 | 22 | 20 | 38 | 8 | 24 | 3.0159 | 38 | 24 | 20 | 28 | 8 | 24 | 3.7346 | 36 | 23 | 34 | 38 | 8 | 24 |
| 2.3126 | 29 | 22 | 25 | 38 | 8 | 24 | 3.0313 | 38 | 26 | 21 | 27 | 8 | 24 | 3.7500 | 25 | 24 | 27 | 20 | 8 | 24 |
| 2.3280 | 22 | 21 | 20 | 24 | 8 | 24 | 3.0465 | 26 | 30 | 29 | 22 | 8 | 24 | 3.7658 | 28 | 23 | 29 | 25 | 8 | 24 |
| 2.3437 | 25 | 24 | 27 | 32 | 8 | 24 | 3.0623 | 36 | 26 | 22 | 28 | 8 | 24 | 3.7818 | 30 | 22 | 26 | 25 | 8 | 24 |
| 2.3590 | 23 | 20 | 20 | 26 | 8 | 24 | 3.0782 | 34 | 24 | 22 | 27 | 8 | 24 | 3.7968 | 26 | 20 | 23 | 21 | 8 | 24 |
| 2.3750 | 38 | 28 | 21 | 32 | 8 | 24 | 3.0933 | 29 | 20 | 20 | 25 | 8 | 24 | 3.8119 | 38 | 22 | 24 | 29 | 8 | 24 |
| 2.3908 | 26 | 20 | 20 | 29 | 8 | 24 | 3.1093 | 32 | 38 | 36 | 26 | 8 | 24 | 3.8281 | 38 | 25 | 34 | 36 | 8 | 24 |
| 2.4064 | 25 | 22 | 27 | 34 | 8 | 24 | 3.1250 | 30 | 20 | 25 | 32 | 8 | 24 | 3.8437 | 38 | 20 | 22 | 29 | 8 | 24 |
| 2.4217 | 34 | 26 | 25 | 36 | 8 | 24 | 3.1401 | 25 | 23 | 26 | 24 | 8 | 24 | 3.8601 | 36 | 22 | 23 | 26 | 8 | 24 |
| 2.4375 | 26 | 24 | 27 | 32 | 8 | 24 | 3.1565 | 24 | 28 | 29 | 21 | 8 | 24 | 3.8746 | 30 | 26 | 34 | 27 | 8 | 24 |
| 2.4533 | 23 | 20 | 20 | 25 | 8 | 24 | 3.1724 | 23 | 29 | 30 | 20 | 8 | 24 | 3.8889 | 28 | 20 | 25 | 24 | 8 | 24 |
| 2.4686 | 24 | 25 | 27 | 28 | 8 | 24 | 3.1875 | 27 | 32 | 34 | 24 | 8 | 24 | 3.9057 | 29 | 22 | 30 | 27 | 8 | 24 |
| 2.4845 | 24 | 23 | 25 | 28 | 8 | 24 | 3.2031 | 38 | 24 | 22 | 29 | 8 | 24 | 3.9216 | 40 | 20 | 25 | 34 | 8 | 24 |
| 2.5000 | 25 | 20 | 21 | 28 | 8 | 24 | 3.2188 | 27 | 34 | 38 | 25 | 8 | 24 | 3.9370 | 28 | 22 | 29 | 25 | 8 | 24 |
| 2.5151 | 28 | 25 | 32 | 38 | 8 | 24 | 3.2339 | 29 | 22 | 23 | 25 | 8 | 24 | 3.9529 | 36 | 20 | 28 | 34 | 8 | 24 |
| 2.5312 | 26 | 21 | 23 | 30 | 8 | 24 | 3.2500 | 30 | 20 | 26 | 32 | 8 | 24 | 3.9686 | 34 | 22 | 26 | 27 | 8 | 24 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Table Trip Lever is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|---|----|--------|----|----|----|----|---|----|--------|----|----|----|----|---|----|
| 3.9842 | 36 | 22 | 21 | 23 | 8 | 24 | 5.4071 | 38 | 22 | 27 | 23 | 8 | 24 | 6.8400 | 38 | 20 | 27 | 20 | 8 | 24 |
| 4.0000 | 25 | 20 | 24 | 20 | 8 | 24 | 5.4373 | 40 | 23 | 34 | 29 | 8 | 24 | 6.8687 | 40 | 24 | 34 | 22 | 8 | 24 |
| 4.0318 | 38 | 26 | 30 | 29 | 8 | 24 | 5.4688 | 38 | 21 | 34 | 30 | 8 | 24 | 6.9079 | 34 | 21 | 32 | 20 | 8 | 24 |
| 4.0627 | 36 | 22 | 27 | 29 | 8 | 24 | 5.5020 | 36 | 22 | 29 | 23 | 8 | 24 | 6.9333 | 40 | 20 | 26 | 20 | 8 | 24 |
| 4.0936 | 34 | 23 | 27 | 26 | 8 | 24 | 5.5309 | 40 | 20 | 28 | 27 | 8 | 24 | 6.9744 | 40 | 20 | 34 | 26 | 8 | 24 |
| 4.1244 | 28 | 21 | 29 | 25 | 8 | 24 | 5.5636 | 34 | 20 | 27 | 22 | 8 | 24 | 6.9968 | 38 | 20 | 29 | 21 | 8 | 24 |
| 4.1558 | 36 | 21 | 20 | 22 | 8 | 24 | 5.5944 | 40 | 22 | 30 | 26 | 8 | 24 | 7.0154 | 38 | 26 | 36 | 20 | 8 | 24 |
| 4.1889 | 29 | 20 | 26 | 24 | 8 | 24 | 5.6242 | 32 | 20 | 29 | 22 | 8 | 24 | 7.0303 | 40 | 22 | 29 | 20 | 8 | 24 |
| 4.2182 | 29 | 20 | 24 | 22 | 8 | 24 | 5.6566 | 40 | 22 | 28 | 24 | 8 | 24 | 7.0649 | 36 | 22 | 34 | 21 | 8 | 24 |
| 4.2500 | 36 | 24 | 34 | 32 | 8 | 24 | 5.6889 | 32 | 20 | 28 | 21 | 8 | 24 | 7.0933 | 38 | 20 | 28 | 20 | 8 | 24 |
| 4.2809 | 40 | 23 | 24 | 26 | 8 | 24 | 5.7190 | 38 | 21 | 32 | 27 | 8 | 24 | 7.1332 | 38 | 23 | 34 | 21 | 8 | 24 |
| 4.3098 | 40 | 22 | 24 | 27 | 8 | 24 | 5.7464 | 40 | 22 | 32 | 27 | 8 | 24 | 7.1487 | 40 | 27 | 38 | 21 | 8 | 24 |
| 4.3439 | 40 | 26 | 36 | 34 | 8 | 24 | 5.7778 | 40 | 20 | 26 | 24 | 8 | 24 | 7.1958 | 40 | 24 | 34 | 21 | 8 | 24 |
| 4.3761 | 32 | 21 | 28 | 26 | 8 | 24 | 5.8120 | 40 | 24 | 34 | 26 | 8 | 24 | 7.2095 | 38 | 23 | 36 | 22 | 8 | 24 |
| 4.4065 | 40 | 26 | 29 | 27 | 8 | 24 | 5.8435 | 36 | 20 | 28 | 23 | 8 | 24 | 7.2533 | 34 | 20 | 32 | 20 | 8 | 24 |
| 4.4373 | 32 | 20 | 26 | 25 | 8 | 24 | 5.8744 | 38 | 21 | 28 | 23 | 8 | 24 | 7.2727 | 40 | 24 | 36 | 22 | 8 | 24 |
| 4.4690 | 36 | 20 | 27 | 29 | 8 | 24 | 5.9077 | 36 | 25 | 40 | 26 | 8 | 24 | 7.3143 | 36 | 21 | 32 | 20 | 8 | 24 |
| 4.5000 | 27 | 20 | 25 | 20 | 8 | 24 | 5.9362 | 40 | 23 | 32 | 25 | 8 | 24 | 7.3430 | 40 | 24 | 38 | 23 | 8 | 24 |
| 4.5315 | 36 | 22 | 27 | 26 | 8 | 24 | 5.9674 | 40 | 22 | 32 | 26 | 8 | 24 | 7.3697 | 40 | 25 | 38 | 22 | 8 | 24 |
| 4.5630 | 38 | 23 | 29 | 28 | 8 | 24 | 6.0000 | 36 | 20 | 25 | 20 | 8 | 24 | 7.4182 | 36 | 22 | 34 | 20 | 8 | 24 |
| 4.5938 | 38 | 25 | 34 | 30 | 8 | 24 | 6.0317 | 38 | 20 | 25 | 21 | 8 | 24 | 7.4237 | 40 | 26 | 38 | 21 | 8 | 24 |
| 4.6243 | 38 | 21 | 23 | 24 | 8 | 24 | 6.0606 | 40 | 20 | 25 | 22 | 8 | 24 | 7.4667 | 40 | 20 | 28 | 20 | 8 | 24 |
| 4.6561 | 40 | 21 | 22 | 24 | 8 | 24 | 6.0952 | 40 | 20 | 24 | 21 | 8 | 24 | 7.5062 | 40 | 27 | 38 | 20 | 8 | 24 |
| 4.6869 | 40 | 22 | 29 | 30 | 8 | 24 | 6.1222 | 38 | 20 | 29 | 24 | 8 | 24 | 7.5528 | 38 | 23 | 36 | 21 | 8 | 24 |
| 4.7179 | 40 | 20 | 23 | 26 | 8 | 24 | 6.1538 | 40 | 20 | 30 | 26 | 8 | 24 | 7.5556 | 40 | 24 | 34 | 20 | 8 | 24 |
| 4.7500 | 38 | 20 | 30 | 32 | 8 | 24 | 6.1867 | 32 | 20 | 29 | 20 | 8 | 24 | 7.5889 | 40 | 23 | 36 | 22 | 8 | 24 |
| 4.7816 | 40 | 20 | 26 | 29 | 8 | 24 | 6.2182 | 38 | 20 | 27 | 22 | 8 | 24 | 7.6190 | 40 | 21 | 30 | 20 | 8 | 24 |
| 4.8120 | 40 | 21 | 36 | 38 | 8 | 24 | 6.2515 | 40 | 21 | 32 | 26 | 8 | 24 | 7.6768 | 40 | 24 | 38 | 22 | 8 | 24 |
| 4.8417 | 36 | 23 | 29 | 25 | 8 | 24 | 6.2799 | 34 | 21 | 32 | 22 | 8 | 24 | 7.6800 | 36 | 20 | 32 | 20 | 8 | 24 |
| 4.8762 | 32 | 20 | 24 | 21 | 8 | 24 | 6.3101 | 38 | 21 | 34 | 26 | 8 | 24 | 7.7206 | 38 | 21 | 32 | 20 | 8 | 24 |
| 4.9067 | 32 | 20 | 23 | 20 | 8 | 24 | 6.3443 | 36 | 23 | 38 | 25 | 8 | 24 | 7.7576 | 40 | 22 | 32 | 20 | 8 | 24 |
| 4.9371 | 36 | 21 | 27 | 25 | 8 | 24 | 6.3776 | 36 | 22 | 38 | 26 | 8 | 24 | 7.7714 | 36 | 21 | 34 | 20 | 8 | 24 |
| 4.9689 | 36 | 21 | 25 | 23 | 8 | 24 | 6.4044 | 40 | 21 | 29 | 23 | 8 | 24 | 7.7949 | 40 | 20 | 38 | 26 | 8 | 24 |
| 5.0000 | 30 | 20 | 25 | 20 | 8 | 24 | 6.4339 | 40 | 21 | 38 | 30 | 8 | 24 | 7.8499 | 40 | 21 | 34 | 22 | 8 | 24 |
| 5.0317 | 38 | 25 | 36 | 29 | 8 | 24 | 6.4646 | 40 | 21 | 28 | 22 | 8 | 24 | 7.8841 | 40 | 20 | 34 | 23 | 8 | 24 |
| 5.0618 | 36 | 22 | 29 | 25 | 8 | 24 | 6.5016 | 40 | 21 | 32 | 25 | 8 | 24 | 7.8961 | 38 | 21 | 36 | 22 | 8 | 24 |
| 5.0928 | 36 | 26 | 40 | 29 | 8 | 24 | 6.5306 | 40 | 21 | 36 | 28 | 8 | 24 | 7.9304 | 38 | 20 | 36 | 23 | 8 | 24 |
| 5.1246 | 34 | 20 | 26 | 23 | 8 | 24 | 6.5625 | 38 | 21 | 34 | 25 | 8 | 24 | 7.9503 | 40 | 21 | 36 | 23 | 8 | 24 |
| 5.1556 | 28 | 20 | 29 | 21 | 8 | 24 | 6.5939 | 34 | 20 | 32 | 22 | 8 | 24 | | | | | | | |
| 5.1840 | 36 | 20 | 27 | 25 | 8 | 24 | 6.6253 | 40 | 21 | 30 | 23 | 8 | 24 | | | | | | | |
| 5.2200 | 29 | 20 | 27 | 20 | 8 | 24 | 6.6557 | 40 | 29 | 38 | 21 | 8 | 24 | | | | | | | |
| 5.2513 | 40 | 25 | 32 | 26 | 8 | 24 | 6.6813 | 38 | 26 | 36 | 21 | 8 | 24 | | | | | | | |
| 5.2825 | 32 | 20 | 26 | 21 | 8 | 24 | 6.7200 | 36 | 20 | 28 | 20 | 8 | 24 | | | | | | | |
| 5.3123 | 36 | 22 | 28 | 23 | 8 | 24 | 6.7457 | 40 | 22 | 32 | 23 | 8 | 24 | | | | | | | |
| 5.3430 | 38 | 22 | 29 | 25 | 8 | 24 | 6.7781 | 40 | 26 | 38 | 23 | 8 | 24 | | | | | | | |
| 5.3755 | 34 | 22 | 30 | 23 | 8 | 24 | 6.8090 | 38 | 22 | 34 | 23 | 8 | 24 | | | | | | | |

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Feed Direction Lever on Change Gear Box is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|
| 8.0000 | 20 | 30 | 20 | 40 | 24 | 8 | 10.875 | 20 | 32 | 29 | 40 | 24 | 8 | 13.750 | 20 | 24 | 22 | 32 | 24 | 8 |
| 8.0702 | 20 | 36 | 23 | 38 | 24 | 8 | 10.937 | 21 | 32 | 25 | 36 | 24 | 8 | 13.810 | 20 | 28 | 29 | 36 | 24 | 8 |
| 8.1176 | 20 | 34 | 23 | 40 | 24 | 8 | 11.000 | 20 | 30 | 22 | 32 | 24 | 8 | 13.867 | 26 | 36 | 32 | 40 | 24 | 8 |
| 8.1734 | 20 | 34 | 22 | 38 | 24 | 8 | 11.053 | 25 | 38 | 28 | 40 | 24 | 8 | 13.938 | 20 | 29 | 32 | 38 | 24 | 8 |
| 8.2500 | 20 | 32 | 22 | 40 | 24 | 8 | 11.118 | 21 | 34 | 30 | 40 | 24 | 8 | 14.000 | 20 | 24 | 21 | 30 | 24 | 8 |
| 8.3333 | 20 | 32 | 20 | 36 | 24 | 8 | 11.191 | 21 | 32 | 27 | 38 | 24 | 8 | 14.063 | 25 | 32 | 30 | 40 | 24 | 8 |
| 8.4000 | 20 | 30 | 21 | 40 | 24 | 8 | 11.250 | 20 | 28 | 21 | 32 | 24 | 8 | 14.123 | 22 | 27 | 26 | 36 | 24 | 8 |
| 8.4333 | 22 | 36 | 23 | 40 | 24 | 8 | 11.313 | 21 | 34 | 29 | 38 | 24 | 8 | 14.187 | 20 | 28 | 24 | 29 | 24 | 8 |
| 8.5235 | 21 | 34 | 23 | 40 | 24 | 8 | 11.375 | 21 | 32 | 26 | 36 | 24 | 8 | 14.250 | 20 | 40 | 38 | 32 | 24 | 8 |
| 8.5714 | 20 | 28 | 20 | 40 | 24 | 8 | 11.435 | 24 | 34 | 27 | 40 | 24 | 8 | 14.311 | 21 | 27 | 23 | 30 | 24 | 8 |
| 8.6250 | 20 | 32 | 23 | 40 | 24 | 8 | 11.500 | 20 | 24 | 23 | 40 | 24 | 8 | 14.375 | 20 | 24 | 23 | 32 | 24 | 8 |
| 8.6897 | 20 | 29 | 21 | 40 | 24 | 8 | 11.556 | 20 | 27 | 26 | 40 | 24 | 8 | 14.437 | 21 | 24 | 22 | 32 | 24 | 8 |
| 8.7500 | 20 | 32 | 21 | 36 | 24 | 8 | 11.621 | 23 | 38 | 32 | 40 | 24 | 8 | 14.500 | 29 | 24 | 20 | 40 | 24 | 8 |
| 8.8235 | 20 | 32 | 20 | 34 | 24 | 8 | 11.684 | 20 | 29 | 24 | 34 | 24 | 8 | 14.560 | 21 | 25 | 26 | 36 | 24 | 8 |
| 8.8772 | 22 | 36 | 23 | 38 | 24 | 8 | 11.757 | 21 | 29 | 23 | 34 | 24 | 8 | 14.625 | 21 | 28 | 26 | 32 | 24 | 8 |
| 8.9294 | 22 | 34 | 23 | 40 | 24 | 8 | 11.813 | 21 | 32 | 27 | 36 | 24 | 8 | 14.682 | 26 | 34 | 32 | 40 | 24 | 8 |
| 9.0000 | 20 | 28 | 21 | 40 | 24 | 8 | 11.880 | 22 | 30 | 27 | 40 | 24 | 8 | 14.753 | 22 | 40 | 38 | 34 | 24 | 8 |
| 9.0588 | 21 | 34 | 22 | 36 | 24 | 8 | 11.937 | 21 | 30 | 27 | 38 | 24 | 8 | 14.815 | 20 | 24 | 20 | 27 | 24 | 8 |
| 9.1228 | 20 | 36 | 26 | 38 | 24 | 8 | 12.000 | 20 | 25 | 20 | 32 | 24 | 8 | 14.875 | 21 | 36 | 34 | 32 | 24 | 8 |
| 9.1954 | 20 | 29 | 20 | 36 | 24 | 8 | 12.057 | 20 | 22 | 21 | 38 | 24 | 8 | 14.933 | 20 | 25 | 21 | 27 | 24 | 8 |
| 9.2400 | 21 | 30 | 22 | 40 | 24 | 8 | 12.126 | 20 | 25 | 24 | 38 | 24 | 8 | 15.000 | 20 | 24 | 21 | 28 | 24 | 8 |
| 9.3176 | 22 | 34 | 24 | 40 | 24 | 8 | 12.170 | 20 | 29 | 25 | 34 | 24 | 8 | 15.062 | 21 | 29 | 26 | 30 | 24 | 8 |
| 9.3750 | 20 | 32 | 25 | 40 | 24 | 8 | 12.250 | 21 | 32 | 28 | 36 | 24 | 8 | 15.126 | 24 | 28 | 25 | 34 | 24 | 8 |
| 9.4421 | 23 | 38 | 26 | 40 | 24 | 8 | 12.316 | 21 | 28 | 26 | 38 | 24 | 8 | 15.188 | 21 | 28 | 27 | 32 | 24 | 8 |
| 9.4875 | 22 | 32 | 23 | 40 | 24 | 8 | 12.375 | 21 | 28 | 22 | 32 | 24 | 8 | 15.247 | 27 | 34 | 32 | 40 | 24 | 8 |
| 9.5586 | 21 | 29 | 22 | 40 | 24 | 8 | 12.434 | 21 | 32 | 30 | 38 | 24 | 8 | 15.312 | 29 | 25 | 22 | 40 | 24 | 8 |
| 9.6250 | 21 | 32 | 22 | 36 | 24 | 8 | 12.500 | 25 | 36 | 30 | 40 | 24 | 8 | 15.374 | 21 | 26 | 23 | 29 | 24 | 8 |
| 9.6842 | 20 | 30 | 23 | 38 | 24 | 8 | 12.567 | 26 | 36 | 29 | 40 | 24 | 8 | 15.439 | 30 | 27 | 22 | 38 | 24 | 8 |
| 9.7500 | 20 | 32 | 26 | 40 | 24 | 8 | 12.627 | 21 | 27 | 23 | 34 | 24 | 8 | 15.502 | 27 | 22 | 20 | 38 | 24 | 8 |
| 9.8080 | 22 | 34 | 24 | 38 | 24 | 8 | 12.687 | 21 | 32 | 29 | 36 | 24 | 8 | 15.562 | 28 | 25 | 22 | 38 | 24 | 8 |
| 9.8765 | 20 | 27 | 20 | 36 | 24 | 8 | 12.750 | 20 | 32 | 34 | 40 | 24 | 8 | 15.625 | 25 | 32 | 30 | 36 | 24 | 8 |
| 9.9310 | 20 | 29 | 24 | 40 | 24 | 8 | 12.814 | 23 | 28 | 26 | 40 | 24 | 8 | 15.688 | 23 | 25 | 27 | 38 | 24 | 8 |
| 10.000 | 20 | 30 | 25 | 40 | 24 | 8 | 12.874 | 20 | 27 | 21 | 29 | 24 | 8 | 15.750 | 21 | 20 | 20 | 32 | 24 | 8 |
| 10.063 | 21 | 32 | 23 | 36 | 24 | 8 | 12.938 | 21 | 28 | 23 | 32 | 24 | 8 | 15.812 | 28 | 25 | 20 | 34 | 24 | 8 |
| 10.125 | 20 | 32 | 27 | 40 | 24 | 8 | 13.000 | 20 | 24 | 26 | 40 | 24 | 8 | 15.874 | 26 | 30 | 29 | 38 | 24 | 8 |
| 10.191 | 21 | 32 | 22 | 34 | 24 | 8 | 13.067 | 21 | 27 | 28 | 40 | 24 | 8 | 15.937 | 25 | 32 | 34 | 40 | 24 | 8 |
| 10.254 | 23 | 34 | 24 | 38 | 24 | 8 | 13.125 | 20 | 24 | 21 | 32 | 24 | 8 | 16.000 | 24 | 20 | 20 | 36 | 24 | 8 |
| 10.313 | 22 | 32 | 25 | 40 | 24 | 8 | 13.187 | 20 | 26 | 20 | 28 | 24 | 8 | 16.127 | 22 | 26 | 27 | 34 | 24 | 8 |
| 10.376 | 20 | 28 | 23 | 38 | 24 | 8 | 13.248 | 23 | 25 | 24 | 40 | 24 | 8 | 16.250 | 26 | 24 | 20 | 32 | 24 | 8 |
| 10.435 | 20 | 23 | 20 | 40 | 24 | 8 | 13.311 | 22 | 28 | 24 | 34 | 24 | 8 | 16.376 | 29 | 25 | 20 | 34 | 24 | 8 |
| 10.500 | 21 | 32 | 24 | 36 | 24 | 8 | 13.375 | 24 | 34 | 30 | 38 | 24 | 8 | 16.500 | 22 | 20 | 20 | 32 | 24 | 8 |
| 10.560 | 20 | 25 | 22 | 40 | 24 | 8 | 13.436 | 23 | 29 | 24 | 34 | 24 | 8 | 16.625 | 38 | 32 | 21 | 36 | 24 | 8 |
| 10.625 | 22 | 34 | 26 | 38 | 24 | 8 | 13.500 | 21 | 28 | 24 | 32 | 24 | 8 | 16.750 | 22 | 25 | 23 | 29 | 24 | 8 |
| 10.688 | 20 | 26 | 22 | 38 | 24 | 8 | 13.565 | 20 | 23 | 26 | 40 | 24 | 8 | 16.875 | 25 | 32 | 36 | 40 | 24 | 8 |
| 10.747 | 21 | 34 | 29 | 40 | 24 | 8 | 13.630 | 20 | 27 | 23 | 30 | 24 | 8 | 17.000 | 30 | 36 | 34 | 40 | 24 | 8 |
| 10.807 | 22 | 36 | 28 | 38 | 24 | 8 | 13.689 | 21 | 27 | 22 | 30 | 24 | 8 | 17.129 | 26 | 30 | 28 | 34 | 24 | 8 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Feed Direction Lever on Change Gear Box is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | F | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|
| 17.250 | 23 | 20 | 20 | 32 | 24 | 8 | 23.000 | 23 | 20 | 20 | 24 | 24 | 8 | 28.750 | 25 | 20 | 23 | 24 | 24 | 8 |
| 17.376 | 20 | 34 | 32 | 26 | 24 | 8 | 23.124 | 38 | 29 | 25 | 34 | 24 | 8 | 28.874 | 34 | 25 | 23 | 26 | 24 | 8 |
| 17.500 | 25 | 20 | 21 | 36 | 24 | 8 | 23.248 | 34 | 26 | 20 | 27 | 24 | 8 | 29.000 | 29 | 20 | 20 | 24 | 24 | 8 |
| 17.625 | 23 | 27 | 25 | 29 | 24 | 8 | 23.375 | 34 | 24 | 22 | 32 | 24 | 8 | 29.120 | 28 | 24 | 26 | 25 | 24 | 8 |
| 17.748 | 32 | 28 | 22 | 34 | 24 | 8 | 23.497 | 28 | 22 | 20 | 26 | 24 | 8 | 29.250 | 30 | 20 | 26 | 32 | 24 | 8 |
| 17.875 | 26 | 24 | 22 | 32 | 24 | 8 | 23.625 | 30 | 20 | 21 | 32 | 24 | 8 | 29.376 | 34 | 25 | 27 | 30 | 24 | 8 |
| 18.000 | 21 | 20 | 20 | 28 | 24 | 8 | 23.750 | 38 | 24 | 20 | 32 | 24 | 8 | 29.506 | 38 | 20 | 22 | 34 | 24 | 8 |
| 18.125 | 29 | 24 | 20 | 32 | 24 | 8 | 23.875 | 26 | 23 | 22 | 25 | 24 | 8 | 29.623 | 27 | 21 | 24 | 25 | 24 | 8 |
| 18.252 | 22 | 27 | 28 | 30 | 24 | 8 | 24.000 | 30 | 24 | 20 | 25 | 24 | 8 | 29.750 | 34 | 24 | 28 | 32 | 24 | 8 |
| 18.375 | 28 | 24 | 21 | 32 | 24 | 8 | 24.126 | 25 | 22 | 23 | 26 | 24 | 8 | 29.876 | 34 | 23 | 32 | 38 | 24 | 8 |
| 18.499 | 38 | 29 | 20 | 34 | 24 | 8 | 24.253 | 40 | 25 | 24 | 38 | 24 | 8 | 30.000 | 36 | 27 | 30 | 32 | 24 | 8 |
| 18.626 | 34 | 23 | 21 | 40 | 24 | 8 | 24.375 | 26 | 20 | 25 | 32 | 24 | 8 | 30.124 | 28 | 20 | 26 | 29 | 24 | 8 |
| 18.750 | 25 | 20 | 20 | 32 | 24 | 8 | 24.504 | 36 | 28 | 27 | 34 | 24 | 8 | 30.252 | 40 | 28 | 30 | 34 | 24 | 8 |
| 18.872 | 32 | 26 | 23 | 36 | 24 | 8 | 24.624 | 38 | 25 | 27 | 40 | 24 | 8 | 30.375 | 30 | 20 | 27 | 32 | 24 | 8 |
| 19.000 | 38 | 24 | 20 | 40 | 24 | 8 | 24.750 | 30 | 20 | 22 | 32 | 24 | 8 | 30.502 | 38 | 23 | 20 | 26 | 24 | 8 |
| 19.125 | 34 | 28 | 21 | 32 | 24 | 8 | 24.873 | 38 | 22 | 24 | 40 | 24 | 8 | 30.624 | 29 | 20 | 22 | 25 | 24 | 8 |
| 19.250 | 28 | 24 | 22 | 32 | 24 | 8 | 25.000 | 25 | 20 | 20 | 24 | 24 | 8 | 30.748 | 34 | 23 | 26 | 30 | 24 | 8 |
| 19.373 | 38 | 34 | 26 | 36 | 24 | 8 | 25.123 | 34 | 28 | 25 | 29 | 24 | 8 | 30.875 | 38 | 24 | 26 | 32 | 24 | 8 |
| 19.500 | 26 | 20 | 20 | 32 | 24 | 8 | 25.247 | 24 | 28 | 27 | 22 | 24 | 8 | 31.005 | 40 | 22 | 27 | 38 | 24 | 8 |
| 19.624 | 30 | 28 | 29 | 38 | 24 | 8 | 25.375 | 28 | 24 | 29 | 32 | 24 | 8 | 31.115 | 38 | 25 | 29 | 34 | 24 | 8 |
| 19.749 | 25 | 22 | 21 | 29 | 24 | 8 | 25.500 | 34 | 20 | 20 | 32 | 24 | 8 | 31.250 | 40 | 24 | 25 | 32 | 24 | 8 |
| 19.876 | 20 | 21 | 20 | 23 | 24 | 8 | 25.625 | 38 | 27 | 22 | 29 | 24 | 8 | 31.373 | 40 | 27 | 30 | 34 | 24 | 8 |
| 20.000 | 25 | 20 | 20 | 30 | 24 | 8 | 25.751 | 38 | 25 | 24 | 34 | 24 | 8 | 31.500 | 25 | 20 | 21 | 20 | 24 | 8 |
| 20.125 | 28 | 24 | 23 | 32 | 24 | 8 | 25.875 | 30 | 20 | 23 | 32 | 24 | 8 | 31.624 | 32 | 20 | 28 | 34 | 24 | 8 |
| 20.250 | 27 | 24 | 21 | 28 | 24 | 8 | 26.000 | 26 | 20 | 20 | 24 | 24 | 8 | 31.746 | 30 | 21 | 25 | 27 | 24 | 8 |
| 20.371 | 32 | 26 | 20 | 29 | 24 | 8 | 26.125 | 38 | 24 | 22 | 32 | 24 | 8 | 31.875 | 34 | 20 | 25 | 32 | 24 | 8 |
| 20.499 | 23 | 26 | 28 | 29 | 24 | 8 | 26.250 | 25 | 20 | 21 | 24 | 24 | 8 | 32.000 | 28 | 20 | 20 | 21 | 24 | 8 |
| 20.625 | 25 | 20 | 22 | 32 | 24 | 8 | 26.375 | 36 | 25 | 29 | 38 | 24 | 8 | 32.253 | 34 | 22 | 20 | 23 | 24 | 8 |
| 20.749 | 26 | 28 | 27 | 29 | 24 | 8 | 26.496 | 36 | 25 | 23 | 30 | 24 | 8 | 32.500 | 26 | 20 | 25 | 24 | 24 | 8 |
| 20.874 | 36 | 28 | 23 | 34 | 24 | 8 | 26.624 | 32 | 25 | 26 | 30 | 24 | 8 | 32.749 | 34 | 23 | 24 | 26 | 24 | 8 |
| 21.000 | 21 | 20 | 20 | 24 | 24 | 8 | 26.749 | 36 | 34 | 40 | 38 | 24 | 8 | 33.000 | 25 | 20 | 22 | 20 | 24 | 8 |
| 21.129 | 34 | 28 | 29 | 40 | 24 | 8 | 26.871 | 36 | 22 | 26 | 38 | 24 | 8 | 33.250 | 38 | 24 | 28 | 32 | 24 | 8 |
| 21.250 | 34 | 24 | 20 | 32 | 24 | 8 | 27.000 | 27 | 20 | 20 | 24 | 24 | 8 | 33.498 | 34 | 21 | 25 | 29 | 24 | 8 |
| 21.375 | 38 | 28 | 21 | 32 | 24 | 8 | 27.130 | 26 | 20 | 20 | 23 | 24 | 8 | 33.750 | 27 | 20 | 25 | 24 | 24 | 8 |
| 21.501 | 27 | 23 | 29 | 38 | 24 | 8 | 27.255 | 38 | 29 | 26 | 30 | 24 | 8 | 34.000 | 34 | 20 | 20 | 24 | 24 | 8 |
| 21.621 | 38 | 29 | 22 | 32 | 24 | 8 | 27.378 | 28 | 20 | 22 | 27 | 24 | 8 | 34.255 | 34 | 23 | 28 | 29 | 24 | 8 |
| 21.750 | 29 | 20 | 20 | 32 | 24 | 8 | 27.500 | 25 | 20 | 22 | 24 | 24 | 8 | 34.500 | 25 | 20 | 23 | 20 | 24 | 8 |
| 21.875 | 25 | 24 | 28 | 32 | 24 | 8 | 27.625 | 34 | 24 | 26 | 32 | 24 | 8 | 34.751 | 40 | 26 | 32 | 34 | 24 | 8 |
| 22.000 | 25 | 20 | 22 | 30 | 24 | 8 | 27.748 | 38 | 29 | 30 | 34 | 24 | 8 | 35.000 | 28 | 20 | 25 | 24 | 24 | 8 |
| 22.123 | 28 | 27 | 32 | 36 | 24 | 8 | 27.876 | 34 | 23 | 22 | 28 | 24 | 8 | 35.246 | 38 | 23 | 24 | 27 | 24 | 8 |
| 22.251 | 29 | 23 | 25 | 34 | 24 | 8 | 28.000 | 28 | 20 | 20 | 24 | 24 | 8 | 35.510 | 30 | 21 | 29 | 28 | 24 | 8 |
| 22.371 | 29 | 21 | 27 | 40 | 24 | 8 | 28.125 | 30 | 20 | 25 | 32 | 24 | 8 | 35.749 | 34 | 21 | 23 | 25 | 24 | 8 |
| 22.500 | 25 | 20 | 21 | 28 | 24 | 8 | 28.247 | 29 | 22 | 25 | 28 | 24 | 8 | 36.000 | 25 | 20 | 24 | 20 | 24 | 8 |
| 22.626 | 28 | 22 | 20 | 27 | 24 | 8 | 28.374 | 36 | 21 | 20 | 29 | 24 | 8 | 36.252 | 36 | 22 | 24 | 26 | 24 | 8 |
| 22.750 | 26 | 24 | 28 | 32 | 24 | 8 | 28.500 | 38 | 20 | 20 | 32 | 24 | 8 | 36.503 | 30 | 22 | 29 | 26 | 24 | 8 |
| 22.871 | 27 | 20 | 24 | 34 | 24 | 8 | 28.622 | 28 | 20 | 23 | 27 | 24 | 8 | 36.747 | 38 | 21 | 22 | 26 | 24 | 8 |

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Feed Direction Lever on Change Gear Box is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|
| 36.998 | 38 | 29 | 40 | 34 | 24 | 8 | 48.485 | 40 | 22 | 30 | 27 | 24 | 8 | 60.000 | 40 | 20 | 25 | 20 | 24 | 8 |
| 37.249 | 40 | 21 | 22 | 27 | 24 | 8 | 48.762 | 36 | 21 | 32 | 27 | 24 | 8 | 60.260 | 40 | 21 | 29 | 22 | 24 | 8 |
| 37.500 | 30 | 20 | 25 | 24 | 24 | 8 | 48.994 | 34 | 21 | 29 | 23 | 24 | 8 | 60.480 | 36 | 20 | 28 | 20 | 24 | 8 |
| 37.762 | 36 | 22 | 25 | 26 | 24 | 8 | 49.248 | 38 | 20 | 27 | 25 | 24 | 8 | 60.711 | 40 | 22 | 32 | 23 | 24 | 8 |
| 38.000 | 38 | 20 | 20 | 24 | 24 | 8 | 49.518 | 36 | 22 | 29 | 23 | 24 | 8 | 61.003 | 40 | 23 | 38 | 26 | 24 | 8 |
| 38.250 | 36 | 24 | 34 | 32 | 24 | 8 | 49.745 | 38 | 20 | 24 | 22 | 24 | 8 | 61.281 | 38 | 22 | 34 | 23 | 24 | 8 |
| 38.503 | 40 | 22 | 30 | 34 | 24 | 8 | 50.000 | 40 | 20 | 25 | 24 | 24 | 8 | 61.524 | 38 | 21 | 34 | 24 | 24 | 8 |
| 38.758 | 30 | 21 | 26 | 23 | 24 | 8 | 50.269 | 36 | 22 | 32 | 25 | 24 | 8 | 61.714 | 40 | 20 | 27 | 21 | 24 | 8 |
| 39.000 | 26 | 20 | 25 | 20 | 24 | 8 | 50.494 | 36 | 21 | 27 | 22 | 24 | 8 | 62.016 | 38 | 20 | 34 | 25 | 24 | 8 |
| 39.234 | 40 | 27 | 32 | 29 | 24 | 8 | 50.755 | 38 | 23 | 32 | 25 | 24 | 8 | 62.182 | 38 | 22 | 36 | 24 | 24 | 8 |
| 39.497 | 36 | 21 | 24 | 25 | 24 | 8 | 51.000 | 34 | 20 | 25 | 20 | 24 | 8 | 62.537 | 38 | 21 | 36 | 25 | 24 | 8 |
| 39.752 | 40 | 21 | 20 | 23 | 24 | 8 | 51.225 | 40 | 22 | 27 | 23 | 24 | 8 | 62.769 | 40 | 20 | 34 | 26 | 24 | 8 |
| 40.000 | 40 | 27 | 36 | 32 | 24 | 8 | 51.471 | 38 | 21 | 32 | 27 | 24 | 8 | 62.971 | 38 | 20 | 29 | 21 | 24 | 8 |
| 40.248 | 30 | 21 | 27 | 23 | 24 | 8 | 51.717 | 40 | 22 | 32 | 27 | 24 | 8 | 63.273 | 40 | 20 | 29 | 22 | 24 | 8 |
| 40.500 | 36 | 20 | 30 | 32 | 24 | 8 | 52.000 | 40 | 20 | 26 | 24 | 24 | 8 | 63.443 | 40 | 23 | 38 | 25 | 24 | 8 |
| 40.743 | 40 | 26 | 32 | 29 | 24 | 8 | 52.245 | 40 | 21 | 32 | 28 | 24 | 8 | 63.776 | 38 | 22 | 40 | 26 | 24 | 8 |
| 40.985 | 40 | 21 | 26 | 29 | 24 | 8 | 52.476 | 38 | 21 | 29 | 24 | 24 | 8 | 64.000 | 40 | 20 | 28 | 21 | 24 | 8 |
| 41.244 | 32 | 20 | 29 | 27 | 24 | 8 | 52.747 | 40 | 21 | 30 | 26 | 24 | 8 | 64.506 | 40 | 22 | 34 | 23 | 24 | 8 |
| 41.481 | 40 | 24 | 28 | 27 | 24 | 8 | 52.987 | 34 | 21 | 30 | 22 | 24 | 8 | 64.885 | 38 | 22 | 36 | 23 | 24 | 8 |
| 41.758 | 38 | 21 | 25 | 26 | 24 | 8 | 53.217 | 34 | 20 | 30 | 23 | 24 | 8 | 65.455 | 40 | 22 | 36 | 24 | 24 | 8 |
| 42.000 | 28 | 20 | 25 | 20 | 24 | 8 | 53.486 | 36 | 20 | 26 | 21 | 24 | 8 | 66.087 | 38 | 23 | 40 | 24 | 24 | 8 |
| 42.257 | 34 | 20 | 29 | 28 | 24 | 8 | 53.760 | 32 | 20 | 28 | 20 | 24 | 8 | 66.493 | 40 | 21 | 32 | 22 | 24 | 8 |
| 42.500 | 34 | 20 | 25 | 24 | 24 | 8 | 54.000 | 36 | 20 | 25 | 20 | 24 | 8 | 67.117 | 38 | 21 | 34 | 22 | 24 | 8 |
| 42.750 | 38 | 20 | 30 | 32 | 24 | 8 | 54.261 | 40 | 20 | 26 | 23 | 24 | 8 | 67.556 | 40 | 20 | 38 | 27 | 24 | 8 |
| 43.008 | 32 | 20 | 28 | 25 | 24 | 8 | 54.470 | 36 | 20 | 29 | 23 | 24 | 8 | 68.000 | 40 | 20 | 34 | 24 | 24 | 8 |
| 43.257 | 38 | 22 | 24 | 23 | 24 | 8 | 54.758 | 38 | 21 | 29 | 23 | 24 | 8 | 68.571 | 20 | 28 | 20 | 40 | 24 | 1 |
| 43.500 | 40 | 20 | 29 | 32 | 24 | 8 | 54.982 | 36 | 20 | 28 | 22 | 24 | 8 | 69.000 | 20 | 32 | 23 | 40 | 24 | 1 |
| 43.754 | 38 | 23 | 32 | 29 | 24 | 8 | 55.238 | 40 | 21 | 29 | 24 | 24 | 8 | 69.517 | 20 | 29 | 21 | 40 | 24 | 1 |
| 44.000 | 40 | 20 | 22 | 24 | 24 | 8 | 55.510 | 40 | 21 | 34 | 28 | 24 | 8 | 70.000 | 20 | 32 | 21 | 36 | 24 | 1 |
| 44.227 | 38 | 23 | 29 | 26 | 24 | 8 | 55.680 | 32 | 20 | 29 | 20 | 24 | 8 | 70.588 | 20 | 32 | 20 | 34 | 24 | 1 |
| 44.509 | 34 | 22 | 36 | 30 | 24 | 8 | 56.000 | 40 | 20 | 28 | 24 | 24 | 8 | 71.018 | 22 | 36 | 23 | 38 | 24 | 1 |
| 44.743 | 29 | 20 | 27 | 21 | 24 | 8 | 56.264 | 40 | 21 | 32 | 26 | 24 | 8 | 71.435 | 22 | 34 | 23 | 40 | 24 | 1 |
| 45.000 | 30 | 20 | 25 | 20 | 24 | 8 | 56.492 | 36 | 20 | 34 | 26 | 24 | 8 | 72.000 | 20 | 28 | 21 | 40 | 24 | 1 |
| 45.253 | 40 | 22 | 28 | 27 | 24 | 8 | 56.749 | 40 | 21 | 36 | 29 | 24 | 8 | 72.471 | 21 | 34 | 22 | 36 | 24 | 1 |
| 45.508 | 34 | 20 | 29 | 26 | 24 | 8 | 57.000 | 38 | 20 | 25 | 20 | 24 | 8 | 72.982 | 20 | 36 | 26 | 38 | 24 | 1 |
| 45.753 | 38 | 23 | 30 | 26 | 24 | 8 | 57.247 | 38 | 21 | 29 | 22 | 24 | 8 | 73.563 | 20 | 29 | 20 | 36 | 24 | 1 |
| 46.000 | 40 | 20 | 23 | 24 | 24 | 8 | 57.496 | 38 | 20 | 29 | 23 | 24 | 8 | 73.920 | 21 | 30 | 22 | 40 | 24 | 1 |
| 46.261 | 38 | 23 | 28 | 24 | 24 | 8 | 57.793 | 40 | 23 | 36 | 26 | 24 | 8 | 74.541 | 22 | 34 | 24 | 40 | 24 | 1 |
| 46.496 | 40 | 26 | 34 | 27 | 24 | 8 | 58.000 | 40 | 20 | 29 | 24 | 24 | 8 | 75.000 | 20 | 32 | 25 | 40 | 24 | 1 |
| 46.748 | 32 | 20 | 28 | 23 | 24 | 8 | 58.286 | 34 | 20 | 30 | 21 | 24 | 8 | 75.537 | 23 | 38 | 26 | 40 | 24 | 1 |
| 46.995 | 38 | 23 | 32 | 27 | 24 | 8 | 58.514 | 40 | 21 | 32 | 25 | 24 | 8 | 75.900 | 22 | 32 | 23 | 40 | 24 | 1 |
| 47.262 | 40 | 25 | 32 | 26 | 24 | 8 | 58.752 | 36 | 20 | 34 | 25 | 24 | 8 | 76.469 | 21 | 29 | 22 | 40 | 24 | 1 |
| 47.500 | 38 | 20 | 25 | 24 | 24 | 8 | 59.063 | 38 | 21 | 34 | 25 | 24 | 8 | 77.000 | 21 | 32 | 22 | 36 | 24 | 1 |
| 47.771 | 38 | 20 | 22 | 21 | 24 | 8 | 59.280 | 38 | 20 | 26 | 20 | 24 | 8 | 77.474 | 23 | 36 | 24 | 38 | 24 | 1 |
| 48.000 | 32 | 20 | 25 | 20 | 24 | 8 | 59.478 | 38 | 23 | 36 | 24 | 24 | 8 | 78.000 | 20 | 32 | 26 | 40 | 24 | 1 |
| 48.254 | 40 | 27 | 38 | 28 | 24 | 8 | 59.780 | 40 | 21 | 34 | 26 | 24 | 8 | 78.464 | 22 | 34 | 24 | 38 | 24 | 1 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Feed Direction Lever on Change Gear Box is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|
| 79.012 | 20 | 27 | 20 | 36 | 24 | 1 | 102.00 | 20 | 40 | 34 | 32 | 24 | 1 | 125.00 | 30 | 32 | 25 | 36 | 24 | 1 |
| 79.448 | 20 | 29 | 24 | 40 | 24 | 1 | 102.51 | 23 | 28 | 26 | 40 | 24 | 1 | 125.51 | 27 | 25 | 23 | 38 | 24 | 1 |
| 80.000 | 20 | 30 | 25 | 40 | 24 | 1 | 102.99 | 20 | 29 | 28 | 36 | 24 | 1 | 126.00 | 21 | 20 | 20 | 32 | 24 | 1 |
| 80.500 | 21 | 32 | 23 | 36 | 24 | 1 | 103.50 | 21 | 28 | 23 | 32 | 24 | 1 | 126.50 | 22 | 24 | 23 | 32 | 24 | 1 |
| 81.000 | 20 | 32 | 27 | 40 | 24 | 1 | 104.00 | 26 | 24 | 20 | 40 | 24 | 1 | 126.99 | 26 | 30 | 29 | 38 | 24 | 1 |
| 81.529 | 21 | 32 | 22 | 34 | 24 | 1 | 104.53 | 21 | 27 | 28 | 40 | 24 | 1 | 127.50 | 25 | 32 | 34 | 40 | 24 | 1 |
| 81.900 | 21 | 32 | 26 | 40 | 24 | 1 | 105.00 | 20 | 24 | 21 | 32 | 24 | 1 | 128.00 | 20 | 24 | 20 | 25 | 24 | 1 |
| 82.500 | 22 | 32 | 25 | 40 | 24 | 1 | 105.49 | 20 | 26 | 20 | 28 | 24 | 1 | 129.01 | 22 | 26 | 27 | 34 | 24 | 1 |
| 83.008 | 20 | 28 | 23 | 38 | 24 | 1 | 105.98 | 23 | 25 | 24 | 40 | 24 | 1 | 130.00 | 26 | 24 | 20 | 32 | 24 | 1 |
| 83.478 | 20 | 23 | 20 | 40 | 24 | 1 | 106.49 | 22 | 28 | 24 | 34 | 24 | 1 | 130.99 | 25 | 27 | 28 | 38 | 24 | 1 |
| 84.000 | 21 | 32 | 24 | 36 | 24 | 1 | 107.00 | 20 | 38 | 36 | 34 | 24 | 1 | 132.00 | 22 | 20 | 20 | 32 | 24 | 1 |
| 84.480 | 22 | 30 | 24 | 40 | 24 | 1 | 107.49 | 23 | 29 | 24 | 34 | 24 | 1 | 133.00 | 38 | 32 | 21 | 36 | 24 | 1 |
| 85.003 | 22 | 34 | 26 | 38 | 24 | 1 | 108.00 | 21 | 28 | 24 | 32 | 24 | 1 | 134.00 | 22 | 25 | 23 | 29 | 24 | 1 |
| 85.506 | 20 | 26 | 22 | 38 | 24 | 1 | 108.46 | 23 | 30 | 28 | 38 | 24 | 1 | 135.00 | 25 | 32 | 36 | 40 | 24 | 1 |
| 85.976 | 21 | 34 | 29 | 40 | 24 | 1 | 109.04 | 20 | 27 | 23 | 30 | 24 | 1 | 136.00 | 30 | 36 | 34 | 40 | 24 | 1 |
| 86.456 | 22 | 36 | 28 | 38 | 24 | 1 | 109.51 | 21 | 27 | 22 | 30 | 24 | 1 | 137.04 | 26 | 30 | 28 | 34 | 24 | 1 |
| 87.000 | 20 | 32 | 29 | 40 | 24 | 1 | 110.00 | 20 | 24 | 22 | 32 | 24 | 1 | 138.00 | 23 | 20 | 20 | 32 | 24 | 1 |
| 87.500 | 21 | 32 | 25 | 36 | 24 | 1 | 110.48 | 20 | 36 | 29 | 28 | 24 | 1 | 139.01 | 32 | 26 | 20 | 34 | 24 | 1 |
| 88.000 | 20 | 30 | 22 | 32 | 24 | 1 | 110.93 | 26 | 36 | 32 | 40 | 24 | 1 | 140.00 | 28 | 32 | 30 | 36 | 24 | 1 |
| 88.421 | 25 | 38 | 28 | 40 | 24 | 1 | 111.51 | 20 | 38 | 32 | 29 | 24 | 1 | 141.00 | 23 | 27 | 25 | 29 | 24 | 1 |
| 88.941 | 21 | 34 | 30 | 40 | 24 | 1 | 112.00 | 20 | 24 | 21 | 30 | 24 | 1 | 141.98 | 32 | 28 | 22 | 34 | 24 | 1 |
| 89.526 | 21 | 32 | 27 | 38 | 24 | 1 | 112.50 | 25 | 32 | 27 | 36 | 24 | 1 | 143.00 | 22 | 24 | 26 | 32 | 24 | 1 |
| 90.000 | 20 | 28 | 21 | 32 | 24 | 1 | 112.99 | 22 | 27 | 26 | 36 | 24 | 1 | 144.00 | 21 | 20 | 20 | 28 | 24 | 1 |
| 90.502 | 21 | 34 | 29 | 38 | 24 | 1 | 113.50 | 20 | 28 | 24 | 29 | 24 | 1 | 145.00 | 29 | 24 | 20 | 32 | 24 | 1 |
| 91.000 | 21 | 32 | 26 | 36 | 24 | 1 | 114.00 | 20 | 40 | 38 | 32 | 24 | 1 | 146.02 | 22 | 27 | 28 | 30 | 24 | 1 |
| 91.482 | 24 | 34 | 27 | 40 | 24 | 1 | 114.50 | 21 | 29 | 28 | 34 | 24 | 1 | 147.00 | 28 | 24 | 21 | 32 | 24 | 1 |
| 92.000 | 20 | 24 | 23 | 40 | 24 | 1 | 115.00 | 20 | 24 | 23 | 32 | 24 | 1 | 147.99 | 38 | 29 | 20 | 34 | 24 | 1 |
| 92.444 | 20 | 27 | 26 | 40 | 24 | 1 | 115.50 | 21 | 24 | 22 | 32 | 24 | 1 | 149.01 | 34 | 23 | 21 | 40 | 24 | 1 |
| 92.968 | 23 | 38 | 32 | 40 | 24 | 1 | 116.00 | 29 | 24 | 20 | 40 | 24 | 1 | 150.00 | 25 | 20 | 20 | 32 | 24 | 1 |
| 93.469 | 20 | 29 | 24 | 34 | 24 | 1 | 116.48 | 26 | 30 | 28 | 40 | 24 | 1 | 150.97 | 32 | 26 | 23 | 36 | 24 | 1 |
| 94.053 | 21 | 29 | 23 | 34 | 24 | 1 | 117.00 | 26 | 32 | 27 | 36 | 24 | 1 | 152.00 | 38 | 24 | 20 | 40 | 24 | 1 |
| 94.500 | 21 | 32 | 27 | 36 | 24 | 1 | 117.46 | 26 | 34 | 32 | 40 | 24 | 1 | 153.00 | 34 | 28 | 21 | 32 | 24 | 1 |
| 95.040 | 22 | 30 | 27 | 40 | 24 | 1 | 118.02 | 22 | 40 | 38 | 34 | 24 | 1 | 154.00 | 28 | 24 | 22 | 32 | 24 | 1 |
| 95.495 | 27 | 38 | 28 | 40 | 24 | 1 | 118.52 | 20 | 24 | 20 | 27 | 24 | 1 | 154.98 | 38 | 34 | 26 | 36 | 24 | 1 |
| 96.000 | 20 | 25 | 20 | 32 | 24 | 1 | 119.00 | 21 | 36 | 34 | 32 | 24 | 1 | 156.00 | 26 | 20 | 20 | 32 | 24 | 1 |
| 96.459 | 20 | 22 | 21 | 38 | 24 | 1 | 119.47 | 24 | 30 | 28 | 36 | 24 | 1 | 156.99 | 29 | 28 | 30 | 38 | 24 | 1 |
| 97.011 | 20 | 25 | 24 | 38 | 24 | 1 | 120.00 | 27 | 24 | 20 | 36 | 24 | 1 | 157.99 | 25 | 22 | 21 | 29 | 24 | 1 |
| 97.500 | 25 | 32 | 26 | 40 | 24 | 1 | 120.50 | 21 | 29 | 26 | 30 | 24 | 1 | 159.01 | 20 | 21 | 20 | 23 | 24 | 1 |
| 98.000 | 21 | 32 | 28 | 36 | 24 | 1 | 121.01 | 24 | 28 | 25 | 34 | 24 | 1 | 160.00 | 25 | 20 | 20 | 30 | 24 | 1 |
| 98.526 | 21 | 28 | 26 | 38 | 24 | 1 | 121.50 | 21 | 28 | 27 | 32 | 24 | 1 | 161.00 | 28 | 24 | 23 | 32 | 24 | 1 |
| 99.000 | 21 | 28 | 22 | 32 | 24 | 1 | 122.02 | 23 | 20 | 21 | 38 | 24 | 1 | 162.00 | 27 | 24 | 21 | 28 | 24 | 1 |
| 99.474 | 21 | 32 | 30 | 38 | 24 | 1 | 122.50 | 29 | 25 | 22 | 40 | 24 | 1 | 162.97 | 32 | 26 | 20 | 29 | 24 | 1 |
| 100.00 | 25 | 36 | 30 | 40 | 24 | 1 | 122.99 | 21 | 26 | 23 | 29 | 24 | 1 | 163.99 | 23 | 26 | 28 | 29 | 24 | 1 |
| 100.53 | 26 | 36 | 29 | 40 | 24 | 1 | 123.51 | 30 | 27 | 22 | 38 | 24 | 1 | 165.00 | 25 | 20 | 22 | 32 | 24 | 1 |
| 101.02 | 21 | 27 | 23 | 34 | 24 | 1 | 123.98 | 29 | 26 | 22 | 38 | 24 | 1 | 165.99 | 26 | 28 | 27 | 29 | 24 | 1 |
| 101.50 | 21 | 32 | 29 | 36 | 24 | 1 | 124.50 | 28 | 25 | 22 | 38 | 24 | 1 | 166.99 | 27 | 21 | 23 | 34 | 24 | 1 |

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Feed Direction Lever on Change Gear Box is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|
| 168.00 | 21 | 20 | 20 | 24 | 24 | 1 | 213.99 | 40 | 34 | 36 | 38 | 24 | 1 | 264.00 | 25 | 20 | 22 | 20 | 24 | 1 |
| 169.03 | 34 | 28 | 29 | 40 | 24 | 1 | 214.97 | 36 | 22 | 26 | 38 | 24 | 1 | 266.00 | 38 | 24 | 28 | 32 | 24 | 1 |
| 170.00 | 34 | 24 | 20 | 32 | 24 | 1 | 216.00 | 27 | 20 | 20 | 24 | 24 | 1 | 267.98 | 34 | 21 | 25 | 29 | 24 | 1 |
| 171.00 | 38 | 28 | 21 | 32 | 24 | 1 | 217.04 | 26 | 20 | 20 | 23 | 24 | 1 | 270.00 | 27 | 20 | 25 | 24 | 24 | 1 |
| 172.01 | 29 | 23 | 27 | 38 | 24 | 1 | 218.04 | 38 | 29 | 26 | 30 | 24 | 1 | 272.00 | 34 | 20 | 20 | 24 | 24 | 1 |
| 172.97 | 38 | 29 | 22 | 32 | 24 | 1 | 219.02 | 28 | 20 | 22 | 27 | 24 | 1 | 274.04 | 34 | 23 | 28 | 29 | 24 | 1 |
| 174.00 | 29 | 20 | 20 | 32 | 24 | 1 | 220.00 | 25 | 20 | 22 | 24 | 24 | 1 | 276.00 | 25 | 20 | 23 | 20 | 24 | 1 |
| 175.00 | 25 | 24 | 28 | 32 | 24 | 1 | 221.00 | 34 | 24 | 26 | 32 | 24 | 1 | 278.01 | 40 | 26 | 32 | 34 | 24 | 1 |
| 176.00 | 25 | 20 | 22 | 30 | 24 | 1 | 221.99 | 30 | 29 | 38 | 34 | 24 | 1 | 280.00 | 28 | 20 | 25 | 24 | 24 | 1 |
| 176.99 | 28 | 27 | 32 | 36 | 24 | 1 | 223.01 | 34 | 23 | 22 | 28 | 24 | 1 | 281.97 | 38 | 23 | 24 | 27 | 24 | 1 |
| 178.01 | 29 | 23 | 25 | 34 | 24 | 1 | 224.00 | 28 | 20 | 20 | 24 | 24 | 1 | 284.08 | 29 | 21 | 30 | 28 | 24 | 1 |
| 178.97 | 29 | 21 | 27 | 40 | 24 | 1 | 225.00 | 30 | 20 | 25 | 32 | 24 | 1 | 285.99 | 34 | 21 | 23 | 25 | 24 | 1 |
| 180.00 | 27 | 36 | 40 | 32 | 24 | 1 | 225.97 | 29 | 22 | 25 | 28 | 24 | 1 | 288.00 | 25 | 20 | 24 | 20 | 24 | 1 |
| 181.01 | 28 | 22 | 20 | 27 | 24 | 1 | 227.00 | 36 | 21 | 20 | 29 | 24 | 1 | 290.01 | 36 | 22 | 24 | 26 | 24 | 1 |
| 182.00 | 26 | 24 | 28 | 32 | 24 | 1 | 228.00 | 38 | 20 | 20 | 32 | 24 | 1 | 292.03 | 30 | 22 | 29 | 26 | 24 | 1 |
| 182.96 | 27 | 20 | 24 | 34 | 24 | 1 | 228.98 | 28 | 20 | 23 | 27 | 24 | 1 | 293.98 | 38 | 21 | 22 | 26 | 24 | 1 |
| 184.00 | 23 | 20 | 20 | 24 | 24 | 1 | 230.00 | 25 | 20 | 23 | 24 | 24 | 1 | 295.98 | 40 | 29 | 38 | 34 | 24 | 1 |
| 185.00 | 28 | 26 | 34 | 38 | 24 | 1 | 230.99 | 34 | 25 | 23 | 26 | 24 | 1 | 297.99 | 40 | 21 | 22 | 27 | 24 | 1 |
| 185.98 | 34 | 26 | 20 | 27 | 24 | 1 | 232.00 | 29 | 20 | 20 | 24 | 24 | 1 | 300.00 | 30 | 20 | 25 | 24 | 24 | 1 |
| 187.00 | 22 | 32 | 34 | 24 | 24 | 1 | 232.96 | 28 | 24 | 26 | 25 | 24 | 1 | 302.10 | 36 | 22 | 25 | 26 | 24 | 1 |
| 187.97 | 28 | 22 | 20 | 26 | 24 | 1 | 234.00 | 30 | 20 | 26 | 32 | 24 | 1 | 304.00 | 38 | 20 | 20 | 24 | 24 | 1 |
| 189.00 | 30 | 20 | 21 | 32 | 24 | 1 | 235.01 | 34 | 25 | 27 | 30 | 24 | 1 | 306.00 | 36 | 24 | 34 | 32 | 24 | 1 |
| 190.00 | 38 | 24 | 20 | 32 | 24 | 1 | 236.05 | 38 | 20 | 22 | 34 | 24 | 1 | 308.02 | 40 | 22 | 30 | 34 | 24 | 1 |
| 191.00 | 26 | 23 | 22 | 25 | 24 | 1 | 236.98 | 27 | 21 | 24 | 25 | 24 | 1 | 310.06 | 30 | 21 | 26 | 23 | 24 | 1 |
| 192.00 | 30 | 24 | 20 | 25 | 24 | 1 | 238.00 | 34 | 24 | 28 | 32 | 24 | 1 | 312.00 | 26 | 20 | 25 | 20 | 24 | 1 |
| 193.01 | 23 | 22 | 25 | 26 | 24 | 1 | 239.01 | 34 | 23 | 32 | 38 | 24 | 1 | 313.87 | 40 | 27 | 32 | 29 | 24 | 1 |
| 194.02 | 40 | 25 | 24 | 38 | 24 | 1 | 240.00 | 36 | 27 | 30 | 32 | 24 | 1 | 315.98 | 36 | 21 | 24 | 25 | 24 | 1 |
| 195.00 | 26 | 20 | 25 | 32 | 24 | 1 | 240.99 | 28 | 20 | 26 | 29 | 24 | 1 | 318.01 | 40 | 21 | 20 | 23 | 24 | 1 |
| 196.03 | 36 | 28 | 27 | 34 | 24 | 1 | 242.02 | 40 | 28 | 30 | 34 | 24 | 1 | 320.00 | 40 | 27 | 36 | 32 | 24 | 1 |
| 196.99 | 38 | 25 | 27 | 40 | 24 | 1 | 243.00 | 30 | 20 | 27 | 32 | 24 | 1 | 321.99 | 30 | 21 | 27 | 23 | 24 | 1 |
| 198.00 | 36 | 24 | 22 | 32 | 24 | 1 | 244.01 | 38 | 23 | 20 | 26 | 24 | 1 | 324.00 | 27 | 20 | 25 | 20 | 24 | 1 |
| 198.98 | 38 | 22 | 24 | 40 | 24 | 1 | 244.99 | 29 | 20 | 22 | 25 | 24 | 1 | 325.94 | 40 | 26 | 32 | 29 | 24 | 1 |
| 200.00 | 25 | 20 | 20 | 24 | 24 | 1 | 245.98 | 34 | 23 | 26 | 30 | 24 | 1 | 327.88 | 40 | 21 | 26 | 29 | 24 | 1 |
| 200.99 | 34 | 28 | 25 | 29 | 24 | 1 | 247.00 | 38 | 24 | 26 | 32 | 24 | 1 | 329.96 | 32 | 20 | 29 | 27 | 24 | 1 |
| 201.97 | 27 | 22 | 24 | 28 | 24 | 1 | 248.04 | 40 | 22 | 27 | 38 | 24 | 1 | 331.85 | 40 | 24 | 28 | 27 | 24 | 1 |
| 203.00 | 28 | 24 | 29 | 32 | 24 | 1 | 248.92 | 38 | 25 | 29 | 34 | 24 | 1 | 334.07 | 38 | 21 | 25 | 26 | 24 | 1 |
| 204.00 | 34 | 20 | 20 | 32 | 24 | 1 | 250.00 | 40 | 24 | 25 | 32 | 24 | 1 | 336.00 | 28 | 20 | 25 | 20 | 24 | 1 |
| 205.00 | 38 | 27 | 22 | 29 | 24 | 1 | 250.98 | 40 | 27 | 30 | 34 | 24 | 1 | 338.06 | 34 | 20 | 29 | 28 | 24 | 1 |
| 206.00 | 38 | 25 | 24 | 34 | 24 | 1 | 252.00 | 25 | 20 | 21 | 20 | 24 | 1 | 340.00 | 34 | 20 | 25 | 24 | 24 | 1 |
| 207.00 | 30 | 20 | 23 | 32 | 24 | 1 | 252.99 | 32 | 20 | 28 | 34 | 24 | 1 | 342.00 | 38 | 20 | 30 | 32 | 24 | 1 |
| 208.00 | 26 | 20 | 20 | 24 | 24 | 1 | 253.97 | 30 | 21 | 25 | 27 | 24 | 1 | 344.06 | 32 | 20 | 28 | 25 | 24 | 1 |
| 209.00 | 38 | 24 | 22 | 32 | 24 | 1 | 255.00 | 34 | 20 | 25 | 32 | 24 | 1 | 346.06 | 38 | 22 | 24 | 23 | 24 | 1 |
| 210.00 | 25 | 20 | 21 | 24 | 24 | 1 | 256.00 | 28 | 20 | 20 | 21 | 24 | 1 | 348.00 | 40 | 20 | 29 | 32 | 24 | 1 |
| 211.00 | 36 | 25 | 29 | 38 | 24 | 1 | 258.02 | 34 | 22 | 20 | 23 | 24 | 1 | 350.03 | 38 | 23 | 32 | 29 | 24 | 1 |
| 211.97 | 36 | 25 | 23 | 30 | 24 | 1 | 260.00 | 26 | 20 | 25 | 24 | 24 | 1 | 352.00 | 40 | 20 | 22 | 24 | 24 | 1 |
| 212.99 | 32 | 25 | 26 | 30 | 24 | 1 | 261.99 | 34 | 23 | 24 | 26 | 24 | 1 | 353.82 | 38 | 23 | 29 | 26 | 24 | 1 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Feed Direction Lever on Change Gear Box is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|
| 356.07 | 34 | 22 | 36 | 30 | 24 | 1 | 448.00 | 40 | 20 | 28 | 24 | 24 | 1 | 567.93 | 32 | 28 | 22 | 34 | 96 | 1 |
| 357.94 | 29 | 20 | 27 | 21 | 24 | 1 | 450.11 | 40 | 21 | 32 | 26 | 24 | 1 | 572.00 | 26 | 24 | 22 | 32 | 96 | 1 |
| 360.00 | 30 | 20 | 25 | 20 | 24 | 1 | 451.94 | 36 | 20 | 34 | 26 | 24 | 1 | 576.00 | 21 | 20 | 20 | 28 | 96 | 1 |
| 362.02 | 40 | 22 | 28 | 27 | 24 | 1 | 453.99 | 40 | 21 | 36 | 29 | 24 | 1 | 580.00 | 29 | 24 | 20 | 32 | 96 | 1 |
| 364.06 | 34 | 20 | 29 | 26 | 24 | 1 | 456.00 | 38 | 20 | 25 | 20 | 24 | 1 | 584.06 | 28 | 27 | 22 | 30 | 96 | 1 |
| 366.02 | 38 | 23 | 30 | 26 | 24 | 1 | 457.97 | 38 | 21 | 29 | 22 | 24 | 1 | 588.00 | 28 | 24 | 21 | 32 | 96 | 1 |
| 368.00 | 40 | 20 | 23 | 24 | 24 | 1 | 459.97 | 38 | 20 | 29 | 23 | 24 | 1 | 591.97 | 38 | 29 | 20 | 34 | 96 | 1 |
| 370.09 | 38 | 23 | 28 | 24 | 24 | 1 | 462.34 | 40 | 23 | 36 | 26 | 24 | 1 | 596.03 | 34 | 23 | 21 | 40 | 96 | 1 |
| 371.97 | 40 | 26 | 34 | 27 | 24 | 1 | 464.00 | 40 | 20 | 29 | 24 | 24 | 1 | 600.00 | 25 | 20 | 20 | 32 | 96 | 1 |
| 373.98 | 32 | 20 | 28 | 23 | 24 | 1 | 466.29 | 34 | 20 | 30 | 21 | 24 | 1 | 603.90 | 32 | 26 | 23 | 36 | 96 | 1 |
| 375.96 | 38 | 23 | 32 | 27 | 24 | 1 | 468.11 | 40 | 21 | 32 | 25 | 24 | 1 | 608.00 | 38 | 24 | 20 | 40 | 96 | 1 |
| 378.09 | 40 | 25 | 32 | 26 | 24 | 1 | 470.02 | 36 | 20 | 34 | 25 | 24 | 1 | 612.00 | 34 | 28 | 21 | 32 | 96 | 1 |
| 380.00 | 38 | 20 | 25 | 24 | 24 | 1 | 472.50 | 38 | 21 | 34 | 25 | 24 | 1 | 616.00 | 28 | 24 | 22 | 32 | 96 | 1 |
| 382.17 | 38 | 20 | 22 | 21 | 24 | 1 | 474.24 | 38 | 20 | 26 | 20 | 24 | 1 | 619.92 | 38 | 34 | 26 | 36 | 96 | 1 |
| 384.00 | 32 | 20 | 25 | 20 | 24 | 1 | 475.83 | 38 | 23 | 36 | 24 | 24 | 1 | 624.00 | 26 | 20 | 20 | 32 | 96 | 1 |
| 386.03 | 40 | 27 | 38 | 28 | 24 | 1 | 478.24 | 40 | 21 | 34 | 26 | 24 | 1 | 627.97 | 30 | 28 | 29 | 38 | 96 | 1 |
| 387.88 | 40 | 22 | 30 | 27 | 24 | 1 | 480.00 | 40 | 20 | 25 | 20 | 24 | 1 | 631.97 | 25 | 22 | 21 | 29 | 96 | 1 |
| 390.10 | 36 | 21 | 32 | 27 | 24 | 1 | 482.08 | 40 | 21 | 29 | 22 | 24 | 1 | 636.02 | 20 | 21 | 20 | 23 | 96 | 1 |
| 391.95 | 34 | 21 | 29 | 23 | 24 | 1 | 483.84 | 36 | 20 | 28 | 20 | 24 | 1 | 640.00 | 25 | 20 | 20 | 30 | 96 | 1 |
| 393.98 | 38 | 20 | 27 | 25 | 24 | 1 | 485.69 | 40 | 22 | 32 | 23 | 24 | 1 | 644.00 | 28 | 24 | 23 | 32 | 96 | 1 |
| 396.14 | 36 | 22 | 29 | 23 | 24 | 1 | 488.03 | 40 | 23 | 38 | 26 | 24 | 1 | 648.00 | 21 | 28 | 27 | 24 | 96 | 1 |
| 397.96 | 38 | 20 | 24 | 22 | 24 | 1 | 490.25 | 38 | 22 | 34 | 23 | 24 | 1 | 651.88 | 32 | 26 | 20 | 29 | 96 | 1 |
| 400.00 | 40 | 20 | 25 | 24 | 24 | 1 | 492.19 | 38 | 21 | 34 | 24 | 24 | 1 | 655.96 | 28 | 26 | 23 | 29 | 96 | 1 |
| 402.15 | 36 | 22 | 32 | 25 | 24 | 1 | 493.71 | 40 | 20 | 27 | 21 | 24 | 1 | 660.00 | 25 | 20 | 22 | 32 | 96 | 1 |
| 403.95 | 36 | 21 | 27 | 22 | 24 | 1 | 496.13 | 38 | 20 | 34 | 25 | 24 | 1 | 663.96 | 27 | 28 | 26 | 29 | 96 | 1 |
| 406.04 | 38 | 23 | 32 | 25 | 24 | 1 | 497.46 | 38 | 22 | 36 | 24 | 24 | 1 | 667.97 | 27 | 21 | 23 | 34 | 96 | 1 |
| 408.00 | 34 | 20 | 25 | 20 | 24 | 1 | 500.30 | 38 | 21 | 36 | 25 | 24 | 1 | 672.00 | 21 | 20 | 20 | 24 | 96 | 1 |
| 409.80 | 40 | 22 | 27 | 23 | 24 | 1 | 502.15 | 40 | 20 | 34 | 25 | 24 | 1 | 676.11 | 29 | 28 | 34 | 40 | 96 | 1 |
| 411.77 | 38 | 21 | 32 | 27 | 24 | 1 | 503.77 | 38 | 20 | 29 | 21 | 24 | 1 | 680.00 | 34 | 24 | 20 | 32 | 96 | 1 |
| 413.74 | 40 | 22 | 32 | 27 | 24 | 1 | 505.18 | 40 | 20 | 29 | 22 | 24 | 1 | 684.00 | 38 | 28 | 21 | 32 | 96 | 1 |
| 416.00 | 40 | 20 | 26 | 24 | 24 | 1 | 507.55 | 40 | 23 | 38 | 25 | 24 | 1 | 688.04 | 27 | 23 | 29 | 38 | 96 | 1 |
| 417.96 | 40 | 21 | 32 | 28 | 24 | 1 | 510.21 | 40 | 22 | 38 | 26 | 24 | 1 | 691.86 | 38 | 29 | 22 | 32 | 96 | 1 |
| 419.81 | 38 | 21 | 29 | 24 | 24 | 1 | 512.00 | 40 | 20 | 28 | 21 | 24 | 1 | 696.00 | 29 | 20 | 20 | 32 | 96 | 1 |
| 421.98 | 40 | 21 | 30 | 26 | 24 | 1 | 516.05 | 40 | 22 | 34 | 23 | 24 | 1 | 700.00 | 25 | 24 | 28 | 32 | 96 | 1 |
| 423.90 | 34 | 21 | 30 | 22 | 24 | 1 | 419.08 | 38 | 22 | 36 | 23 | 24 | 1 | 704.00 | 25 | 20 | 22 | 30 | 96 | 1 |
| 425.74 | 34 | 20 | 30 | 23 | 24 | 1 | 523.64 | 40 | 22 | 36 | 24 | 24 | 1 | 707.95 | 28 | 27 | 32 | 36 | 96 | 1 |
| 427.89 | 36 | 20 | 26 | 21 | 24 | 1 | 528.00 | 22 | 20 | 20 | 32 | 96 | 1 | 712.02 | 29 | 23 | 25 | 34 | 96 | 1 |
| 430.08 | 32 | 20 | 28 | 20 | 24 | 1 | 532.00 | 38 | 32 | 21 | 36 | 96 | 1 | 715.89 | 29 | 21 | 27 | 40 | 96 | 1 |
| 432.00 | 36 | 20 | 25 | 20 | 24 | 1 | 536.01 | 23 | 25 | 22 | 29 | 96 | 1 | 720.00 | 25 | 20 | 21 | 28 | 96 | 1 |
| 434.09 | 40 | 20 | 26 | 23 | 24 | 1 | 540.00 | 36 | 32 | 25 | 40 | 96 | 1 | 724.04 | 28 | 22 | 20 | 27 | 96 | 1 |
| 435.76 | 36 | 20 | 29 | 23 | 24 | 1 | 544.00 | 34 | 36 | 30 | 40 | 96 | 1 | 728.00 | 26 | 24 | 28 | 32 | 96 | 1 |
| 438.06 | 38 | 21 | 29 | 23 | 24 | 1 | 548.14 | 28 | 30 | 26 | 34 | 96 | 1 | 731.86 | 27 | 20 | 24 | 34 | 96 | 1 |
| 439.86 | 36 | 20 | 28 | 22 | 24 | 1 | 552.00 | 23 | 20 | 20 | 32 | 96 | 1 | 736.00 | 23 | 20 | 20 | 24 | 96 | 1 |
| 441.91 | 40 | 21 | 29 | 24 | 24 | 1 | 556.02 | 32 | 26 | 20 | 34 | 96 | 1 | 740.02 | 34 | 26 | 28 | 38 | 96 | 1 |
| 444.08 | 40 | 21 | 34 | 28 | 24 | 1 | 560.00 | 30 | 32 | 28 | 36 | 96 | 1 | 743.93 | 34 | 26 | 20 | 27 | 96 | 1 |
| 445.44 | 32 | 20 | 29 | 20 | 24 | 1 | 563.99 | 25 | 27 | 23 | 29 | 96 | 1 | 748.00 | 34 | 24 | 22 | 32 | 96 | 1 |

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Feed Direction Lever on Change Gear Box is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G |
|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|
| 751.89 | 28 | 22 | 20 | 26 | 96 | 1 | 936.00 | 30 | 20 | 26 | 32 | 96 | 1 | 1216.0 | 38 | 20 | 20 | 24 | 96 | 1 |
| 756.00 | 30 | 20 | 21 | 32 | 96 | 1 | 940.03 | 34 | 25 | 27 | 30 | 96 | 1 | 1224.0 | 36 | 24 | 34 | 32 | 96 | 1 |
| 760.00 | 38 | 24 | 20 | 32 | 96 | 1 | 944.19 | 38 | 20 | 22 | 34 | 96 | 1 | 1232.1 | 40 | 22 | 30 | 34 | 96 | 1 |
| 763.99 | 26 | 23 | 22 | 25 | 96 | 1 | 947.93 | 27 | 21 | 24 | 25 | 96 | 1 | 1240.3 | 30 | 21 | 26 | 23 | 96 | 1 |
| 768.00 | 30 | 24 | 20 | 25 | 96 | 1 | 952.00 | 34 | 24 | 28 | 32 | 96 | 1 | 1248.0 | 26 | 20 | 25 | 20 | 96 | 1 |
| 772.03 | 25 | 22 | 23 | 26 | 96 | 1 | 956.05 | 34 | 23 | 32 | 38 | 96 | 1 | 1255.5 | 40 | 27 | 32 | 29 | 96 | 1 |
| 776.08 | 40 | 25 | 24 | 38 | 96 | 1 | 960.00 | 36 | 27 | 30 | 32 | 96 | 1 | 1263.9 | 36 | 21 | 24 | 25 | 96 | 1 |
| 780.00 | 30 | 24 | 26 | 32 | 96 | 1 | 963.97 | 28 | 20 | 26 | 29 | 96 | 1 | 1272.1 | 40 | 21 | 20 | 23 | 96 | 1 |
| 784.13 | 36 | 28 | 27 | 34 | 96 | 1 | 968.07 | 40 | 28 | 30 | 34 | 96 | 1 | 1280.0 | 40 | 27 | 36 | 32 | 96 | 1 |
| 787.97 | 38 | 25 | 27 | 40 | 96 | 1 | 972.00 | 30 | 20 | 27 | 32 | 96 | 1 | 1288.0 | 30 | 21 | 27 | 23 | 96 | 1 |
| 792.00 | 36 | 24 | 22 | 32 | 96 | 1 | 976.05 | 38 | 23 | 20 | 26 | 96 | 1 | 1296.0 | 36 | 20 | 30 | 32 | 96 | 1 |
| 796.93 | 38 | 22 | 24 | 40 | 96 | 1 | 979.97 | 29 | 20 | 22 | 25 | 96 | 1 | 1303.8 | 40 | 26 | 32 | 29 | 96 | 1 |
| 800.00 | 25 | 20 | 20 | 24 | 96 | 1 | 983.93 | 34 | 23 | 26 | 30 | 96 | 1 | 1311.5 | 40 | 21 | 26 | 29 | 96 | 1 |
| 803.94 | 34 | 23 | 25 | 29 | 96 | 1 | 988.00 | 38 | 24 | 26 | 32 | 96 | 1 | 1319.9 | 32 | 20 | 29 | 27 | 96 | 1 |
| 807.90 | 27 | 22 | 24 | 28 | 96 | 1 | 992.15 | 40 | 22 | 27 | 38 | 96 | 1 | 1327.4 | 40 | 24 | 28 | 27 | 96 | 1 |
| 812.00 | 28 | 24 | 29 | 32 | 96 | 1 | 995.69 | 38 | 25 | 29 | 34 | 96 | 1 | 1336.3 | 38 | 21 | 25 | 26 | 96 | 1 |
| 816.00 | 34 | 20 | 20 | 32 | 96 | 1 | 1000.0 | 40 | 24 | 25 | 32 | 96 | 1 | 1344.0 | 28 | 20 | 25 | 20 | 96 | 1 |
| 819.98 | 38 | 27 | 22 | 29 | 96 | 1 | 1003.9 | 40 | 27 | 30 | 34 | 96 | 1 | 1352.2 | 34 | 20 | 29 | 28 | 96 | 1 |
| 824.02 | 38 | 25 | 24 | 34 | 96 | 1 | 1008.0 | 25 | 20 | 21 | 20 | 96 | 1 | 1360.0 | 34 | 20 | 25 | 24 | 96 | 1 |
| 828.00 | 30 | 20 | 23 | 32 | 96 | 1 | 1012.0 | 32 | 20 | 28 | 34 | 96 | 1 | 1368.0 | 38 | 20 | 30 | 32 | 96 | 1 |
| 832.00 | 26 | 20 | 20 | 24 | 96 | 1 | 1015.9 | 30 | 21 | 25 | 27 | 96 | 1 | 1376.3 | 32 | 20 | 28 | 25 | 96 | 1 |
| 836.00 | 38 | 24 | 22 | 32 | 96 | 1 | 1020.0 | 34 | 20 | 25 | 32 | 96 | 1 | 1384.2 | 38 | 22 | 24 | 23 | 96 | 1 |
| 840.00 | 25 | 20 | 21 | 24 | 96 | 1 | 1024.0 | 28 | 20 | 20 | 21 | 96 | 1 | 1392.0 | 40 | 20 | 29 | 32 | 96 | 1 |
| 843.99 | 36 | 25 | 29 | 38 | 96 | 1 | 1032.1 | 34 | 22 | 20 | 23 | 96 | 1 | 1400.1 | 38 | 23 | 32 | 29 | 96 | 1 |
| 847.87 | 36 | 25 | 23 | 30 | 96 | 1 | 1040.0 | 26 | 20 | 25 | 24 | 96 | 1 | 1408.0 | 40 | 20 | 22 | 24 | 96 | 1 |
| 851.97 | 32 | 25 | 26 | 30 | 96 | 1 | 1048.0 | 34 | 23 | 24 | 26 | 96 | 1 | 1415.3 | 38 | 23 | 29 | 26 | 96 | 1 |
| 855.98 | 40 | 34 | 36 | 38 | 96 | 1 | 1056.0 | 25 | 20 | 22 | 20 | 96 | 1 | 1424.3 | 34 | 22 | 36 | 30 | 96 | 1 |
| 859.87 | 36 | 22 | 26 | 38 | 96 | 1 | 1064.0 | 38 | 24 | 28 | 32 | 96 | 1 | 1431.8 | 29 | 20 | 27 | 21 | 96 | 1 |
| 864.00 | 27 | 20 | 20 | 24 | 96 | 1 | 1071.9 | 34 | 21 | 25 | 29 | 96 | 1 | 1440.0 | 30 | 20 | 25 | 20 | 96 | 1 |
| 868.17 | 26 | 20 | 20 | 23 | 96 | 1 | 1080.0 | 27 | 20 | 25 | 24 | 96 | 1 | 1448.1 | 40 | 22 | 28 | 27 | 96 | 1 |
| 872.17 | 38 | 29 | 26 | 30 | 96 | 1 | 1088.0 | 34 | 20 | 20 | 24 | 96 | 1 | 1456.2 | 34 | 20 | 29 | 26 | 96 | 1 |
| 876.09 | 28 | 20 | 22 | 27 | 96 | 1 | 1096.2 | 34 | 23 | 28 | 29 | 96 | 1 | 1464.1 | 38 | 23 | 30 | 26 | 96 | 1 |
| 880.00 | 25 | 20 | 22 | 24 | 96 | 1 | 1104.0 | 25 | 20 | 23 | 20 | 96 | 1 | 1472.0 | 40 | 20 | 23 | 24 | 96 | 1 |
| 884.00 | 34 | 24 | 26 | 32 | 96 | 1 | 1112.0 | 40 | 26 | 32 | 34 | 96 | 1 | 1480.3 | 38 | 23 | 28 | 24 | 96 | 1 |
| 887.95 | 38 | 29 | 30 | 34 | 96 | 1 | 1120.0 | 28 | 20 | 25 | 24 | 96 | 1 | 1487.9 | 40 | 26 | 34 | 27 | 96 | 1 |
| 892.02 | 34 | 23 | 22 | 28 | 96 | 1 | 1127.9 | 38 | 23 | 24 | 27 | 96 | 1 | 1495.9 | 32 | 20 | 28 | 23 | 96 | 1 |
| 896.00 | 28 | 20 | 20 | 24 | 96 | 1 | 1136.3 | 30 | 21 | 29 | 28 | 96 | 1 | 1503.8 | 38 | 23 | 32 | 27 | 96 | 1 |
| 900.00 | 30 | 20 | 25 | 32 | 96 | 1 | 1144.0 | 34 | 21 | 23 | 25 | 96 | 1 | 1512.4 | 40 | 25 | 32 | 26 | 96 | 1 |
| 903.90 | 29 | 22 | 25 | 28 | 96 | 1 | 1152.0 | 25 | 20 | 24 | 20 | 96 | 1 | 1520.0 | 38 | 20 | 25 | 24 | 96 | 1 |
| 907.98 | 36 | 21 | 20 | 29 | 96 | 1 | 1160.1 | 36 | 22 | 24 | 26 | 96 | 1 | 1528.7 | 38 | 20 | 22 | 21 | 96 | 1 |
| 912.00 | 38 | 20 | 20 | 32 | 96 | 1 | 1168.1 | 30 | 22 | 29 | 26 | 96 | 1 | 1536.0 | 32 | 20 | 25 | 20 | 96 | 1 |
| 915.91 | 28 | 20 | 23 | 27 | 96 | 1 | 1175.9 | 38 | 21 | 22 | 26 | 96 | 1 | 1544.1 | 40 | 27 | 38 | 28 | 96 | 1 |
| 920.00 | 25 | 20 | 23 | 24 | 96 | 1 | 1183.9 | 40 | 29 | 38 | 34 | 96 | 1 | 1551.5 | 40 | 22 | 30 | 27 | 96 | 1 |
| 923.96 | 34 | 25 | 23 | 26 | 96 | 1 | 1192.0 | 40 | 21 | 22 | 27 | 96 | 1 | 1560.4 | 36 | 21 | 32 | 27 | 96 | 1 |
| 928.00 | 29 | 20 | 20 | 24 | 96 | 1 | 1200.0 | 30 | 20 | 25 | 24 | 96 | 1 | 1567.8 | 34 | 21 | 29 | 23 | 96 | 1 |
| 931.84 | 28 | 24 | 26 | 25 | 96 | 1 | 1208.4 | 36 | 22 | 25 | 26 | 96 | 1 | 1575.9 | 38 | 20 | 27 | 25 | 96 | 1 |

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Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 3 (continued) — LEADS — LOW LEAD ATTACHMENT

CAUTION Be Sure Feed Direction Lever on Change Gear Box is Locked for All Leads Shown on This Page.

| Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | Lead | A | B | C | D | F | G | |
|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--------|----|----|----|----|----|---|--|
| 1584.6 | 36 | 22 | 29 | 23 | 96 | 1 | 1952.1 | 40 | 23 | 38 | 26 | 96 | 1 | 2633.1 | 40 | 20 | 36 | 21 | 96 | 1 | |
| 1591.9 | 38 | 20 | 24 | 22 | 96 | 1 | 1961.0 | 38 | 22 | 34 | 23 | 96 | 1 | 2653.1 | 40 | 20 | 38 | 22 | 96 | 1 | |
| 1600.0 | 40 | 20 | 25 | 24 | 96 | 1 | 1968.8 | 38 | 21 | 34 | 24 | 96 | 1 | 2779.4 | 40 | 20 | 38 | 21 | 96 | 1 | |
| 1608.6 | 36 | 22 | 32 | 25 | 96 | 1 | 1974.9 | 40 | 20 | 27 | 21 | 96 | 1 | 2918.4 | 40 | 20 | 38 | 20 | 96 | 1 | |
| 1615.8 | 36 | 21 | 27 | 22 | 96 | 1 | 1984.5 | 38 | 20 | 34 | 25 | 96 | 1 | | | | | | | | |
| 1624.2 | 38 | 23 | 32 | 25 | 96 | 1 | 1989.8 | 38 | 22 | 36 | 24 | 96 | 1 | | | | | | | | |
| 1632.0 | 34 | 20 | 25 | 20 | 96 | 1 | 2001.2 | 38 | 21 | 36 | 25 | 96 | 1 | | | | | | | | |
| 1639.2 | 40 | 22 | 27 | 23 | 96 | 1 | 2008.6 | 40 | 20 | 34 | 26 | 96 | 1 | | | | | | | | |
| 1647.1 | 38 | 21 | 32 | 27 | 96 | 1 | 2015.1 | 38 | 20 | 29 | 21 | 96 | 1 | | | | | | | | |
| 1654.9 | 40 | 22 | 32 | 27 | 96 | 1 | 2024.7 | 40 | 20 | 29 | 22 | 96 | 1 | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | |
| 1664.0 | 40 | 20 | 26 | 24 | 96 | 1 | 2030.2 | 40 | 23 | 38 | 25 | 96 | 1 | | | | | | | | |
| 1671.8 | 40 | 21 | 32 | 28 | 96 | 1 | 2040.8 | 40 | 22 | 38 | 26 | 96 | 1 | | | | | | | | |
| 1679.2 | 38 | 21 | 29 | 24 | 96 | 1 | 2048.0 | 40 | 20 | 28 | 21 | 96 | 1 | | | | | | | | |
| 1687.9 | 40 | 21 | 30 | 26 | 96 | 1 | 2064.2 | 40 | 22 | 34 | 23 | 96 | 1 | | | | | | | | |
| 1695.6 | 34 | 21 | 30 | 22 | 96 | 1 | 2076.3 | 38 | 22 | 36 | 23 | 96 | 1 | | | | | | | | |
| 1703.0 | 34 | 20 | 30 | 23 | 96 | 1 | 2094.5 | 40 | 22 | 36 | 24 | 96 | 1 | | | | | | | | |
| 1711.5 | 36 | 20 | 26 | 21 | 96 | 1 | 2114.8 | 40 | 23 | 38 | 24 | 96 | 1 | | | | | | | | |
| 1720.3 | 32 | 20 | 28 | 20 | 96 | 1 | 2127.8 | 40 | 21 | 32 | 22 | 96 | 1 | | | | | | | | |
| 1728.0 | 36 | 20 | 25 | 20 | 96 | 1 | 2147.7 | 38 | 21 | 34 | 22 | 96 | 1 | | | | | | | | |
| 1736.3 | 40 | 20 | 26 | 23 | 96 | 1 | 2161.8 | 40 | 20 | 38 | 27 | 96 | 1 | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | |
| 1743.0 | 36 | 20 | 29 | 23 | 96 | 1 | 2176.0 | 40 | 20 | 34 | 24 | 96 | 1 | | | | | | | | |
| 1752.2 | 38 | 21 | 29 | 23 | 96 | 1 | 2194.3 | 40 | 20 | 30 | 21 | 96 | 1 | | | | | | | | |
| 1759.4 | 36 | 20 | 28 | 22 | 96 | 1 | 2210.9 | 40 | 22 | 38 | 24 | 96 | 1 | | | | | | | | |
| 1767.6 | 40 | 21 | 29 | 24 | 96 | 1 | 2223.5 | 38 | 20 | 32 | 21 | 96 | 1 | | | | | | | | |
| 1776.3 | 40 | 21 | 34 | 28 | 96 | 1 | 2238.2 | 36 | 20 | 34 | 21 | 96 | 1 | | | | | | | | |
| 1786.8 | 38 | 21 | 36 | 28 | 96 | 1 | 2255.1 | 38 | 20 | 34 | 22 | 96 | 1 | | | | | | | | |
| 1792.0 | 40 | 20 | 28 | 24 | 96 | 1 | 2270.6 | 40 | 20 | 34 | 23 | 96 | 1 | | | | | | | | |
| 1800.4 | 40 | 21 | 32 | 26 | 96 | 1 | 2289.7 | 40 | 21 | 36 | 23 | 96 | 1 | | | | | | | | |
| 1807.8 | 36 | 20 | 34 | 26 | 96 | 1 | 2304.0 | 40 | 20 | 30 | 20 | 96 | 1 | | | | | | | | |
| 1816.0 | 40 | 21 | 36 | 29 | 96 | 1 | 2316.2 | 40 | 21 | 38 | 24 | 96 | 1 | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | |
| 1824.0 | 38 | 20 | 25 | 20 | 96 | 1 | 2334.7 | 38 | 20 | 32 | 20 | 96 | 1 | | | | | | | | |
| 1831.9 | 38 | 21 | 29 | 22 | 96 | 1 | 2362.5 | 38 | 20 | 34 | 21 | 96 | 1 | | | | | | | | |
| 1839.9 | 38 | 20 | 29 | 23 | 96 | 1 | 2362.5 | 38 | 20 | 34 | 21 | 96 | 1 | | | | | | | | |
| 1849.4 | 40 | 23 | 36 | 26 | 96 | 1 | 2387.8 | 38 | 20 | 36 | 22 | 96 | 1 | | | | | | | | |
| 1856.0 | 40 | 20 | 29 | 24 | 96 | 1 | 2393.8 | 40 | 21 | 36 | 22 | 96 | 1 | | | | | | | | |
| 1865.1 | 34 | 20 | 30 | 21 | 96 | 1 | 2416.9 | 40 | 21 | 38 | 23 | 96 | 1 | | | | | | | | |
| 1872.5 | 40 | 21 | 32 | 25 | 96 | 1 | 2432.0 | 40 | 20 | 38 | 24 | 96 | 1 | | | | | | | | |
| 1880.1 | 36 | 20 | 34 | 25 | 96 | 1 | 2457.6 | 40 | 20 | 32 | 20 | 96 | 1 | | | | | | | | |
| 1890.0 | 38 | 21 | 34 | 25 | 96 | 1 | 2480.6 | 38 | 20 | 34 | 20 | 96 | 1 | | | | | | | | |
| 1897.0 | 38 | 20 | 26 | 20 | 96 | 1 | 2486.9 | 40 | 20 | 34 | 21 | 96 | 1 | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | |
| 1903.3 | 38 | 23 | 36 | 24 | 96 | 1 | 2501.5 | 38 | 20 | 36 | 21 | 96 | 1 | | | | | | | | |
| 1913.0 | 40 | 21 | 34 | 26 | 96 | 1 | 2513.5 | 40 | 20 | 36 | 22 | 96 | 1 | | | | | | | | |
| 1920.0 | 40 | 20 | 25 | 20 | 96 | 1 | 2526.8 | 40 | 21 | 38 | 22 | 96 | 1 | | | | | | | | |
| 1928.3 | 40 | 21 | 29 | 22 | 96 | 1 | 2537.7 | 40 | 20 | 38 | 23 | 96 | 1 | | | | | | | | |
| 1935.4 | 36 | 20 | 28 | 20 | 96 | 1 | 2611.2 | 40 | 20 | 34 | 20 | 96 | 1 | | | | | | | | |
| 1942.8 | 40 | 22 | 32 | 23 | 96 | 1 | 2626.6 | 38 | 20 | 36 | 20 | 96 | 1 | | | | | | | | |

TABLE 4 — THREAD MILLING — SINGLE THREAD

CAUTION Be Sure That Table Trip Lever is Locked.

| Threads Per Inch | A | B | C | D | F | G | Threads Per Inch | A | B | C | D | F | G |
|------------------|----|----|----|----|---|----|------------------|----|----|----|----|---|----|
| 40 | | | | | | | 10 | 36 | 20 | 20 | 30 | 1 | 96 |
| 39 | | | | | | | 9 | 40 | 20 | 20 | 30 | 1 | 96 |
| 38 | 20 | 38 | 24 | 40 | 1 | 96 | 8 | 36 | 20 | 20 | 24 | 1 | 96 |
| 36 | 20 | 36 | 24 | 40 | 1 | 96 | 7 | 30 | 21 | 24 | 20 | 1 | 96 |
| 35 | | | | | | | 6 | 40 | 24 | 36 | 30 | 1 | 96 |
| 34 | 20 | 34 | 24 | 40 | 1 | 96 | 5-1/2 | 40 | 20 | 24 | 22 | 1 | 96 |
| 32 | 20 | 32 | 24 | 40 | 1 | 96 | 5 | 40 | 20 | 24 | 20 | 1 | 96 |
| 30 | 20 | 30 | 24 | 40 | 1 | 96 | 4-1/2 | 24 | 20 | 20 | 36 | 1 | 24 |
| 29 | 20 | 29 | 24 | 40 | 1 | 96 | 4 | 24 | 20 | 20 | 32 | 1 | 24 |
| 28 | 20 | 28 | 24 | 40 | 1 | 96 | 3-1/2 | 24 | 20 | 20 | 28 | 1 | 24 |
| 27 | 20 | 27 | 24 | 40 | 1 | 96 | 3-1/4 | 24 | 20 | 20 | 26 | 1 | 24 |
| 26 | 20 | 26 | 24 | 40 | 1 | 96 | 3 | 36 | 24 | 20 | 30 | 1 | 24 |
| 25 | 20 | 25 | 24 | 40 | 1 | 96 | 2-7/8 | 24 | 20 | 20 | 23 | 1 | 24 |
| 24 | 30 | 36 | 24 | 40 | 1 | 96 | 2-3/4 | 36 | 22 | 20 | 30 | 1 | 24 |
| 23 | 24 | 23 | 20 | 40 | 1 | 96 | 2-5/8 | 32 | 20 | 20 | 28 | 1 | 24 |
| 22 | 24 | 22 | 20 | 40 | 1 | 96 | 2-1/2 | 30 | 20 | 20 | 25 | 1 | 24 |
| 21 | 24 | 21 | 20 | 40 | 1 | 96 | 2-3/8 | 24 | 38 | 40 | 20 | 1 | 24 |
| 20 | 24 | 20 | 20 | 40 | 1 | 96 | 2-1/4 | 40 | 20 | 20 | 30 | 1 | 24 |
| 19 | 24 | 20 | 20 | 38 | 1 | 96 | 2-1/8 | 40 | 20 | 24 | 34 | 1 | 24 |
| 18 | 24 | 20 | 20 | 36 | 1 | 96 | 2 | 40 | 20 | 24 | 32 | 1 | 24 |
| 17 | 24 | 20 | 20 | 34 | 1 | 96 | 1-7/8 | 40 | 20 | 24 | 30 | 1 | 24 |
| 16 | 24 | 20 | 20 | 32 | 1 | 96 | 1-3/4 | 30 | 21 | 24 | 20 | 1 | 24 |
| 15 | 24 | 20 | 20 | 30 | 1 | 96 | 1-5/8 | 40 | 20 | 24 | 26 | 1 | 24 |
| 14 | 24 | 20 | 20 | 28 | 1 | 96 | 1-1/2 | 40 | 24 | 36 | 30 | 1 | 24 |
| 13 | 24 | 20 | 20 | 26 | 1 | 96 | 1-3/8 | 40 | 20 | 24 | 22 | 1 | 24 |
| 12 | 36 | 24 | 20 | 30 | 1 | 96 | 1-1/4 | 40 | 20 | 24 | 20 | 1 | 24 |
| 11-1/2 | 24 | 20 | 20 | 23 | 1 | 96 | 1-1/8 | 40 | 20 | 28 | 21 | 1 | 24 |
| 11 | 30 | 20 | 20 | 40 | 1 | 96 | 1 | 21 | 28 | 20 | 40 | 8 | 24 |

Operator's Manual

Table of Leads and Indexing Divisions for Milling Machines

Equipped with Model K Universal Spiral Dividing Head and Conventional or Low Lead Attachment (U. S. Standard Lead Screw)

TABLE 4 (continued) — THREAD MILLING — DOUBLE THREAD

CAUTION Be Sure That Table Trip Lever is Locked.

| Threads per Inch | A | B | C | D | F | G | Threads per Inch | A | B | C | D | F | G |
|---------------------|----|----|----|----|---|----|---------------------|----|----|----|----|---|----|
| 40 | 24 | 20 | 20 | 40 | 1 | 96 | 10 | 24 | 20 | 20 | 40 | 1 | 24 |
| 39 | 32 | 26 | 20 | 40 | 1 | 96 | 9 | 24 | 20 | 20 | 36 | 1 | 24 |
| 38 | 24 | 20 | 20 | 38 | 1 | 96 | 8 | 30 | 20 | 20 | 40 | 1 | 24 |
| 36 | 24 | 20 | 20 | 36 | 1 | 96 | 7 | 24 | 20 | 20 | 28 | 1 | 24 |
| 35 | 20 | 25 | 24 | 28 | 1 | 96 | 6 | 36 | 24 | 20 | 30 | 1 | 24 |
| 34 | 24 | 20 | 20 | 34 | 1 | 96 | 5-1/2 | 36 | 22 | 20 | 30 | 1 | 24 |
| 32 | 24 | 20 | 20 | 32 | 1 | 96 | 5 | 30 | 20 | 20 | 25 | 1 | 24 |
| 30 | 24 | 20 | 20 | 30 | 1 | 96 | 4-1/2 | 40 | 20 | 20 | 30 | 1 | 24 |
| 29 | 24 | 20 | 20 | 29 | 1 | 96 | 4 | 40 | 20 | 24 | 32 | 1 | 24 |
| 28 | 24 | 20 | 20 | 28 | 1 | 96 | 3-1/2 | 30 | 21 | 24 | 20 | 1 | 24 |
| 27 | 24 | 20 | 20 | 27 | 1 | 96 | 3-1/4 | 40 | 20 | 24 | 26 | 1 | 24 |
| 26 | 24 | 20 | 20 | 26 | 1 | 96 | 3 | 40 | 24 | 36 | 30 | 1 | 24 |
| 25 | 24 | 20 | 20 | 25 | 1 | 96 | 2-7/8 | 40 | 20 | 24 | 23 | 1 | 24 |
| 24 | 36 | 24 | 20 | 30 | 1 | 96 | 2-3/4 | 40 | 20 | 24 | 22 | 1 | 24 |
| 23 | 24 | 20 | 20 | 23 | 1 | 96 | 2-5/8 | 40 | 20 | 24 | 21 | 1 | 24 |
| 22 | 36 | 22 | 20 | 30 | 1 | 96 | 2-1/2 | 40 | 20 | 30 | 25 | 1 | 24 |
| 21 | 32 | 20 | 20 | 28 | 1 | 96 | 2-3/8 | 20 | 40 | 24 | 38 | 8 | 24 |
| 20 | 36 | 20 | 20 | 30 | 1 | 96 | 2-1/4 | 20 | 30 | 20 | 40 | 8 | 24 |
| 19 | 20 | 38 | 24 | 40 | 1 | 24 | 2-1/8 | 20 | 34 | 24 | 40 | 8 | 24 |
| 18 | 20 | 36 | 24 | 40 | 1 | 24 | 2 | 20 | 28 | 21 | 40 | 8 | 24 |
| 17 | 20 | 34 | 24 | 40 | 1 | 24 | 1-7/8 | 20 | 30 | 24 | 40 | 8 | 24 |
| 16 | 20 | 32 | 24 | 40 | 1 | 24 | 1-3/4 | 20 | 28 | 24 | 40 | 8 | 24 |
| 15 | 20 | 30 | 24 | 40 | 1 | 24 | 1-5/8 | 20 | 26 | 24 | 40 | 8 | 24 |
| 14 | 20 | 28 | 24 | 40 | 1 | 24 | 1-1/2 | 21 | 28 | 24 | 36 | 8 | 24 |
| 13 | 20 | 26 | 24 | 40 | 1 | 24 | 1-3/8 | 20 | 22 | 24 | 40 | 8 | 24 |
| 12 | 20 | 28 | 21 | 30 | 1 | 24 | 1-1/4 | 20 | 25 | 21 | 28 | 8 | 24 |
| 11-1/2 | 24 | 23 | 20 | 40 | 1 | 24 | 1-1/8 | 20 | 36 | 24 | 20 | 8 | 24 |
| 11 | 24 | 22 | 20 | 40 | 1 | 24 | 1 | 30 | 20 | 20 | 40 | 8 | 24 |

TABLE 4 (continued) — THREAD MILLING — TRIPLE THREAD

CAUTION Be Sure That Table Trip Lever is Locked.

| Threads per Inch | A | B | C | D | F | G | Threads Per Inch | A | B | C | D | F | G |
|---------------------|----|----|----|----|---|----|---------------------|----|----|----|----|---|----|
| 40 | 36 | 20 | 20 | 40 | 1 | 96 | 10 | 27 | 20 | 20 | 30 | 1 | 24 |
| 39 | 24 | 20 | 20 | 26 | 1 | 96 | 9 | 25 | 20 | 24 | 30 | 1 | 24 |
| 38 | 36 | 20 | 20 | 38 | 1 | 96 | 8 | 27 | 20 | 20 | 24 | 1 | 24 |
| 36 | 36 | 24 | 20 | 30 | 1 | 96 | 7 | 36 | 20 | 20 | 28 | 1 | 24 |
| 35 | 36 | 25 | 20 | 28 | 1 | 96 | 6 | 36 | 20 | 20 | 24 | 1 | 24 |
| 34 | 36 | 20 | 20 | 34 | 1 | 96 | 5-1/2 | 36 | 20 | 20 | 22 | 1 | 24 |
| 33 | 36 | 22 | 20 | 30 | 1 | 96 | 5 | 40 | 20 | 27 | 30 | 1 | 24 |
| 32 | 30 | 20 | 24 | 32 | 1 | 96 | 4-1/2 | 32 | 20 | 25 | 20 | 1 | 24 |
| 30 | 36 | 20 | 20 | 30 | 1 | 96 | 4 | 36 | 32 | 40 | 20 | 1 | 24 |
| 29 | 36 | 20 | 20 | 29 | 1 | 96 | 3-1/2 | 40 | 20 | 27 | 21 | 1 | 24 |
| 28 | 36 | 20 | 20 | 28 | 1 | 96 | 3-1/4 | 40 | 20 | 36 | 26 | 1 | 24 |
| 27 | 36 | 20 | 20 | 27 | 1 | 96 | 3 | 40 | 20 | 36 | 24 | 1 | 24 |
| 26 | 36 | 20 | 20 | 26 | 1 | 96 | 2-7/8 | 40 | 20 | 36 | 23 | 1 | 24 |
| 25 | 36 | 20 | 20 | 25 | 1 | 96 | 2-3/4 | 40 | 20 | 36 | 22 | 1 | 24 |
| 24 | 36 | 20 | 20 | 24 | 1 | 96 | 2-5/8 | 24 | 28 | 20 | 40 | 8 | 24 |
| 23 | 36 | 20 | 20 | 23 | 1 | 96 | 2-1/2 | 24 | 28 | 21 | 40 | 8 | 24 |
| 22 | 36 | 20 | 20 | 22 | 1 | 96 | 2-3/8 | 24 | 38 | 30 | 40 | 8 | 24 |
| 21 | 36 | 20 | 20 | 21 | 1 | 96 | 2-1/4 | 24 | 30 | 25 | 40 | 8 | 24 |
| 20 | 30 | 20 | 24 | 20 | 1 | 96 | 2-1/8 | 21 | 28 | 24 | 34 | 8 | 24 |
| 19 | 36 | 38 | 40 | 20 | 1 | 96 | 2 | 21 | 40 | 30 | 28 | 8 | 24 |
| 18 | 30 | 20 | 28 | 21 | 1 | 96 | 1-7/8 | 24 | 20 | 20 | 40 | 8 | 24 |
| 17 | 40 | 20 | 36 | 34 | 1 | 96 | 1-3/4 | 30 | 28 | 24 | 40 | 8 | 24 |
| 16 | 36 | 20 | 30 | 24 | 1 | 96 | 1-5/8 | 21 | 26 | 24 | 28 | 8 | 24 |
| 15 | 24 | 20 | 20 | 40 | 1 | 24 | 1-1/2 | 30 | 20 | 20 | 40 | 8 | 24 |
| 14 | 20 | 40 | 36 | 28 | 1 | 24 | 1-3/8 | 21 | 22 | 24 | 28 | 8 | 24 |
| 13 | 20 | 30 | 27 | 26 | 1 | 24 | 1-1/4 | 30 | 20 | 24 | 40 | 8 | 24 |
| 12 | 30 | 20 | 20 | 40 | 1 | 24 | 1-1/8 | 30 | 24 | 20 | 25 | 8 | 24 |
| 11-1/2 | 20 | 40 | 36 | 23 | 1 | 24 | 1 | 36 | 24 | 30 | 40 | 8 | 24 |
| 11 | 27 | 22 | 20 | 30 | 1 | 24 | | | | | | | |

TABLE 4 (continued) — THREAD MILLING — QUADRUPLE THREAD

CAUTION Be Sure That Table Trip Lever is Locked.

| Threads Per Inch | A | B | C | D | F | G | Threads Per Inch | A | B | C | D | F | G |
|------------------|----|----|----|----|---|----|------------------|----|----|----|----|---|----|
| 40 | 36 | 20 | 20 | 30 | 1 | 96 | 10 | 36 | 20 | 20 | 30 | 1 | 24 |
| 39 | 40 | 30 | 24 | 26 | 1 | 96 | 9 | 36 | 20 | 20 | 27 | 1 | 24 |
| 38 | 40 | 20 | 24 | 38 | 1 | 96 | 8 | 36 | 20 | 20 | 24 | 1 | 24 |
| 36 | 40 | 20 | 20 | 30 | 1 | 96 | 7 | 36 | 20 | 20 | 21 | 1 | 24 |
| 35 | 36 | 21 | 20 | 25 | 1 | 96 | 6 | 36 | 30 | 40 | 24 | 1 | 24 |
| 34 | 40 | 20 | 24 | 34 | 1 | 96 | 5-1/2 | 40 | 22 | 24 | 20 | 1 | 24 |
| 33 | 40 | 22 | 24 | 30 | 1 | 96 | 5 | 36 | 30 | 40 | 20 | 1 | 24 |
| 32 | 40 | 20 | 24 | 32 | 1 | 96 | 4-1/2 | 24 | 36 | 20 | 40 | 8 | 24 |
| 30 | 24 | 30 | 20 | 40 | 1 | 24 | 4 | 24 | 32 | 20 | 40 | 8 | 24 |
| 29 | 24 | 29 | 20 | 40 | 1 | 24 | 3-1/2 | 24 | 28 | 20 | 40 | 8 | 24 |
| 28 | 24 | 28 | 20 | 40 | 1 | 24 | 3-1/4 | 24 | 26 | 20 | 40 | 8 | 24 |
| 27 | 24 | 27 | 20 | 40 | 1 | 24 | 3 | 30 | 36 | 24 | 40 | 8 | 24 |
| 26 | 24 | 26 | 20 | 40 | 1 | 24 | 2-7/8 | 24 | 23 | 20 | 40 | 8 | 24 |
| 25 | 24 | 25 | 20 | 40 | 1 | 24 | 2-3/4 | 24 | 22 | 20 | 40 | 8 | 24 |
| 24 | 24 | 40 | 30 | 36 | 1 | 24 | 2-5/8 | 24 | 21 | 20 | 40 | 8 | 24 |
| 23 | 24 | 23 | 20 | 40 | 1 | 24 | 2-1/2 | 24 | 20 | 20 | 40 | 8 | 24 |
| 22 | 24 | 22 | 20 | 40 | 1 | 24 | 2-3/8 | 24 | 20 | 20 | 38 | 8 | 24 |
| 21 | 20 | 25 | 20 | 28 | 1 | 24 | 2-1/4 | 24 | 20 | 20 | 36 | 8 | 24 |
| 20 | 24 | 20 | 20 | 40 | 1 | 24 | 2-1/8 | 24 | 20 | 20 | 34 | 8 | 24 |
| 19 | 24 | 20 | 20 | 38 | 1 | 24 | 2 | 24 | 20 | 20 | 32 | 8 | 24 |
| 18 | 24 | 20 | 20 | 36 | 1 | 24 | 1-7/8 | 24 | 20 | 20 | 30 | 8 | 24 |
| 17 | 24 | 20 | 20 | 34 | 1 | 24 | 1-3/4 | 24 | 20 | 20 | 28 | 8 | 24 |
| 16 | 24 | 20 | 20 | 32 | 1 | 24 | 1-5/8 | 24 | 20 | 20 | 26 | 8 | 24 |
| 15 | 24 | 20 | 20 | 30 | 1 | 24 | 1-1/2 | 30 | 24 | 20 | 25 | 8 | 24 |
| 14 | 24 | 20 | 20 | 28 | 1 | 24 | 1-3/8 | 36 | 22 | 20 | 30 | 8 | 24 |
| 13 | 24 | 20 | 20 | 26 | 1 | 24 | 1-1/4 | 36 | 20 | 20 | 30 | 8 | 24 |
| 12 | 20 | 25 | 30 | 24 | 1 | 24 | 1-1/8 | 36 | 20 | 20 | 27 | 8 | 24 |
| 11-1/2 | 24 | 20 | 20 | 23 | 1 | 24 | 1 | 36 | 20 | 20 | 24 | 8 | 24 |
| 11 | 24 | 20 | 20 | 22 | 1 | 24 | | | | | | | |

TABLE 4 (continued) — THREAD MILLING — METRIC THREAD

On Machines Having 1/4 Inch Pitch (Four threads per inch) Lead Screws.

CAUTION Be Sure That Table Trip Lever is Locked.

| Lead in M/M | Required Lead in Inches | Nearest Lead in Inches | Error per Turn in Inches | A | B | C | D | F | G |
|----------------|-------------------------------|------------------------------|--------------------------------|----|----|----|----|---|----|
| .70 | .02755956 | .02763 | +.000072 | 21 | 38 | 24 | 40 | 1 | 96 |
| .75 | .02952810 | .02960 | +.000067 | 21 | 34 | 23 | 40 | 1 | 96 |
| .80 | .03149664 | .03152 | +.000027 | 20 | 32 | 23 | 38 | 1 | 96 |
| .90 | .03543372 | .03543 | -.000008 | 20 | 26 | 21 | 38 | 1 | 96 |
| 1.00 | .03937080 | .03938 | +.000004 | 21 | 30 | 27 | 40 | 1 | 96 |
| 1.25 | .04921350 | .04922 | +.000005 | 21 | 24 | 27 | 40 | 1 | 96 |
| 1.50 | .05905620 | .05905 | -.000002 | 26 | 28 | 29 | 38 | 1 | 96 |
| 1.75 | .06889890 | .06890 | -.000003 | 26 | 24 | 29 | 38 | 1 | 96 |
| 2.00 | .07874160 | .07874 | -.000003 | 26 | 21 | 29 | 38 | 1 | 96 |
| 2.50 | .09842700 | .09842 | -.000001 | 29 | 26 | 36 | 34 | 1 | 96 |
| 3.00 | .11811240 | .11813 | +.000001 | 21 | 20 | 27 | 20 | 1 | 96 |
| 3.50 | .1377978 | .13780 | +.000001 | 22 | 34 | 23 | 36 | 1 | 24 |
| 4.00 | .1574832 | .15750 | +.000016 | 21 | 30 | 27 | 40 | 1 | 24 |
| 4.50 | .1771686 | .17717 | +.000002 | 22 | 28 | 23 | 34 | 1 | 24 |
| 5.00 | .1968540 | .19688 | +.000002 | 21 | 24 | 27 | 40 | 1 | 24 |
| 5.50 | .2165394 | .21647 | -.000069 | 23 | 25 | 24 | 34 | 1 | 24 |
| 6.00 | .2362248 | .23622 | -.000009 | 26 | 28 | 29 | 38 | 1 | 24 |
| 6.50 | .2559102 | .25588 | -.000028 | 29 | 34 | 36 | 40 | 1 | 24 |
| 7.00 | .2755956 | .27558 | -.000001 | 26 | 24 | 29 | 38 | 1 | 24 |

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