



THREADING CHART

A - B - C ARE GEAR STUD POSITIONS
 B = BACK POSITION (TOWARD HEADSTOCK)
 F = FRONT POSITION (AWAY FROM HEADSTOCK)
 I = IDLER GEAR
 S = SPACER GEAR
 ---- = BLANK
 XXS = STEEL SPACER

THREADS PER INCH	GEAR ON SCREW	POSITION C		POSITION B		POSITION A		SPINDLE STUD GEAR	FIG.
		B	F	B	F	B	F		
8	32F	32	64	----	----	64I	XXS	32	1
9	36F	32	64	----	----	64I	XXS	32	1
10	40F	32	64	----	----	64I	XXS	32	1
11	44F	20	40	----	----	64I	XXS	32	1
11.5	46F	20	40	----	----	64I	XXS	32	1
12	48F	20	40	----	----	64I	XXS	32	1
13	52F	20	40	----	----	64I	XXS	32	1
14	56F	20	40	----	----	64I	XXS	32	1
16	64F	20	40	----	----	64I	XXS	32	1
18	36B	----	----	64I	XXS	----	----	32	2
20	40B	----	----	64I	XXS	----	----	32	2
22	44B	----	----	64I	XXS	----	----	32	2
24	48B	----	----	64I	XXS	----	----	32	2
27	54B	----	----	64I	XXS	----	----	32	2
28	56B	----	----	64I	XXS	----	----	32	2
32	64B	----	----	64I	XXS	----	----	32	2
36	36F	20S	32I	----	----	64I	XXS	16	3
40	40F	20S	32I	----	----	64I	XXS	16	3
44	44F	20S	32I	----	----	64I	XXS	16	3
48	48F	20S	32I	----	----	64I	XXS	16	3
56	56F	20S	32I	----	----	64I	XXS	16	3
64	64F	20S	32I	----	----	64I	XXS	16	3
72	36B	56I	XXS	----	----	32	64	16	4
80	40B	56I	XXS	----	----	32	64	16	4
96	48B	56I	XXS	----	----	32	64	16	4
FEED PER REVOLUTION OF SPINDLE									
.0024"	32F	64	20	----	----	24	48	16	5
.0039"	32F	64	32	----	----	24	48	16	5
.0048"	32F	20	64	----	----	48	24	32	6
.0078"	32F	32	64	----	----	48	24	32	6