MODEL B OVERSIZE MACHINE - With Threading - 45 Cycle

2:1 THREADING METHOD TABLE (Formerly Brass Method)

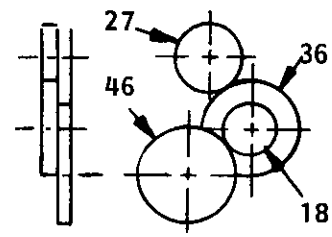
Work Spindle Speed 2384 r.p.m., Gears 46 T. Driver, 18 T. Driven

Threading Change Gears 36 T. Driver, 27 T. Driven

Table for selecting brass threading cam and location of block on threading cam lever for right and left hand threads. Threading spindle does not revolve when tap or die is running on to work, but runs twice the speed of work spindles, in the same direction, when running off (right hand threads only). Threading spindle revolves twice the speed of the work spindles, in the same directions, when tap or die is running on to work, but is stopped when running off (left hand threads only).

Select number of effective rev's of spindle in table which is nearest number required to complete piece.

Upper figure in each square denotes number of cam to be used. Lower figure denotes position of block on threading cam lever.



Seconds Per Piece	Effec. rev's of Spin. per piece	No. of threads that can be cut	Number of Threads Per Inch														
			12	14	16	18	20	22	24	26	28	30	32	34	36	38	40
1.3	24	12	5 .91	4 1.2	4 1.11	4 .98	4 .89	3 .97	3 .89	3 .82	2 1.10	2 1.03	2 .96	2 .91	2 .86	2 .81	1 1.2
1.6	36	18	6 .98	5 1.17	5 1.03	5 .91	5 .82	4 1.2	4 1.11	4 1.02	4 .95	4 .89	3 1.0	3 .94	3 .89	2 1.2	2 1.16
1.9	48	24	7 .80	6 1.12	6 .98	6 .87	5 1.10	5 1.0	5 .91	5 .84	4 1.2	4 1.18	4 1.11	4 1.04	4 .99	4 .94	4 .89
2.2	60	30	7 1.2	7 .86	6 1.2	6 1.09	6 .98	6 .89	5 1.14	5 1.05	5 1.07	5 .91	5 .86	5 .80	4 1.2	4 1.17	4 1.11
2.5	72	36	7 1.2	7 1.03	7 .90	7 .80	6 1.18	6 1.07	6 .98	6 .91	5 1.17	5 1.10	5 1.03	5 .97	5 .91	5 .86	5 .82
2.9	88	44	8 .95	7 1.2	7 1.10	7 .98	7 .88	7 .80	6 1.2	6 1.11	6 1.03	6 .96	6 .90	5 1.18	5 1.12	5 1.06	5 1.0
3.2	100	50	8 1.08	8 .93	7 1.2	7 1.11	7 1.0	7 .91	7 .83	6 1.2	6 1.17	6 1.09	6 1.02	6 .96	6 .91	6 .86	5 1.14
3.5	112	56	8 1.2	8 1.04	8 .91	7 1.2	7 1.12	7 1.02	7 .93	7 .86	7 .80	6 1.2	6 1.15	6 1.08	6 1.02	6 .97	6 .92
3.9	128	64		8 1.19	8 1.04	8 .92	8 .83	7 1.16	7 1.07	7 .98	7 .91	7 .85	7 .80	6 1.2	6 1.16	6 1.10	6 1.05
4.2	140	70			8 1.14	8 1.01	8 .91	8 .83	7 1.17	7 1.08	7 1.0	7 .93	7 .88	7 .82	6 1.2	6 1.2	6 1.15
4.5	150	75			8 1.2	8 1.08	8 .98	8 .89	7 1.2	7 1.15	7 1.07	7 1.0	7 .94	7 .88	7 .83	6 1.2	6 1.2
4.7	158	79				8 1.14	8 1.03	8 .93	8 .86	7 1.2	7 1.13	7 1.05	7 1.0	7 .93	7 .88	7 .83	6 1.2
5.0	170	85				8 1.2	8 1.10	8 1.0	8 .92	8 .85	7 1.2	7 1.13	7 1.06	7 1.0	7 .94	7 .89	.85