TO FIGURE WORKING TIME IN SECONDS

The motor speed times the pitch diameter of the motor pulley divided by the drive shaft pulley pitch diameter times (934) gear divided by large gear on compound gear (MB-41) times the small gear on the compound gear (MB-41) divided by driving clutch gear times idler shaft driving gear divided by idler shaft driven gear times change gear divided by meshing compound gear times other segment of compound gear divided by clutch body gear times worm divided by worm wheel equals R.P.M. of Cam Shaft during working (0-50) portion of time cycle.

The example shown below is at 75 indexes using a 75 tooth change gear to attain 1.2 seconds cycle time:

Motor Speed		(75Cycle) Motor Pulley		(934) Gear		Small Gear Compound		Idler Shaft Driving Gear		Change Gear		Compound Driven Gear		Worm		37.54 R.P.M. of Cam Shaft
1745 / 1	x	7.4 / 8.6	x	32 / 32	x	26 / 104	x	32 / 60	x	75 / 30	x	60 / 80	x	6 / 60	=	
		Drive Pulley Shaft		Large Compound Gear		Driving Clutch Gear		Idler Shaft Driven Gear		Compound Gear Drive		Clutch Body Gear		Worm Wheel		

$$\frac{60 \text{ Seconds divided by } 37.54 \text{ R.P.M. of Cam Shaft}}{2} = \frac{1.6}{2} = .8 \text{ Working Time (0-50)}$$

.8 Working Time plus .4 Index Time equals 1.2 Cycle Time.