## MODEL B MACHINE WITH THREADING 75 Cycle - 60 Cycle - 45 Cycle 6:1 THREADING METHOD TABLE (Formerly Steel Threading Method)

Threading Change Gears - 32 T. Driver, 32 T. Driven

Table for selecting steel threading cam and location of block on threading cam lever for right hand threads only. Ratio of work spindles to threading spindles is 4 to 3 going on and 1 to  $1\frac{1}{2}$  coming off.

Select number of effective rev's of spindle in table which is nearest number required to complete piece.	6016	, 011 0	114 1	<b>0</b> 0 <b>1</b> 2	3 001111	6								<del></del>			
Position of block on threading can lever.   Position of block on	r's pie	of thread t can be	in table which is nearest number required to														
12	ffec. re pin. per		of cam to be used. Lower figure denotes														
24	E O	4 N															
24	-				<u></u>	1						<del></del>		34	<del></del>		<del></del>
So	24	4		T	1 -	-	-	1 -		_	, –	~	_	.94	_	-	-
36         6         .97         .83         1.13         8         .91         .82         1.19         1.1         1.00         .95         .89         .84         .8         1.2         1.19           42         7         1.13         .97         .85         1.17         1.06         .96         .88         .81         1.19         1.1         1.04         .98         .82         .82         2	30	5	-	-	-	ļ =		1	; —	_	-	_	_	1	1 1.1	1 -	ı – ı
42         7         1.13         .97         .85         1.17         1.06         .96         .88         .81         1.19         1.1         1.04         .98         .92         .87         .83           48         8         8         1.1         .97         .86         1.2         1.1         1.         .93         3.8         3.8         2	36	6	ı <del>-</del>	j -	3	3	3	3	2	2	2	2	2	2	2	1	1
48         8         5         4         4         4         3         3         3         3         2	<u> </u>	Ť	<del></del>		<del> </del>				+			<u> </u>					
48         8         .8         1.1         .97         .86         1.2         1.1         1.         .93         .86         .81         1.19         1.12         1.06         1.         .95           54         9         .9         1.2         1.09         .97         .87         1.2         1.13         1.04         .97         .91         .81         1.19         1.13         1.07           60         10         1.         .85         1.2         1.08         .97         .88         1.2         1.16         1.08         1.         .94         .89         .84         .8         1.19           66         11         1.1         .94         .82         1.18         1.07         .97         .89         .82         1.19         1.1         1.04         .89         .92         .83         3	42	7	<del></del>					<b></b>							<u> </u>	•87	.83
54         9         5         4         4         4         3	48	8	_	_	1 -	_	1 -	l		. •	_	1		1	_	1 - 7	-
60         10         1.         .85         1.2         1.08         .97         .88         1.2         1.16         1.08         1.         .94         .89         .84         .8         1.19           66         11         1.1         .94         .82         1.18         1.07         .97         .89         .82         1.19         1.04         .98         .92         .88         1.19           66         11         1.1         .94         .82         1.18         1.07         .97         .89         .82         1.11         1.04         .98         .92         .88         .83           72         12         1.2         1.03         .9         .8         1.16         1.06         .97         .89         .83         .78         1.13         1.07         1.         .96         .91           78         13         .83         1.1         .97         .86         .78         1.15         1.05         .97         .9         .84         1.2         1.16         1.09         .93         .98         1.2         1.13         1.04         .97         .9         .85         .8         1.18         1.1         1.06		<u> </u>	5	4	4	4	4	3	3	3	3	3	3	3	<del></del>	2	
60         10         1.         .85         1.2         1.08         .97         .88         1.2         1.16         1.08         1.         .94         .89         .84         .8         1.19           66         11         1.1         .94         .82         1.18         1.07         .97         .89         .82         1.19         1.1         1.04         .98         .92         .88         .83           72         12         1.2         1.03         .9         .8         1.16         1.06         .97         .89         .82         1.19         1.1         1.04         .98         .92         .88         .83           72         12         1.2         1.03         .98         1.61         1.06         .97         .89         .82         7.81         1.13         1.00         .98         .91         .91         .93         .83         1.15         1.05         .97         .9         .84         1.2         1.16         1.09         1.03         .98         .91         .93         .83         1.2         1.13         1.00         .97         .9         .84         1.2         1.16         1.09         1.03 <td< td=""><td>54</td><td>9</td><td></td><td>1.2</td><td><del> </del></td><td><del></del></td><td></td><td><del></del></td><td></td><td><del></del></td><td></td><td></td><td></td><td></td><td>+</td><td></td><td>-</td></td<>	54	9		1.2	<del> </del>	<del></del>		<del></del>		<del></del>					+		-
66         11         5, 4         4, 82         1,18         1,07         9,97         8,89         8,82         1,19         1,1         1,04         9,88         9,22         3,88         8,83           72         12         1,2         1,03         9         8         1,16         1,06         9,7         8,89         8,82         1,19         1,11         1,04         9,88         3,83         3 <td>60</td> <td>10</td> <td>Ĭ</td> <td>85</td> <td>, -</td> <td>  -</td> <td></td> <td>  -</td> <td>_</td> <td>1 -</td> <td>I -</td> <td>1</td> <td>-</td> <td>} -</td> <td>1</td> <td>  -</td> <td>1 1</td>	60	10	Ĭ	85	, -	-		-	_	1 -	I -	1	-	} -	1	-	1 1
72         12         1.2         1.03         .9         .8         1.16         1.06         .97         .89         .83         .78         1.13         1.07         1.         .96         .91           6         5         5         5         5         4         4         4         4         3			5	5	5	4	4	4	4	4	3	3	3	3	3	3	3
72         12         1.2         1.03         .9         .8         1.16         1.06         .97         .89         .83         .78         1.13         1.07         1.         .96         .91           78         13         .83         1.1         .97         .86         .78         1.15         1.05         .97         .9         .84         1.2         1.16         1.09         1.03         .98           84         14         .89         1.2         1.05         .93         .83         1.2         1.13         1.04         .97         .9         .84         1.2         1.16         1.09         1.03         .98           84         14         .89         1.2         1.05         .93         .83         1.2         1.13         1.04         .97         .9         .85         .8         1.18         1.10         1.06         .98         .83         1.2         1.13         1.04         .97         .91         .85         .8         1.19         1.10         .97         .91         .85         .8         1.19         1.13         1.04         .97         .91         .85         .8         1.19         1.1         1	66	11_			-		<b>.</b>		<del></del>							.88	_
78         13         6.83         5.         5         5         5         4         4         4         4         4         3         3         3         3         3         98           84         14         .89         1.2         1.05         .93         .83         1.2         1.13         1.04         .97         .9         .85         .8         1.18         1.1         1.06         .98           84         14         .89         1.2         1.05         .93         .83         1.2         1.13         1.04         .97         .9         .85         .8         1.18         1.1         1.06           90         15         .96         .82         1.12         1.         .89         .81         1.2         1.12         1.04         .97         .91         .85         .8         1.19         1.13           90         15         .96         .82         1.2         1.06         .96         .87         .8         1.12         1.04         .97         .91         .85         .8         1.13         1.02         .92         .85         .78         1.18         1.1         1.03         .97	72	12	١ -	~	-	•	-	ı –	ı ~	_	ı -	-	_	-	-	•96	1 '
84         14         .89         1.2         1.05         .93         .83         1.2         1.13         1.04         .97         .9         .85         .8         1.18         1.1         1.06           90         15         .96         .82         1.12         1.         .89         .81         1.2         1.12         1.04         .97         .91         .85         .8         1.18         1.1         1.06           90         15         .96         .82         1.12         1.         .89         .81         1.2         1.04         .97         .91         .85         .8         1.19         1.13           96         16         1.02         .88         1.2         1.06         .96         .87         .8         1.19         1.1         1.03         .97         .91         .86         .81         1.2           102         17         1.09         .93         .81         1.13         1.02         .92         .85         .78         1.18         1.1         1.03         .97         .91         .86         .81         1.2           102         17         1.09         .93         .81         1.13			١ *	_	-	5	5	4	4	4	4	4	3	3	3	3	3
84         14         .89         1.2         1.05         .93         .83         1.2         1.13         1.04         .97         .9         .85         .8         1.18         1.1         1.06         90         15         .96         .82         1.12         1.         .89         .81         1.2         1.12         1.04         .97         .91         .85         .8         1.19         1.13         1.06         .96         .81         1.2         1.12         1.04         .97         .91         .85         .8         1.19         1.13         1.04         .97         .91         .85         .8         1.19         1.13         1.04         .97         .91         .85         .8         1.19         1.13         1.04         .97         .91         .85         .8         1.19         1.13         .94         .4         4<	78	13	•	-	+			1.15		†						-	
90         15         .96         .82         1.12         1.         .89         .81         1.2         1.12         1.04         .97         .91         .85         .8         1.19         1.13           96         16         1.02         .88         1.2         1.06         .96         .87         .8         1.19         1.1         1.03         .97         .91         .86         .81         1.2           96         16         1.02         .88         1.2         1.06         .96         .87         .8         1.19         1.1         1.03         .97         .91         .86         .81         1.2           102         17         1.09         .93         .81         1.13         1.02         .92         .85         .78         1.18         1.1         1.03         .97         .91         .86         .81         1.2           102         17         1.09         .93         .81         1.13         1.02         .92         .85         .78         1.18         1.1         1.03         .97         .91         .87         .82           108         18         1.15         .98         .86         1.2 <td>84</td> <td>14</td> <td>١ -</td> <td>T</td> <td>T .</td> <td>  -</td> <td>  -</td> <td>1.2</td> <td>_</td> <td>  -</td> <td>  -</td> <td>  -</td> <td></td> <td>  -</td> <td>1 *</td> <td>  -</td> <td>1 .</td>	84	14	١ -	T	T .	-	-	1.2	_	-	-	-		-	1 *	-	1 .
96         16         1.02         .88         1.2         1.06         .96         .87         .8         1.19         1.1         1.03         .97         .91         .86         .81         1.2           102         17         1.09         .93         .81         1.13         1.02         .92         .85         .78         1.18         1.1         1.03         .97         .91         .86         .81         1.2           102         17         1.09         .93         .81         1.13         1.02         .92         .85         .78         1.18         1.1         1.03         .97         .91         .87         .82           108         18         1.15         .98         .86         1.2         1.08         .98         .89         .83         1.2         1.16         1.09         1.03         .97         .92         .87           108         18         1.15         .98         .86         1.2         1.08         .98         .89         .83         1.2         1.16         1.03         .97         .92         .87           108         1.9         .81         1.14         1.03         .94 <td< td=""><td></td><td></td><td>  ~</td><td>_</td><td>  ~</td><td>١٠</td><td>5</td><td>5</td><td>4</td><td>4</td><td>4</td><td>4</td><td>4</td><td>4</td><td>4</td><td>3</td><td>3</td></td<>			~	_	~	١٠	5	5	4	4	4	4	4	4	4	3	3
96       16       1.02       .88       1.2       1.06       .96       .87       .8       1.19       1.1       1.03       .97       .91       .86       .81       1.2         102       17       1.09       .93       .81       1.13       1.02       .92       .85       .78       1.18       1.1       1.03       .97       .91       .87       .82         108       18       1.15       .98       .86       1.2       1.08       .98       .89       .83       1.2       1.16       1.09       1.03       .97       .91       .87       .82         108       18       1.15       .98       .86       1.2       1.08       .98       .89       .83       1.2       1.16       1.09       1.03       .97       .92       .87         108       18       1.15       .98       .86       1.2       1.08       .98       .89       .83       1.2       1.16       1.09       1.03       .97       .92       .87         114       19       1.2       1.04       .91       .81       1.14       1.03       .94       .87       .81       1.2       1.15       1.08 <td< td=""><td>90</td><td>15</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td><del></del></td><td><del>                                     </del></td><td><del></del></td></td<>	90	15													<del></del>	<del>                                     </del>	<del></del>
102       17       1.09       .93       .81       1.13       1.02       .92       .85       .78       1.18       1.1       1.03       .97       .91       .87       .82         108       18       1.15       .98       .86       1.2       1.08       .98       .89       .83       1.2       1.16       1.09       1.03       .97       .92       .87         108       18       1.15       .98       .86       1.2       1.08       .98       .89       .83       1.2       1.16       1.09       1.03       .97       .92       .87         108       18       1.15       .98       .86       1.2       1.08       .98       .89       .83       1.2       1.16       1.09       1.03       .97       .92       .87         114       19       1.2       1.04       .91       .81       1.14       1.03       .94       .87       .81       1.2       1.15       1.08       1.02       .97       .92         120       20       .83       1.1       .96       .85       1.2       1.09       .99       .92       .85       .8       1.2       1.14       1.08 <t< td=""><td>96</td><td>16</td><td>-</td><td>_</td><td></td><td>1.06</td><td>•96</td><td>.87</td><td>.8</td><td>1.19</td><td></td><td></td><td></td><td></td><td>1 -</td><td>_</td><td></td></t<>	96	16	-	_		1.06	•96	.87	.8	1.19					1 -	_	
108       18       1.15       .98       .86       1.2       1.08       .98       .89       .83       1.2       1.16       1.09       1.03       .97       .92       .87         114       19       1.2       1.04       .91       .81       1.14       1.03       .94       .87       .81       1.2       1.15       1.08       1.02       .97       .92         120       20       .83       1.1       .96       .85       1.2       1.09       .99       .92       .85       .8       1.2       1.14       1.08       1.02       .97         126       21       .87       1.15       1.01       .89       .81       1.14       1.04       .97       .89       .84       .78       1.2       1.13       1.07       1.01         126       21       .87       1.15       1.01       .89       .81       1.14       1.04       .97       .89       .84       .78       1.2       1.13       1.07       1.01         126       21       .87       1.15       1.01       .89       .81       1.14       1.04       .97       .89       .84       .78       1.2       1.13	102	17		6	6	5	5	5	5								4 82
114       19       1.2       1.04       .91       .81       1.14       1.03       .94       .87       .81       1.2       1.15       1.08       1.02       .97       .92         120       20       .83       1.1       .96       .85       1.2       1.09       .99       .92       .85       .8       1.2       1.14       1.08       1.02       .97         126       21       .87       1.15       1.01       .89       .81       1.14       1.04       .97       .89       .84       .78       1.2       1.13       1.07       1.01         132       22       .91       1.2       1.06       .94       .84       1.2       1.1       1.01       .94       .88       .82       .78       1.18       1.12       1.06         7       6       6       6       6       5       5       5       5       5       5       5       4       4       4       4         132       22       .91       1.2       1.06       .94       .84       1.2       1.1       1.01       .94       .88       .82       .78       1.18       1.12       1.06   <	10.5		6	6	6	5	5	5	5	5	5	4	4	4	4	4	4
114       19       1.2       1.04       .91       .81       1.14       1.03       .94       .87       .81       1.2       1.15       1.08       1.02       .97       .92         120       7       6       6       6       5       5       5       5       5       4	108	18	1.15				1.08										
120     20     .83     1.1     .96     .85     1.2     1.09     .99     .92     .85     .8     1.2     1.14     1.08     1.02     .97       126     21     .87     1.15     1.01     .89     .81     1.14     1.04     .97     .89     .84     .78     1.2     1.13     1.07     1.01       132     22     .91     1.2     1.06     .94     .84     1.2     1.1     1.01     .94     .88     .82     .78     1.18     1.12     1.06       7     7     6     6     6     6     5     5     5     5     5     5     5     5     4     4       132     22     .91     1.2     1.06     .94     .84     1.2     1.1     1.01     .94     .88     .82     .78     1.18     1.12     1.06       7     7     6     6     6     6     5     5     5     5     5     5     5     5     5     4     4	114	19	6 1.2	-		-							_				
126     21     .87     1.15     1.01     .89     .81     1.14     1.04     .97     .89     .84     .78     1.2     1.13     1.07     1.01       132     22     .91     1.2     1.06     .94     .84     1.2     1.1     1.01     .94     .88     .82     .78     1.18     1.12     1.06       7     7     6     6     6     6     5     5     5     5     5     5     5     5     4     4       132     22     .91     1.2     1.06     .94     .84     1.2     1.1     1.01     .94     .88     .82     .78     1.18     1.12     1.06       7     7     6     6     6     5     5     5     5     5     5     5     5			7	6	6	6	5	5	5	5	5	5	4	4	4	4	4
126     21     .87     1.15     1.01     .89     .81     1.14     1.04     .97     .89     .84     .78     1.2     1.13     1.07     1.01       132     22     .91     1.2     1.06     .94     .84     1.2     1.1     1.01     .94     .88     .82     .78     1.18     1.12     1.06       7     7     6     6     6     5     5     5     5     5     5     5     4     4	120	20	•83				1.2	1.09	.99	.92	•85 5	-8	1.2		I		.97
132 22 -91 1.2 1.06 -94 -84 1.2 1.1 1.01 -94 -88 -82 -78 1.18 1.12 1.06 7 7 6 6 6 6 5 5 5 5 5 5 5 4 4	126	21	.87	_		.89	.81	-	_	,97	.89	_	-	-	-	_	1.01
7 7 6 6 6 6 5 5 5 5 5 4 4	7.00		7	_	6	6	6	5	5	5	5	5	5	5	4	4	4
	132	22		7				6		5	•94 5			•78 5		_	
······································	138	23	'	.82	-	-	-	•8									