

6:1 THREADING TABLE

		2.50	2.00	1.75	1.50	1.25	1.00	.90	.80	.75	.70	.60	.50	.45	.40
456	76	10 1.15	10 .92	10 .80	9 1.10	9 .92	8 1.10	8 .99	8 .88	8 .83	7 1.20	7 1.03	7 .86	6 1.18	6 1.05
462	77	10 1.16	10 .93	10 .82	9 1.12	9 .93	8 1.12	8 1.01	8 .90	8 .84	7 1.2	7 1.04	7 .87	6 1.20	6 1.06
468	78	10 1.18	10 .94	10 .83	9 1.13	9 .94	8 1.13	8 1.02	8 .91	8 .85	7 1.2	7 1.06	7 .88	6 1.2	6 1.08
474	79	10 1.20	10 .96	10 .84	9 1.15	9 .96	8 1.15	8 1.03	8 .92	8 .86	7 .80	7 1.07	7 .89	6 .80	6 1.09
480	80	10 1.2	10 .97	10 .85	9 1.16	9 .97	8 1.16	8 1.05	8 .93	8 .87	7 .81	7 1.09	7 .90	6 .81	6 1.10
486	81	10 1.2	10 .98	10 .86	9 1.18	9 .98	8 1.18	8 1.06	8 .94	8 .88	7 .82	7 1.10	7 .92	6 .82	6 1.12
492	82	10 1.2	10 .99	10 .87	9 1.19	9 .99	8 1.19	8 1.07	8 .95	8 .89	7 .83	7 1.11	7 .93	6 .83	6 1.13
498	83	10 1.2	10 1.00	10 .88	9 1.2	9 1.00	8 .80	8 1.08	8 .96	8 .90	7 .84	7 1.13	7 .94	6 .84	6 1.15
504	84	10 1.2	10 1.02	10 .89	9 1.2	9 1.02	8 .81	8 1.10	8 .98	8 .92	7 .85	7 1.14	7 .95	6 .86	6 1.16
510	85	10 1.2	10 1.03	10 .90	9 1.2	9 1.03	8 .82	8 1.11	8 .99	8 .93	7 .86	7 1.15	7 .96	6 .86	6 1.17
516	86	10 1.2	10 1.04	10 .91	9 1.2	9 1.04	8 .83	8 1.12	8 1.00	8 .94	7 .88	7 1.17	7 .97	6 .87	6 1.19
522	87	10 1.2	10 1.05	10 .92	9 1.2	9 1.05	8 .84	8 1.14	8 1.01	8 .95	7 .88	7 1.18	7 .98	6 .88	6 1.20
528	88	10 1.2	10 1.06	10 .93	9 1.2	9 1.07	8 .85	8 1.15	8 1.02	8 .96	7 .89	7 1.19	7 1.00	6 .90	6 1.2
534	89	10 1.2	10 1.08	10 .94	9 1.08	9 1.08	8 .86	8 1.16	8 1.03	8 .97	7 .90	7 1.2	7 1.01	6 .91	6 .80
540	90	10 1.2	10 1.09	10 .95	9 1.09	9 1.09	8 .87	8 1.18	8 1.05	8 .98	7 .92	7 1.2	7 1.02	6 .92	6 .81
546	91	10 1.2	10 1.10	10 .96	9 1.10	9 1.10	8 .88	8 1.19	8 1.06	8 .99	7 .92	7 1.2	7 1.03	6 .93	6 .82
552	92	10 1.2	10 1.11	10 .98	9 1.11	9 1.11	8 .89	8 1.20	8 1.07	8 1.00	7 .94	7 .80	7 1.04	6 .94	6 .83
558	93	10 1.2	10 1.13	10 .98	9 1.13	9 1.13	8 .90	8 .81	8 1.08	8 1.01	7 .95	7 .81	7 1.05	6 .95	6 .84
564	94	10 1.2	10 1.14	10 1.00	9 1.14	9 1.14	8 .91	8 .82	8 1.09	8 1.02	7 .96	7 .82	7 1.06	6 .96	6 .85
570	95	10 1.2	10 1.15	10 1.01	9 1.15	9 1.15	8 .92	8 .83	8 1.10	8 1.04	7 .97	7 .83	7 1.07	6 .97	6 .86
576	96	10 1.2	10 1.16	10 1.02	9 1.16	9 1.16	8 .93	8 .84	8 1.12	8 1.05	7 .98	7 .84	7 1.09	6 .98	6 .87
582	97	11 .81	10 1.18	10 1.03	9 1.18	9 1.18	8 .94	8 .85	8 1.13	8 1.06	7 .99	7 .85	7 1.10	6 .99	6 .88
588	98	11 .82	10 1.19	10 1.04	9 1.19	9 1.19	8 .95	8 .85	8 1.14	8 1.07	7 1.00	7 .85	7 1.11	6 1.00	6 .89
594	99	11 .82	10 1.20	10 1.05	9 1.20	9 1.20	8 .96	8 .86	8 1.15	8 1.08	7 1.01	7 .86	7 1.12	6 1.01	6 .90
600	100	11 .83	10 1.2	10 1.06	9 1.2	9 1.2	8 .97	8 .87	8 1.16	8 1.09	7 1.02	7 .87	7 1.13	6 1.02	6 .90
606	101	11 .84	10 1.2	10 1.07	9 1.2	9 1.2	8 .98	8 .88	8 1.17	8 1.10	7 1.03	7 .88	7 1.14	6 1.03	6 .91