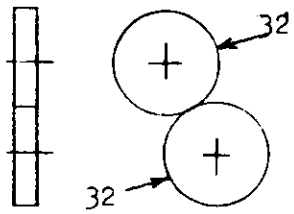
MODEL B MACHINE WITH THREADING
75 Cycle - 60 Cycle - 45 Cycle
6:1 THREADING METHOD TABLE
(Formerly Steel Threading Method)

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 1-1/2 coming off.

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.



Effec. rev's of spin. per piece	No of threads that can be cut	PITCH MM												
		2.50	2.00	1.75	1.50	1.25	1.00	.90	.80	.75	.70	.60	.50	.45	.40
24	4	4 .87	3 .99	3 .87	2 1.18	2 .98	1 1.2	1 1.20	1 1.07	1 1.00	1 .93	1 .80	-	-	-
30	5	4 1.09	4 .87	3 1.09	3 .93	2 1.2	2 .98	2 .89	1 1.2	1 1.2	1 1.17	1 1.00	1 .83	-	-
36	6	5 .83	4 1.04	4 .91	3 1.12	3 .93	2 1.18	2 1.06	2 .94	2 .87	2 .83	1 1.20	1 1.00	1 .90	1 .80
42	7	5 .96	4 1.2	4 1.07	4 .91	3 1.09	3 .87	2 1.2	2 1.10	2 1.03	2 .96	2 .83	1 1.17	1 1.05	1 .93
48	8	5 1.10	5 .88	4 1.2	4 1.04	4 .87	3 .99	3 .89	2 1.2	2 1.18	2 1.10	2 .94	1 1.2	1 1.20	1 1.07
54	9	5 1.2	5 .99	5 .87	4 1.18	4 .98	3 1.12	3 1.00	3 .89	3 .84	2 1.2	2 1.06	2 .89	1 1.2	1 1.20
60	10	6 .86	5 1.10	5 .96	5 .83	4 1.09	4 .87	3 1.12	3 .99	3 .93	3 .87	2 1.18	2 .98	2 .89	1 1.2
66	11	6 .95	5 1.2	5 1.06	5 .91	4 1.20	4 .96	4 .86	3 1.09	3 1.02	3 .96	3 .82	2 1.08	2 .97	2 .87
72	12	6 1.04	6 .83	5 1.16	5 .99	5 .83	4 1.04	4 .94	3 1.19	3 1.12	3 1.04	3 .89	2 1.18	2 1.06	2 .94
78	13	6 1.12	6 .90	5 1.2	5 1.07	5 .89	4 1.13	4 1.02	4 .90	4 .85	3 1.13	3 .97	3 .81	2 1.15	2 1.03
84	14	6 1.2	6 .97	6 .85	5 1.16	5 .96	4 1.2	4 1.10	4 .98	4 .91	4 .85	3 1.04	3 .87	2 1.2	2 1.10
90	15	7 .85	6 1.04	6 .91	5 1.2	5 1.03	5 .83	4 1.18	4 1.04	4 .98	4 .91	3 1.12	3 .93	3 .84	2 1.18
96	16	7 .90	6 1.10	6 .97	6 .83	5 1.10	5 .88	4 1.2	4 1.11	4 1.04	4 .98	3 1.19	3 .99	3 .89	2 1.2
102	17	7 .96	6 1.17	6 1.03	6 .88	5 1.17	5 .94	5 .84	4 1.18	4 1.11	4 1.04	4 .89	3 1.06	3 .95	3 .84
108	18	7 1.02	7 .81	6 1.09	6 .93	5 1.2	5 .99	5 .89	4 1.2	4 1.18	4 1.10	4 .94	3 1.12	3 1.00	3 .89
114	19	7 1.07	7 .86	6 1.15	6 .98	6 .82	5 1.05	5 .94	5 .84	4 1.2	4 1.16	4 .99	3 1.18	3 1.06	3 .94
120	20	7 1.13	7 .90	6 1.2	6 1.04	6 .86	5 1.10	5 .99	5 .88	5 .83	4 1.2	4 1.04	4 .87	3 1.12	3 .99
126	21	7 1.19	7 .95	7 .83	6 1.09	6 .91	5 1.16	5 1.04	5 .92	5 .87	5 .81	4 1.10	4 .91	3 1.17	3 1.04
132	22	8 .80	7 .99	7 .87	6 1.14	6 .95	5 1.2	5 1.09	5 .97	5 .91	5 .85	4 1.15	4 .96	4 .86	3 1.09
138	23	8 .84	7 1.04	7 .91	6 1.19	6 .99	5 1.2	5 1.14	5 1.01	5 .95	5 .89	4 1.2	4 1.00	4 .90	3 1.14