

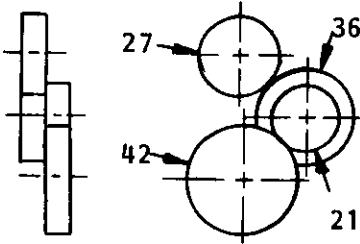
# MODEL B MACHINE WITH THREADING

60 Cycle

## 2:1 Threading Method Table (Formerly Brass Threading Method)

Work Spindle Speed 2400 R.P.M., Gears 42 T. Driver, 21 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 direction, when tap or die is running on to work, but is stopped when running off (left hand threads only).

Seconds Per Piece	Effec. Rev's of Spin. Per Piece	No of Threads That Can Be Cut	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.															
			Pitch in Millimeters																													
			2.50	2.00	1.75	1.50	1.25	1.00	.90	.80	.75	.70	.60	.50	.45	.40																
1.00	18	9	5 .81	4 1.05	3 1.11	3 .94	2 1.14	2 .91	2 .82	1 1.19	1 1.12	1 1.04	1 .89	-	-	-																
1.25	26	13	5 1.17	5 .93	5 .82	4 1.14	3 1.14	3 .91	2 1.18	2 1.05	2 .99	2 .92	1 1.20	1 1.07	1 .97	1 .86																
1.50	36	18	6 1.16	6 .93	5 1.13	5 .97	5 .81	4 1.05	3 1.14	3 1.01	3 .95	3 .88	2 1.09	2 .91	2 .82	1 1.19																
1.75	44	22	7 .87	6 1.14	6 .99	5 1.19	5 .99	4 1.20	4 1.15	4 1.03	3 1.16	3 1.08	3 .93	2 1.11	2 1.00	2 .89																
2.00	54	27	7 1.06	7 .85	6 1.20	6 1.04	6 .87	5 .97	5 .87	4 1.20	4 1.18	4 1.10	4 .94	3 .95	3 .85	2 1.09																
2.25	62	31	7 1.20	7 .98	7 .85	6 1.20	6 1.00	5 1.11	5 1.00	5 .89	5 .84	4 1.20	4 1.08	3 1.09	3 .98	3 .87																
2.50	72	36	8 .88	7 1.13	7 .99	7 .85	6 1.16	6 .93	5 1.16	5 1.04	5 .97	5 .91	4 1.20	4 1.05	3 1.14	3 1.01																
2.75	80	40	8 .98	7 1.20	7 1.10	7 .94	6 1.20	6 1.03	6 .93	5 1.15	5 1.08	5 1.01	5 .86	4 1.17	4 1.05	3 1.12																
3.00	90	45	8 1.11	8 .88	7 1.20	7 1.06	7 .88	6 1.16	6 1.04	6 .93	6 .87	5 1.13	5 .97	5 .81	4 1.18	4 1.05																
3.50	108	54		8 1.06	8 .93	8 .80	7 1.06	7 .85	6 1.20	6 1.11	6 1.04	6 .98	5 1.16	5 .97	5 .87	4 1.20																
4.00	126	63		8 1.20	8 1.08	8 .93	7 1.20	7 .99	7 .89	6 1.20	6 1.20	6 1.14	6 .97	5 1.13	5 1.02	5 .91																
4.50	144	72			8 1.20	8 1.06	8 .89	7 1.13	7 1.02	7 .91	7 .85	6 1.20	6 1.12	6 .93	5 1.16	5 1.04																
5.00	162	81				8 1.20	8 1.00	8 .80	7 1.15	7 1.02	7 .96	7 .89	6 1.20	6 1.04	6 .94	5 1.16																