To Cut Left Hand Threads using 6:1 threading method (formerly steel threading method) for 75 cycle, 60 cycle, or 45 cycle machines with 30 T. driver - 34 T. Driven threading change gears:

Formulas for figuring the number of threads that can be cut, rise of cam necessary and correct location of cam lever block, after the effective revolutions to complete one piece have been determined are as follows:

1 - Effective revolutions to complete one piece divided by 6 equals number of threads that can be cut.

2 - Number of threads that can be cut divided by number of threads per inch equals rise of cam necessary. (Adjust cam lever block to allow tap or die to pull out slightly.)

Select a threading cam from the list below, with a rise nearest to the rise of the necessary cam.

3 - Divide rise of necessary cam by actual rise on threading cam selected to obtain location of cam lever block.

For example, if the effective revolutions to complete the piece is 90 and the number of threads per inch is 32:

1 - 90 divided by 6 equals 15 threads that can be cut.

2 - 15 divided by 32 equals .468"
.468" minus 10% (.047") equals .421" rise of cam necessary.

Select a cam with a rise nearest to .421", which is a #2 cam with a rise of .389".

3 - .421 divided by .489" equals 1.08 location of cam lever block.

2:1 THREADING CAMS (Formerly Brass Threading Cams)

CAM #	RISE	100ths	DROP	100ths	PART #
1	.238"	0-25	.276"	25-50	5-C-82
2	.389"	0-25	.450"	25-50	5-C-84
3	.560	0-25	.657"	25-50	5-C-86
4	.675"	0-25	.782"	25-50	5-C-88
5	1.095"	0-25	1.265"	25-50	5-C-90
6	1.525"	0-25	1.770"	25-50	5-C-92
7	2.000"	5-25	2.000"	25-42½	5-C-94
8	2.000"	12-25	2.000"	25-37	5-C-80