

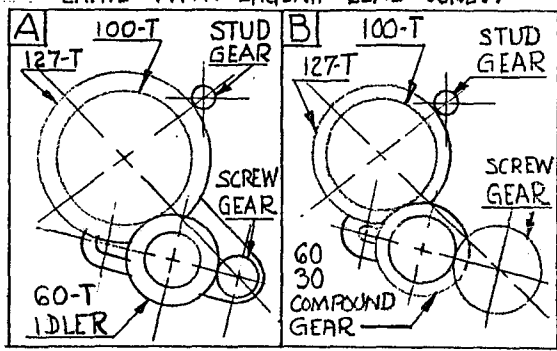
M-109

Unless Otherwise Specified—Fractional Dim. + OR —)—Remove Burs and Sharp Corners. Finish: f1 = 1/32"; f2 = 1/16"; f3 = 1/32"; f4 = 1/8"

3 3/8" 3 1/8"

CLAUSING CORPORATION
KALAMAZOO, MICHIGAN, U.S.A.

TRANSPOSING GEAR CHART FOR CUTTING METRIC PITCH THREADS ON QUICK CHANGE LATHE WITH ENGLISH LEAD SCREW



MM PITCH THREAD	STUD GEAR	A OR B	SCREW GEAR	SET GEAR BOX TO CUT
7.	28	A	20	5 THREADS
6.	24	A	25	4 "
5.5	22	A	25	4 "
5.	20	A	25	4 "
4.5	18	A	25	4 "
4.	18	A	25	4 1/2 "
3.5	28	A	20	10 "
3.	18	A	25	6 "
2.5	20	A	25	8 "
2.	18	A	25	9 "
1.75	28	A	20	20 "
1.5	18	A	25	12 "
1.25	20	A	25	16 "
1.	18	A	25	18 "
.9	18	A	25	20 "
.8	16	A	25	20 "
.75	18	A	25	24 "
.70	28	A	50	20 "
.60	24	A	50	20 "
.50	16	A	50	16 "
.45	18	A	50	20 "
.40	16	A	50	20 "
.30	24	B	50	20 "
.25	16	B	50	16 "

1/11" DIA. HOLE
4 BEAD.

4 1/2"

7 1/2" 7 1/2"

3/32" BORDER

1" .032"

NOTE: BACKGROUND - ETCHED BLACK
REMAINDER - SATIN FINISH



ATLAS PRESS CO.
KALAMAZOO, MICH.

THREADING CHART (METRIC) - REC'D. LATHES

USED ON ---
MATHL - S4 ALUM
H.T. ---
DR. BY - ADD

REQD. - 1 WT. ---
CK. BY - DATE - 10-30-50

SCALE - FULL M-109

DESCRIPTION

Op. No. RATE SET UP

Study No. PCS.

WAS

Auth. by

DATE

SYM.

WAS

Auth. by