

(A) METRIC THREADS on METRIC LEADSCREW MACHINES  
or  
ENGLISH THREADS on ENGLISH LEADSCREW MACHINES

For these threads it is recommended that the "thread indicator dial" be used - this allows the leadscrew nuts to be disengaged at the end of each screwcutting pass, provided that they are re-engaged in accordance with the chart mounted on the front face of the dial unit.

METRIC LEADSCREW MACHINES  
(METRIC THREADS ONLY)

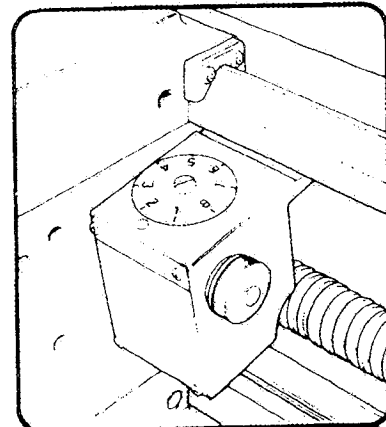
The chart shows:-

- in column 1. mm pitch to be cut.
- in column 2. (★) The number of teeth in the 'pick-off gear' arranged to mesh with the leadscrew, (this being selected from the stack, stored on the bottom of the dial spindle).
- in column 3. The dial numbers at which the leadscrew nuts may be engaged.

ENGLISH LEADSCREW MACHINES  
(ENGLISH THREADS ONLY)

The chart shows:-

- in column 1. T.P.I. to be cut.
- in column 2. Dial numbers at which the leadscrew nuts may be engaged.



mm

225	18 15	4	16 1-8
25	16 1-8	4 5	18 15
75	16 1-8	5	20 1357
1	16 1-8	5 5	22 15
1 25	20 1357	6	16 1-8
1 5	16 1-8	7	14 15
1 6	16 1357	8	16 1357
1 75	14 15	9	18 15
2	16 1-8	10	20 1357
2 5	20 1357	11	22 15
3	16 1-8	12	16 1-8
3 5	14 15	14	14 15

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2	1 8	8	1-8	22	1-8
2 1/2	15	9	1357	24	1-8
2 1/2	1	10	1-8	26	1-8
3	1357	11	1357	27	1357
3 1/4	1	11 1/2	15	28	1 8
3 1/2	15	12	1-8	30	1 8
4	1-8	13	1357	32	1-8
4 1/2	15	14	1-8	36	1-8
5	1357	16	1-8	40	1-8
6	1-8	18	1-8	44	1-8
7	1357	19	1357	48	1-8
7 1/2	15	20	1 8	56	1-8

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(B) ENGLISH THREADS on METRIC LEADSCREW MACHINES  
or  
METRIC THREADS on ENGLISH LEADSCREW MACHINES

For these threads the leadscrew nuts are kept engaged throughout the cutting of any one thread. This involves reversing the whole drive by means of the 'spindle control lever' (22) at each end of the screwcutting pass whilst at the same time relieving or increasing the cut as required.

(Threads 'A' may also be cut by this method).

## Thread – cutting