TABLES SHEWING THE SCREWS THAT CAN BE CUT ON SLIDE LATHES

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H. L.

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SHEWING

THE SCREWS

THAT CAN BE CUT ON

SLIDE LATHES,

BY

H. L.

———→●●←———

THESE TABLES are calculated for a leading screw with four threads to the inch. For one with two threads, the wheels which will cut double the number of threads required must be used. The whole of the screws which ordinary wheel work will cut with a 20 pinion wheel will be found in this Book, arranged in terms in the order of the screws, and not in the order of the wheel work, as in Morton's Tables. Thus it is possible at a glance to see what pitches can be cut, instead of having to work through ten pages to see whether the exact pitch required exists.

For example :—I want to match a thread which I find on exact measurement to contain 14·22 turns to the inch. Taking Morton's Tables I have to hunt through ten pages of closely printed matter very carefully indeed before I can be sure that I have found the nearest pitch. But with these Tables I can at once pick out the nearest possible pitch without trouble.

In the Appendix will be found Whitworth's Standard threads and sizes.

<div align="right">

H. L.

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DRAGSÆT, 1873.

No. signifies ....the Number of Threads.

M. ,, ...Wheel on Mandril.

P. ,, ... ,, Pinion.

In. ,, ... ,, Intermediate.

S. ,, ... ,, Screw.

TABLES

FOR

CHANGE WHEELS,

FOR

SCREW CUTTING,

BY

H. H. L.

No.	M.	P.	In.	S.	No.	M.	P.	In.	S.
110·4	25	20	115	120	80·5	30	20	105	115
105·6	...	...	110	...	80	...	...	100	120
101·2	...	...	...	115	79·8	25	...	95	105
100·8	...	...	105	120	79·2	...	...	90	110
96·6	...	...	...	115	78·857	35	...	115	120
96	...	...	100	120	78·2	25	...	85	115
92·4	...	...	105	110	77	30	...	105	110
92	...	...	100	115	76·8	25	...	80	120
...	30	...	115	120	76·6	30	...	110	115
91·2	25	...	95	...	76	25	...	95	100
88	...	...	100	110	...	30	...	...	120
...	30	...	110	120	75·6	25	...	90	105
87·4	25	...	95	115	75·428	35	...	110	120
86·4	...	...	90	120	74·8	25	...	85	110
84·3̇	30	...	110	115	73·6	...	...	80	115
84	25	...	100	105	73·3̇	30	...	100	110
...	30	...	105	120	72·83̇	...	...	95	115
83·6	25	...	95	110	72·285	35	...	110	...
82·8	...	...	90	115	72	25	...	75	120
81·6	...	...	85	120	...	...	...	90	100

No.	M.	P.	In.	S.	No.	M.	P.	In.	S.
72	30	20	90	120	62·428	...	20	95	115
...	35	...	105	...	62·4	25	...	65	120
71·4	25	...	85	105	62·3	30	...	85	110
70·4	...	...	80	110	61·714	35	...	90	120
70	30	...	100	105	61·6	25	...	70	110
69·6	...	...	95	110	61·3	30	...	80	115
69	25	...	75	115	...	45	...	115	120
...	30	...	90	...	61·2	25	...	85	90
...	35	...	105	...	60·8	...	...	80	95
...	40	...	115	120	60·375	40	...	105	115
68·571	35	...	100	...	60	25	...	75	100
68·4	26	...	90	95	...	30	...	...	120
68	...	...	85	100	...	...	...	90	100
...	30	...	...	120	...	35	...	100	105
67·2	25	...	70	...	...	40	...	...	120
...	...	...	80	105	59·8	25	...	65	115
66·5	30	...	95	...	59·714	35	...	95	110
66	25	...	75	110	59·5	30	...	85	105
...	30	...	90	...	59·142	35	...	90	115
...	35	...	105	...	58·8	25	...	70	105
...	40	...	110	120	58·6	30	...	80	110
65·714	35	...	100	115	58·6	45	...	110	120
65·16	30	...	85	...	58·285	35	...	85	...
65·142	35	...	95	120	57·75	40	...	105	110
64·6	25	...	85	95	57·6	25	...	60	120
64·4	...	...	70	115	...	...	...	80	90
64	...	...	80	100	57·5	30	...	75	115
...	30	...	...	120	...	40	...	100	...
63·3	...	...	95	100	57·2	25	...	65	110
63·25	40	...	110	115	57	30	...	90	95
63	25	...	75	105	...	25	...	75	...
...	30	...	90	...	...	35	...	95	105
...	40	...	105	120	...	40	...	...	120
62·857	35	...	100	110	56·6	30	...	85	100

No.	M.	P.	In.	S.	No.	M.	P.	In.	S.
56.571	35	20	90	110	52	30	20	65	120
56·2	45	...	110	115	51·75	40	...	90	115
56	25	...	70	100	51·428	35	...	75	120
...	30	...	...	120	...	...	...	90	100
...	...	...	80	105	51·3	30	...	70	110
...	45	...	105	120	...	45	...	105	...
55·857	35	...	85	115	51·1	...	...	100	115
55·2	25	...	60	...	51	25	...	75	85
...	50	...	115	120	...	30	...	85	90
55	30	...	75	110	...	35	...	...	105
...	40	...	100	...	...	40	...	...	120
54·857	35	...	80	120	50·6	30	...	80	95
54·625	40	...	95	115	...	50	...	110	115
54·6	25	...	65	105	50·6	25	...	55	...
54·4	...	...	80	85	...	45	...	95	120
54·285	35	...	95	100	50·4	25	...	60	105
54	25	...	75	90	...	...	...	70	90
...	...	...	90	105	...	50	...	105	120
...	40	...	...	120	50·285	35	...	80	110
53·83	30	...	85	95	50·181	55	...	115	120
53·6	...	...	70	115	50	30	...	75	100
...	45	...	105	...	49·875	40	...	95	105
53·428	35	...	85	110	49·83	30	...	65	115
53·3	30	...	80	100	49·5	40	...	90	110
...	45	...	100	120	49·4	25	...	65	95
53·2	25	...	70	95	49·285	35	...	75	115
52·8	...	...	55	120	49	30	...	70	105
...	...	...	60	110	48·8	45	...	100	110
...	50	...	110	120	48·875	40	...	85	115
52·571	35	...	80	115	48·857	35	...	90	95
52·5	30	...	75	105	48·571	...	...	85	100
...	40	...	100	...	48·5	45	...	95	115
52·25	...	...	95	110	48·4	25	...	55	110
52	25	...	65	100	48·3	50	...	105	115

No.	M.	P.	In.	S.	No.	M.	P.	In.	S.
48	25	20	50	120	45·714	35	20	80	100
...	...	...	60	100	45·6	25	...	60	95
...	...	...	75	80	...	50	...	95	120
...	30	...	60	120	45·5	30	...	65	105
...	...	...	80	90	45·3	45	...	85	120
...	35	...	70	120	...	30	...	80	85
...	...	...	80	105	45	...	...	75	90
..	40	...	...	120	...	35	...	...	105
...	45	...	90	...	...	40	...	...	120
...	50	...	100	...	...	...	...	90	100
...	55	...	110	...	44·8	25	...	70	80
47·8	30	...	65	110	44·625	40	...	85	105
47·6	25	...	70	85	44·571	35	...	65	120
47·5	30	...	75	95	44·3	30	...	70	95
...	40	...	95	100	44·3	45	...	95	105
47·25	...	...	90	105	44·2	25	...	65	85
47·142	35	...	75	110	44	...	...	50	110
46·8	25	...	65	90	...	...	...	55	100
46·75	40	...	85	110	...	30	...	...	120
46·6	30	...	70	100	...	...	...	60	110
...	45	...	100	105	...	35	...	70	...
46·4	...	...	95	110	...	40	...	80	...
46·2	25	...	55	105	...	45	...	90	...
...	50	...	105	110	...	50	...	100	...
46·142	35	...	85	95	...	60	...	110	120
46	25	...	50	115	43·908	55	...	105	115
...	30	...	60	...	43·714	35	...	85	90
...	35	...	70	...	43·7	50	...	95	115
...	40	...	80	...	43·636	55	...	100	120
...	45	...	90	...	43·4	45	...	85	115
...	50	...	100	...	43·428	35	...	80	95
...	55	...	110	...	43·3	30	...	65	100
...	60	...	115	120	43·2	25	...	45	120
45·818	55	...	105	...	...	...	...	60	90