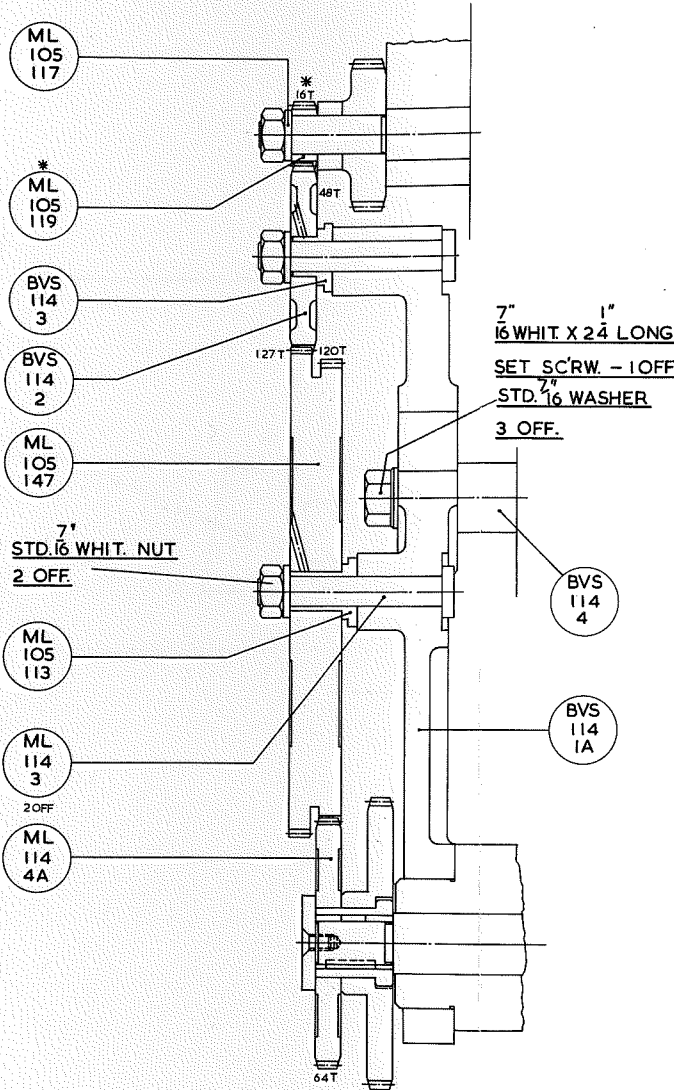


Metric to English Conversion
Metric Leadscrew 3mm
Stud Gears Supplied 48T-49T-52T-54T
Quadrant with 48T-135/127T-48T
General Arrangement and Assembly
identical to this drawing.
Available TPI: 4 to 28 details see supplied plate

HOLE DRILL THRO. $\frac{23}{64}$ " DIA. & TAP $\frac{7}{16}$ " WHIT.
MARK OFF FROM QUADRANT THUS. PLACE
16T STUD GEAR ON REVERSING BRACKET
& MESH WITH 120/127T GEAR COMPOUND.
MARK POSITION OF QUADRANT POINT X
ON CASTING WALL PLACE 66T STUD
GEAR ON REVERSING BRACKET REPEAT
MARKING POINT Y, OF QUADRANT ON
CASTING WALL DRILL HOLE HALFWAY
BETWEEN THE SCRIBED LINES ON THE
CASTING.

| TOP LEVER | 1 | 2 | 2 | 1 | 2 | 6 | 8 | DIAL READING |
|-----------|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|--------------------|--------------|
| | 64 | 66 | 60 | 48 | 48 | 56 | 56 | STUD GEAR |
| LEFT | 6.0 1.833 720 | 5.5 1.680 660 | 5.0 1.528 600 | 4.5 1.372 532 | 4.0 1.220 480 | 3.5 1.070 420 | 3.0 .916 360 | |
| CENTRE | 3.0 916 360 | 2.75 840 330 | 2.5 764 300 | 2.25 686 266 | 2.0 610 240 | 1.75 535 210 | 1.5 458 180 | |
| RIGHT | 1.5 450 180 | 1.375 420 165 | 1.250 382 150 | 1.125 343 133 | 1.0 305 120 | .875 267 105 | .750 229 90 | |
| DIAL | 3 | 8 | 3 | 6 | | 7 | 8 | |
| STUD | 24 | 26 | 16 | 16 | | 16 | 16 | |
| LEFT | 1.8 550 216 | 1.4 426 168 | 1.2 367 144 | 1.0 305 120 | | .236 .092 | .218 .086 | |
| CENTRE | .90 275 108 | .70 213 84 | .60 183 72 | .50 153 60 | | .118 .046 | .109 .043 | |
| RIGHT | .45 137 54 | .35 107 42 | .30 92 36 | .25 76 30 | | .059 .023 | .054 .021 | |
| | | | | | | | | |

CHART CH238
2 X FULL.



SECTION THRO IN DIRECTION
OF ARROWS 'A'-A'

