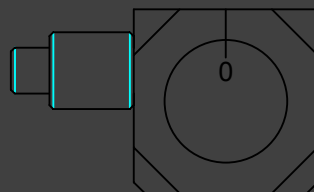


## ENGLISH

THE ENGLISH LATHE  
HAS AN 8 TPI LEADSCREW



## METRIC

THE METRIC LATHE  
HAS A 3mm PITCH LEADSCREW

## ENGAGEMENT PROCEDURE

### ENGLISH LATHE

ANY TPI DIVISIBLE BY 8	.....	ENGAGE ANYWHERE
EVEN NUMBER OF TPI	.....	ANY LINE
ODD NUMBER OR TPI	.....	ANY NUMBERED LINE
HALF THREADS	.....	EVERY HALF REVOLUTION

### METRIC LATHE

ONE LINE ONLY

THREAD DIAL INDICATORS ON A METRIC LATHE  
FITTED WITH A 30T OR 28T GEAR WILL ALIGN  
WITH THE METRIC PITCHES LISTED BELOW

### 30T

0.4	1.5
0.45	2.0
0.5	2.5
0.6	3.0
0.75	4.5
1.0	5.0
1.25	6.0

### 28T

0.35
0.7
0.8
1.75
3.5
4.0

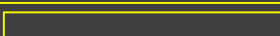
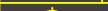
## ADDITIONAL DATA


### DEPTH OF THREAD

ISO COURSE,  
UNF & UNC ... PITCH X 0.6134

BSW, BSF  
& BSP ... PITCH X 0.64

$$\text{PITCH} = \frac{1}{\text{TPI}}$$

	DRAWN	IV	CHECKED	
	DATE	20.02.79		3 <sup>RD</sup>
	SCALE	1:1		
	MACHINE	5" & 280 LATHES		
TITLE	THREAD DIAL INDICATOR			
DWG N°.	ML109			



COMPUTERISED MACHINES AND SYSTEMS

COMPUTERISED MACHINES AND SYSTEMS