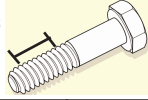
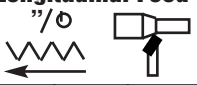
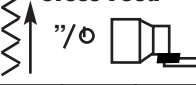
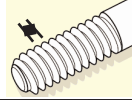


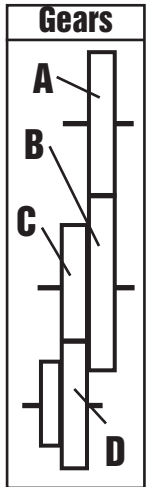
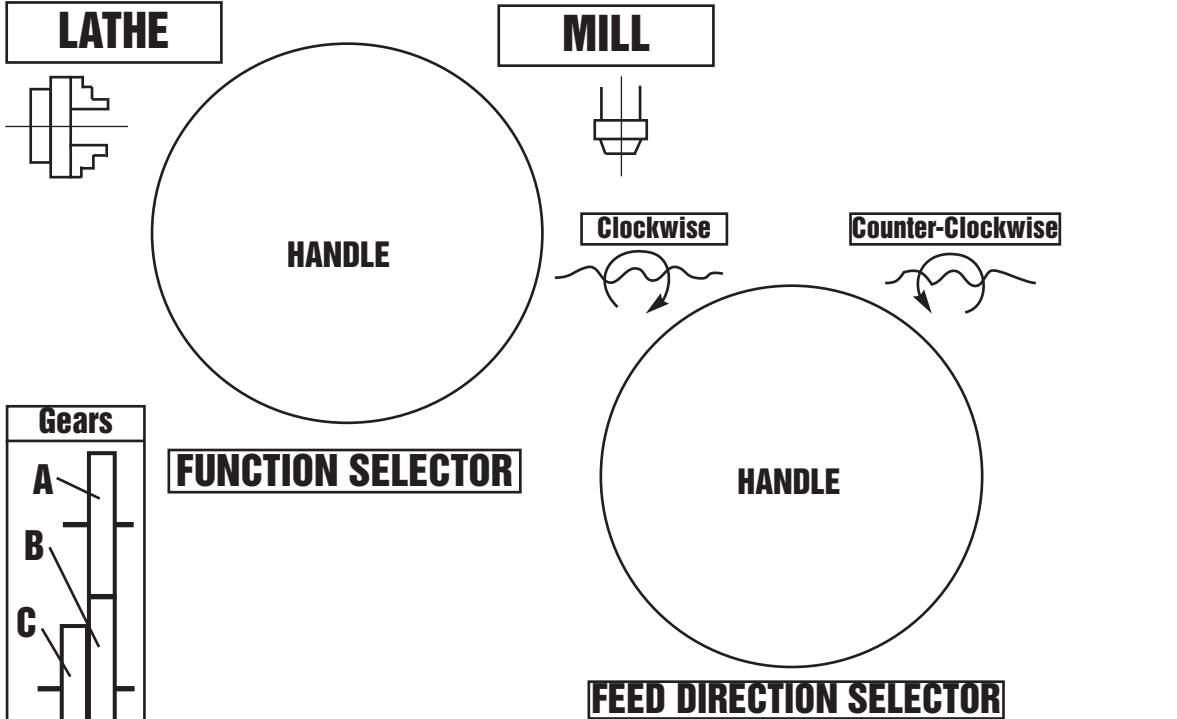


THREADING CHART	INCH THREADS			FEED RATES = Distance traveled per Spindle Revolution						METRIC THREADS							
	Inch threads are defined as the number of threads in one inch. 			Longitudinal Feed 			Cross Feed 			Metric threads are defined as the distance between two adjacent crests. 							
Speeds I - III	I	II	III	I	II	III	I	II	III	I	II	III	I	II	III		
S P E E D S 1-7	1	7	14	28	0.0197"	0.0098"	0.0049"	0.0062"	0.0031"	0.0015"			0.70	0.35	3.50	1.75	
	2	8	16	32	0.0172"	0.0086"	0.0043"	0.0054"	0.0027"	0.0014"			0.80	0.40	4.00	2.00	
	3	9	18	36	0.0153"	0.0076"	0.0038"	0.0048"	0.0024"	0.0012"			0.45	4.50			
	4	10	20	40	0.0137"	0.0069"	0.0034"	0.0043"	0.0022"	0.0011"			1.00	0.50	5.00	2.50	
	5	11	22	44	0.0125"	0.0062"	0.0031"	0.0039"	0.0020"	0.0010"					5.50	2.75	
	6	12	24	48	0.0115"	0.0057"	0.0029"	0.0036"	0.0018"	0.0009"					0.60	6.00	3.00
	7	13	26	52	0.0106"	0.0053"	0.0026"	0.0033"	0.0017"	0.0008"					6.50	3.25	
Gear Selection	*N=Teeth per gear A = 30 B = 66 C = 60 D = 60						A = 33 C = 63 A = 66 C = 63 B = 80 D = 60 B = 64 D = 60										
Lever located inside Pully Box below gear cluster	INCH						METRIC			INCH			 METRIC				



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ALWAYS WEAR EYE PROTECTION
KEEP COVER IN PLACE
KEEP MACHINE LUBRICATED