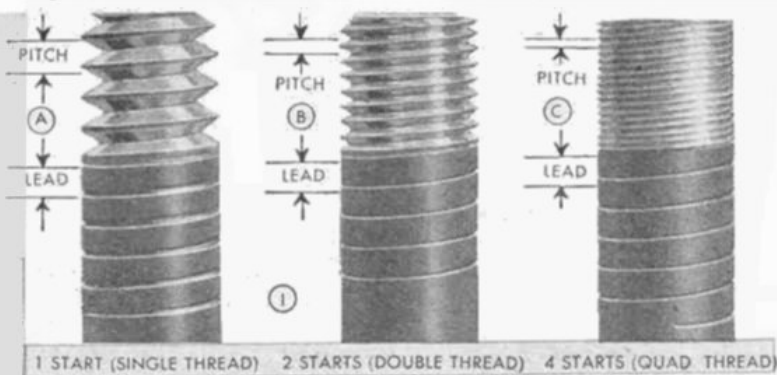




Spacing
with Dog
on Faceplate

DOG PLACED
IN
OPPOSITE
SLOT

FIRST THREAD CUT



MULTIPLE

WHEN you want fast travel with a fine thread, you use a multiple thread, breaking the original lead distance into two, three or more threads as desired. The cap of a fountain pen is a good example—you want the cap to screw on quickly and a coarse thread is not satisfactory. Focusing devices on cameras and binoculars offer another everyday example of the use of multiple threads.

General terms: Fig. 1 illustrates the two terms used to describe any thread—lead and pitch. Lead is the distance the thread advances in one revolution; pitch is the distance between threads. In a single thread, detail A, Fig. 1, lead and pitch are the same. The second detail, B, shows the original lead broken into two threads so that the pitch is one half the lead. Detail C shows a quad or 4-start thread, where the pitch is one fourth of the lead. In all multiple

SPACING MULTIPLE THREADS BY PLACING DOG IN VARIOUS SLOTS IS USEFUL METHOD OF WORKING. PHOTOS SHOW DOUBLE THREAD. THREE STOPS ARE USED FOR TRIPLE THREAD

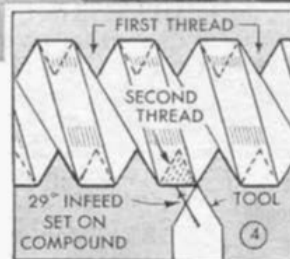


TABLE 1		USEFUL RANGE OF MULTIPLE THREADS																					
NUMBER OF STARTS	LEAD (NUMBER OF TURNS PER INCH OF SINGLE THREAD)																						
	1½	2	2½	3	3½	4	4½	5	5½	6	6½	7	8	9	10	11	11½	12	13	14	16	18	20
2 STARTS	3	4	5	6	7	8	9	10	11	12	13	14	16	18	20	22	23	24	26	28	32	36	40
3 STARTS	4½	6	7½	9	10½	12	13½	15	16½	18	19½	21	24	27	30	33	34½	36	39				
4 STARTS	6	8	10	12	14	16	18	20	22	24	26	28	32	36	40								
5 STARTS	7½	10	12½	15	17½	20	22½	25	27½	30	32½	35	40										
6 STARTS	9	12	15	18	21	24	27	30	33	36	39												
8 STARTS	12	16	20	24	28	32	36	40															
10 STARTS	15	20	25	30	35	40																	
12 STARTS	18	24	30	36																			

FIGURES IN BODY OF TABLE GIVE PITCH OF THREAD (NUMBER OF THREADS PER INCH)

NOTES

- FIGURES IN SHADED BOXES CAN BE CUT WITH USE OF THREAD DIAL
- FAST LEADS FROM 1½ TO 3½ ARE NOT USUALLY SHOWN ON GEAR CHARTS BUT CAN BE SET UP WITH REGULAR GEARS

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