



THREADS

threads, the lead multiplied by the number of starts gives the pitch. For example, an 8-lead thread having two starts is 16-pitch, or there are 16 threads per in., and the distance between threads is $\frac{1}{16}$ in. Eight-lead means there are 8 turns per in., and the distance advanced in one turn is $\frac{1}{8}$ in.

Spacing with lathe dog: Spacing a multiple thread by using the lathe dog is a common method of working. Suppose, for example, you want to cut a double thread of 8-lead and 16-pitch. Set up the gear box or gear train for the lead. Always gear for the

PHOTO SHOWS HOW THE THREAD DIAL IS USED TO CUT A DOUBLE THREAD OF 6-LEAD, 12-PITCH

Using the Thread Dial

TABLE 2

THREAD DIAL SETTING FOR MULTIPLE THREADS

| STARTS | LEAD | | | | | | | | | | | | | | | | | | | | | |
|----------|----------|-----------|-----------|----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|--|
| | 4 | 12 | 20 | 2 | 6 | 10 | 14 | 18 | 3 | 5 | 7 | 9 | 11 | 13 | 1½ | 2½ | 3½ | 4½ | 5½ | 6½ | 11½ | |
| 2 STARTS | 8 (A) | 24 (A) | 40 (A) | 4 (B) | 12 (B) | 20 (B) | 28 (B) | 36 (B) | 6 (C) | 10 (C) | 14 (C) | 18 (C) | 22 (C) | 26 (C) | 3 (D) | 5 (D) | 7 (D) | 9 (D) | 11 (D) | 13 (D) | 23 (D) | |
| 4 STARTS | — | — | — | 8 (B) | 24 (B) | 40 (B) | 56 (B) | 72 (B) | 12 (C) | 20 (C) | 28 (C) | 36 (C) | 44 (C) | 52 (C) | 6 (D) | 10 (D) | 14 (D) | 18 (D) | 22 (D) | 26 (D) | 46 (D) | |
| 8 STARTS | — | — | — | — | — | — | — | — | 24 (C) | 40 (C) | 56 (C) | 72 (C) | 88 (C) | 104 (C) | 12 (D) | 20 (D) | 28 (D) | 36 (D) | 44 (D) | 52 (D) | 92 (D) | |

DIAL SETTING

DIAL STYLE No. 1

(A)

DIAL SETTING

(B)

DIAL SETTING

(C)

NUMBERS IN TABLE ARE PITCH OF THREAD

(D)

SHORT LIGHT LINES ARE NOT SHOWN ON DIAL

DIAL STYLE No. 2

(A)

(B)

(C)

(D)

FOR DOUBLE THREAD, ENGAGE AT ANY POINT MARKED 1 (ON OUTSIDE RIM OF DRAWING) FOR FIRST THREAD AND AT ANY POINT MARKED 2 FOR SECOND THREAD. IF A QUAD THREAD IS DESIRED, ENGAGE AT 1-2-3-4 FOR THE RESPECTIVE THREADS. FOR 8 STARTS, ENGAGE AT 1-2-3-4-5-6-7-8 AS MARKED.