

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

MINOR DIAMETER TURNED AT END OF WORK (SEE TABLE 3)

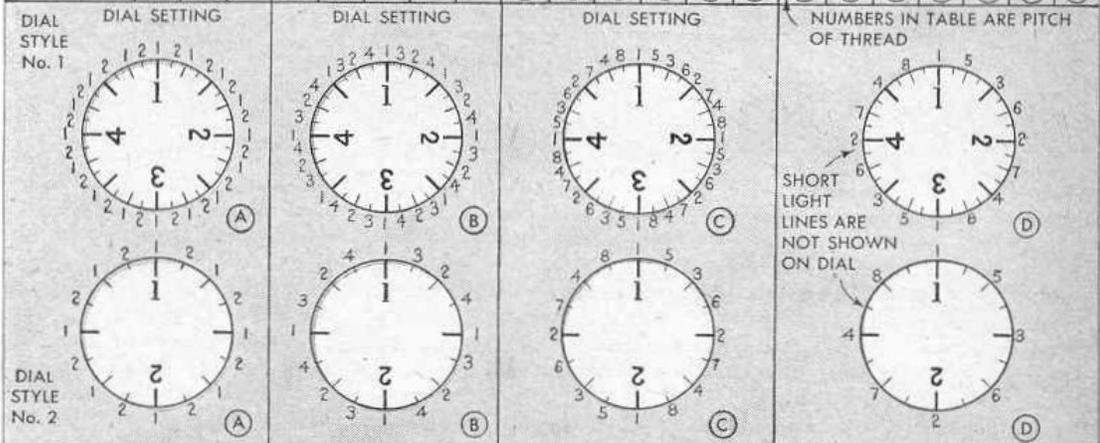
ENGAGEMENT IS MADE ON ANY LINE FOR FIRST THREAD, AND BETWEEN LINES FOR SECOND THREAD (B-POSITION IN TABLE 2 BELOW)

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)



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.