

CHART FOR THREADS

For screwcutting attachment by carriage feed through universal joints and carriage adjusting-screw with a pitch of 10 threads per inch.

Use with open and enclosed types W20 and W25 headstocks.

Maximum length to be cut : 2 3/4 in (70 mm).

Set of change gears for Whitworth threads (10 pieces)

25 - 30 - 40 - 40 - 55 - 60 - 65 - 70 - 80 - 80 - 90 - 95 - 100 - 100 - 125 teeth

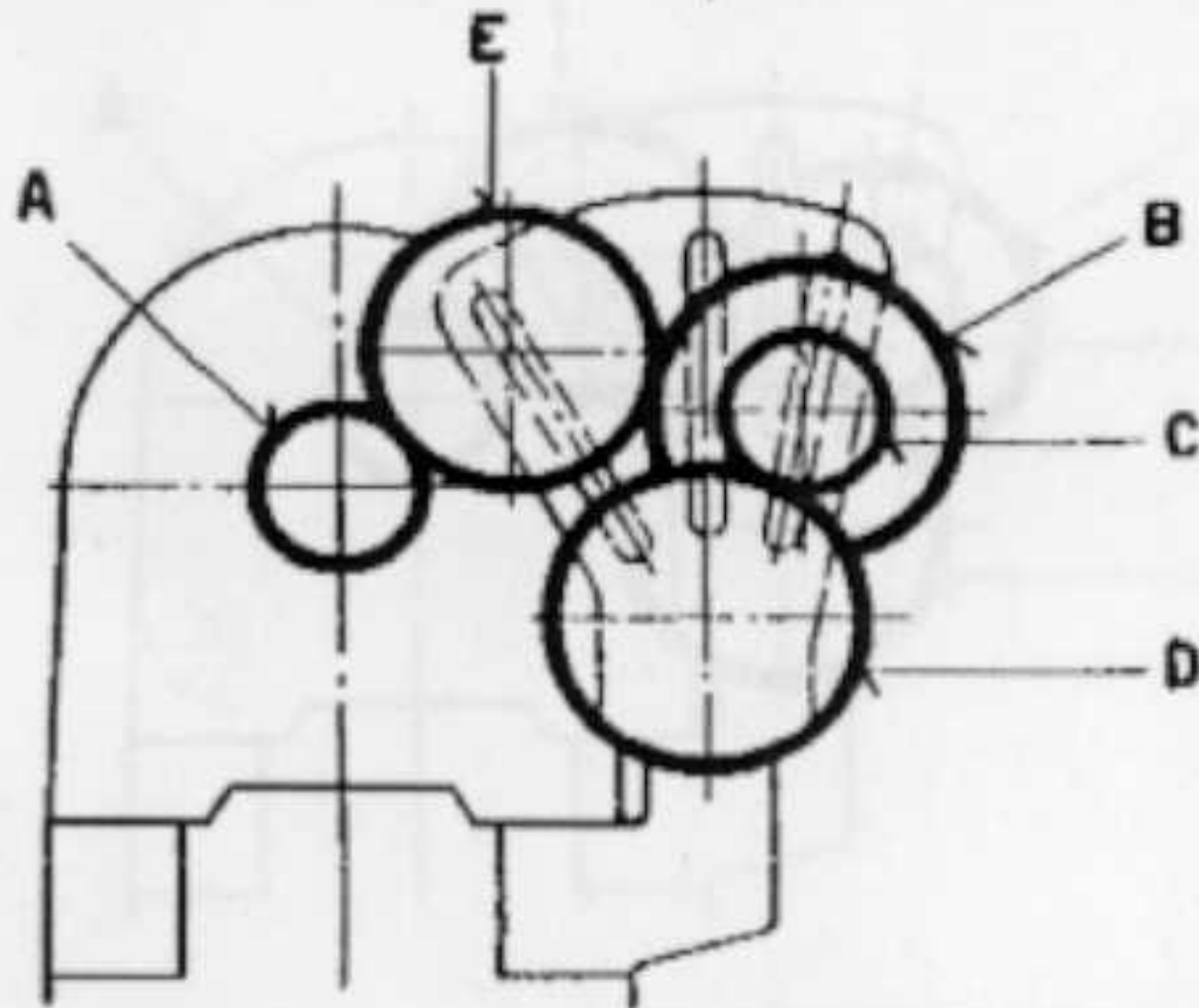
Set of change gears for metric threads (11 pieces)

25 - 30 - 40 - 40 - 60 - 70 - 80 - 90 - 100 - 125 - 127 teeth

Complete set of change gears (16 pieces)

25 - 30 - 40 - 40 - 55 - 60 - 65 - 70 - 80 - 80 - 80 - 90 - 95 - 100 - 100 - 125 - 127 teeth

✓ ✓ ✓ | ✓ ✓ ✓ | ✓ ✓ ✓



Standard set of change gears normally supplied (9 pieces)

25 - 30 - 40 - 60 - 70 - 80 - 80 - 90 - 100 teeth

Remark : The necessary 50-teeth gear is represented by the driving gear A which is normally supplied with the attachment.

The standard set of change gears supplied with the attachment is suitable to cut all threads marked with ▼

$$\frac{\text{Pitch to be cut}}{\text{Pitch of carriage adjusting-screw}} = \frac{A \cdot C}{B \cdot D}$$

(4-gear system)

$$\text{or } = \frac{A}{D} \quad (\text{2 or 3-gear system})$$

E = intermediate gear for right-hand threads

N° of thr. per in	Change gears (Whitworth)					Pitch mm	Change gears (Metric)				
	A	B	C	D	E		A	B	C	D	E
90	50	90	25	125	95	0,25	50	100	25	127	90
80	50	100	25	100	90	0,5	50	80	40	127	90
72	50	90	25	100	95	0,75	50	40	30	137	90
64	50	80	25	100	90	0,8	50	100	80	127	90
56	50	70	25	100	90	1	50	40	40	127	90
48	50	80	30	90	100	1,25	50	80	100	127	125
44	50	55	25	100	100	1,5	50	60	90	127	125
40	50	80	40	100	90	1,75	50	40	70	127	90
36	50	80	40	90	100	2	50	30	60	127	90
32	50	60	30	80	100						
28	50	70	40	80	100						
24	50	60	40	80	100						
20	50	100	80	80	90						
19	50	40	40	95	90						
18	50	90	80	80	100						
16	50	40	30	60	90						
14	50	70	80	80	90						
13	50	40	40	65	90						
12	50	30	40	80	90						
11	50	55	40	40	90						
10	50	50	60	100	90						

CHART FOR THREADS

For screwcutting attachment by carriage feed through universal joints type 102-85 and carriage adjusting-screw with metric pitch ≥ 2 mm.

Use with open and enclosed types W20 and W25 headstocks.

Maximum length of thread to be cut : 2 3/4 in (70 mm).

Set of change gears for metric threads (14 pieces)

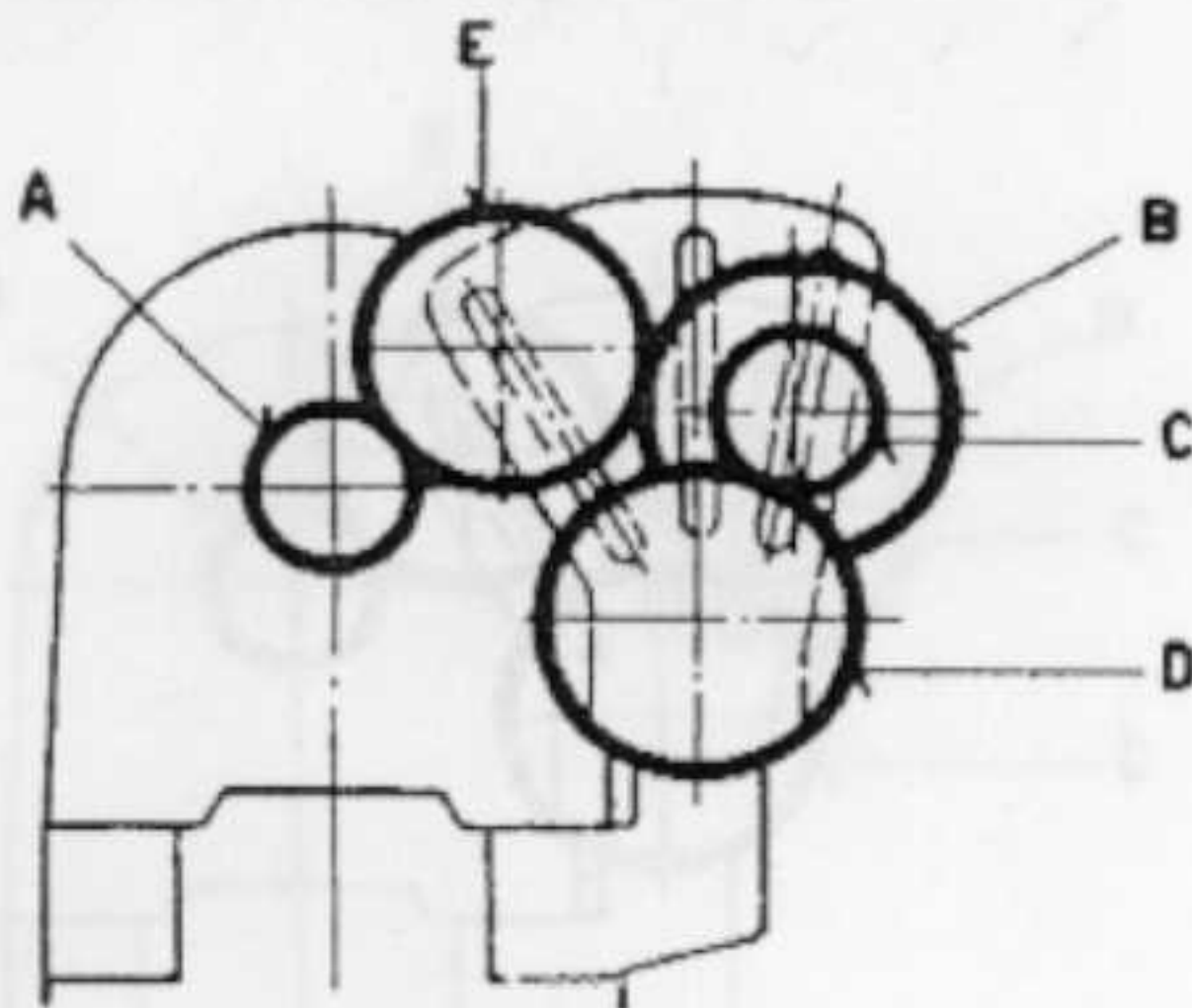
25 - 30 - 35 - 40 - 45 - 50* - 60 - 70 - 75 - 80 - 90 - 100 - 100 - 125 teeth

Set of change gears for Whitworth threads (22 pieces)

25 - 30 - 40 - 45 - 50 - 54 - 55 - 60 - 65 - 70 - 75 - 80 - 84 - 85 - 90 - 94 - 95 - 97 - 100
100 - 125 - 127 teeth

Complete set change gears (23 pieces)

25 - 30 - 35 - 40 - 45 - 50* - 54 - 55 - 60 - 65 - 70 - 75 - 80 - 84 - 85 - 90 - 94 - 95 - 97
100 - 100 - 125 - 127 teeth



Standard set of change gears normally supplied (10 pieces)

45 - 50* - 60 - 70 - 75 - 80 - 90 - 100 - 100 - 125 teeth

* The second necessary 50-teeth gear is represented by the driving gear A which is normally supplied with the attachment.

Remark : The standard set of change gears supplied with the attachment is suitable to cut all threads marked with ∇

Pitch of carriage adjusting-screw $= \frac{A \cdot C}{B \cdot D}$

(4-gear system)

or $= \frac{A}{D}$ (2 or 3-gear system)

E = Intermediate gear for right-hand threads

Metric threads						Whitworth threads					
Pitch mm	Change gears (N° of teeth)					N° of thr. per in	Change gears (N° of teeth)				
	A	B	C	D	E		A	B	C	D	E
0,25	50	100	25	100	90	60	50	85	45	125	90
0,3	50	100	30	100	90	55	50	97	55	125	90
0,35	50	100	35	100	90	52	50	95	45	97	90
0,4	50	90	45	125	100	50	50	85	54	125	90
0,45	50	100	45	100	90	45	50	85	45	100	90
0,5	50	100	50	100	90	45	50	84	45	97	100
0,6	50	75	45	100	100	44	50	125	70	97	127
0,7	50	100	70	100	90	42	50	94	54	95	90
0,75	50	80	60	100	90	40	127	100	25	100	50
0,8	50	75	60	100	100	38	127	95	25	100	50
0,9	50	50	45	100	100	35	127	90	95	100	50
1	50	75	--	100	125	34	127	85	95	100	50
1 left	50	--	--	100	90	32	127	80	25	100	70
1,25	50	50	75	100	100	30	127	75	95	100	70
1,5	50	100	75	50	90	28	127	70	95	100	75
1,75	50	80	70	50	90	26	127	65	25	100	70
2	50	50	--	50	100	25	127	75	30	100	70
2 left	50	--	--	50	100	24	127	80	30	90	70
2,5	50	80	--	40	100	22	127	55	25	100	80
						20	127	80	40	100	70
						19	127	80	40	95	70
						18	127	80	40	90	70
						16	127	90	45	80	70
						14	127	80	40	70	60
						13	127	80	40	65	70
						12	127	40	30	90	100
						11	127	55	40	80	70
						10	127	40	30	75	80

FABRIQUE DE MACHINES SCHAUBLIN S.A. BÉVILARD / SUISSE

CHART FOR THREADS

For screwcutting attachment by carriage feed through universal joints type 102-85 and carriage adjusting-screw with metric pitch ± 2 mm.

Use with open and enclosed types W20 and W25 headstocks.

Maximum length of thread to be cut : 2 3/4 in (70 mm).

Set of change gears for metric threads (14 pieces)

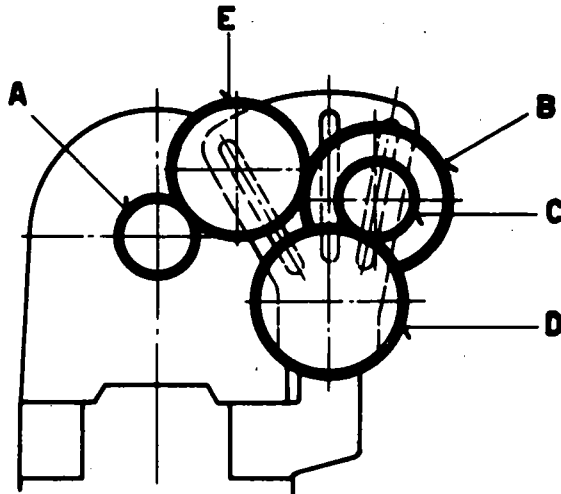
25 - 30 - 35 - 40 - 45 - 50+ - 60 - 70 - 75 - 80 - 90 - 100 - 100 - 125 teeth

Set of change gears for Whitworth threads (22 pieces)

25 - 30 - 40 - 45 - 50 - 54 - 55 - 60 - 65 - 70 - 75 - 80 - 84 - 85 - 90 - 94 - 95 - 97 - 100 - 100 - 125 - 127 teeth

Complete set change gears (23 pieces)

25 - 30 - 35 - 40 - 45 - 50+ - 54 - 55 - 60 - 65 - 70 - 75 - 80 - 84 - 85 - 90 - 94 - 95 - 97 - 100 - 100 - 125 - 127 teeth



Standard set of change gears normally supplied (10 pieces)

45 - 50+ - 60 - 70 - 75 - 80 - 90 - 100 - 100 - 125 teeth

+ The second necessary 50-teeth gear is represented by the driving gear A which is normally supplied with the attachment.

Remark : The standard set of change gears supplied with the attachment is suitable to cut all threads marked with ∇

-----Pitch to be cut----- = $\frac{A \cdot C}{B \cdot D}$
Pitch of carriage adjusting-screw

(4-gear system)
or $\pm \frac{A}{D}$ (2 or 3-gear system)

E = Intermediate gear for right-hand threads

Pitch mm	Metric threads					N° of thr. per in	Whitworth threads				
	Change gears (N° of teeth)						Change gears (N° of teeth)				
	A	B	C	D	E		A	B	C	D	E
0,25	50	100	25	100	90	60	50	85	45	125	90
0,3	50	100	30	100	90	56	50	97	55	125	90
0,35	50	100	35	100	90	52	50	95	45	97	90
0,4	50	90	45	125	100	50	50	85	54	125	90
0,45	50	100	45	100	90	48	50	85	45	100	90
0,5	50	100	50	100	90	46	50	84	45	97	100
0,6	50	75	45	100	100	44	50	125	70	97	127
0,7	50	100	70	100	90	42	50	94	54	95	90
0,75	50	80	60	100	90	40	127	100	25	100	50
0,8	50	75	60	100	100	38	127	95	25	100	50
0,9	50	50	45	100	100	36	127	90	25	100	50
1	50	75	--	100	125	34	127	85	25	100	50
1 left	50	--	--	100	90	32	127	80	25	100	70
1,25	50	60	75	100	100	30	127	75	25	100	70
1,5	50	100	75	50	90	28	127	70	25	100	75
1,75	50	80	70	50	90	26	127	65	25	100	70
2	50	60	--	50	100	25	127	75	30	100	70
2 left	50	--	--	50	100	24	127	80	30	90	70
2,5	50	80	--	40	100	22	127	55	25	100	80
						20	127	80	40	100	70
						19	127	80	40	95	70
						18	127	80	40	90	70
						16	127	90	45	80	70
						14	127	80	40	70	60
						13	127	80	40	65	70
						12	127	40	30	90	100
						11	127	55	40	80	70
						10	127	40	30	75	80

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