

METRIC THREADING ON LOGAN LATHES

Must include 100 T. and 127 T. Transposing Gears (Accurate)
or may use 37 T. and 47 T. Transposing Gears (2/100 of 1% Inaccuracy)

Caution When cutting metric threads, the Half-Nut cannot be disengaged.
 Reverse the spindle direction after retracting the tool at the end of the cut

	For 9", 10", 11" and 2900 Series 12" Logan Lathes	For 2500 Series 12" and 14" Logan Lathes
100 T	LP-1056	LP-1071
127 T	LP-1057	LP-1072
37 T	LP-1665	N/A
47 T	LP-1666	N/A

Lathes with Quick Change Gear Box:
 MM Pitch=(40/Gearbox Setting) X (Stud Gear/Gear Box Gear)

Plain Change Lathes (without Gear Box):
 MM Pitch=2.5 X (Stud Gear/Lead Screw Gear) (Typical Diagrams on Next Page)

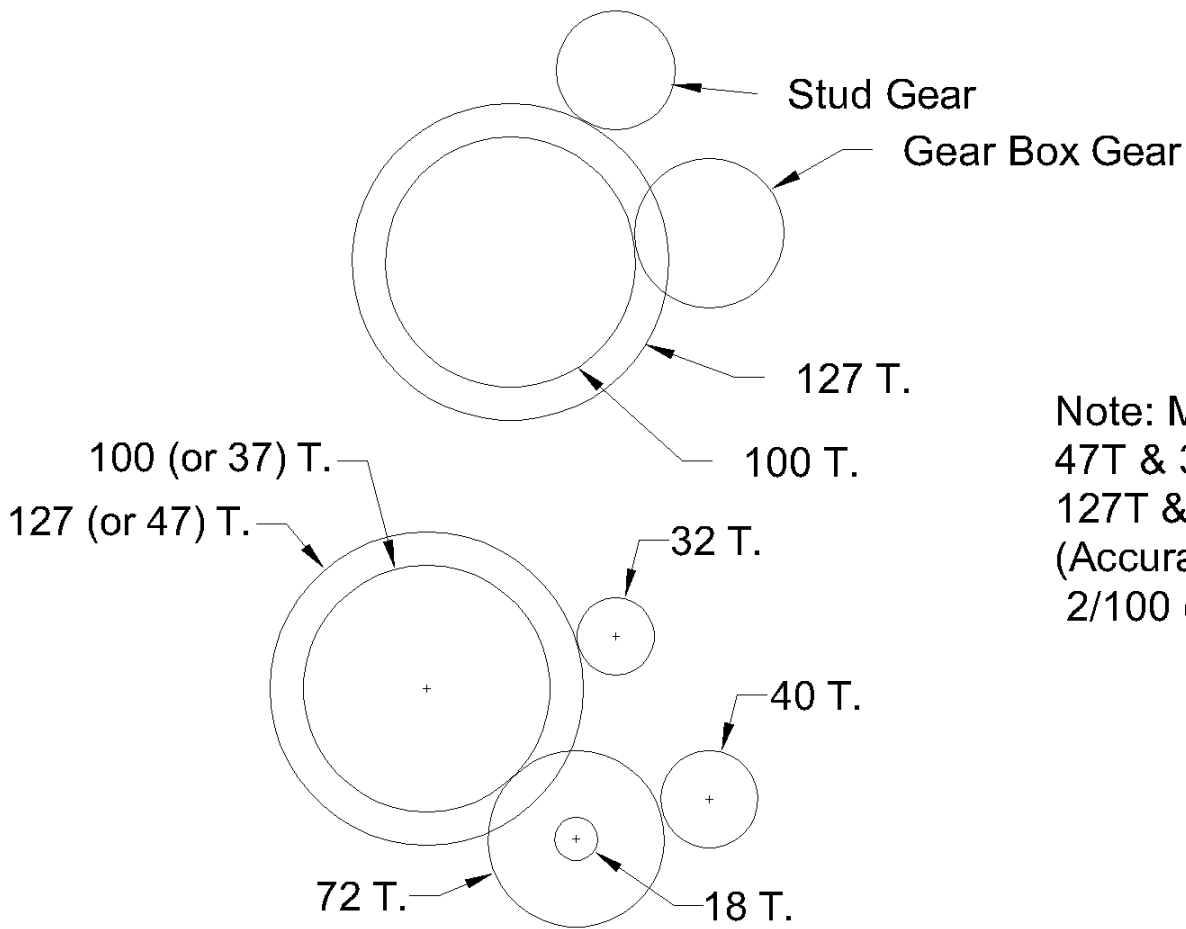
QC Lathes (60T Gearbox Gear)

Plain Change Lathes

MM Pitch	Stud Gear	Gear Box Setting	Stud Gear (Driver)	Driven	Driver	Driven	Screw Gear	
*	0.20	48	160	32	127 (or 47)	100 (or 37)	72	100
*	0.25	48	128	40	127 (or 47)	100 (or 37)	72	100
*	0.30	72	160	48	127 (or 47)	100 (or 37)	72	100
*	0.35	42	80	56	127 (or 47)	100 (or 37)	72	100
*	0.40	48	80	16	127 (or 47)	100 (or 37)	(none)	100
*	0.45	54	80	18	127 (or 47)	100 (or 37)	(none)	100
*	0.50	48	64	20	127 (or 47)	100 (or 37)	(none)	100
*	0.60	72	80	24	127 (or 47)	100 (or 37)	(none)	100
*	0.65	39	40	26	127 (or 47)	100 (or 37)	(none)	100
*	0.70	42	40	28	127 (or 47)	100 (or 37)	(none)	100
*	0.75	72	64	24	127 (or 47)	100 (or 37)	(none)	80
*	0.80	48	40	30	127 (or 47)	100 (or 37)	(none)	100
*	0.90	54	40	36	127 (or 47)	100 (or 37)	(none)	100
*	1.00	48	32	40	127 (or 47)	100 (or 37)	(none)	100
*	1.20	72	40	48	127 (or 47)	100 (or 37)	(none)	100
*	1.25	60	32	40	127 (or 47)	100 (or 37)	(none)	80
*	1.30	39	20	52	127 (or 47)	100 (or 37)	(none)	100
*	1.40	42	20	56	127 (or 47)	100 (or 37)	(none)	100
*	1.50	72	32	48	127 (or 47)	100 (or 37)	(none)	80
*	1.75	42	16	56	127 (or 47)	100 (or 37)	(none)	80
*	2.00	48	16	32	127 (or 47)	100 (or 37)	72	40
*	2.25	54	16	36	127 (or 47)	100 (or 37)	72	40
*	2.50	60	16	32	127 (or 47)	100 (or 37)	72	32
*	2.75	66	16	44	127 (or 47)	100 (or 37)	72	40
*	3.00	72	16	48	127 (or 47)	100 (or 37)	72	40
*	3.50	42	8	28	127 (or 47)	100 (or 37)	72	20
*	4.00	48	8	32	127 (or 47)	100 (or 37)	72	20
*	4.50	54	8	36	127 (or 47)	100 (or 37)	72	20
*	5.00	60	8	40	127 (or 47)	100 (or 37)	72	20
*	5.50	66	8	44	127 (or 47)	100 (or 37)	72	20
*	6.00	72	8	48	127 (or 47)	100 (or 37)	72	20

Note: * indicates ISO Standard Metric Pitches.

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Note: May Substitute
47T & 37T Gears for
127T & 100T Gears
(Accurate to Within
2/100 of 1%)

Note: For Some Pitches, May Have To
Compound, Such As For 2.00 MM Pitch
As Shown Above