

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)

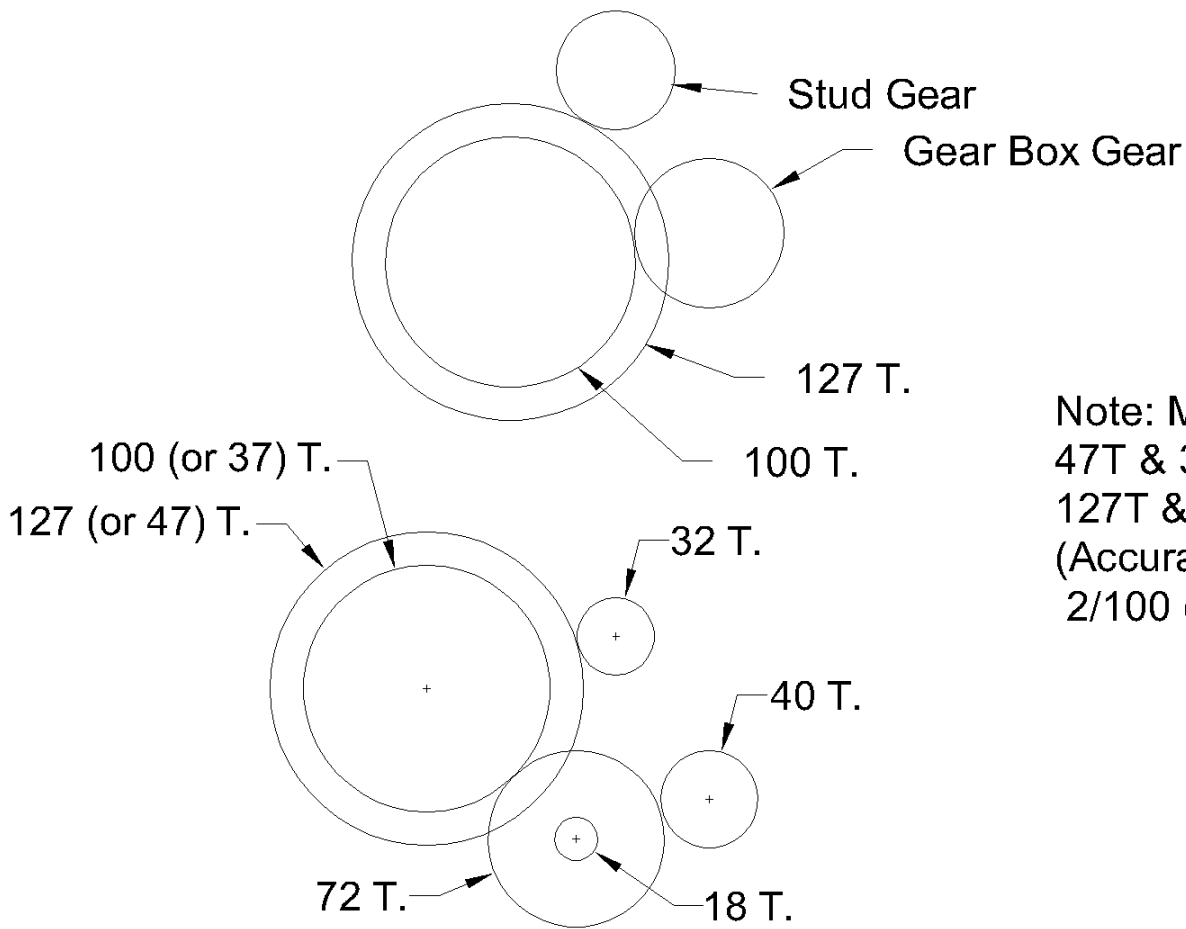
**QC Lathes
(60T Gearbox Gear)**

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.

METRIC THREADING ON LOGAN LATHES



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