
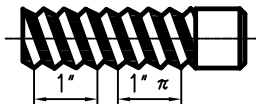
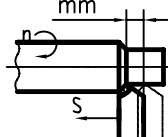
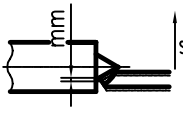




Table 18.2 Table of various threads and feed rate

item	metric thread				module thread				inch thread				diametral pitch thread				longitudinal feed rate				cross feed rate				
handle of coarse pitch for headlock	handle of feedbox																								
		use lead screw 																use feed rod 							
		I	II	III	IV	I	II	III	IV	I	II	III	IV	I	II	III	IV	I	II	III	IV	I	II	III	IV
1:1	1	1	2	4	8	0.5	1	2	4	16	8	4	2	32	16	8	4	0.10	0.20	0.40	0.80	0.05	0.10	0.20	0.40
	2	1.125	2.25	4.5	9	0.5625	1.125	2.25	4.5	18	9	4½	2¼	36	18	9	4½	0.113	0.23	0.45	0.90	0.06	0.113	0.225	0.45
	3	1.25	2.5	5	10	0.6250	1.25	2.5	5	20	10	5	2½	40	20	10	5	0.13	0.25	0.50	1.00	0.065	0.125	0.25	0.5
	4	1.375	2.75	5.5	11	0.6875	1.375	2.75	5.5	22	11	5½	2¾	44	22	11	5½	0.14	0.28	0.55	1.10	0.07	0.14	0.275	0.55
	5	1.5	3	6	12	0.75	1.5	3	6	24	12	6	3	48	24	12	6	0.15	0.30	0.60	1.20	0.075	0.15	0.30	0.60
	6	1.625	3.25	6.5	13	0.8125	1.625	3.25	6.5	26	13	6½	3¼	52	26	13	6½	0.16	0.32	0.65	1.30	0.08	0.16	0.325	0.65
	7	1.75	3.5	7	14	0.8750	1.75	3.5	7	28	14	7	3½	56	28	14	7	0.18	0.35	0.70	1.40	0.09	0.175	0.35	0.70
	8	1.875	3.75	7.5	15	0.9375	1.875	3.75	7.5	30	15	7½	3¾	60	30	15	7½	0.19	0.38	0.75	1.50	0.095	0.19	0.375	0.75
8:1	1	<8>	16	32	64	<4>	8	16	32	<2>	1	½	¼	<4>	2	1	½	<0.80>	1.60	3.20	6.40	<0.40>	0.80	1.60	3.20
	2	<9>	18	36	72	<4.5>	9	18	36	<2½>	1⅙	⅝	⅜	<4½>	2¼	1⅙	⅝	<0.90>	2.80	3.60	7.20	<0.45>	0.90	1.80	3.60
	3	<10>	20	40	80	<5>	10	20	40	<2⅔>	1¼	⅝	⅜	<5>	2½	1¼	⅝	<1.00>	2.00	4.00	8.00	<0.50>	1.00	2.00	4.00
	4	<11>	22	44	88	<5.5>	11	22	44	<2⅔>	1⅜	11/16	3/8	<5½>	2⅔	1⅜	11/16	<1.00>	2.20	4.40	8.80	<0.55>	1.10	2.20	4.40
	5	<12>	24	48	96	<6>	12	24	48	<3>	1½	¾	3/8	<6>	3	1½	¾	<1.20>	2.40	4.80	9.60	<0.60>	1.20	2.40	4.80
	6	<13>	26	52	104	<6.5>	13	26	52	<3½>	1⅝	13/16	7/16	<6½>	3¼	1⅝	13/16	<1.30>	2.60	5.20	10.4	<0.65>	1.30	2.60	5.20
	7	<14>	28	56	112	<7>	14	28	56	<3⅔>	1⅞	7/8	7/16	<7>	3½	1⅞	7/8	<1.40>	2.80	5.60	11.2	<0.70>	1.40	2.80	5.60
	8	<15>	30	60	120	<7.5>	15	30	60	<3⅔>	1⅞	15/16	15/32	<7½>	3¾	1⅞	15/16	<1.50>	3.00	6.00	12.0	<0.75>	1.50	3.00	6.00

Note: 1. Feed rate of top tool post is 1/4 of longitudinal feed rate.

2. Allowed load of feed system: $P_y=44100N$; $P_z=17640N$.

3. Feed rate for refining is 0.64S.

4. Number in brackets is repeated.