

Metric threads on a Myford 7/Super 7 lathe using a 42 tooth change wheel

Leadscrew pitch = 3.175mm (8 TPI)

metric pitch	Driver	driven	D	d	D	d	ISO thread series	
							coarse pitch	fine pitch
0.20	24	50	28	80	30	80	coarse pitch	fine pitch
0.25	25	50	27	75	35	80	M1.1, M1.2	
0.30	24	50	27	60	35	80	M1.4	
0.35	27	50	28	60	35	80	M1.6, M1.8	M1.7
0.40	24	50	35	75	45	80	M2	M2.3
0.45	27	50	35	70	42	80	M2.2, M2.5	M2, M2.6
0.50	30	50	35	75	45	80	M3	M4, M5,
0.60	30	50	42	75	45	80	M3.5	M3
0.70	35	50	42	75	45	80	M4	
0.75	27	40	35	60	45	75	M4.5	M4, M6, M8, M10
0.80	30	50	42	60	45	75	M5	
0.90	27	40	35	50	45	75		M5
1.00	40	50	42	60	45	80	M6, M7 & OBA	M8, M9, M10, M12, M16, M20, M24
1.10	27	40	35	50	55	75		
1.20	30	40	42	50	45	75		
1.25	35	50	45	55	55	80	M8, M9	M12, M14
1.30	39	40	42	60	45	75		
1.40	27	30	35	50	42	60		
1.50	27	40	35	45	45	50	M10, M11	M12, M14, M16, M18, M20, M22, M24, M25, M32
1.60	45	50	42	55	55	75		M20
1.75	35	40	42	50	45	60	M12	
1.80	27	40	42	45	45	50		
2.00	42	50	45	55	55	60	M14, M16	
2.25	42	40	45	50	60	80		
2.50	42	40	45	50	50	60	M18, M20, M22	
2.75	42	40	45	50	55	60		
3.00	42	40	45	60	60	50	M24, M27	
3.50	42	40	45	50	70	60	M30, M33	
4.00	45	40	60	50	70	75	M36, M39	
4.50	42	40	60	50	45	40	M42, M45	
5.00	42	30	45	50	50	40	M48, M52	
5.50	42	30	45	40	55	50	M56	


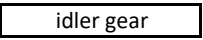


DISCLAIMER

Although I have checked the mathematical accuracy of this table I have not assembled or tested the gear trains themselves. They may require idlers or they may require rearranging to give a workable gear train.

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additional change gears

39T	once		
28T	twice		repeated gears
24T	3 times		
27T	10 times	