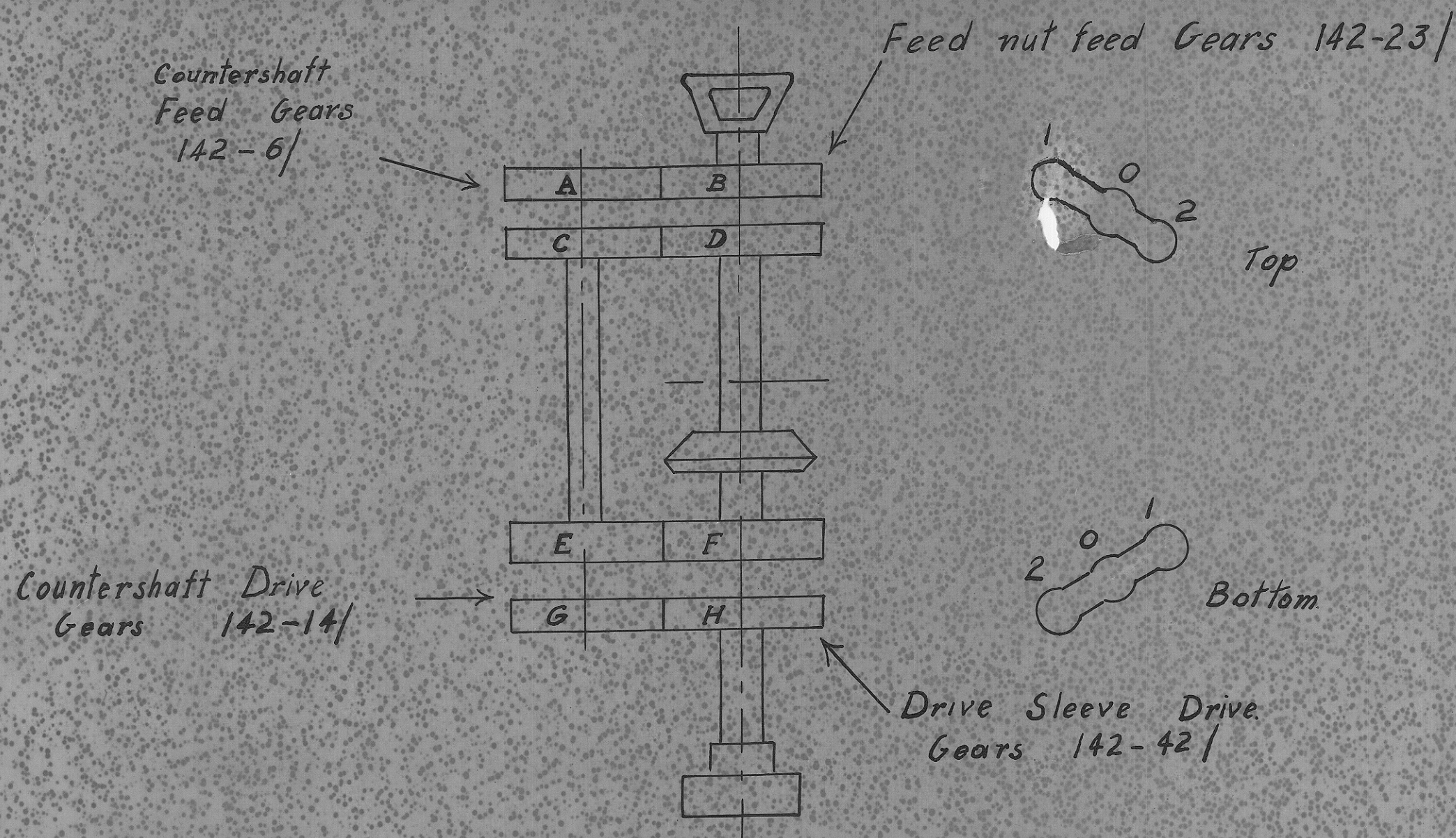


5 cm

REMOVE SHARP EDGES



Note:- The figures given in the table gives the number of teeth in the gear. This figure is also used as a suffix to the part number of the gear.

Example:- for 300 feed

Gear A Part No 142-6/27.
 " B " " 142-23/26.
 " G " " 142-14/39.
 " H " " 142-42/38.

Feed	Position of feed Shifter Handle		A	B	C	D	E	F	G	H
	Top	Bottom								
300	Position 1	Position 2	27	26	—	—	—	—	39	38
400	" 2	" 2	—	—	29B	28A	—	—	39	38
500	" 1	" 1	27	26	—	—	34	33	—	—
770	" 2	" 1	—	—	29B	28A	34	33	—	—
150	" 2	" 2	—	—	40	38	—	—	39	38
200	" 2	" 1	—	—	40	38	34	33	—	—
300	" 1	" 2	27	26	—	—	—	—	39	38
500	" 1	" 1	27	26	—	—	34	33	—	—
80	" 2	" 2	—	—	29A	27	—	—	39	38
100	" 2	" 1	—	—	29A	27	34	33	—	—
150	" 1	" 2	40	38	—	—	—	—	39	38
200	" 1	" 1	40	38	—	—	34	33	—	—
80	" 2	" 2	—	—	29A	27	—	—	39	38
100	" 2	" 1	—	—	29A	27	34	33	—	—
300	" 1	" 2	27	26	—	—	—	—	39	38
500	" 1	" 1	27	26	—	—	34	33	—	—

"A" Feed Screw Head
 Chart of feeds.

29-11-56

142-81.