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Saturday, March 30, 2013 - 23:16

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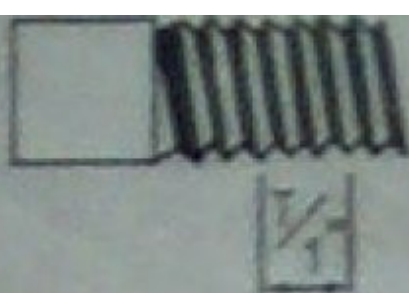
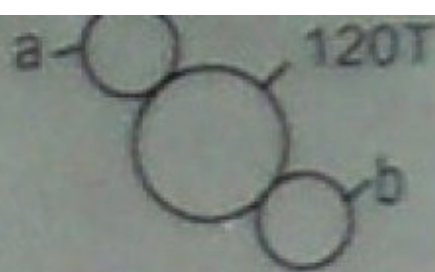
Heres the feed charts for cutting and threading both Inch and Metric

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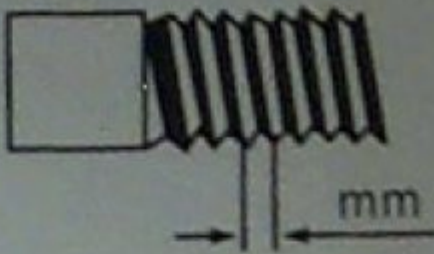
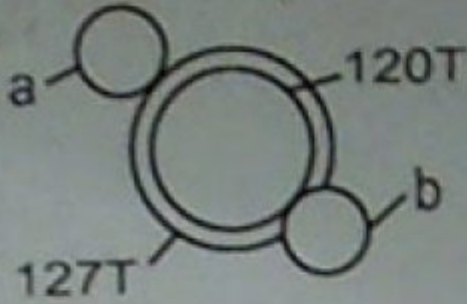
| a | | 60T | | | | 30T | | | |
|-------|---|-------|-------|-------|-------|-------|-------|-------|-------|
| LEVER | | T | S | R | V | T | S | R | V |
| A | D | .0548 | .0512 | .0411 | .0328 | .0274 | .0256 | .0205 | .0164 |
| | | .0187 | .0175 | .0140 | .0112 | .0094 | .0087 | .0070 | .0056 |
| B | D | .0274 | .0256 | .0205 | .0164 | .0137 | .0128 | .0102 | .0082 |
| | | .0094 | .0087 | .0070 | .0056 | .0047 | .0044 | .0035 | .0028 |
| A | C | .0137 | .0128 | .0102 | .0082 | .0069 | .0064 | .0051 | .0041 |
| | | .0047 | .0044 | .0035 | .0028 | .0024 | .0022 | .0017 | .0014 |
| B | C | .0069 | .0064 | .0051 | .0041 | .0034 | .0031 | .0025 | .0020 |
| | | .0024 | .0022 | .0017 | .0014 | .0012 | .0011 | .0009 | .0007 |

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| | | | | | | | | | | |
|-------|----|----|----|----|----|----|-----|----|----|----|
| a | 60 | 60 | 60 | 60 | 40 | 40 | 56 | 40 | 60 | |
| b | 60 | 54 | 57 | 60 | 44 | 46 | 54 | 52 | 63 | |
| LEVER | 4 | 1 | 1 | 1 | 1 | 1 | 2 | 1 | 3 | |
| | V | V | V | V | V | V | V | V | V | |
| A | D | 4 | 4½ | | 5 | 5½ | | 6 | 6½ | 7 |
| B | D | 8 | 9 | 9½ | 10 | 11 | 11½ | 12 | 13 | 14 |
| A | C | 16 | 18 | 19 | 20 | 22 | 23 | 24 | 26 | 28 |
| B | C | 32 | 36 | 38 | 40 | 44 | 46 | 48 | 52 | 56 |

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8TPI

| | | | | | | | | | |
|-------|----|------|------|-----|------|-----|------|-----|------|
| a | 56 | 60 | 60 | 30 | 60 | 60 | 30 | 60 | 56 |
| b | 60 | 60 | 60 | 60 | 60 | 60 | 60 | 60 | 63 |
| LEVER | 4 | 1 | 3 | 4 | 1 | 3 | 1 | 3 | 3 |
| | R | R | S | T | V | R | T | V | V |
| A | D | 7.0 | 6.0 | | 5 | | 4.5 | 4.0 | |
| B | D | 3.5 | 3.0 | | 2.5 | | 2.25 | 2.0 | 1.8 |
| A | C | 1.75 | 1.5 | 1.4 | 1.25 | 1.2 | | 1.0 | 0.9 |
| B | C | | 0.75 | 0.7 | | 0.6 | | 0.5 | 0.45 |

| | | |
|-------|-----------------|-----|
| a | 60T | 30T |
| LEVER | T S R V T S R V | |
| A D | | |
| B D | | |
| A C | | |

| | | | | | | | | | |
|-------|----|-----|-----|-----|----|------|----|----|----|
| a | 60 | 60 | 60 | 60 | 40 | 40 | 56 | 40 | 60 |
| b | 60 | 54 | 57 | 60 | 44 | 46 | 54 | 50 | 63 |
| LEVER | 4 | 1 | 1 | 1 | 1 | 1 | 3 | 1 | 3 |
| A D | 4 | 4.5 | 5 | 5.5 | 6 | 6.5 | 7 | | |
| B D | 8 | 9 | 9.5 | 10 | 11 | 11.5 | 12 | 13 | 14 |

| | | | | | | | | | |
|-------|-----|-----|----|----|----|-----|-----|----|----|
| 8TPI | | | | | | | | | |
| a | 56 | 60 | 60 | 30 | 60 | 60 | 30 | 60 | 56 |
| b | 60 | 60 | 60 | 60 | 60 | 60 | 60 | 60 | 63 |
| LEVER | 4 | 1 | 3 | 4 | 1 | 3 | 1 | 3 | 3 |
| | R | R | S | T | V | R | T | V | V |
| A D | 7.0 | 6.0 | | 5 | | 4.5 | 4.0 | | |

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