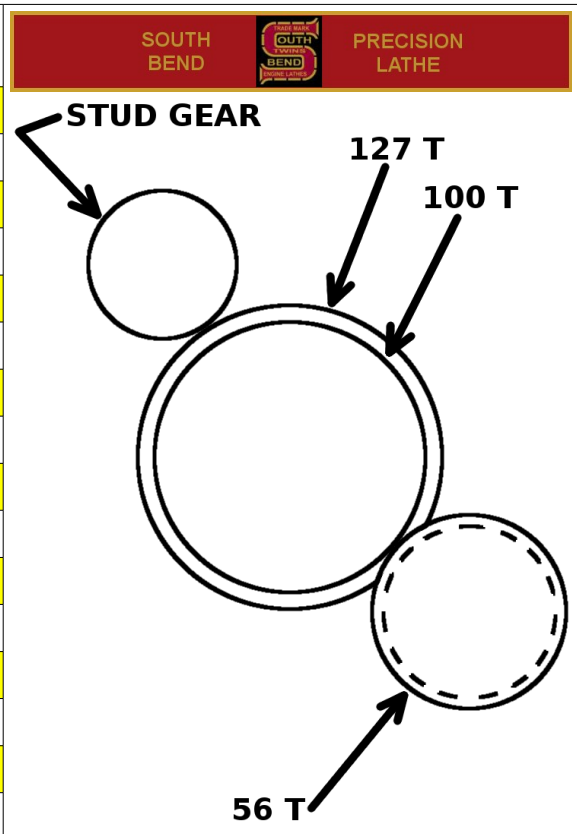


# METRIC TRANSPOSING GEAR CHART

METRIC THREADS - ENGLISH LEAD SCREW - 8 THREADS PER INCH - SB 9A or 10K

| MM PITCH | STUD GEAR | PLUNGER HOLE | PLUNGER HOLE |
|----------|-----------|--------------|--------------|
| 6.00     | 48        | A            | 1            |
| 5.50     | 44        | A            | 1            |
| 5.00     | 40        | A            | 1            |
| 4.50     | 36        | A            | 1            |
| 4.00     | 32        | A            | 1            |
| 3.50     | 28        | A            | 1            |
| 3.00     | 48        | B            | 1            |
| 2.75     | 44        | B            | 1            |
| 2.50     | 40        | B            | 1            |
| 2.25     | 36        | B            | 1            |
| 2.00     | 32        | B            | 1            |
| 1.75     | 28        | B            | 1            |
| 1.50     | 48        | C            | 1            |
| 1.40     | 28        | B            | 3            |
| 1.30     | 26        | B            | 3            |
| 1.25     | 40        | C            | 1            |
| 1.20     | 48        | C            | 3            |
| 1.10     | 44        | C            | 3            |
| 1.00     | 32        | C            | 1            |
| 0.90     | 36        | C            | 3            |
| 0.80     | 32        | C            | 3            |
| 0.75     | 48        | D            | 1            |
| 0.70     | 28        | C            | 3            |
| 0.65     | 26        | C            | 3            |
| 0.60     | 48        | D            | 1            |
| 0.70     | 28        | C            | 3            |
| 0.65     | 26        | C            | 3            |
| 0.60     | 48        | D            | 3            |
| 0.55     | 44        | D            | 3            |
| 0.50     | 32        | D            | 1            |
| 0.45     | 36        | D            | 3            |
| 0.40     | 32        | D            | 3            |
| 0.35     | 28        | D            | 3            |
| 0.30     | 48        | E            | 3            |
| 0.25     | 32        | E            | 1            |
| 0.20     | 32        | E            | 3            |



The lathe should have a 20T or 40T stud gear on the reverse handle, a 80T idler gear on a bushing on the banjo and a 56T gear on the gearbox end with a 20T or 40T gear stored on top of it.

1. Remove all the gears listed above.
2. Use the chart to set the gear box plungers and to install the proper stud gear on the reverse handle.
3. Use a spacer on the gearbox end followed by a 56T gear.
4. Install the 100/127 transposing gear on the bushing that was in the 80T idler. The 127T will mesh with the stud gear and go closest to the machine. The 100T will mesh with the 56T on the gearbox end.
5. Make sure the 100/127 gear spins freely on the bushing.
6. Tighten the bolts and adjust the gears to mesh properly and then lock the banjo position with the allen bolt. Make sure the 127T isn't rubbing against the face of the 56T.