

Single Point Threading Guide

| | Pass 1 | Pass 2 | Pass 3 | Pass 4 | Pass 5 | Pass 6 | Pass 7 | Pass 8 | Pass 9 | Pass 10 | Pass 11 | Pass 12 | Pass 13 | Pass 14 | Total Cut | Passes |
|------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|---------|---------|---------|---------|---------|-----------|--------|
| TPI | | | | | | | | | | | | | | | | |
| 10 | .0234 | .0331 | .0405 | .0468 | .0523 | .0573 | .0619 | .0661 | .0702 | .0740 | .0776 | .0810 | .0843 | .0875 | .0875 | 14 |
| 11 | .0221 | .0312 | .0382 | .0441 | .0493 | .0540 | .0584 | .0624 | .0662 | .0698 | .0732 | .0764 | .0795 | | .0795 | 13 |
| 12 | .0210 | .0298 | .0365 | .0421 | .0471 | .0516 | .0557 | .0595 | .0631 | .0666 | .0698 | .0729 | | | .0729 | 12 |
| 13 | .0203 | .0287 | .0352 | .0406 | .0454 | .0497 | .0537 | .0574 | .0609 | .0642 | .0673 | | | | .0673 | 11 |
| 14 | .0198 | .0280 | .0342 | .0395 | .0442 | .0484 | .0523 | .0559 | .0593 | .0625 | | | | | .0625 | 10 |
| 16 | .0182 | .0258 | .0316 | .0365 | .0408 | .0447 | .0482 | .0516 | .0547 | | | | | | .0547 | 9 |
| 18 | .0172 | .0243 | .0298 | .0344 | .0384 | .0421 | .0455 | .0486 | | | | | | | .0486 | 8 |
| 20 | .0165 | .0234 | .0286 | .0331 | .0370 | .0405 | .0438 | | | | | | | | .0438 | 7 |
| 24 | .0149 | .0210 | .0258 | .0298 | .0333 | .0365 | | | | | | | | | .0365 | 6 |
| 28 | .0140 | .0198 | .0242 | .0280 | .0313 | | | | | | | | | | .0313 | 5 |
| 32 | .0122 | .0173 | .0212 | .0245 | .0273 | | | | | | | | | | .0273 | 5 |
| 36 | .0122 | .0172 | .0210 | .0243 | | | | | | | | | | | .0243 | 4 |
| 40 | .0109 | .0155 | .0189 | .0219 | | | | | | | | | | | .0219 | 4 |
| 44 | .0099 | .0141 | .0172 | .0199 | | | | | | | | | | | .0199 | 4 |
| 48 | .0105 | .0149 | .0182 | | | | | | | | | | | | .0182 | 3 |
| 56 | .0090 | .0128 | .0156 | | | | | | | | | | | | .0156 | 3 |
| 64 | .0079 | .0112 | .0137 | | | | | | | | | | | | .0137 | 3 |
| 72 | .0086 | .0122 | | | | | | | | | | | | | .0122 | 2 |
| 80 | .0077 | .0109 | | | | | | | | | | | | | .0109 | 2 |
| | | | | | | | | | | | | | | | | |

NOTE: All readings are cumulative and are 60° infeeds read on the compound micrometer collar.