

THREADS PER INCH (ENGLISH / SAE)					
Control Lever		Gear Positions			
Position I	Position II	A	B	C	D
10	5	60	30	50	27
12	6	60	36	50	27
14	7	60	42	50	27
16	8	60	48	50	27
18	9	50	54	60	27
20	10	50	36	56	42
22	11	60	33	50	54
24	12	60	36	50	54
26	13	60	39	50	54
28	14	60	42	50	54
30	15	56	42	50	54
32	16	60	48	50	54
34	17	60	51	50	54
36	18	63	40	32	49
38	19	50	57	60	54
40	20	50	36	42	63

MILLIMETERS PER THREAD (METRIC)					
Control Lever		Gear Positions			
Position I	Position II	A	B	C	D
0.15	0.30	30	60	27	63
0.50	1.00	50	60	42	48
0.60	1.20	42	56	63	54
0.70	1.40	42	63	49	32
0.75	1.50	50	60	42	32
0.80	1.60	49	56	48	36
1.00	2.00	50	40	49	42
1.25	2.50	63	32	50	54
1.50	3.00	60	36	42	32
1.75	3.50	60	36	49	32
2.00	4.00	60	36	56	32
2.50	5.00	63	32	50	27
3.00	6.00	63	32	60	27

**THREAD CHART FOR USE WITH BALL SCREWS OR ST 85
COARSE THREAD KIT**