Single Point Threading Guide

Single Depth With Compound Rest At 30.0°

TPI	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	Pass 15	Pass 16	Pass 17	Tot Cut	Passes
8	.0265	.0375	.0459	.0531	.0593	.0650	.0702	.0750	.0796	.0839	.0880	.0919	.0956	.0993	.1027	.1061	.1094	.1094	17
9	.0251	.0355	.0435	.0502	.0561	.0615	.0664	.0710	.0753	.0794	.0833	.0870	.0905	.0939	.0972			.0972	15
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: For compound micrometer collars calibrated for actual movement of the compound rest. All readings are cumulative.