

PM 1340GT Threading Configuration

Imperial TPI

Gear Arrangement

Top Pair	40	127
Bottom Pair	127	40

		Right Gear Lever Position							
		1	2	3	4	5	6	7	8
Left Gear Lever Position	A	4	4.5	4.75	5	5.5	6	6.5	7
	B	8	9	9.5	10	11	12	13	14
	C	16	18	19	20	22	24	26	28
	D	32	36	38	40	44	48	52	56
	E	64	72	76	80	88	96	104	112

PM1340 Metric Threading - as delivered with 120/127 tooth main gear, 30, 32, and 40 tooth smaller gears

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Metric Pitch	Where Used		Gear Configuration		Gear Box Settings		Metric Pitch
	Metric Coarse	Metric Fine	Upper Pair	Lower Pair	Letter	Number	
0.2		M1.0 to M1.8	30/127	120/32	E	8	0.2
0.25		M2.0 , M2.2	40/127	120/40	E	6	0.25
0.35	M1.6 x 0.35	M2.5 , M3 , 3.5	40/120 **	127/32	E	6	0.35
0.4	M2.0 x 0.4		32/127	120/40	D	6	0.4
0.45	M2.5 x 0.45		30/120 **	127/32	D	8	0.45
0.5	M3 x 0.5	M4 to M5.5	40/127	120/40	D	6	0.5
0.6	M3.5 x 0.6		32/127	120/40	D	1	0.6
0.7	M4 x 0.7		35/127 *	120/30	D	4	0.7
0.75		M6, M7, M8	40/127	120/40	D	1	0.75
0.8	M5 x 0.8		32/127	120/40	C	6	0.8
1	M6 x 1.0	M8 to M11 x 1.0	40/127	120/40	C	6	1
1.25	M8 x 1.25	M10 x 1.25	30/127	120/32	C	2	1.25
1.5	M10 x 1.5		40/127	120/40	C	1	1.5
1.75	M12 x 1.75		32/127	120/40	B	5	1.75
2	M14 & M16 x 2.0		40/127	120/40	B	6	2
2.5	M20 & M22 x 2.5		30/127	120/32	B	2	2.5
3	M24 & M 27 x 3		40/127	120/40	B	1	3
3.5	M30 x 3.5		35/127 *	120/40	A	4	3.5
4	M36 x 4		40/127	120/40	A	6	4
4.5	M42 x 4.5		30/127	120/32	A	4	4.5
5	M48 x 5		40/127	120/32	A	6	5
5.5	M56 x 5.5		Not available				5.5
6	M64 & M68 x 6		40/127	120/40	A	1	6

* This thread require a 35 tooth gear from Quality Machine Tools. Better accomplished with a threading die.

** Requires inverting 120/127 Gear If which may require spacer or bushing to ensure clearance and proper alignment with smaller threading gears.

Coarse Metric Thread Pitches				
Size - Nominal Diameter (mm)	Pitch ¹⁾ (mm)	Clearance Drill (mm)	Tap Drill (mm)	Size - Nominal Diameter (mm)
M 1.0	0.25	1.2	0.75	M 1.0
M 1.1	0.25	1.3	0.85	M 1.1
M 1.2	0.25	1.4	0.95	M 1.2
M 1.4	0.3	1.6	1.1	M 1.4
M 1.60	0.35	1.8	1.25	M 1.60
M 2.00	0.4	2.4	1.6	M 2.00
M 2.50	0.45	2.9	2	M 2.50
M 3.00	0.5	3.4	2.5	M 3.00
M 3.50	0.6	3.9	2.9	M 3.50
M 4.00	0.7	4.5	3.3	M 4.00
M 4.5	0.75	5	3.7	M 4.5
M 5.00	0.8	5.5	4.2	M 5.00
M 6.00	1	6.6	5	M 6.00
M 8.00	1.25	9	6.8	M 8.00
M 10.00	1.5	12	8.5	M 10.00
M 12.00	1.75	14	10.2	M 12.00
M 14.00	2	16	12	M 14.00
M 16.00	2	18	14	M 16.00
M 20.00	2.5	22	17.5	M 20.00
M 22.00	2.5	25	19.5	M 22.00
M 24.00	3	27	21	M 24.00
M 27.00	3	30	24	M 27.00
M 30.00	3.5	33	26.5	M 30.00
M 36.00	4	40	32	M 36.00
M 42.00	4.5	46	37.5	M 42.00
M 48.00	5	53	43	M 48.00
M 56.00	5.5	62	50.5	M 56.00
M 64.00	6	70	58	M 64.00
M 68.00	6	74	62	M 68.00

Fine Metric Thread Pitches					
Size - Nominal Diameter (mm)	Pitch ¹⁾ (mm)	Tap Drill (mm)	Size - Nominal Diameter (mm)	Pitch ¹⁾ (mm)	Tap Drill (mm)
M 1.0 x 0.2	0.2	0.8	M 12 x 1	1	11.00
M 1.1 x 0.2	0.2	0.9	M 12 x 1.25	1.25	10.80
M 1.2 x 0.2	0.2	1	M 12 x 1.5	1.5	10.50
M 1.4 x 0.2	0.2	1.2	M 14 x 1.0	1	13.00
M 1.6 x 0.2	0.2	1.4	M 14 x 1.25	1.25	12.80
M 1.8 x 0.2	0.2	1.6	M 14 x 1.5	1.5	12.50
M 2 x 0.25	0.25	1.75	M 12 x 1.5	1.5	10.50
M 2.2 x 0.25	0.25	1.95	M 14 x 1.0	1	13.00
M 2.5 x 0.35	0.35	2.1	M 14 x 1.25	1.25	12.80
M 3 x 0.35	0.35	2.6	M 14 x 1.5	1.5	12.50
M 3.5 x 0.35	0.35	3.1	M 15 x 1	1	14.00
M 4 x 0.35	0.35	3.6	M 15 x 1.5	1.5	13.50
M 4 x 0.5	0.5	3.5	M 16 x 1	1	15.00
M 4.5 x 0.5	0.5	4	M 16 x 1.5	1.5	14.50
M 5 x 0.5	0.5	4.5	M 17 x 1.0	1	16.00
M 5.5 x 0.5	0.5	5	M 17 x 1.5	1.5	15.50
M 6 x 0.75	0.75	5.2	M 18 x 1.0	1	17.00
M 7 x 0.75	0.75	6.2	M 18 x 1.5	1.5	16.50
M 8 x 0.5	0.5	7.5	M 18 x 2.0	2	16.00
M 8 x 0.75	0.75	7.2	M 20 x 1.0	1	19.00
M 8 x 1.0	1	7	M 20 x 1.5	1.5	18.50
M 9 x 0.75	0.75	8.2	M 20 x 2.0	2	18.00
M 9 x 1	1	8	M 22 x 1.0	1	21.00
M 10 x 0.75	0.75	9.2	M 22 x 1.5	1.5	20.50
M 10 x 1	1	9	M 22 x 2.0	2	20.00
M 10 x 1.25	1.25	8.8	M 24 x 1.0	1	23.00
M 11 x 0.75	0.75	10.2	M 24 x 1.5	1.5	22.50
M 11 x 0.75	0.75	10.2	M 24 x 2.0	2	22.00
M 11 x 1	1	10	M 25 x 1.0	1	24.00
			M 25 x 1.5	1.5	23.50
			M 25 x 2.0	2	23.00