

APPENDIX I

GLOSSARY

AISI—American Iron and Steel Institute.

ABRASIVE—A hard, tough substance that has many sharp edges.

ALLOWANCE—The difference between maximum size limits of mating parts.

ALLOYING—The procedure of adding elements other than those usually comprising a metal or alloy to change its characteristics and properties.

ALLOYING ELEMENTS—Elements added to nonferrous and ferrous metals and alloys to change their characteristics and properties.

ANNEALING—The softening of metal by heating and slow cooling.

ARBOR—The principal axis member, or spindle, of a machine by which a motion of revolution is transmitted.

ASTM—American Society for Testing Metals.

BABBITT—A lead base alloy used for bearings.

BEND ALLOWANCE—An additional amount of metal used in a bend in metal fabrication.

BENCH MOLDING—The process of making small molds on a bench.

BEVEL—A term for a plane having any angle other than 90° to a given reference plane.

BINARY ALLOY—An alloy of two metals.

BISECT—To divide into two equal parts.

BLOWHOLE—A hole in a casting caused by trapped air or gases.

BOND—Appropriate substance used to hold grains together in grinding wheels.

BORING BAR—A tool used for boring, counter-boring, re-boring, facing, grooving, and so forth, where true alignment is of primary importance.

BRINELL—A type of hardness test.

BRITTLENESS—The property of a material that causes it to break or snap suddenly with little or no prior sign of deformation.

BRONZE—A nonferrous alloy composed of copper and tin and sometimes other elements.

CALIBRATION—The procedure required to adjust an instrument or device to produce a standardized output with a given input.

CARBON—An alloying element.

CASTING—A metal object made by pouring melted metal into a mold.

CHAMFER—A bevel surface formed by cutting away the angle of one or two intersecting faces of a piece of material.

CONTOUR—The outline of a figure or body.

DRIFT PIN—A conical-shaped pin gradually tapered from a blunt point to a diameter larger than the hole diameter.

DUCTILITY—The ability to be molded or shaped without breaking.

EXTRACTOR—Tool used in removal of broken taps.

FABRICATE—To shape, assemble, and secure in place component parts to form a complete device.

FALSE CHUCK—Sometimes applied to the facing material used in rechucking a piece of work in the lathe.

FATIGUE—The tendency of a material to break under repeated strain.

FILE FINISH—Finishing a metal surface with a file.

FILLET—A concave internal corner in a metal component.

FINISH ALLOWANCE—An amount of stock left on the surface of a casting to allow for machine finishing.

FINISH MARKS—Marks used to indicate the degree of smoothness of finish to be achieved on surfaces to be machined.

GRAIN—The cutting particles of a grinding wheel.

HARDNESS—The ability of a material to resist penetration.

HONING—Finishing machine operation using stones vice a tool bit or cutting tool.

INVOLUTE—Usually referred to as a cutter used in gearing.

KNOOP—Trade name used in hardness testing.

MANDREL—Tool used to mount work usually done in a lathe or milling machine.

NORMALIZING—Heating iron-base alloys to approximately 100°F above the critical temperature range followed by cooling to below that range in still air at room temperature.

PERPENDICULAR—A straight line that meets another straight line at a 90 degree angle. Also a vertical line extending through the outline of the hull ends and the designer's waterline.

PIG IRON—Cast iron as it comes from the blast furnace in which it was produced from iron ore.

PINHOLE—Small hole under the surface of the casting.

PLAN—A drawing prepared for use in building a ship.

PLASTICITY—The property that enables a material to be excessively and permanently deformed without breaking.

PREHEATING—The application of heat to the base metal before it is welded or cut.

PUNCH, PRICK—A small punch used to transfer the holes from the template to the plate. Also called a **CENTER PUNCH**.

QUENCHING—Rapid cooling of steels at different rates.

REAMING—Enlarging a hole by revolving in it a cylindrical, slightly tapered tool with cutting edges running along its sides.

RECHUCKING—Reversing of a piece of work on a faceplate so that the surface that was against the faceplate may be turned to shape.

REFERENCE PLANE—On a drawing, the normal plane from which all information is referenced.

RPM—Revolutions per minute.

SCALE—The ratio between the measurement used on a drawing and the measurement of the object it represents. A measuring device such as a ruler, having special graduations.

SECTOR—A figure bounded by two radii and the included arc of a circle, ellipse, or other central curve.

SPOT FACING—Turning a circular bearing surface about a hole. It does not affect a pattern.

STANDARD CASING—The half of a split casing that is bolted to the foundation, as opposed to the half, or cover, which can be removed with minimum disturbance to other elements of the equipment.

STRAIGHTEDGE—Relatively long piece of material whose working edge is a true plane.

STRENGTH—The ability of a material to resist strain.

STRESS RELIEVING—Heat treatment to remove stresses or casting strains.

STUD—(1) A light vertical structure member, usually of wood or light structural steel, used as part of a wall and for supporting moderate loads. (2) A bolt threaded on both ends, one end of which is screwed into a hole drilled and tapped in the work, and used where a through bolt cannot be fitted.

SYNTHETIC MATERIAL—A complex chemical compound that is artificially formed by the combining of two or more simpler compounds or elements.

TEMPER—To relieve internal stress by heat treating.

TEMPLATE—A pattern used to reproduce parts.

TOLERANCE—An allowable variation in the dimensions of a machined part.

VICKERS—A scale or test used in metal hardness testing.

VITRIFIED BOND—A man-made bond used in grinding wheels.

WAVINESS—Used as a term in the testing finish machining of parts.

ZINC—An alloy used widely in die casting.

APPENDIX II

TABULAR INFORMATION OF BENEFIT TO A MACHINERY REPAIRMAN

Table AII-1.—Decimal Equivalents of Fractions (inch)

frac- tions	# 64ths	# 32ds	# 16ths	# 8ths	# 4ths	decimal equiv.	frac- tions	# 64ths	# 32ds	# 16ths	# 8ths	# 4ths	decimal equiv.
$\frac{1}{64}$	1					0.015625	$\frac{33}{64}$	33					0.515625
$\frac{1}{32}$	2	1				0.03125	$\frac{17}{32}$	34	17				0.53125
$\frac{3}{64}$	3					0.046875	$\frac{35}{64}$	35					0.546875
$\frac{1}{16}$	4	2	1			0.0625	$\frac{9}{16}$	36	18	9			0.5625
$\frac{5}{64}$	5					0.078125	$\frac{37}{64}$	37					0.578125
$\frac{3}{32}$	6	3				0.09375	$\frac{19}{32}$	38	19				0.59375
$\frac{7}{64}$	7					0.109375	$\frac{39}{64}$	39					0.609375
$\frac{1}{8}$	8	4	2	1		0.125	$\frac{5}{8}$	40	20	10	5		0.625
$\frac{9}{64}$	9					0.140625	$\frac{41}{64}$	41					0.640625
$\frac{5}{32}$	10	5				0.15625	$\frac{21}{32}$	42	21				0.65625
$\frac{11}{64}$	11					0.171875	$\frac{43}{64}$	43					0.671875
$\frac{3}{16}$	12	6	3			0.1875	$\frac{11}{16}$	44	22	11			0.6875
$\frac{13}{64}$	13					0.203125	$\frac{45}{64}$	45					0.703125
$\frac{7}{32}$	14	7				0.21875	$\frac{23}{32}$	46	23				0.71875
$\frac{15}{64}$	15					0.234375	$\frac{47}{64}$	47					0.734375
$\frac{1}{4}$	16	8	4	2	1	0.250	$\frac{1}{4}$	48	24	12	6	3	0.750
$\frac{17}{64}$	17					0.265625	$\frac{49}{64}$	49					0.765625
$\frac{9}{32}$	18	9				0.28125	$\frac{25}{32}$	50	25				0.78125
$\frac{19}{64}$	19					0.296875	$\frac{51}{64}$	51					0.796875
$\frac{5}{16}$	20	10	5			0.3125	$\frac{13}{16}$	52	26	13			0.8125
$\frac{21}{64}$	21					0.328125	$\frac{53}{64}$	53					0.828125
$\frac{11}{32}$	22	11				0.34375	$\frac{27}{32}$	54	27				0.84375
$\frac{23}{64}$	23					0.359375	$\frac{55}{64}$	55					0.859375
$\frac{3}{8}$	24	12	6	3		0.375	$\frac{3}{8}$	56	28	14	7		0.875
$\frac{25}{64}$	25					0.390625	$\frac{57}{64}$	57					0.890625
$\frac{13}{32}$	26	13				0.40625	$\frac{29}{32}$	58	29				0.90625
$\frac{27}{64}$	27					0.421875	$\frac{59}{64}$	59					0.921875
$\frac{7}{16}$	28	14	7			0.4375	$\frac{15}{16}$	60	30	15			0.9375
$\frac{29}{64}$	29					0.453125	$\frac{61}{64}$	61					0.953125
$\frac{15}{32}$	30	15				0.46875	$\frac{31}{32}$	62	31				0.96875
$\frac{31}{64}$	31					0.484375	$\frac{63}{64}$	63					0.984375
$\frac{1}{2}$	32	16	8	4	2	0.500	1 inch	64	32	16	8	4	1.000

Table AII-2.—Decimal Equivalents of Millimeters

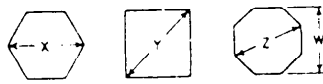
mm	inches	mm	inches	mm	inches	mm	inches	mm	inches
0.1	0.00394	3.5	0.13779	6.9	0.27165	10.3	0.40551	13.8	0.54330
0.2	0.00787	3.6	0.14173	7.0	0.27559	10.4	0.40944	13.9	0.54724
0.3	0.01181	3.7	0.14566	7.1	0.27952	10.5	0.41388	14.0	0.55118
0.4	0.01575	3.8	0.14960	7.2	0.28346	10.6	0.41732	14.1	0.55511
0.5	0.01968	3.9	0.15354	7.3	0.28740	10.7	0.42125	14.2	0.55905
0.6	0.02362	4.0	0.15748	7.4	0.29133	10.8	0.42519	14.3	0.56299
0.7	0.02756	4.1	0.16141	7.5	0.29527	10.9	0.42913	14.4	0.56692
0.8	0.03149	4.2	0.16535	7.6	0.29921	11.0	0.43307	14.5	0.57086
0.9	0.03543	4.3	0.16929	7.7	0.30314	11.1	0.43700	14.6	0.57480
1.0	0.03937	4.4	0.17322	7.8	0.30708	11.2	0.44094	14.7	0.57873
1.1	0.04330	4.5	0.17716	7.9	0.31102	11.3	0.44488	14.8	0.58267
1.2	0.04724	4.6	0.18110	8.0	0.31496	11.4	0.44881	14.9	0.58661
1.3	0.05118	4.7	0.18503	8.1	0.31889	11.5	0.45275	15.0	0.59055
1.4	0.05512	4.8	0.18897	8.2	0.32283	11.6	0.45669	15.5	0.61023
1.5	0.05905	4.9	0.19291	8.3	0.32677	11.7	0.46062	16.0	0.62992
1.6	0.06299	5.0	0.19685	8.4	0.33070	11.8	0.46456	16.5	0.64960
1.7	0.06692	5.1	0.20078	8.5	0.33464	11.9	0.46850	17.0	0.66929
1.8	0.07086	5.2	0.20472	8.6	0.33858	12.0	0.47244	17.5	0.68897
1.9	0.07480	5.3	0.20866	8.7	0.34251	12.1	0.47637	18.0	0.70866
2.0	0.07874	5.4	0.21259	8.8	0.34645	12.2	0.48031	18.5	0.72834
2.1	0.08267	5.5	0.21653	8.9	0.35039	12.3	0.48425	19.0	0.74803
2.2	0.08661	5.6	0.22047	9.0	0.35433	12.4	0.48818	19.5	0.76771
2.3	0.09055	5.7	0.22440	9.1	0.35826	12.5	0.49212	20.0	0.78740
2.4	0.09448	5.8	0.22834	9.2	0.36220	12.6	0.49606	20.5	0.80708
2.5	0.09842	5.9	0.23228	9.3	0.36614	12.7	0.49999	21.0	0.82677
2.6	0.10236	6.0	0.23622	9.4	0.37007	12.8	0.50393	21.5	0.84645
2.7	0.10629	6.1	0.24015	9.5	0.37401	12.9	0.50787	22.0	0.86614
2.8	0.11023	6.2	0.24409	9.6	0.37795	13.0	0.51181	22.5	0.88582
2.9	0.11417	6.3	0.24803	9.7	0.38188	13.1	0.51574	23.0	0.90551
3.0	0.11811	6.4	0.25196	9.8	0.38582	13.2	0.51968	23.5	0.92519
3.1	0.12204	6.5	0.25590	9.9	0.38976	13.3	0.52362	24.0	0.94488
3.2	0.12598	6.6	0.25984	10.0	0.39370	13.4	0.52755	24.5	0.96456
						13.5	0.53149	25.0	0.98425
3.3	0.12992	6.7	0.26377	10.1	0.39763	13.6	0.53543	25.5	1.00393
3.4	0.13385	6.8	0.26771	10.2	0.40157	13.7	0.53936	26.0	1.02362

Table AII-3.—Dividing a Circle into Parts

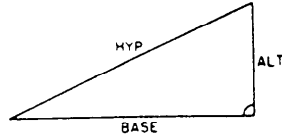
To find the length of the chord for dividing the circumference of a circle into a required number of equal parts, multiply the factor in the table by the diameter.

no. of spaces	chord length	no. of spaces	chord length	no. of spaces	chord length
3	0.866	21	0.149	39	0.0805
4	0.7071	22	0.1423	40	0.0785
5	0.5878	23	0.1362	41	0.0765
6	0.5	24	0.1305	42	0.0747
7	0.4339	25	0.1253	43	0.073
8	0.3827	26	0.1205	44	0.0713
9	0.342	27	0.1161	45	0.0698
10	0.309	28	0.112	46	0.0682
11	0.2818	29	0.1081	47	0.0668
12	0.2584	30	0.1045	48	0.0654
13	0.2393	31	0.1012	49	0.0641
14	0.2224	32	0.098	50	0.0628
15	0.2079	33	0.0951	51	0.0616
16	0.1951	34	0.0932	52	0.0604
17	0.1837	35	0.0896	53	0.0592
18	0.1736	36	0.0872	54	0.0581
19	0.1645	37	0.0848	55	0.0571
20	0.1564	38	0.0826		

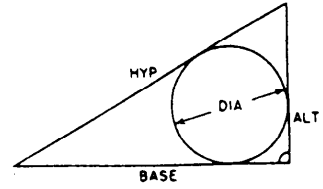
Table AII-4.—Formulas for Dimension, Area, and Volume



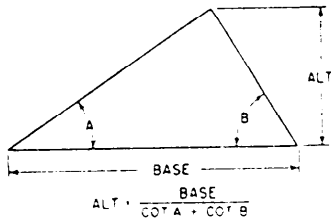
W = WIDTH
 $X = 1.1547 W$
 $Y = 1.4142 W$
 $Z = 1.0824 W$



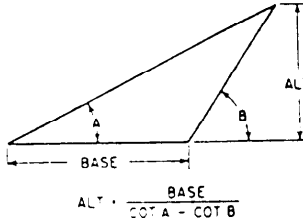
$$\begin{aligned} \text{HYP} &= \sqrt{\text{BASE}^2 + \text{ALT}^2} \\ \text{BASE} &= \sqrt{\text{HYP}^2 - \text{ALT}^2} \\ \text{ALT} &= \sqrt{\text{HYP}^2 - \text{BASE}^2} \end{aligned}$$



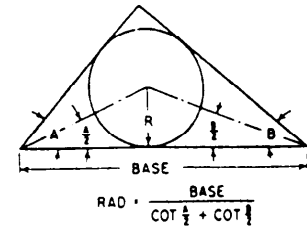
$$\text{DIA} = \text{BASE} + \text{ALT} - \text{HYP}$$



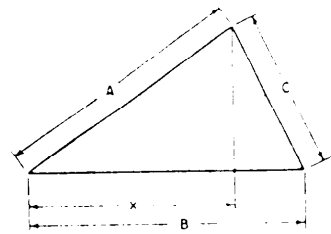
$$\text{ALT} = \frac{\text{BASE}}{\cot A + \cot B}$$



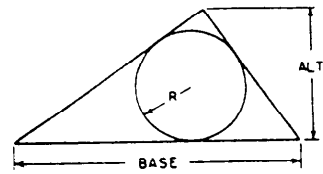
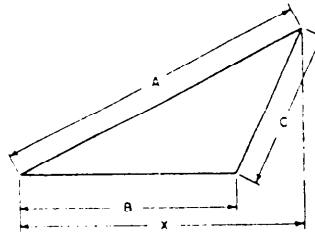
$$\text{ALT} = \frac{\text{BASE}}{\cot A - \cot B}$$



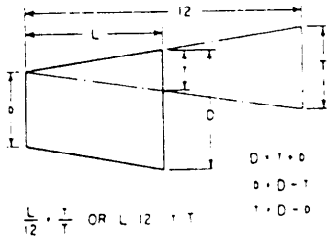
$$\text{RAD} = \frac{\text{BASE}}{\cot \frac{A}{2} + \cot \frac{B}{2}}$$



$$X = \frac{A^2 + B^2 - C^2}{2B}$$

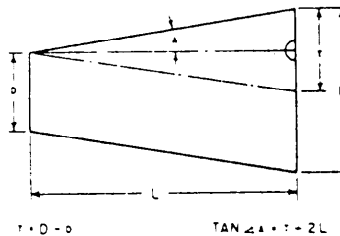


$$\begin{aligned} \text{PERIMETER} &= \text{BASE} + \text{ALT} + R \\ R &= \frac{\text{BASE} \times \text{ALT}}{\text{PERIMETER}} \end{aligned}$$



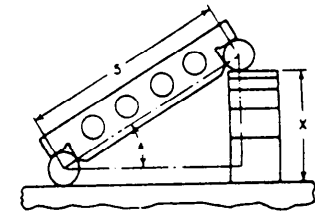
$$\frac{L}{12} = \frac{T}{T} \text{ OR } L = 12 + T$$

$$\begin{aligned} D &= T + D \\ D &= D - T \\ T &= D - D \end{aligned}$$

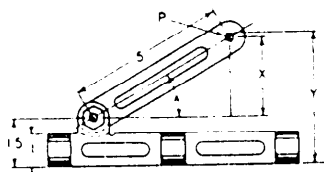


$$T = D - D$$

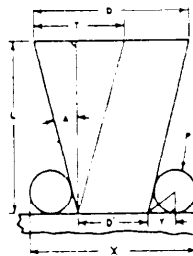
$$\tan \angle A = \frac{T}{2L}$$



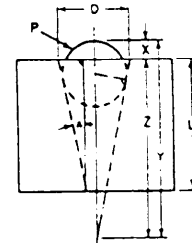
$$X = 5 \times \text{SINE OF } \angle A$$



$$\begin{aligned} A &= \text{INCLUDED } \angle \\ X &= 5 \times \text{SINE OF } \angle A \\ P &= \text{PLUG SIZE} \\ Y &= X + 15 = \frac{P}{2} \end{aligned}$$



$$\begin{aligned} P &= \text{PLUG SIZE} \\ T &= \text{TAPER PER FT} \\ \frac{T}{24} &= \tan \angle A \\ T &= 2(L \times \tan \angle A) \\ D &= D - T \\ T &= \frac{P}{2} \times \cot \frac{90^\circ - A}{2} \\ X &= D + 2T + P \end{aligned}$$



$$\begin{aligned} \tan \angle A &= \frac{T}{24} \\ Y &= \left(\frac{P}{2} \csc \angle A \right) + \frac{P}{2} \\ Z &= \frac{D}{2} \cot \angle A \\ X &= Y - Z \end{aligned}$$

Table AII-4.—Formulas for Dimension, Area, and Volume—Continued

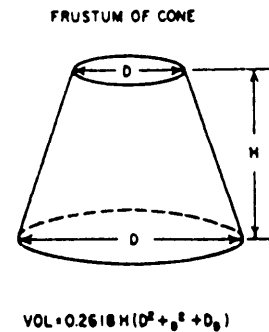
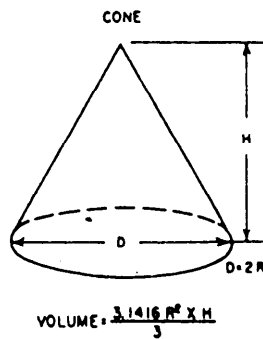
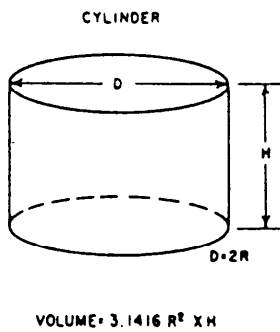
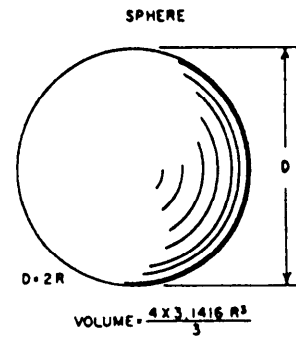
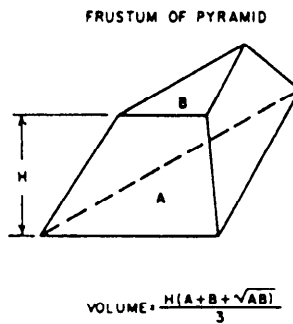
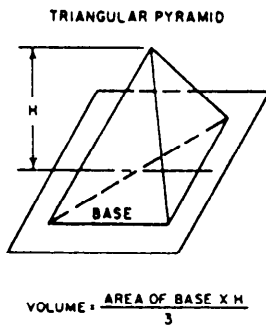
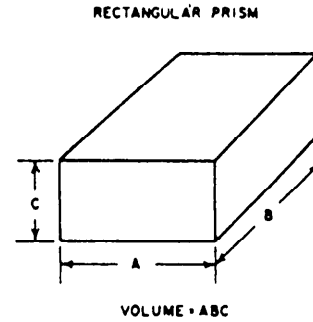
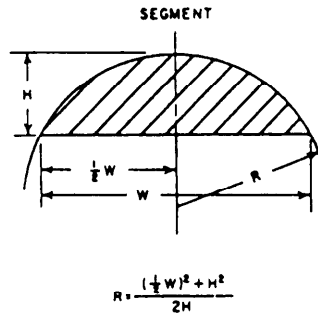
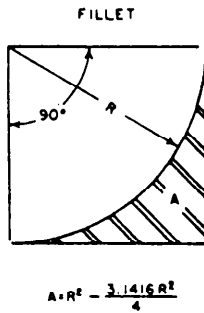
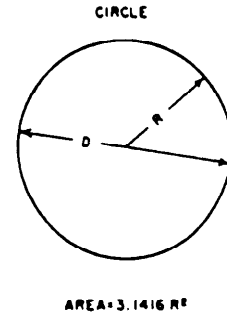
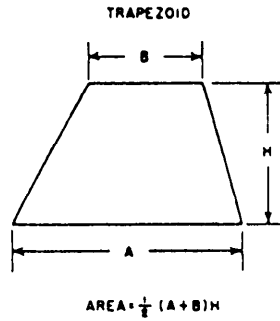
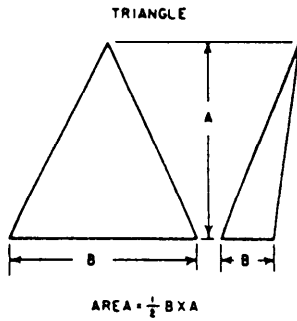


Table AII-5.—Number, Letter and Fractional Identification of Drill Sizes (Letter drills are larger than number drills; they begin where number drills end.)

no. & letter drills	fractional drills	decimal equiv.	no. & letter drills	fractional drills	decimal equiv.	no. & letter drills	fractional drills	decimal equiv.	no. & letter drills	fractional drills	decimal equiv.
800135	420935		$1\frac{3}{64}$.2031	Z	$1\frac{3}{32}$.4062
790145		$\frac{3}{32}$.0937	62040	4130
	$\frac{1}{64}$.0156	410960	52055		$2\frac{7}{64}$.4219
780160	400980	42090		$\frac{7}{16}$.4375
770180	390995	32130		$2\frac{9}{64}$.4531
760200	381015		$\frac{7}{32}$.2187		$1\frac{5}{32}$.4687
750210	371040	22210		$3\frac{1}{64}$.4844
740225	361065	12280		$\frac{1}{2}$.5000
730240		$\frac{7}{64}$.1094	A2340			
720250	351100		$1\frac{5}{64}$.2344		$3\frac{3}{64}$.5156
710260	341110	B2380		$1\frac{7}{32}$.5312
700280	331130	C2420		$3\frac{5}{64}$.5469
690292	321160	D2460		$\frac{9}{16}$.5625
680310	311200	E	$\frac{1}{4}$.2500		$3\frac{7}{64}$.5781
	$\frac{1}{32}$.0312		$\frac{1}{8}$.1250	F2570		$1\frac{9}{32}$.5937
670320	301285	G2610		$3\frac{9}{64}$.6094
660330	291360		$1\frac{7}{64}$.2656		$\frac{5}{8}$.6250
650350	281405	H2660		$4\frac{1}{64}$.6406
640360		$\frac{9}{64}$.1406	I2720		$2\frac{1}{32}$.6562
630370	271440	J2770		$4\frac{3}{64}$.6719
620380	261470	K2810		$1\frac{1}{16}$.6875
610390	251495		$\frac{9}{32}$.2812		$4\frac{5}{64}$.7031
600400	241520	L2900		$2\frac{3}{32}$.7187
590410	231540	M2950		$4\frac{7}{64}$.7344
580420		$\frac{5}{32}$.1562		$1\frac{9}{64}$.2969		$\frac{3}{4}$.7500
570430	221570	N3020			
560465	211590		$\frac{5}{16}$.3125		$4\frac{9}{64}$.7656
	$\frac{3}{64}$.0469	201610	O3160		$2\frac{5}{32}$.7812
550520	191660	P3230		$5\frac{1}{64}$.7969
540550	181695		$2\frac{1}{64}$.3281		$1\frac{3}{16}$.8125
530595		$1\frac{1}{64}$.1719	Q3320		$5\frac{3}{64}$.8281
	$\frac{1}{16}$.0625	171720	R3390		$2\frac{7}{32}$.8437
520635	161770		$1\frac{1}{32}$.3437		$5\frac{5}{64}$.8594
510670	151800	S3480		$\frac{7}{8}$.8750
500700	141820	T3580			
490730	131850		$2\frac{3}{64}$.3594		$5\frac{7}{64}$.8906
480760		$\frac{3}{16}$.1875	U3680		$2\frac{9}{32}$.9062
	$\frac{5}{64}$.0781	121890		$\frac{3}{8}$.3750		$5\frac{9}{64}$.9219
470785	111910	V3770		$1\frac{5}{16}$.9375
460810	101935	W3860		$6\frac{1}{64}$.9531
450820	91960		$2\frac{5}{64}$.3906		$3\frac{1}{32}$.9687
440860	81990	X3970		$6\frac{3}{64}$.9844
430890	72010	Y4040		1	1.0000

Table AII-6.—Units of Weight, Volume, and Temperature

AVOIRDUPOIS WEIGHT

16 drams or 437.5 grains = 1 ounce
 16 ounces or 7,000 grains = 1 pound
 2,000 pounds = 1 net or short ton
 2,240 pounds = 1 gross or long ton
 2,204.6 pounds = 1 metric ton

BOARD MEASURE

One board foot measure is a piece of wood 12 inches square by 1 inch thick, or 144 cubic inches. A piece of wood 2 by 4, 12 feet long contains 8 feet board measure.

DRY MEASURE

2 pints = 1 quart
 8 quarts = 1 peck
 4 pecks = 1 bushel
 1 standard U.S. bushel = 1.2445 cubic feet
 1 British imperial bushel = 1.2837 cubic feet

LIQUID MEASURE

4 gills = 1 pint
 2 pints = 1 quart
 4 quarts = 1 gallon
 1 U.S. gallon = 231 cubic inches
 1 British imperial gallon = 1.2 U.S. gallons
 7.48 U.S. gallons = 1 cubic foot

LONG MEASURE

12 inches = 1 foot
 3 feet = 1 yard
 1,760 yards = 1 mile
 5,280 feet = 1 mile
 16.5 feet = 1 rod

PAPER MEASURE

24 sheets = 1 quire
 20 quires = 1 ream
 2 reams = 1 bundle
 5 bundles = 1 bale

SHIPPING MEASURE

1 U.S. shipping ton = 40 cubic feet
 1 U.S. shipping ton = 32.143 U.S. bushels
 1 U.S. shipping ton = 31.16 imperial bushels
 1 British shipping ton = 42 cubic feet
 1 British shipping ton = 33.75 U.S. bushels
 1 British shipping ton = 32.718 imperial bushels

SQUARE MEASURE

144 square inches = 1 square foot
 9 square feet = 1 square yard
 30.25 square yards = 1 square rod
 160 square rods = 1 acre
 640 acres = 1 square mile

TEMPERATURE

Freezing, Fahrenheit scale = 32 degrees
 Freezing, celcius scale = 0 degrees
 Boiling, Fahrenheit scale = 212 degrees
 Boiling, celcius scale = 100 degrees

If any degree on the celcius scale, either above or below zero, be multiplied by 1.8, the result will, in either case, be the number of degrees above or below 32 degrees Fahrenheit.

TROY WEIGHT

24 grains = 1 pennyweight
 20 pennyweights = 1 ounce
 12 ounces = 1 pound

WEIGHT OF WATER

1 cubic centimeter = 1 gram or 0.035 ounce
 1 cubic inch = 0.5787 ounce
 1 cubic foot = 62.48 pounds
 1 U.S. gallon = 8.355 pounds
 1 British imperial gallon = 10 pounds
 32 cubic feet = 1 net ton (2,000 pounds)
 35.84 cubic feet = 1 long ton (2,240 pounds)
 1 net ton = 240 U.S. gallons
 1 long ton = 268 U.S. gallons

ENGLISH-METRIC EQUIVALENTS

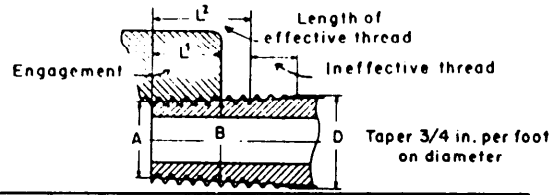
1 inch = 2.54 centimeters
 1 centimeter = 0.3937 inch
 1 meter = 39.37 inches
 1 kilometer = 0.62 mile
 1 quart = 0.946 liter
 1 U.S. gallon = 3.785 liters
 1 British gallon = 4.543 liters
 1 liter = 1.06 quarts
 1 pound = 0.454 kilogram
 1 kilogram = 2.205 pounds
 1 watt = 44.24 foot-pounds per minute
 1 horsepower = 33,000 foot-pounds per minute
 1 kilowatt = 1.34 horsepower

Table AII-7.—Screw Thread and Tap Drill Sizes (American National)

screw size	threads per inch		dimensions, inches				tap drill 75% full thread		body drill	decimal equiv.
	NC coarse thread	NF fine thread	major diameter	pitch diameter	single depth of thread	minor diameter	tap drill	decimal equiv.		
0		80	0.060	0.0519	0.00812	0.0438	3/64	0.0469	52	0.0635
1	64		0.073	0.0629	0.01015	0.0527	53	0.0595	47	0.0785
1		72	0.073	0.0640	0.00902	0.0550	53	0.0595	47	0.0785
2	56		0.086	0.0744	0.01160	0.0628	50	0.0700	42	0.0935
2		64	0.086	0.0759	0.01015	0.0657	50	0.0700	42	0.0935
3	48		0.099	0.0855	0.01353	0.0719	47	0.0785	37	0.1040
3		56	0.099	0.0874	0.01160	0.0758	45	0.0820	37	0.1040
4	40		0.112	0.0958	0.01624	0.0795	43	0.0890	31	0.1200
4		48	0.112	0.0985	0.01353	0.0849	42	0.0935	31	0.1200
5	40		0.125	0.1088	0.01624	0.0925	38	0.1015	29	0.1360
5		44	0.125	0.1102	0.01476	0.0955	37	0.1040	29	0.1360
6	32		0.138	0.1177	0.02030	0.0974	36	0.1065	27	0.1440
6		40	0.138	0.1218	0.01624	0.1055	33	0.1130	27	0.1440
8	32		0.164	0.1437	0.02030	0.1234	29	0.1360	18	0.1695
8		36	0.164	0.1460	0.01804	0.1279	29	0.1360	18	0.1695
10	24		0.190	0.1629	0.02706	0.1359	25	0.1495	9	0.1960
10		32	0.190	0.1697	0.02030	0.1494	21	0.1590	9	0.1960
12	24		0.216	0.1889	0.02706	0.1619	16	0.1770	2	0.2210
12		28	0.216	0.1928	0.02320	0.1696	14	0.1820	2	0.2210
1/4	20		0.2500	0.2175	0.03248	0.1850	7	0.2010		
1/4		28	0.2500	0.2268	0.02320	0.2036	3	0.2130		
5/16	18		0.3125	0.2764	0.03608	0.2403	F	0.2570		
5/16		24	0.3125	0.2854	0.02706	0.2584	I	0.2720		
3/8	16		0.3750	0.3344	0.04059	0.2938	5/16	0.3125		
3/8		24	0.3750	0.3479	0.02706	0.3209	Q	0.3320		
7/16	14		0.4375	0.3911	0.04639	0.3447	U	0.3680		
7/16		20	0.4375	0.4050	0.03248	0.3725	25/64	0.3906		
1/2	13		0.5000	0.4500	0.04996	0.4001	21/64	0.4219		
1/2		20	0.5000	0.4675	0.03248	0.4350	29/64	0.4531		
9/16	12		0.5625	0.5084	0.05413	0.4542	31/64	0.4844		
9/16		18	0.5625	0.5264	0.03608	0.4903	33/64	0.5156		
5/8	11		0.6250	0.5660	0.05905	0.5069	11/32	0.5313		
5/8		18	0.6250	0.5889	0.03608	0.5528	31/64	0.5781		
3/4	10		0.7500	0.6850	0.06495	0.6201	21/32	0.6562		
3/4		16	0.7500	0.7094	0.04059	0.6688	11/16	0.6875		
7/8	9		0.8750	0.8028	0.07217	0.7307	49/64	0.7656		
7/8		14	0.8750	0.8286	0.04639	0.7822	13/16	0.8125		
1	8		1.0000	0.9188	0.08119	0.8376	1/4	0.8750		
1		14	1.0000	0.9536	0.04639	0.9072	15/16	0.9375		
1 1/8	7		1.1250	1.0322	0.09279	0.9394	63/64	0.9844		
1 1/8		12	1.1250	1.0709	0.05413	1.0167	17/64	1.0469		
1 1/4	7		1.2500	1.1572	0.09279	1.0644	17/64	1.1094		
1 1/4		12	1.2500	1.1959	0.05413	1.1417	111/64	1.1719		
1 3/8	6		1.3750	1.2667	0.10825	1.1585	17/32	1.2188		
1 3/8		12	1.3750	1.3209	0.05413	1.2667	119/64	1.2969		
1 1/2	6		1.5000	1.3917	0.10825	1.2835	111/32	1.3438		
1 1/2		12	1.5000	1.4459	0.05413	1.3917	127/64	1.4219		
1 3/4	5		1.7500	1.6201	0.12990	1.4902	17/16	1.5625		
2	4 1/2		2.0000	1.8557	0.14434	1.7113	125/32	1.7813		

Table AII-8.—American National Pipe Thread

A = Pitch diameter of thread at end of pipe
 B = Pitch diameter of thread at gauging notch
 D = Outside diameter of pipe
 L¹ = Normal engagement by hand between
 external and internal thread



Size Inches	Threads per Inch	Pitch Diameter		Length		Pipe O.D. D Inches	Depth of Thread Inches	Tap Drills for Pipe Threads	
		A Inches	B Inches	L ² Inches	L ¹ Inches			Minor Diameter Small End of Pipe	Size Drill
1/8	27	.36351	.37476	.2639	.180	.405	.02963	.3339	R
1/4	18	.47739	.48989	.4018	.200	.540	.04444	.4329	3/16
3/8	18	.61201	.62701	.4078	.240	.675	.04444	.5676	23/64
1/2	14	.75843	.77843	.5337	.320	.840	.05714	.7013	23/32
3/4	14	.96768	.98887	.5457	.339	1.050	.05714	.9105	29/64
1	11 1/4	1.21363	1.23863	.6828	.400	1.315	.06957	1.1441	1 1/32
1 1/4	11 1/4	1.55713	1.58338	.7068	.420	1.660	.06957	1.4876	1 1/2
1 1/2	11 1/4	1.79609	1.82234	.7235	.420	1.900	.06957	1.7265	1 5/8
2	11 1/4	2.26902	2.29627	.7565	.436	2.375	.06957	2.1995	2 1/32
2 1/2	8	2.71953	2.76216	1.1375	.682	2.875	.10000	2.6195	2 3/8
3	8	3.34062	3.38850	1.2000	.766	3.500	.10000	3.2406	3 1/4
3 1/2	8	3.83750	3.88881	1.2500	.821	4.000	.10000	3.7375	3 3/4
4	8	4.33438	4.38712	1.3000	.844	4.500	.10000	4.2344	4 1/4

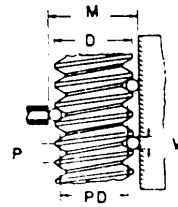
Table AII-9.—3-Wire Method of Measuring American National Standard Threads

$$M = D - (1.5166 \times P) =) 3 \times W$$

$$PD - M + \frac{.86603}{\text{No. of thds. per inch}} (3 \times W)$$

$$\text{To Check Angle } \frac{M_1 - M_2}{W_1 - W_2}$$

M = Measurement over best size wire.
 M₁ = Measurement over maximum size wire.
 M₂ = Measurement over minimum size wire.
 D = Outside Diameter of Thread.
 P.D. = Pitch Diameter.
 W = Diameter Best size wire.
 W₁ = Diameter maximum size wire.
 W₂ = Diameter minimum size wire.



0.57735 X pitch
 0.90 X pitch
 0.56 X pitch

No. Thds. per inch	Pitch Thds. per inch	Best Wire Size .57735 x Pitch	Maximum Wire Size	Minimum Wire Size
4	.250000	.144337	.225000	.140000
4 ½	.222222	.128300	.200000	.124444
5	.200000	.115470	.180000	.112000
5 ½	.181818	.104969	.163636	.101818
6	.166666	.096224	.149999	.093333
7	.142857	.082478	.128571	.080000
7 ½	.133333	.076979	.120000	.074666
8	.125000	.072168	.112500	.070000
9	.111111	.064149	.100000	.062222
10	.100000	.057735	.090000	.056000
11	.090999	.052486	.081818	.050909
11 ½	.086956	.050204	.078260	.048695
12	.083333	.048112	.075000	.046666
13	.076923	.044411	.069231	.043077
14	.071428	.041239	.064285	.040000
16	.062500	.036084	.056250	.035000
18	.055555	.032074	.050000	.031111
20	.050000	.028867	.045000	.028000
22	.046454	.026242	.040909	.025454
24	.041666	.024055	.037499	.023333
26	.038461	.022205	.034615	.021538
27	.037037	.024383	.033333	.022543
28	.035714	.020620	.032143	.020000
30	.033333	.019244	.030000	.018666
32	.031250	.018042	.028125	.017500
36	.027777	.016037	.024999	.015555
40	.025000	.014433	.022500	.014000
44	.022727	.013121	.020454	.014727
48	.020833	.012027	.018750	.011666
50	.020000	.011547	.018000	.011200
56	.017857	.010309	.016071	.010000

Table AII-10.—Diagonals of Squares and Hexagons



$$E = 1.4142 d$$

$$D = 1.1547 d$$

d	D	E	d	D	E	d	D	E
$\frac{1}{4}$	0.2886	0.3535	$1\frac{1}{4}$	1.4434	1.7677	$2\frac{5}{16}$	2.6702	3.2703
$\frac{3}{32}$	0.3247	0.3977	$1\frac{9}{32}$	1.4794	1.8119	$2\frac{3}{8}$	2.7424	3.3587
$\frac{1}{16}$	0.3608	0.4419	$1\frac{5}{16}$	1.5155	1.8561	$2\frac{7}{16}$	2.8145	3.4471
$1\frac{1}{32}$	0.3968	0.4861	$1\frac{11}{32}$	1.5516	1.9003	$2\frac{1}{2}$	2.8867	3.5355
$\frac{3}{8}$	0.4329	0.5303	$1\frac{3}{8}$	1.5877	1.9445	$2\frac{9}{16}$	2.9583	3.6239
$1\frac{1}{32}$	0.4690	0.5745	$1\frac{13}{32}$	1.6238	1.9887	$2\frac{5}{8}$	3.0311	3.7123
$\frac{7}{16}$	0.5051	0.6187	$1\frac{7}{16}$	1.6598	2.0329	$2\frac{11}{16}$	3.1032	3.8007
$1\frac{5}{32}$	0.5412	0.6629	$1\frac{5}{32}$	1.6959	2.0771	$2\frac{3}{4}$	3.1754	3.8891
$\frac{1}{2}$	0.5773	0.7071	$1\frac{1}{2}$	1.7320	2.1213	$2\frac{13}{16}$	3.2476	3.9794
$1\frac{7}{32}$	0.6133	0.7513	$1\frac{17}{32}$	1.7681	2.1655	$2\frac{7}{8}$	3.3197	4.0658
$\frac{9}{16}$	0.6494	0.7955	$1\frac{9}{16}$	1.8042	2.2097	$2\frac{15}{16}$	3.3919	4.1542
$1\frac{9}{32}$	0.6855	0.8397	$1\frac{19}{32}$	1.8403	2.2539	3	3.4641	4.2426
$\frac{5}{8}$	0.7216	0.8839	$1\frac{5}{8}$	1.8764	2.2981	$3\frac{1}{16}$	3.5362	4.3310
$2\frac{1}{32}$	0.7576	0.9281	$1\frac{21}{32}$	1.9124	2.3423	$3\frac{1}{8}$	3.6084	4.4194
$1\frac{1}{16}$	0.7937	0.9723	$1\frac{11}{16}$	1.9485	2.3865	$3\frac{3}{16}$	3.6806	4.5078
$2\frac{3}{32}$	0.8298	1.0164	$1\frac{23}{32}$	1.9846	2.4306	$3\frac{1}{4}$	3.7527	4.5962
$\frac{3}{4}$	0.8659	1.0606	$1\frac{3}{4}$	2.0207	2.4708	$3\frac{5}{16}$	3.8249	4.6846
$2\frac{5}{32}$	0.9020	1.1048	$1\frac{25}{32}$	2.0568	2.5190	$3\frac{7}{8}$	3.8971	4.7729
$1\frac{3}{16}$	0.9380	1.1490	$1\frac{13}{16}$	2.0929	2.5632	$3\frac{7}{16}$	3.9692	4.8613
$2\frac{7}{32}$	0.9741	1.1932	$1\frac{27}{32}$	2.1289	2.6074	$3\frac{1}{2}$	4.0414	4.9497
$\frac{7}{8}$	1.0102	1.2374	$1\frac{7}{8}$	2.1650	2.6516	$3\frac{9}{16}$	4.1136	5.0381
$2\frac{9}{32}$	1.0463	1.2816	$1\frac{29}{32}$	2.2011	2.6958	$3\frac{5}{8}$	4.1857	5.1265
$1\frac{5}{16}$	1.0824	1.3258	$1\frac{15}{16}$	2.2372	2.7400	$3\frac{11}{16}$	4.2579	5.2149
$3\frac{1}{32}$	1.1184	1.3700	$1\frac{31}{32}$	2.2733	2.7842	$3\frac{3}{4}$	4.3301	5.3033
1	1.1547	1.4142	2	2.3094	2.8284	$3\frac{13}{16}$	4.4023	5.3917
$1\frac{1}{32}$	1.1907	1.4584	$2\frac{1}{32}$	2.3453	2.8726	$3\frac{7}{8}$	4.4744	5.4801
$1\frac{1}{16}$	1.2268	1.5026	$2\frac{1}{16}$	2.3815	2.9168	$3\frac{15}{16}$	4.5466	5.5684
$1\frac{3}{32}$	1.2629	1.5468	$2\frac{3}{32}$	2.4176	2.9610	4	4.6188	5.6568
$1\frac{1}{8}$	1.2990	1.5910	$2\frac{1}{8}$	2.4537	3.0052	$4\frac{1}{8}$	4.7631	5.8336
$1\frac{5}{32}$	1.3351	1.6352	$2\frac{5}{32}$	2.4898	3.0494	$4\frac{1}{4}$	4.9074	6.0104
$1\frac{3}{16}$	1.3712	1.6793	$2\frac{3}{16}$	2.5259	3.0936	$4\frac{3}{8}$	5.0518	6.1872
$1\frac{7}{32}$	1.4073	1.7235	$2\frac{1}{4}$	2.5981	3.1820	$4\frac{1}{2}$	5.1961	6.3639

Table AII-11.—Circles

Circumference of a circle = diameter \times 3.1416

Diameter of a circle = circumference \times .31831

Area of a circle = the square of the diameter \times 0.7854

Surface of a ball (sphere) = the square of the diameter \times 3.1416

Side of a square inscribed in a circle = diameter \times 0.70711

Diameter of a circle to circumscribe a square = one side \times 1.4142

Cubic inches (volume) in a ball = cube of the diameter \times 0.5236

When doubled, the diameter of a pipe increases its capacity four times

Radius of a circle \times 6.283185 = circumference

Square of the circumference of a circle \times 0.07958 = area

1/2 circumference of a circle \times 1/2 its diameter = area

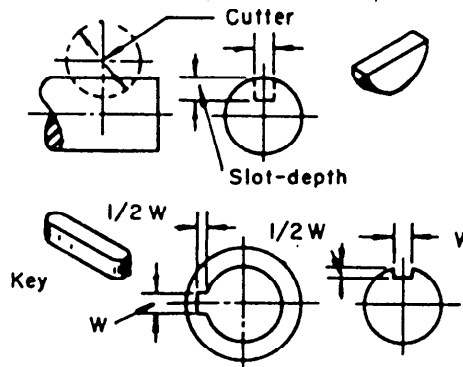
Circumference of a circle \times .159155 = radius

Square root of the area of a circle \times 0.56419 = radius

Square root of the area of a circle \times 1.12838 = diameter

Table AII-12.—Keyway Dimensions

shaft dia	square keyways	Woodruff keyways*			
		key	thickness	cutter dia	slot depth
0.500	$\frac{1}{8} \times \frac{1}{16}$	404	0.1250	0.500	0.1405
0.562	$\frac{1}{8} \times \frac{1}{16}$	404	0.1250	0.500	0.1405
0.625	$\frac{5}{32} \times \frac{5}{64}$	505	0.1562	0.625	0.1669
0.688	$\frac{3}{16} \times \frac{3}{32}$	606	0.1875	0.750	0.2193
0.750	$\frac{3}{16} \times \frac{3}{32}$	606	0.1875	0.750	0.2193
0.812	$\frac{3}{16} \times \frac{3}{32}$	606	0.1875	0.750	0.2193
0.875	$\frac{7}{32} \times \frac{7}{64}$	607	0.1875	0.875	0.2763
0.938	$\frac{1}{4} \times \frac{1}{8}$	807	0.2500	0.875	0.2500
1.000	$\frac{1}{4} \times \frac{1}{8}$	808	0.2500	1.000	0.3130
1.125	$\frac{5}{16} \times \frac{5}{32}$	1009	0.3125	1.125	0.3228
1.250	$\frac{5}{16} \times \frac{5}{32}$	1010	0.3125	1.250	0.3858
1.375	$\frac{3}{8} \times \frac{3}{16}$	1210	0.3750	1.250	0.3595
1.500	$\frac{3}{8} \times \frac{3}{16}$	1212	0.3750	1.500	0.4535
1.625	$\frac{3}{8} \times \frac{3}{16}$	1212	0.3750	1.500	0.4535
1.750	$\frac{7}{16} \times \frac{7}{32}$				
1.875	$\frac{1}{2} \times \frac{1}{4}$				
2.000	$\frac{1}{2} \times \frac{1}{4}$				
2.250	$\frac{5}{8} \times \frac{5}{16}$				
2.500	$\frac{5}{8} \times \frac{5}{16}$				
2.750	$\frac{3}{4} \times \frac{3}{8}$				
3.000	$\frac{3}{4} \times \frac{3}{8}$				
3.250	$\frac{3}{4} \times \frac{3}{8}$				
3.500	$\frac{3}{8} \times \frac{7}{16}$				
4.000	$1 \times \frac{1}{2}$				

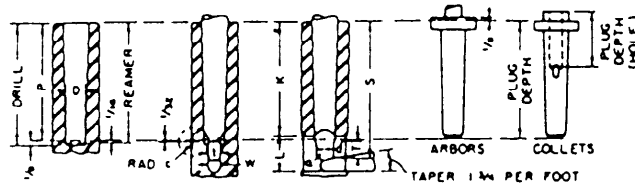


*The depth of a Woodruff keyway is measured from the edge of the slot.

Table AII-13.—Taper Per Foot and Corresponding Angles

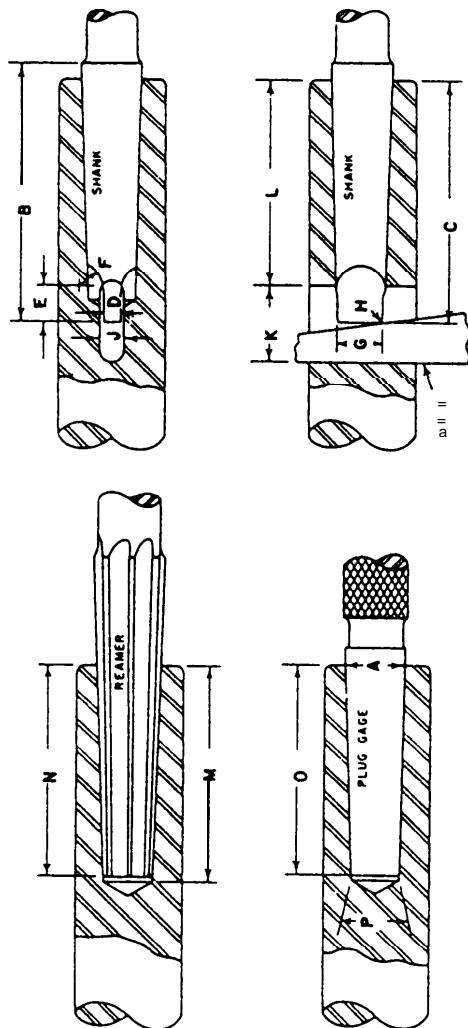
taper per foot	included angle		angle with center line		taper per foot	included angle		angle with center line		taper per foot	included angle		angle with center line	
	deg.	min.	sec.	deg.		deg.	min.	sec.	deg.		deg.	min.	sec.	deg.
$\frac{1}{4}$	0	4	28	0	$\frac{1}{2}$	4	37	20	2	$\frac{3}{4}$	17	45	40	8
$\frac{1}{32}$	0	8	58	0	1	4	46	18	2	$\frac{1}{2}$	18	20	34	9
$\frac{1}{16}$	0	17	54	0	$\frac{1}{8}$	5	4	12	2	$\frac{1}{4}$	18	55	28	9
$\frac{3}{32}$	0	26	52	0	$\frac{1}{4}$	5	21	44	2	$\frac{1}{8}$	19	30	18	9
$\frac{1}{8}$	0	35	48	0	$\frac{3}{16}$	5	39	54	2	$\frac{1}{4}$	20	5	2	10
$\frac{3}{16}$	0	44	44	0	$\frac{1}{2}$	5	57	48	2	$\frac{3}{8}$	20	39	44	10
$\frac{1}{16}$	0	53	44	0	$\frac{5}{16}$	6	15	38	3	$\frac{1}{2}$	21	14	2	10
$\frac{1}{32}$	1	2	34	0	$\frac{3}{8}$	6	33	26	3	$\frac{3}{8}$	21	48	54	10
$\frac{1}{4}$	1	11	36	0	$\frac{7}{16}$	6	51	20	3	$\frac{1}{2}$	22	23	22	11
$\frac{3}{32}$	1	20	30	0	$\frac{1}{2}$	7	9	10	3	$\frac{1}{4}$	22	57	48	11
$\frac{1}{16}$	1	29	30	0	$\frac{9}{16}$	7	26	58	3	$\frac{3}{8}$	23	32	12	11
$\frac{1}{32}$	1	38	22	0	$\frac{1}{2}$	7	44	48	3	$\frac{1}{2}$	24	6	28	12
$\frac{1}{8}$	1	47	24	0	$\frac{11}{16}$	8	2	38	4	$\frac{1}{4}$	24	40	42	12
$\frac{3}{32}$	1	56	24	0	$\frac{1}{2}$	8	20	26	4	$\frac{1}{8}$	25	14	48	12
$\frac{1}{16}$	2	5	18	1	$\frac{13}{16}$	8	38	16	4	$\frac{1}{4}$	25	48	48	12
$\frac{3}{32}$	2	14	16	1	$\frac{1}{2}$	8	56	2	4	$\frac{3}{8}$	26	22	52	13
$\frac{1}{16}$	2	23	10	1	$\frac{15}{16}$	9	13	50	4	$\frac{1}{2}$	26	56	46	13
$\frac{1}{32}$	2	32	4	1	2	9	31	36	4	$\frac{3}{8}$	27	30	34	13
$\frac{3}{16}$	2	41	4	1	$\frac{1}{2}$	10	7	10	5	$\frac{1}{4}$	28	4	2	14
$\frac{1}{8}$	2	50	2	1	$\frac{3}{8}$	10	42	42	5	$\frac{1}{8}$	28	37	58	14
$\frac{3}{32}$	2	59	2	1	$\frac{1}{2}$	11	18	10	5	$\frac{3}{8}$	29	11	34	14
$\frac{1}{16}$	3	7	56	1	$\frac{5}{8}$	11	53	36	5	$\frac{1}{2}$	29	45	18	14
$\frac{1}{32}$	3	16	54	1	$\frac{3}{4}$	12	29	2	6	$\frac{3}{8}$	30	18	26	15
$\frac{3}{16}$	3	25	50	1	$\frac{1}{2}$	13	4	24	6	$\frac{1}{4}$	30	51	48	15
$\frac{1}{8}$	3	34	44	1	$\frac{7}{8}$	13	39	42	6	$\frac{1}{8}$	31	25	2	15
$\frac{3}{32}$	3	43	44	1	3	14	15	0	7	$\frac{3}{8}$	31	58	10	15
$\frac{1}{16}$	3	52	38	1	$\frac{1}{2}$	14	50	14	7	$\frac{1}{2}$	32	31	12	16
$\frac{1}{32}$	4	1	36	2	$\frac{3}{8}$	15	25	24	7	$\frac{3}{8}$	33	4	8	16
$\frac{3}{16}$	4	10	32	2	$\frac{1}{2}$	16	0	34	8	$\frac{1}{4}$	33	36	40	16
$\frac{1}{8}$	4	19	34	2	$\frac{5}{8}$	16	35	40	8	$\frac{1}{8}$	34	9	50	17
$\frac{3}{32}$	4	28	24	2	$\frac{3}{4}$	17	10	40	8	$\frac{1}{2}$	34	20	4	17

Table AII-14.—Taper in Inches (Brown and Sharpe)



taper no.	taper per foot	plug dia. at small end, D	plug depth (P)			keyway from end of spindle, K	shank depth, S	keyway length, L	keyway width, W	arbor tongue length, T	arbor tongue dia., d	arbor tongue thickness, t	tongue circle radius, c	tongue radius, a	limit for tongue to project through test tool
			B & S stand.	for mill mach.	misc.										
1	0.50200	0.20000	1 1/16			1 1/16	1 1/16	1/2	0.135	1/16	0.170	1/8	1/16	0.030	0.003
2	0.50200	0.25000	1 1/16			1 1/16	1 1/2	1/2	0.166	1/8	0.220	3/32	1/16	0.030	0.003
3	0.50200	0.31250	1 1/2	2	1 1/4	1 1/32	1 1/8	3/8	0.197	1/16	0.282	1/16	1/16	0.040	0.003
						1 1/32	2 1/8	3/8	0.197	1/16	0.282	1/16	1/16	0.040	0.003
						1 1/32	2 1/8	3/8	0.197	1/16	0.282	1/16	1/16	0.040	0.003
4	0.50240	0.35000	1 1/16	1 1/4		1 1/4	1 1/32	1 1/16	0.228	1 1/32	0.320	1/32	1/16	0.050	0.003
						1 1/4	2 1/32	1 1/16	0.228	1 1/32	0.320	1/32	1/16	0.050	0.003
5	0.50160	0.45000	2 1/4	3	2	1 1/16	2 1/16	1/2	0.260	1/8	0.420	1/8	1/16	0.060	0.003
						1 1/16	2 1/16	1/2	0.260	1/8	0.420	1/8	1/16	0.060	0.003
						2 1/16	2 1/16	1/2	0.260	1/8	0.420	1/8	1/16	0.060	0.003
6	0.50329	0.50000	2 1/4			2 1/4	2 1/8	1/2	0.291	1/8	0.460	3/32	1/16	0.060	0.005
7	0.50147	0.60000	2 3/4	3	2 1/2	2 1/32	3 1/32	1 1/16	0.322	1 1/32	0.560	1/16	1/8	0.070	0.005
						2 1/32	3 1/32	1 1/16	0.322	1 1/32	0.560	1/16	1/8	0.070	0.005
						2 1/32	3 1/32	1 1/16	0.322	1 1/32	0.560	1/16	1/8	0.070	0.005
8	0.50100	0.75000	3 1/8			3 1/8	4 1/8	1	0.353	1/2	0.710	1 1/32	1/8	0.080	0.005
9	0.50085	0.90010	4 1/4	4		3 1/2	4 1/2	1 1/8	0.385	1/16	0.860	3/8	1/16	0.100	0.005
						4 1/8	4 1/8	1 1/8	0.385	1/16	0.860	3/8	1/16	0.100	0.005
10	0.51612	1.04485	5	5 1/16	6 1/32	4 1/32	5 1/32	1 1/16	0.447	1 1/32	1.010	1/16	1/16	0.110	0.005
						5 1/32	6 1/32	1 1/16	0.447	1 1/32	1.010	1/16	1/16	0.110	0.005
						6 1/16	6 1/16	1 1/16	0.447	1 1/32	1.010	1/16	1/16	0.110	0.005
11	0.50100	1.24995	5 1/16	6 1/4	6 1/4	5 1/32	6 1/32	1 1/16	0.447	1 1/32	1.210	1/16	1/2	0.130	0.005
						6 1/32	7 1/32	1 1/16	0.447	1 1/32	1.210	1/16	1/2	0.130	0.005
12	0.49973	1.50010	7 1/4	7 1/4	6 1/4	6 1/16	7 1/16	1 1/2	0.510	1/2	1.460	1/2	1/2	0.150	0.005
13	0.50020	1.75005	7 3/4			7 1/16	8 1/16	1 1/2	0.510	1/2	1.710	1/2	3/4	0.170	0.010
14	0.50000	2.00000	8 1/4	8 1/4		8 1/32	9 1/32	1 1/16	0.572	1 1/32	1.960	1/16	1/2	0.190	0.010
15	0.50000	2.25000	8 3/4			8 1/32	9 1/32	1 1/16	0.572	1 1/32	2.210	1/16	1/2	0.210	0.010
16	0.50000	2.50000	9 1/4			9	10 1/4	1 1/2	0.635	1 1/16	2.450	1/2	1	0.230	0.010
17	0.50000	2.75000	9 3/4												
18	0.50000	3.00000	10 1/4												

ANSI-A11-15.1-1 Standard Tapers (Morse)

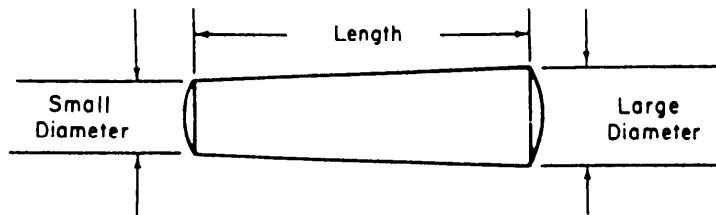


taper no.	diameter		shank		reamed hole depth, N	stan. plug depth, O	tang					tang slot		end of socket to tang slot, L	taper per inch	taper per foot	drift no.
	plug at small end, P	gage line, A	whole length, B	depth, C	drilled hole depth, M		thick-ness, D	length, E	radius, F	dia., G	radius, H	width, J	length, K				
0	0.252	0.356	2 1/32	2 1/32	2 1/16	2	0.156	1/4	3/32	1 1/4	3/4	0.166	3/16	1 1/16	0.052000	0.62400	0
1	0.369	0.475	2 7/16	2 1/16	2 1/16	2 1/2	0.203	1/2	3/16	1 1/2	3/4	0.213	1/2	2 1/16	0.049812	0.59858	1
2	0.572	0.700	3 3/8	2 1/16	2 1/16	2 3/4	0.250	3/4	1/4	1 3/2	1 1/2	0.260	1/2	2 1/2	0.049551	0.59941	2
3	0.778	0.938	3 3/4	3 1/16	3 1/16	3 1/2	0.312	1 1/4	3/32	2 1/2	1 3/4	0.322	1 1/4	3 1/16	0.050196	0.60235	3
4	1.020	1.231	4 1/2	4 3/8	4 1/16	4 1/2	0.469	1 3/4	3/16	3 1/2	2 1/2	0.479	1 1/2	3 3/4	0.051938	0.62326	4
5	1.475	1.748	6 1/2	5 3/8	5 1/16	5 1/2	0.625	2 1/4	1/2	4 1/2	3 1/2	0.635	1 3/4	4 9/16	0.052626	0.63151	5
6	2.116	2.494	8 1/16	8 1/4	7 13/32	7 1/2	0.750	3 1/4	1/2	6 1/2	4 1/2	0.760	2 1/4	7	0.052137	0.62565	6
7	2.750	3.270	11 1/2	11 1/4	10 1/2	10	1.125	4 1/4	3/4	8 1/2	5 1/2	1.135	3 1/4	9 1/2	0.052000	0.62400	7

* Dimensions agree essentially with those of the American Standard on Machine Tapers

+ The No. 5 drift will also eject No. 6 taper shank tools

Table AII-16.—Drill Sizes for Taper Pins



Drill size should be approximately
0.005 smaller than small diameter

Taper = 1/4 in. per foot

Small diameter = large diameter - length X 0.02083

NUMBER	7/0	6/0	5/0	4/0	3/0	2/0	0	1	2	3	4	5	6	7	8	9	10	11	
DIAMETER AT LARGE																			
END	0.0025	0.0070	0.0094	0.0109	0.0125	0.0141	0.0156	0.0172	0.0193	0.0219	0.0250	0.0289	0.0341	0.409	0.492	0.591	0.707	0.857	1/4
LENGTH																			
	DIAMETER OF SMALL END OF PIN AND DRILL SIZE																		LENGTH
1/4	0.0573	0.0720																	1/4
	54	50																	
1/4	0.0547	0.0702	0.0862																1/4
	56	51	45																
1/4	0.0521	0.0676	0.0836	0.0906	0.1146	0.1306	0.1458	0.1616											1/4
	58	52	46	41	34	30	1/4	1/2											
1/4	0.0495	0.0650	0.0810	0.0960	0.1120	0.1280	0.1430	0.1590											1/4
	58	52	1/4	1/2	1/4	1/2	1/4	23											
1/4	0.0469	0.0624	0.0784	0.0934	0.1094	0.1254	0.1404	0.1564	0.1774	0.2034	0.2344								1/4
	56	53	48	43	36	31	29	24	11/4	8	1								
1/4		0.0598	0.0758	0.0908	0.1068	0.1228	0.1378	0.1538	0.1748	0.2008	0.2318								1/4
		54	49	43	37	31	29	25	18	9	1								
1		0.0572	0.0732	0.0882	0.1042	0.1202	0.1352	0.1512	0.1722	0.1982	0.2292	0.2602	0.3202						1
		54	50	44	38	32	30	26	19	10	2	0	0						
1 1/4				0.0856	0.1016	0.1176	0.1326	0.1486	0.1696	0.1956	0.2266	0.2656	0.3176						1 1/4
				45	39	33	30	27	19	11	2	0	1/4						
1 1/4				0.0830	0.0990	0.1150	0.1300	0.1460	0.1670	0.1930	0.2240	0.2630	0.3150	0.3830					1 1/4
				46	41	33	1/4	1/4	20	1/4	1/2	F	M	1/4					
1 1/4				0.0984	0.1124	0.1274	0.1434	0.1644	0.1904	0.2214	0.2604	0.3124	0.3804						1 1/4
				1/2	1/4	1/4	1/4	20	1/4	3	F	M	1/4						
1 1/4				0.0938	0.1098	0.1248	0.1408	0.1618	0.1878	0.2188	0.2578	0.3098	0.3778	0.4608					1 1/4
				43	36	31	28	1/2	14	3	1/4	M	U	1/4					
1 1/4				0.1045	0.1195	0.1355	0.1565	0.1825	0.2135	0.2525	0.3045	0.3725	0.4555						1 1/4
				58	52	30	24	18	4	D	1/4	U	1/4						
2				0.0993	0.1143	0.1303	0.1513	0.1773	0.2203	0.2473	0.2993	0.3673	0.4503	0.5494					2
				41	34	1/4	26	11/4	11/4	C	M	11/4	11/4	11/4					
2 1/4							0.1291	0.1461	0.1721	0.2031	0.2421	0.2941	0.3621	0.4451	0.5442				2 1/4
							31	27	18	8	B	L	T	1/4	1/4				
2 1/4							0.1199	0.1409	0.1669	0.1979	0.2369	0.2889	0.3569	0.4399	0.5390	0.6540			2 1/4
							32	29	20	10	11/4	1/2	S	11/4	11/4	11/4			
2 1/4							0.1357	0.1617	0.1927	0.2317	0.2837	0.3517	0.4347	0.5338	0.6488				2 1/4
							30	1/2	1/4	1	J	11/4	11/4	11/4	11/4				

Table AII-16.—Drill Sizes for Taper Pins—Continued

NUMBER	7/0	6/0	5/0	4/0	3/0	2/0	0	1	2	3	4	5	6	7	8	9	10	11	
DIAMETER AT LARGE END	0.0625	0.078	0.094	0.109	0.125	0.141	0.156	0.172	0.193	0.219	0.250	0.289	0.341	0.409	0.492	0.591	0.707	0.857	¾
LENGTH	DIAMETER OF SMALL END OF PIN AND DRILL SIZE																		LENGTH
3									0.1305	0.1565	0.1875	0.2265	0.2785	0.3465	0.4295	0.5285	0.6435	0.7975	3
									30	24	14	2	1	R	11/64	13/64	¾	15/32	
3¼									0.1823	0.2213	0.2733	0.3413	0.4243	0.5233	0.6383	0.7923			3¼
									16	1/32	17/64		Q	2	13/64	¾	15/32		
3½									0.1771	0.2161	0.2681	0.3361	0.4191	0.5181	0.6331	0.7871			3½
									11/64	3	G		Q	13/32	½	¾	15/32		
3¾											0.2629	0.3309	0.4139	0.5129	0.6279	0.7819			3¾
													F	11/64	13/32	½	15/64	45/64	
4													0.2577	0.3257	0.4087	0.5077	0.6227	0.7767	4
													¾	P	Y	½	15/64	45/64	
4¼													0.3205	0.4035	0.5025	0.6175	0.7715		4¼
													O	X	11/64	15/64	45/64		
4½													0.3153	0.3983	0.4973	0.6123	0.7663		4½
													5/16	15/64	15/64	15/32	¾		
4¾														0.3931	0.4921	0.6071	0.7611		4¾
														W	11/64	15/32	¾		
5														0.3879	0.4869	0.6019	0.7559		5
														¾	15/32	15/32	¾		
5¼															0.4817	0.5967	0.7507		5¼
															15/32	17/64	47/64		
5½															0.4765	0.5915	0.7455		5½
															15/32	17/64	47/64		
5¾															0.4713	0.5863	0.7403		5¾
															17/64	17/64	47/64		
6															0.4660	0.5810	0.7350		6
															15/16	5/8	15/16		
6¼																0.5750	0.7290		6¼
																5/8	11/8		
6½																0.5706	0.7246		6½
																5/8	11/8		
6¾																0.5654	0.7194		6¾
																11/8	45/64		
7																0.5602	0.7142		7
																15/16	45/64		
7¼																	0.7090		7¼
																	45/64		
7½																	0.7038		7½
																	11/8		

APPENDIX III

FORMULAS FOR SPUR GEARING

Having	To Get	Rule	Formula
Diametral pitch	Circular pitch	Divide 3.1416 by the diametral pitch.	$CP = \frac{3.1416}{DP}$
Pitch diameter and number of teeth	Circular pitch	Divide the pitch diameter by the product of 0.3183 and the number of teeth.	$PD = \frac{OD}{0.3183 NT}$
Outside diameter and number of teeth	Circular pitch	Divide the outside diameter by the product of 0.3183 and the number of teeth plus 2.	$CP = \frac{OD}{0.3183 NT + 2}$
Number of teeth and circular pitch	Pitch diameter	The product of the number of teeth, the circular pitch, and 0.3183.	$PD = 0.3183 CP NT$
Number of teeth and outside diameter	Pitch diameter	Divide the product of the number of teeth and the outside diameter by the number of teeth plus 2.	$PD = \frac{NT OD}{NT + 2}$
Outside diameter and circular pitch	Pitch diameter	Subtract from the outside diameter the product of the circular pitch and 0.6366.	$PD = OD - 0.6366 CP$
Addendum and number of teeth	Pitch diameter	Multiply the number of teeth by the addendum.	$PD = NT ADD$
Number of teeth and circular pitch	Outside diameter	The product of the number of teeth plus 2, the circular pitch, and 0.3183.	$OD = (NT + 2) 0.3183 CP$
Pitch diameter and circular pitch	Outside diameter	Add to the pitch diameter the product of the circular pitch and 0.6366.	$OD = PD + 0.6366 CP$
Number of teeth and addendum	Outside diameter	Multiply the addendum by the number of teeth plus 2.	$OD = (NT + 2) ADD$
Pitch diameter and circular pitch	Number of teeth	Divide the product of the pitch diameter and 3.1416 by the circular pitch.	$NT = \frac{3.1416 PD}{CP}$
Circular pitch	Chordal thickness	One-half the circular pitch.	$(t_c) = \frac{CP}{2}$

Having	To Get	Rule	Formula
Circular pitch	Addendum	Multiply the circular pitch by 0.3183.	$ADD = 0.3183 CP$
Circular pitch	Working depth	Multiply the circular pitch by 0.6366.	$WKD = 0.6366 CP$
Circular pitch	Whole depth	Multiply the circular pitch by 0.6866.	$WD = 0.6866 CP$
Circular pitch	Clearance	Multiply the circular pitch by 0.05.	$CL = 0.05 CP$
Circular pitch	Diametral pitch	Divide 3.1416 by the circular pitch.	$DP = \frac{3.1416}{CP}$
Pitch diameter and number of teeth	Diametral pitch	Divide the number of teeth by the pitch diameter.	$DP = \frac{NT}{PD}$
Pitch diameter of gear pinion	Center distance	Add pitch diameter of gear (PD_g) to pitch diameter of pinion (PD_p) and divide by 2.	$C = \frac{PD_g + PD_p}{2}$
Outside diameter and number of teeth	Diametral pitch	Divide the number of teeth plus 2 by the outside diameter.	$DP = \frac{NT + 2}{OD}$
Number of teeth and diametral pitch	Pitch diameter	Divide the number of teeth by the diametral pitch.	$PD = \frac{NT}{DP}$
Outside diameter and diametral pitch	Pitch diameter	Subtract from the outside diameter the quotient of 2 divided by the diametral pitch.	$PD = OD - \frac{2}{DP}$
Number of teeth and diametral pitch	Outside diameter	Divide the number of teeth plus 2 by the diametral pitch.	$OD = \frac{NT + 2}{DP}$
Pitch diameter and diametral pitch	Outside diameter	Add to the pitch diameter the quotient of 2 divided by the diametral pitch.	$OD = PD + \frac{2}{DP}$
Pitch diameter and number of teeth	Outside diameter	Divide the number of teeth plus 2 by the quotient of the number of teeth divided by pitch diameter.	$OD = NT + 2 + \frac{NT}{PD}$
Pitch diameter and diametral pitch	Number of teeth	Multiply the pitch diameter by the diametral pitch.	$NT = PD DP$

Having	To Get	Rule	Formula
Outside diameter and the diametral pitch	Number of teeth	Multiply the outside diameter by the diametral pitch and subtract 2.	$NT = OD DP - 2$
Diametral pitch	Chordal thickness	Divide 1.5708 by the diametral pitch.	$t_c = \frac{1.5708}{DP}$
Diametral pitch	Addendum	Divide 1 by the diametral pitch.	$ADD = \frac{1}{DP}$
Diametral pitch	Working depth	Divide 2 by the diametral pitch.	$WKD = \frac{2}{DP}$
Diametral pitch	Whole depth	Divide 2.157 by the diametral pitch.	$WD = \frac{2.157}{DP}$
Diametral pitch	Clearance	Divide 0.157 by the diametral pitch.	$CL = \frac{0.157}{DP}$

APPENDIX IV

DERIVATION OF FORMULAS FOR DIAMETRAL PITCH SYSTEM

1. TOOTH ELEMENTS based on a No. 1 diametral pitch gear (fig. AIV-1)

a. Addendum (ADD)—.000

(1) The distance from the top of the tooth to the pitch line.

b. Circular Pitch (CP)—3.1416

(1) The length of an arc equal to the circumference of a 1-inch circle, covers one tooth and one space on the pitch circle.

(2) Measure the circular pitch on the pitch line. If you could draw a circle inside the tooth using the 1-inch addendum as the diameter, the circumference of the circle would be 3.1416. Using your imagination, break the circle at one point on the circumference, imagining the circumference is a string. Lay the imaginary string on the pitch line at one side of the tooth. Stretch the other end as far as possible on the pitch line; it will stretch to a corresponding point on the next adjacent tooth on the pitch line.

c. Circular Thickness (CT)—1.5708

(1) One-half of the circular pitch, measured at the pitch line.

d. Clearance (CL)—0.15708

(1) One-tenth of the chordal thickness; move decimal one place to the left.

e. Dedendum (DED)—1.15708

(1) The sum of an addendum plus a clearance.

(2) $1.000 - \text{ADD}$

$\frac{0.1570}{1.1570} - \text{CL}$

$1.1570 - \text{DED}$

f. Working Depth (WKD)—2.000

(1) The sum of two addendums.

(2) $1.000 - \text{ADD}$

$\frac{+1.000}{2.000} - \text{ADD}$

$2.000 - \text{WKD}$

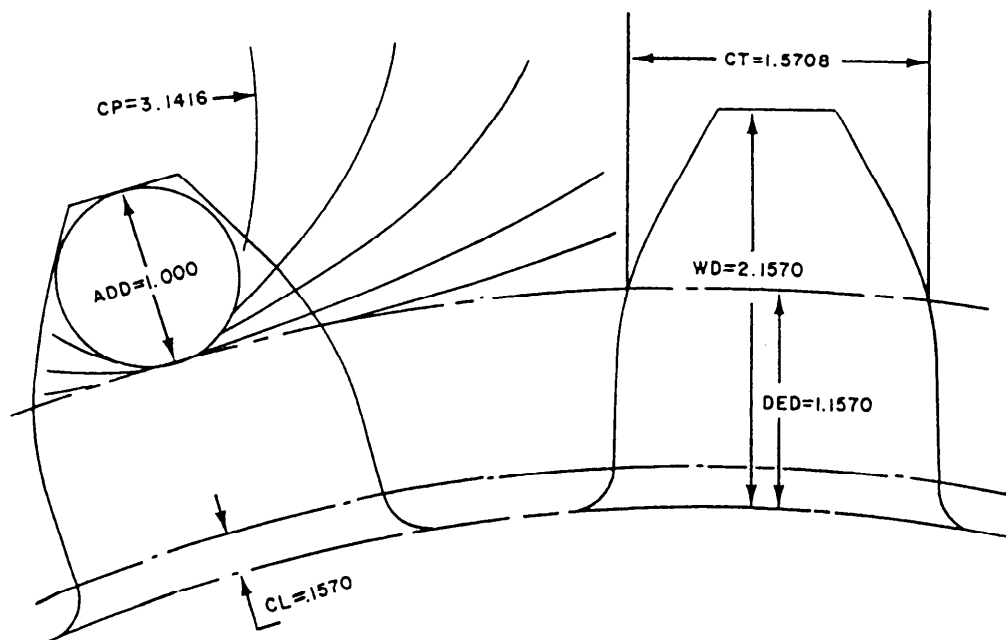


Figure AIV-1.—Tooth elements on a No. 1 diametral pitch gear.

g. Whole Depth (WD)–2.15708

(1) The sum of an addendum and a dedendum.

$$\begin{aligned} (2) & 1.0000 - \text{ADD} \\ & + 1.1570 - \text{DED} \\ & 2.1570 - \text{WD} \end{aligned}$$

h. Diametral Pitch (DP)

(1) The ratio of the number of teeth per inch of pitch diameter.

$$(2) \frac{NT}{PD} = DP$$

i. Chordal Addendum– a_c

(1) The distance from the top of a gear tooth to a chord subtending (extending under) the intersections of the tooth thickness arc and the sides of the tooth.

$$(2) a_c = \text{ADD} + \frac{(CT)^2}{4(PD)}$$

j. Chordal Thickness– t_c

(1) The thickness of the tooth, measured at the pitch circle.

$$t_c = PD \sin \frac{90^\circ}{N}$$

2. GEAR ELEMENTS

a. Number of Teeth (NT)

(1) Connecting link between the tooth elements and gear elements.

(2) Number of teeth in the gear

$$(3) \frac{PD}{\text{ADD}} = NT$$

b. Pitch Diameter (PD)

(1) Diameter of the pitch circle.

(2) For every tooth in the gear there is an addendum on the pitch diameter.

$$(3) \text{ADD} \times NT = PD$$

c. Outside Diameter (OD).

(1) The diameter of the gear.

(2) Since there is an addendum on the pitch diameter for each tooth, the two elements are directly related. Therefore, the outside diameter is simply the pitch diameter plus two addendums, or simulated teeth. The formulas read:

$$(a) \text{ADD} \times NT = PD$$

$$(b) \text{ADD} \times (NT + 2) = OD$$

$$(c) PD + 2\text{ADD} = OD$$

d. Linear Pitch (LP)

(1) The linear pitch is the same as the circular pitch except that it is the lineal measurement of pitch on a gear rack

$$(2) \text{CP} = \text{LP}$$

(3) Figure AIV-2 illustrates linear pitch.

3. GEAR AND TOOTH ELEMENT RELATIONSHIP

<u>TOOTH</u>	<u>GEAR</u>
a. ADD	a. PD
b. DED	b. OD
c. CP	c. a_c
d. CT	d. t_c
e. WD	
f. CL	
g. DP	

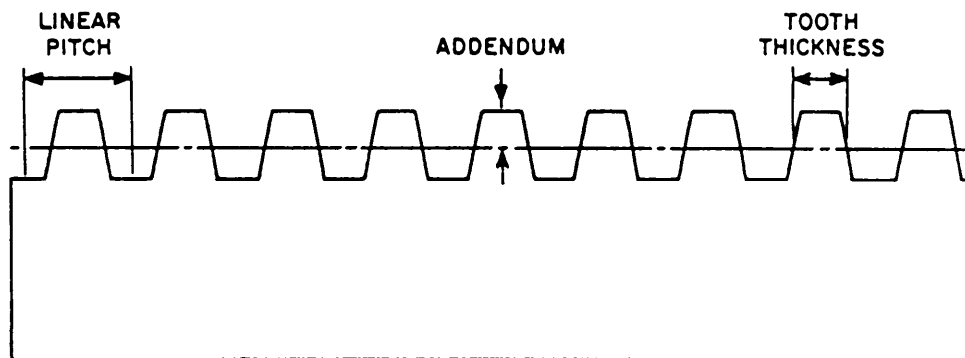


Figure AIV-2.–Linear pitch.

(1) NT is the connecting link between tooth elements and gear elements.

(2) To completely calculate a gear, one tooth and one gear element must be known.

(3) For every tooth in the gear there is a circular pitch on the pitch circle.

(4) For every tooth in the gear there is an addendum on the pitch diameter.

FORMULAS

$$1. ADD = \frac{1.000}{DP}$$

$$2. CP = \frac{3.1416}{DP}$$

$$3. CT = \frac{1.5708}{DP}$$

$$4. CL = \frac{0.15708}{DP}$$

$$5. DED = \frac{1.15708}{DP}$$

$$6. WKD = \frac{2.000}{DP}$$

$$7. WD = \frac{2.15708}{DP}$$

$$8. DP = \frac{NT}{PD} \text{ or transpose any other formula with DP involved.}$$

$$9. NT = \frac{PD}{ADD}$$

$$10. PD = ADD \times NT$$

$$11. OD = ADD \times (NT + 2)$$

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INDEX

A

- Adjustable gauges, 1-7
 - adjustable parallel, 1-14
 - cutter clearance gauge, 1-14
 - dial bore gauge, 1-12
 - dial indicator, 1-9
 - dial vernier caliper, 1-11
 - gear tooth vernier, 1 - 14
 - internal groove gauge, 1- 12
 - micrometers, 1-7
 - surface gauge, 1-16
 - universal bevel, 1-12
 - universal vernier bevel protractor, 1-12
 - vernier caliper, 1-9
 - vernier height gauge, 1-10

- Alloy steels, 3-4
 - chromium, 3-4
 - molybdenum, 3-4
 - nickel, 3-4
 - tungsten, 3-4
 - vanadium, 3-4

B

- Bench and pedestal grinders, 5-3
- Bevel gears, 14-14
 - milling teeth, 14-20
 - nomenclature, 14-16
 - selecting cutters, 14-20

C

- Carbide tool grinder, 5-7
- Care and maintenance of measuring instruments, 1-20
 - dials, 1-22
 - micrometers, 1-21
 - vernier gauges, 1-22

- Cemented carbide, 5-9
 - brazed-on tips, 5-9
 - grades, 5-10
 - insert shapes, 5-11
 - insert sizes, 5-12
 - operating conditions, 5-9
 - toolholder and boring bar styles, 5-12
 - toolholder and carbide insert identification, 5-12

- Chip breaker grinder, 5-8

- Computer numerical control, 11-1
 - computer-aided design/computer-aided manufacturing, 11-5
 - machines, 11-2
 - machine safety, 11-1
 - numerical control systems, 11-5
 - setting the machine origin, 11-9
 - tooling, 11-5

- Computer numerical control machines, 11-2
 - CNC lathe, 11-3
 - CNC vertical spindle milling, 11-3

- Computer numerical control systems, 11-5
 - Cartesian coordinate systems, 11-8
 - positioning systems, 11-9
 - servomechanisms, 11-8
 - types of systems, 11-7

- Contact electroplating, 12-7
 - applications, 12-9
 - electroplating equipment, 12-8
 - operator qualification, 12-9
 - plating procedures, 12-10
 - quality assurance, 12-10

- Continuous feed cutoff saw, 4-11
 - band selection and installation, 4-11
 - operation, 4-12

Control of tools, 1-4
 controlled equipage, 1-6
 methods, 1-4

Copper alloys, 3-4
 aluminum bronze, 3-5
 brass, 3-5
 bronze, 3-5
 copper-nickel, 3-5
 gunmetal, 3-5

Cutting tool materials, 5-8
 cast alloys, 5-8
 cemented carbide, 5-9
 ceramic, 5-12
 high-speed steel, 5-8

Cutting tool terminology, 5-13
 angle of keenness, 5-14
 back rake, 5-14
 end cutting edge, 5-14
 nose, 5-14
 side cutting edge, 5-14
 side rake, 5-14
 side relief, 5-14

Cylindrical grinder, 10-8
 operation, 10-9
 sliding table, 10-8
 wheelhead, 10-9

D

Derivation of formulas for diametral pitch system,
 A-IV

Drilling angular holes, 4-23
 equipment, 4-23
 operation, 4-24

Drilling machines and drills, 4-14
 operations, 4-18
 radial drill press, 4-16
 twist drill, 4-17
 upright drill presses, 4-15

E

Engine lathe attachments and accessories, 6-11
 carriage stop, 6-18
 center rest, 6-6
 centers, 6-15
 chucks, 6-13
 dogs, 6-16
 follower rest, 6-17
 grinding attachment, 6-8
 milling attachment, 6-19
 taper attachment, 6-17
 thread dial indicator, 6-18
 toolholders, 6-12
 tool post, 6-11
 tracing attachment, 6-20

Engine lathe components, 6-1
 apron, 6-14
 bed and ways, 6-6
 carriage, 6-13
 compound rest, 6-22
 feed rod, 6-17
 headstock, 6-8
 lead screw, 6-18
 quick-change gear mechanism, 6-19
 tailstock, 6-10

Engine lathe operations, 6-33
 boring, 6-38
 chatter, 6-34
 coolants, 6-34
 cutting speeds and feeds, 6-33
 drilling and reaming, 6-38
 facing, 6-35
 knurling, 6-39
 parting and grooving, 6-37
 planning the job, 6-33
 setting up the tool post grinder, 6-40
 tapers, 6-42
 turning, 6-35

- Engine lathes, 6-1
 - attachments and accessories, 6-11
 - components, 6-1
 - operations, 6-33
 - other types of engine lathes, 6-20
 - screw threads, 6-46
 - setup, 6-20
- Engine lathe setup, 6-20
 - aligning and leveling, 6-21
 - methods of holding the work, 6-25
 - preparing the centers, 6-23
 - safety, 6-20
 - setting the toolholder and cutting tool, 6-24
- F**
- Filing, 2-18
 - crossfiling, 2-18
 - drawfiling, 2-18
 - using the file card and brush, 2-19
- Fixed gauges, 1-16
 - graduated gauges, 1-16
 - nongraduated gauges, 1-18
- Formulas for spur gearing, A-III
- G**
- Gears and gear cutting, 14-1
 - bevel gears, 14-14
 - helical gears, 14-5
 - materials used for gears, 14-1
 - splines, 14-29
 - sprockets, 14-29
 - spur gears, 14-1
 - stub tooth gears, 14-27
 - worms and worm gears, 14-22
- Glossary, A-I
- Graduated gauges, 1-16
 - acme thread tool gauge, 1-17
 - center gauge, 1-18
 - feeler gauge, 1-18
 - radius gauge, 1-18
 - rules, 1-16
 - scales, 1 - 17
- Grain depth of cut, 10-1
- Grinding handtools, 5-19
- Grinding safety, 5-1
- Grinding speeds, feeds, and coolants, 10-3
 - coolants, 10-4
 - depth of cut, 10-4
 - traverse (work speed), 10-3
 - wheel speed, 10-3
- Grinding wheel balancing, 10-4
- Grinding wheels, 5-2
 - care and storage, 5-7
 - diamond wheels, 5-5
 - installation, 5-5
 - markings and composition, 5-2
 - selection and use, 5-5
 - sizes and shapes, 5-2
 - truing and dressing, 5-6
- Ground single-point, high-speed cutting tools, 5-13
 - cutting tool terminology, 5-13
 - grinding high-speed engine lathe cutting tools, 5-17
 - ground-in chip breakers, 5-15
 - shapes of high-speed engine lathe cutting tools, 5-15
- H**
- Hacksaws, power, 4-4
 - blade selection, 4-6
 - coolant, 4-7
 - feeds and speeds, 4-8
 - operation, 4-10
- Hardness test, 15-28
 - file test, 15-29
 - Rockwell test, 15-28

- Heat-treating equipment, 15-6
 - cooling equipment, 15-10
 - heating equipment, 15-7
- Heat-treating ferrous metals, 15-20
 - alloy tool steels, 15-24
 - annealing, 15-22
 - austempering, 15-22
 - carbon tool steels, 15-23
 - case hardening, 15-23
 - hardening, 15-20
 - martempering, 15-23
 - normalizing, 15-22
 - spheroidizing, 15-22
 - tempering, 15-21
- Heat-treating nonferrous metals, 15-25
- Heat-treating problems, 15-25
 - blistering, 15-28
 - cracking, 15-27
 - design problems, 15-25
 - size changes, 15-27
 - soft spots, 15-27
 - spalling, 15-27
 - warping, 15-27
- Helical gears, 14-5
 - dimensions, real and normal, 14-8
 - gear train ratio, 14-12
 - manufacturing, 14-13
- Honing equipment, 10-20
 - honoring hints, 10-21
 - portable equipment, 10-20
 - stationary honing machine, 10-21
 - stone selection, 10-21
- Horizontal boring mill, 8-6
 - combination boring and facing head, 8-7
 - operations, 8-8
 - right-angle milling attachment, 8-8
- Horizontal shaper components, 9-1
 - crossrail assembly, 9-2
 - drive assembly, 9-1
 - main frame assembly, 9-1
 - table feed mechanism, 9-3
 - toolhead assembly, 9-4
- Horizontal shaper operations, 9-5
 - shaping a rectangular block, 9-7
 - shaping angular surfaces, 9-8
 - shaping internal keyways, 9-9
 - shaping irregular surfaces, 9-10
 - shaping keyways in shafts, 9-8
 - speeds and feeds, 9-6
- Horizontal shapers, 9-1
 - components, 9-1
 - operations, 9-5
 - vices and toolholders, 9-4
- Hydraulic and arbor presses, 2-19
- I**
- Identification of metals, 3-11
 - acid test, 3-14
 - spark test, 3-11
- L**
- Layout and benchwork, 2-1
 - filing, 2-18
 - hydraulic and arbor presses, 2-19
 - layout methods, 2-8
 - limits of accuracy, 2-1
 - oxyacetylene equipment, 2-22
 - reading surface finish quality, 2-5
 - scraping and bluing, 2-17
 - screw thread inserts, 2-20
 - surface characteristics of metal, 2-3
- Layout limits of accuracy, 2-1
 - allowance, 2-2
 - tolerance, 2-2

Layout methods, 2-8

- forming angular lines, 2-9
- geometric construction of layout lines, 2-13
- laying out circles and irregular lines, 2-10
- laying out valve flange boltholes, 2-14
- lines square or parallel to edges, 2-8
- using the sine bar, 2-12
- using the surface plate, 2-11

M

Measuring instruments, 1-6

- adjustable gauges, 1-7
- fixed gauges, 1-16

Metal buildup, 12-1

- contact electroplating, 12-7
- thermal spray systems, 12-1

Metal, designations and markings, 3-6

- ferrous metal designations, 3-6
- nonferrous metal designations, 3-8
- standard markings, 3-9

Metallurgy and heat treatment, 15-1

- hardness test, 15-28
- heat-treating ferrous metals, 15-20
- heat-treating nonferrous metals, 15-25
- heat-treating problems, 15-25
- heat-treating equipment, 15-6
- principles of heat-treating ferrous alloys, 15-13
- structure of metal, 15-1

Metals, 3-1

- designations and markings, 3-6
- identification, 3-11
- properties, 3-1
- types, 3-3

Metals and plastics, 3-1

- metals, 3-1
- plastics, 3-14

Micrometers, 1-7

- ball, 1-8
- blade, 1-8
- depth, 1-8
- groove, 1-8
- inside, 1-7
- outside, 1-7
- thread, 1-8

Milling machine arbors, 7-27

- cutter adapter, 7-29
- fly cutter, 7-28
- screw, 7-29
- screw slotting cutter, 7-28
- shell end, 7-28
- spring collet chuck, 7-30
- standard, 7-27
- stub, 7-28
- taper adapter, 7-29

Milling machine attachments, 7-47

- high-speed universal, 7-48
- rear milling, 7-48
- universal, 7-47
- vertical, 7-48

Milling machine components, 7-3

Milling machine cutters, 7-18

- angle, 7-21
- concave and convex, 7-25
- corner rounding, 7-25
- end mill, 7-22
- face mill, 7-24
- fly, 7-26
- gear, 7-25
- gear hob, 7-26
- half-side milling, 7-20
- metal slitting saw, 7-20
- plain milling, 7-18
- screw slotting, 7-20
- side milling, 7-20
- side milling (interlocking), 7-20
- sprocket wheel, 7-26
- T-slot, 7-24
- woodruff key seat, 7-25

- Milling machine cutter selection, 7-26
- Milling machine feeds, speeds, and coolants, 7-48
 - coolants, 7-52
 - feeds, 7-51
 - speeds, 7-48
- Milling machine indexing, 7-11
 - adjusting sector arms, 7-17
 - angular, 7-13
 - compound, 7-14
 - differential, 7-15
 - direct, 7-11
 - plain, 7-11
 - wide-range divider, 7-15
- Milling machine operations, 7-30
 - angular milling, 7-34
 - drilling, reaming, and boring, 7-45
 - face milling, 7-32
 - fly cutting, 7-45
 - plain milling, 7-30
 - slotting, parting, and milling keyseats, 7-40
- Milling machine workholding devices, 7-7
 - circular milling attachment, 7-8
 - indexing equipment, 7-8
 - right angle plate, 7-7
 - toolmaker's knee, 7-7
 - vises, 7-7
- MR/civilian job descriptions, 1-1

N

- Nickel alloys, 3-5
 - K-monel, 3-5
 - nickel-copper, 3-5
- Nongraduated gauges, 1-18
 - gauge blocks, 1-20
 - machinist's square, 1-19
 - parallel blocks, 1-19
 - ring and plug gauges, 1-20
 - sine bar, 1-19
 - straightedges, 1-18
 - thread and measuring wires, 1-20
- Numerical control systems, 11-5

O

- Oxyacetylene equipment, 2-22
 - adjusting the flame, 2-24
 - backfire and flashback, 2-26
 - extinguishing the flame, 2-25
 - safety, 2-25
 - setting up, 2-24

P

- Pantagraphs, 9-14
 - attachments, 9-20
 - cutter speeds, 9-17
 - engraving a dial face, 9-22
 - engraving a graduated collar, 9-22
 - grinding cutters, 9-17
 - major components, 9-16
 - setting copy, 9-16
 - setting the pantagraph, 9-16
 - using a circular copy plate, 9-22
- Plain-carbon steel, 3-3
 - high-carbon steel, 3-4
 - low-carbon steel, 3-4
 - medium-carbon steel, 3-4
- Planer operations, 9-13
 - feeds, 9-13
 - holding the work, 9-14
 - rail elevation, 9-13
 - table speeds, 9-13
- Planers, 9-11
 - major components, 9-12
 - operations, 9-13
- Plastics, 3-14
 - characteristics, 3-15
 - lathe operations, 3-18
 - machining operations, 3-15
 - major groups, 3-15

Stub tooth gears, 14-27

American standard system, 14-27

Fellows stub-tooth gear system, 14-27

method of manufacture, 14-28

Surface characteristics of metal, 2-3

Surface grinder, 10-5

cross traverse table, 10-5

operation, 10-7

sliding table, 10-6

wheelhead, 10-6

workholding devices, 10-6

T

Thermal spray systems, 12-1

applications, 12-1

applying the coating, 12-6

preparing surfaces, 12-4

qualification of personnel, 12-2

quality assurance, 12-7

surface finishing, 12-6

types of thermal spray, 12-2

Thermal spray; preparing surfaces, 12-4

cleaning, 12-4

surface roughening, 12-5

undercutting, 12-5

Tool and cutter grinder, 10-10

cutter sharpening, 10-11

cutter sharpening setups, 10-14

Toolrooms and tools, 1-1

care and maintenance of measuring instruments,
1-20

control, 1-4

inspection, 1-4

measuring instruments, 1-6

organization, 1-2

safety, 1-2

U

Upright drill presses, 4-37

general-purpose drill press (round column), 4-38

heavy-duty drill press (box column), 4-39

sensitive drill press, 4-16

V

Vertical shapers, 9-11

Vertical turret lathe, 8-1

taper turning, 8-4

tooling, 8-3

W

Worms and worm gears, 14-22

center-to-center distance, 14-25

cutting teeth on a milling machine, 14-26

formula development, 14-23

hobs, 14-25

selecting a cutter, 14-24

worm and worm wheel nomenclature, 14-23

- Power saws, 4-1
 - continuous feed cutoff saw, 4-3
 - hacksaw, 4-1
 - metal-cutting bandsaw, 4-4
- Precision grinding machines, 10-1
 - cylindrical grinder, 10-8
 - grain depth of cut, 10-1
 - honing equipment, 10-20
 - speeds, feeds, and coolants, 10-3
 - surface grinder, 10-5
 - tool and cutter grinder, 10-10
 - wheel balancing, 10-4
- Principles of heat-treating ferrous alloys, 15-13
 - effects of heating, holding, and cooling, 15-16
 - equilibrium diagrams, 15-13
 - iron-carbon phase diagram, 15-14
 - transformation temperatures, 15-13
- R**
- Reading surface finish quality, 2-5
 - interference microscope inspection, 2-6
 - profilometer, 2-6
 - surface analyzer, 2-8
 - touch comparison, 2-6
 - visual inspection, 2-5
- References used to develop the TRAMAN, A-V
- Repair job preparation, 13-1
 - calibration, 13-1
 - planned maintenance system, 13-2
 - planning work, 13-2
 - quality assurance, 13-1
- Repair jobs, 13-2
 - broken bolts and studs, 13-15
 - broken taps, 13-17
 - in-place machining, 13-19
 - pumps, 13-13
 - shafts, 13-2
 - valves, 13-4
- Repair work, 13-1
 - job preparation, 13-1
 - repair jobs, 13-2
- S**
- Scope of MR rating, 1-1
- Scraping and bluing, 2-17
- Screw thread inserts, 2-20
- Screw threads, 6-46
 - classes of threads, 6-52
 - cutting on a lathe, 6-54
 - left-hand screw threads, 6-58
 - measuring threads, 6-52
 - multiple screw threads, 6-58
 - other forms of threads, 6-50
 - threads on tapered work, 6-60
 - V-form threads, 6-48
- Shaper and planer tools, 5-18
- Shapers, 9-1
 - horizontal shapers, 9-1
 - vertical shapers, 9-11
- Sharpening twist drills, 5-21
 - sharpening to drill brass, 5-23
 - thinning the web, 5-23
- Sprockets, 14-29
 - classes, 14-30
 - manufacture, 14-30
 - material, 14-30
- Spur gears, 14-1
 - diametral pitch system, 14-3
 - machining, 14-5
 - terminology, 14-2
- Structure of metal, 15-1
 - allotropy, 15-5
 - crystals and grains, 15-2
 - internal structure, 15-5
 - space lattices, 15-2

