



Instructions and Parts List

No. M6-735
EXTENSION BRACKET

Bulletin M6-735-1
November, 1954

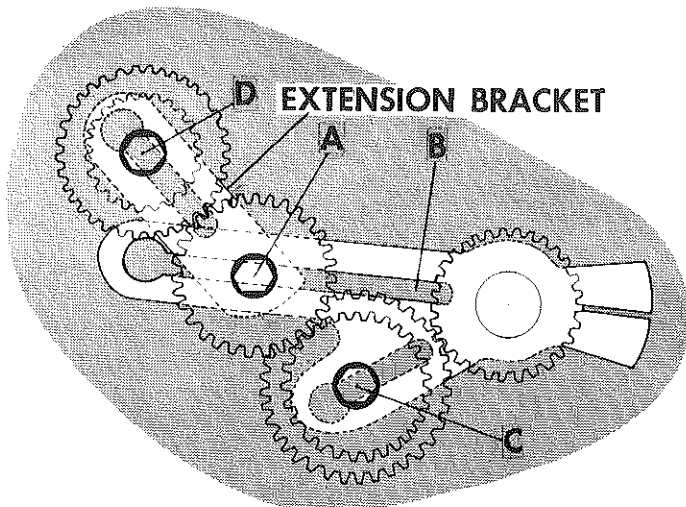


Fig. 1 Extension mounted on change gear quadrant.

Pitch MM.	Gear on Screw	Position C B F	Position B B F	Position A B F	Position D B F	Compound Tumbler Gear
.5	48B	54I xxS	— —	24 56	40 44	32
.6	56B	36 64	— —	44 52	— —	32
.7	64B	24 32	— —	44 52	— —	32
.75	64B	32 40	— —	44 52	— —	32
.8	54B	46 64	— —	44 52	— —	32
.9	46B	36 52	— —	44 52	— —	32
1.0	40B	32 48	— —	44 52	— —	32
1.25	44F	48 52	— —	40I 20S	— —	32
1.50	44F	40S 52I	— —	46I 20S	— —	32
1.75	44B	56 40	— —	20S 46I	48 52	32
2.0	40B	48 44	— —	36 52	64I 20S	32
2.5	44F	24 52	— —	64I 20S	— —	32
3.0	44F	20 52	— —	64I 20S	— —	32

SYMBOLS

B - Back position - (toward
headstock)

F - Forward position - (away
from headstock)

I - Idler Gear S - Spacer Gear

ATLAS PRESS COMPANY
KALAMAZOO MICHIGAN U. S. A.

No. M6-735 EXTENSION BRACKET

For ATLAS No.618
6" Metalworking Lathe

The extension bracket is used
only for cutting 0.5, 1.75
and 2.0 pitch per millimeter
threads.

Bracket mounts to front of
change gear quadrant in "Posi-
tion A" - see Figure 1. The gear
stud sleeves for "Position A"
and "D" should be reversed so
the flanges face away from head-
stock - see Figure 2. The wash-
ers are not used.

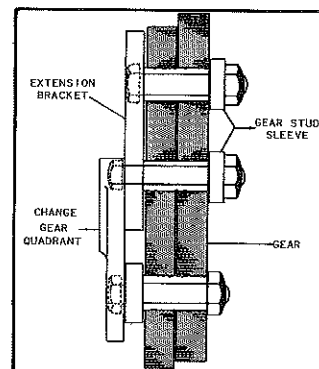
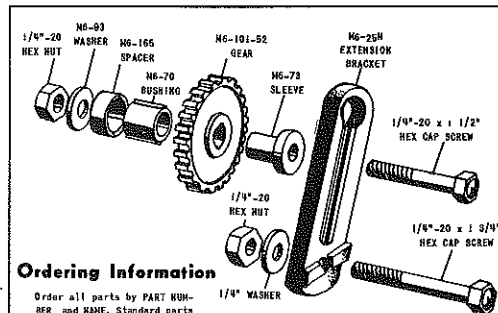


Fig. 2

Showing gear
stud sleeves in
reversed posi-
tion.



Ordering Information

Order all parts by PART NUM-
BER and NAME. Standard parts
such as screws, washers and
nuts shown without part num-
bers should be purchased lo-
cally. We reserve the right
to make changes in design and
specifications without
notice.

