

# WABECO THREAD CUTTING CHANGEWHEEL TABLES

from <https://david.d56.co.uk>

| mm        | 0.35 | 0.4 | 0.45 | 0.5 | 0.6 | 0.7 | 0.75 | 0.8 | 1.0 | 1.25 | 1.5 | 1.75 | 2.0 | 2.5 | 3.0 | 3.5 | 4.0 | 5.0 |
|-----------|------|-----|------|-----|-----|-----|------|-----|-----|------|-----|------|-----|-----|-----|-----|-----|-----|
| <b>C1</b> | 16   | 16  | 16   | 16  | 16  | 16  | 16   | 16  | 20  | 16   | 36  | 28   | 32  | 32  | 32  | 28  | 32  | 32  |
| <b>A1</b> | 40   | 40  | 40   | 40  | 40  | 24  | 32   | 24  | 24  | 24   | 24  | 24   | 14  | 16  | 16  | 16  | 16  | 16  |
| <b>A2</b> | 14   | 16  | 18   | 20  | 24  | 14  | 20   | 16  | 16  | 20   | 16  | 16   | 14  | 20  | 20  | 24  | 24  | 20  |
| <b>C</b>  | 48   | 48  | 48   | 48  | 48  | 40  | 40   | 40  | 40  | 32   | 48  | 32   | 48  | 48  | 40  | 36  | 36  | 24  |
| <b>D</b>  | 130  | 120 | 120  | 120 | 120 | 120 | 120  | 120 | 120 | 120  | 130 | 120  | 120 | 120 | 120 | 120 | 120 | 120 |
| <b>F</b>  | 120  | 120 | 120  | 130 | 140 | 140 | 140  | 140 | 140 | 140  | 140 | 120  | 140 | 140 | 140 | 140 | 140 | 120 |

| TPI           | 8      | 10     | 12     | 13    | 14     | 16     | 18     | 19    | 20     | 24     | 26    | 27     | 28     | 32     | 36     | 40     | 44     | 48     | 56    | 60     | 64    |
|---------------|--------|--------|--------|-------|--------|--------|--------|-------|--------|--------|-------|--------|--------|--------|--------|--------|--------|--------|-------|--------|-------|
| <b>err. %</b> | +0.046 | +0.046 | +0.046 | -.484 | +0.046 | +0.046 | +0.046 | -.263 | +0.046 | +0.046 | +.499 | +0.046 | +0.046 | +0.046 | +0.046 | +0.046 | -1.023 | +0.046 | -.794 | -1.600 | +.781 |
| <b>C1</b>     | 32     | 32     | 32     | 28    | 36     | 16     | 18     | 32    | 16     | 16     | 18    | 16     | 16     | 16     | 16     | 16     | 16     | 16     | 16    | 16     | 16    |
| <b>A1</b>     | 16     | 20     | 24     | 24    | 28     | 32     | 34     | 36    | 34     | 32     | 22    | 34     | 28     | 32     | 34     | 34     | 28     | 34     | 40    | 48     | 40    |
| <b>A2</b>     | 18     | 18     | 18     | 20    | 16     | 36     | 32     | 20    | 36     | 24     | 16    | 24     | 18     | 18     | 18     | 18     | 16     | 18     | 18    | 20     | 16    |
| <b>C</b>      | 34     | 34     | 34     | 36    | 34     | 34     | 36     | 40    | 40     | 34     | 40    | 36     | 34     | 34     | 36     | 40     | 48     | 48     | 48    | 48     | 48    |
| <b>D</b>      | 120    | 120    | 120    | 120   | 130    | 120    | 120    | 130   | 120    | 120    | 120   | 120    | 120    | 120    | 120    | 120    | 120    | 120    | 120   | 130    | 120   |
| <b>F</b>      | 130    | 120    | 120    | 130   | 120    | 140    | 130    | 120   | 140    | 140    | 140   | 140    | 140    | 140    | 140    | 140    | 140    | 140    | 120   | 120    | 120   |

| BA            | 10     | 8     | 7     | 6     | 5     | 4     | 3     | 2     | 0      |
|---------------|--------|-------|-------|-------|-------|-------|-------|-------|--------|
| <b>mm</b>     | 0.35   | 0.43  | 0.48  | 0.53  | 0.59  | 0.66  | 0.73  | 0.81  | 1.00   |
| <b>err. %</b> | +0.000 | -.547 | -.082 | +.111 | -.106 | -.267 | +.114 | +.405 | +0.000 |
| <b>C1</b>     | 16     | 14    | 14    | 16    | 18    | 18    | 14    | 16    | 20     |
| <b>A1</b>     | 40     | 34    | 34    | 34    | 32    | 34    | 32    | 28    | 24     |
| <b>A2</b>     | 14     | 14    | 14    | 18    | 14    | 20    | 20    | 16    | 16     |
| <b>C</b>      | 48     | 40    | 36    | 48    | 40    | 48    | 36    | 34    | 40     |
| <b>D</b>      | 130    | 120   | 120   | 120   | 120   | 120   | 120   | 120   | 120    |
| <b>F</b>      | 120    | 140   | 130   | 140   | 130   | 140   | 140   | 140   | 140    |