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Heres the feed charts for cutting and threading both Inch and Metric

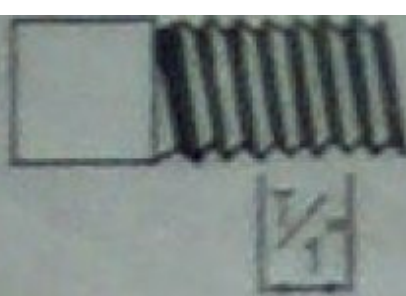
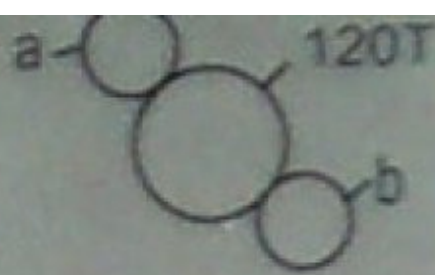
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The diagram shows a lathe tool cutting a thread. Annotations include '120T' and '60T' for different tool angles, '8TPI' for the thread pitch, and 'ins' for the cutting direction. A circular arrow indicates the rotation of the workpiece.

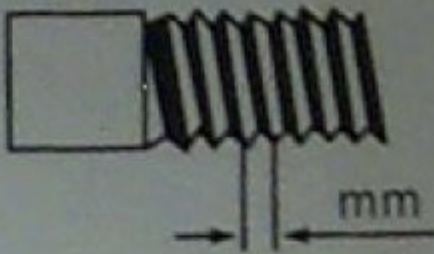
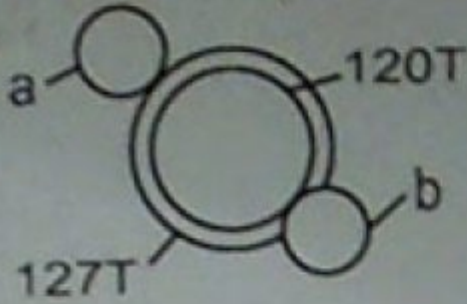
a		60T				30T			
LEVER		T	S	R	V	T	S	R	V
A	D	.0548	.0512	.0411	.0328	.0274	.0256	.0205	.0164
		.0187	.0175	.0140	.0112	.0094	.0087	.0070	.0056
B	D	.0274	.0256	.0205	.0164	.0137	.0128	.0102	.0082
		.0094	.0087	.0070	.0056	.0047	.0044	.0035	.0028
A	C	.0137	.0128	.0102	.0082	.0069	.0064	.0051	.0041
		.0047	.0044	.0035	.0028	.0024	.0022	.0017	.0014
B	C	.0069	.0064	.0051	.0041	.0034	.0031	.0025	.0020
		.0024	.0022	.0017	.0014	.0012	.0011	.0009	.0007

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a	60	60	60	60	40	40	56	40	60	
b	60	54	57	60	44	46	54	52	63	
LEVER	4	1	1	1	1	1	2	1	3	
	V	V	V	V	V	V	V	V	V	
A	D	4	4½		5	5½		6	6½	7
B	D	8	9	9½	10	11	11½	12	13	14
A	C	16	18	19	20	22	23	24	26	28
B	C	32	36	38	40	44	46	48	52	56

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8TPI

a	56	60	60	30	60	60	30	60	56
b	60	60	60	60	60	60	60	60	63
LEVER	4	1	3	4	1	3	1	3	3
	R	R	S	T	V	R	T	V	V
A	D	7.0	6.0		5		4.5	4.0	
B	D	3.5	3.0		2.5		2.25	2.0	1.8
A	C	1.75	1.5	1.4	1.25	1.2		1.0	0.9
B	C		0.75	0.7		0.6		0.5	0.45

a	60T	30T
LEVER	T S R V T S R V	
A D		
B D		
A C		

a	60	60	60	60	40	40	56	40	60
b	60	54	57	60	44	46	54	50	63
LEVER	4	1	1	1	1	1	3	1	3
A D	4	4.5	5	5.5	6	6.5	7		
B D	8	9	9.5	10	11	11.5	12	13	14

a	56	60	60	30	60	60	30	60	56
b	60	60	60	60	60	60	60	60	63
LEVER	4	1	3	4	1	3	1	3	3
	R	R	S	T	V	R	T	V	V
A D	7.0	6.0		5		4.5	4.0		

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