

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES								REMARKS
	BHN	Rc		# 000	# 00	# 0	# 1	# 2	# 3	# 4	# 5	
LEADRITE #6 CARTRIDGE BRASS	121 188	— —	56,000 56,300	1	1	1	1	1	7/8	3/4	11/16	REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
PHOS. BRONZE 8% MUELLER 88	126 115	— —	57,000 56,300	1	1	1	7/8	3/4	5/8	5/8	9/16	
11ST, 17S, 24S ALUMINUM	133-137	—	61-68,000									
SAE 1015	130	—	67,000	1	1	1	13/16	11/16	9/16	9/16	1/2	
SAE 1112 & 1114 OLYMPIC "A" BRASS	200 197	13 —	90,000 90,000									
NAVAL BRASS	156	—	77,000	1	1	13/16	11/16	9/16	1/2	1/2	7/16	
MONEL	229	—	103,000									
EVERDURE 1010	198	—	99,000									
SAE 1025	160	—	80,000	1	15/16	3/4	11/16	9/16	1/2	7/16	7/16	
SAE 3120 & 1144	190-225	11-20	80-105,000									
SAE 4615	190	11	90,000	15/16	3/4	9/16	1/2	7/16	3/8	3/8	5/16	
#347 STAINLESS	171	Ⓒ	88,000									
SAE 1040	215	17	106,000									
SAE 1095 DRILL ROD	230	20	115,000									
SAE 1335	230	21	110,000									
SAE 3140	210	16	106,000									
SAE 3312	225	20	104,000									
SAE 4140	230	21	106,000	13/16	5/8	1/2	7/16	3/8	3/8	5/16	5/16	
SAE 6150	205	16	102,000									
SAE 8620	225	20	103,000									
SAE 8642	200	13	100,000									
#416 STAINLESS	219	18	97,000									
#430 STAINLESS	222	19	106,000									
SAE 1095 DRILL ROD	255	25	128,000									5860224
SAE 4340	230	20	112,000									
M2 H.S.S.	235	22	113,000									
18-4-1 H.S.S.	240	23	110,000	5/8	1/2	7/16	3/8	5/16	5/16	1/4	1/4	
#303 STAINLESS	179	—	92,000									
#304 STAINLESS	163	—	86,000									
#316 STAINLESS	148	—	83,000									
SAE 1095 DRILL ROD	285	30	145,000									
SAE 4140	310	33	161,000	9/16	7/16	3/8	5/16	1/4	1/4	1/4	3/16	
#17A STAINLESS	304	32	131,000 Ⓐ									
SAE 1095	327	35	165,000	7/16	3/8	5/16	1/4	1/4	1/4	3/16	3/16	
SAE 1095	370	40	185,000	3/8	5/16	1/4	1/4	1/4	3/16	3/16	3/16	

MACHINE LOAD RATING BY MAT'L & THD. LENGTH FOR 000-1000 THREAD ROLLER

CROSS REFERENCES		A	REVISED 8-14-84 RAB	TOLERANCES FOR MACHINED DIMS. UNLESS OTHERWISE SPECIFIED: FRACTIONAL ± 1/64 DECIMAL .XX ± .015 DECIMAL .XXX ± .005 ANGLES ± 0'-30' SURFACE FINISH √ = 125 √	DO NOT SCALE THIS DRAWING REFER TO MACHINE ENGINEERING FOR DIMENSIONS		TITLE MACHINE LOAD CHART			
03000B23001		B	WAS 1321,000 9/3/86 FRIES		MATERIAL		PART NO. 03000B23001			
		C	WAS - 9/3/86 FRIES		HEAT TREAT		Reed Machinery, Inc. 10A New Bond Street Worcester, MA 01606 USA			
		D	CONVERT TO AUTOCAD 4/8/97 JAT		SCALE				DRAWN BY BAUGHMAN	
					DATE 8-3-84				CHECKED BY	

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES					REMARKS
	BHN	Rc		#4	#6	#8	#10	#12	
LEADRITE #6 CARTRIDGE BRASS	121 188	— —	56,000 56,300	3	3	2-5/8	2-3/8	2-1/8	REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
PHOS. BRONZE 8% MUELLER 88	126 115	— —	57,000 56,300	3	2-5/8	2-1/4	1-7/8	1-3/4	
11ST, 17S, 24S ALUMINUM	133-137	—	61-68,000						
SAE 1015	130	—	67,000	2-5/8	2-1/4	1-7/8	1-5/8	1-1/2	
SAE 1112 & 1114 OLYMPIC "A" BRASS	200 197	13 —	90,000 90,000						
NAVAL BRASS	156	—	77,000	2-3/8	1-7/8	1-5/8	1-1/2	1-3/8	
MONEL	229	—	103,000						
EVERDURE 1010	198	—	99,000						
SAE 1025	160	—	80,000	2-1/8	1-3/4	1-1/2	1-3/8	1-1/4	
SAE 3120 & 1144	190-225	11-20	80-105,000						
SAE 4615	190	11	90,000	1-7/8	1-1/2	1-3/8	1-1/4	1-1/8	
#347 STAINLESS	171	—	88,000						
SAE 1040	215	17	106,000						
SAE 1095 DRILL ROD	230	20	115,000						
SAE 1335	230	21	110,000						
SAE 3140	210	16	106,000						
SAE 3312	225	20	104,000						
SAE 4140	230	21	106,000	1-1/2	1-3/8	1-1/4	1	7/8	
SAE 6150	205	16	102,000						
SAE 8620	225	20	103,000						
SAE 8642	200	13	100,000						
#416 STAINLESS	219	18	97,000						
#430 STAINLESS	222	19	106,000						
SAE 1095 DRILL ROD	255	25	128,000						
SAE 4340	230	20	112,000						
M2 H.S.S.	235	22	113,000						
18-4-1 H.S.S.	240	23	110,000	1-1/2	1-1/4	1	7/8	3/4	
#303 STAINLESS	179	—	92,000						
#304 STAINLESS	163	—	86,000						
#316 STAINLESS	148	—	83,000						
SAE 1095 DRILL ROD	285	30	145,000						
SAE 4140	310	33	161,000	1-1/4	1	7/8	7/8	3/4	
#17A STAINLESS	304	32	131,000						
SAE 1095	327	35	165,000	1	7/8	7/8	3/4	5/8	
SAE 1095	370	40	185,000	1	7/8	3/4	5/8	5/8	

MACHINE LOAD RATING BY MAT'L & THD. LENGTH FOR #0-500 THREAD ROLLER

CROSS REFERENCES	A	CADAM 9/3/86 FRIES	TOLERANCES FOR MACHINED DIMS. UNLESS OTHERWISE SPECIFIED: FRACTIONAL ± 1/64 DECIMAL .XX ± .015 DECIMAL .XXX ± .005 ANGLES ± 0°-30' SURFACE FINISH √ = 125 √	DO NOT SCALE THIS DRAWING REFER TO MACHINE ENGINEERING FOR DIMENSIONS		TITLE	MACHINE LOAD RATING		
	B	CONVERT TO AUTOCAD 4/8/97 JAT		MATERIAL	PART NO.		03192B00180		
				HEAT TREAT			Reed Machinery, Inc. 10A New Bond Street Worcester, MA 01606 USA		
				SCALE	DRAWN BY	HARTFORD			
				DATE	9/2/86	CHECKED BY			

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES					REMARKS
	BHN	Rc		# 2	# 4	# 6	# 8	# 10	
LEADRITE #6 CARTRIDGE BRASS	121 188	- -	56,000 56,300	1-1/2	1-1/2	1-1/2	1-1/2	1-7/16	REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
PHOS. BRONZE 8% MUELLER 88	126 115	- -	57,000 56,300	1-1/2	1-1/2	1-1/2	1-5/16	1-3/16	
11ST, 17S, 24S ALUMINUM	133-137	-	61-68,000						
SAE 1015	130	-	67,000	1-1/2	1-1/2	1-7/16	1-1/4	1	
SAE 1112 & 1114 OLYMPIC "A" BRASS	200	13	90,000						
NAVAL BRASS	197	-	90,000						
MONEL	156	-	77,000	1-1/2	1-3/8	1-3/16	1	7/8	
EVERDURE 1010	229	-	103,000						
	198	-	99,000						
SAE 1025	160	-	80,000	1-1/2	1-3/8	1-1/8	1	7/8	
SAE 3120 & 1144	190-225	11-20	80-105,000						
SAE 4615	190	11	90,000	1-5/16	1-1/16	15/16	3/4	11/16	
#347 STAINLESS	171	Ⓒ	88,000						
SAE 1040	215	17	106,000						
SAE 1095 DRILL ROD	230	20	115,000						
SAE 1335	230	21	110,000						
SAE 3140	210	16	106,000						
SAE 3312	225	20	104,000						
SAE 4140	230	21	106,000	1-1/8	15/16	13/16	11/16	5/8	
SAE 6150	205	16	102,000						
SAE 8620	225	20	103,000						
SAE 8642	200	13	100,000						
#416 STAINLESS	219	18	97,000						
#430 STAINLESS	222	19	106,000						
SAE 1095 DRILL ROD	255	25	128,000						
SAE 4340	230	20	112,000						
M2 H.S.S.	235	22	113,000						
18-4-1 H.S.S.	240	23	110,000	15/16	11/16	3/4	9/16	9/16	
#303 STAINLESS	179	-	92,000						
#304 STAINLESS	163	-	86,000						
#316 STAINLESS	148	-	83,000						
SAE 1095 DRILL ROD	285	30	145,000						
SAE 4140	310	33	161,000						
#17A STAINLESS	304	32	131,000 Ⓑ	13/16	11/16	1/2	1/2	7/16	
SAE 1095	327	35	165,000	11/16	9/16	1/2	7/16	7/16	
SAE 1095	370	40	185,000	9/16	9/16	7/16	3/8	3/8	

MACHINE LOAD RATING BY MATL & THD LENGTH FOR 0-800 THREAD ROLLER

CROSS REFERENCES	A	REVISED 8-22-84 RAB	TOLERANCES FOR MACHINED DIMS. UNLESS OTHERWISE SPECIFIED: FRACTIONAL ± 1/64 DECIMAL .XX ± .015 DECIMAL .XXX ± .005 ANGLES ± 0°-30' SURFACE FINISH √ = 125 √	DO NOT SCALE THIS DRAWING		TITLE	MACHINE LOAD RATING
	B	WAS 1321,000 9/3/86 FRIES		REFER TO MACHINE ENGINEERING FOR DIMENSIONS		PART NO.	03302B23001
	C	WAS - 9/3/86 FRIES		MATERIAL			
	D	CONVERT TO AUTOCAD 4/8/97 JAT		HEAT TREAT			
				SCALE	DRAWN BY BAUGHMAN		
				DATE 8-3-84	CHECKED BY	Reed Machinery, Inc. 10A New Bond Street Worcester, MA 01606 USA	

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES					REMARKS
	BHN	Rc		#6	#8	#10	#12	1/4	
LEADRITE #6	121	-	56,000	2-1/2	2-1/2	2-1/2	2-3/8	2-1/8	REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
CARTRIDGE BRASS	188	-	56,300						
PHOS. BRONZE 8%	126	-	57,000						
MUELLER 88	115	-	56,300	2-1/2	2-1/2	2-1/4	1-7/8	1-3/4	
11ST, 17S, 24S ALUMINUM	133-137	-	61-68,000						
SAE 1015	130	-	67,000	2-1/2	2-1/4	1-7/8	1-5/8	1-1/2	
SAE 1112 & 1114	200	13	90,000						
OLYMPIC "A" BRASS	197	-	90,000						
NAVAL BRASS	156	-	77,000	2-3/8	1-7/8	1-5/8	1-1/2	1-3/8	
MONEL	229	-	103,000						
EVERDURE 1010	198	-	99,000						
SAE 1025	160	-	80,000	2-1/8	1-3/4	1-1/2	1-3/8	1-1/4	
SAE 3120 & 1144	190-225	11-20	80-105,000						
SAE 4615	190	11	90,000	1-7/8	1-1/2	1-3/8	1-1/4	1-1/8	
#347 STAINLESS	171	-	88,000						
SAE 1040	215	17	106,000						
SAE 1095 DRILL ROD	230	20	115,000						
SAE 1335	230	21	110,000						
SAE 3140	210	16	106,000						
SAE 3312	225	20	104,000						
SAE 4140	230	21	106,000	1-1/2	1-3/8	1-1/4	1	7/8	
SAE 6150	205	16	102,000						
SAE 8620	225	20	103,000						
SAE 8642	200	13	100,000						
#416 STAINLESS	219	18	97,000						
#430 STAINLESS	222	19	106,000						
SAE 1095 DRILL ROD	255	25	128,000						
SAE 4340	230	20	112,000						
M2 H.S.S.	235	22	113,000						
18-4-1 H.S.S.	240	23	110,000	1-1/2	1-1/4	1	7/8	3/4	
#303 STAINLESS	179	-	92,000						
#304 STAINLESS	163	-	86,000						
#316 STAINLESS	148	-	83,000						
SAE 1095 DRILL ROD	285	30	145,000						
SAE 4140	310	33	161,000	1-1/4	1	7/8	7/8	3/4	
#17A STAINLESS	304	32	131,000						
SAE 1095	327	35	165,000	1	7/8	7/8	3/4	5/8	
SAE 1095	370	40	185,000	1	7/8	3/4	5/8	5/8	

MACHINE LOAD RATING BY MAT'L & THD. LENGTH FOR #4-500 THREAD ROLLER

CROSS REFERENCES	A	CADAM 9/3/86 FRIES	TOLERANCES FOR MACHINED DIMS. UNLESS OTHERWISE SPECIFIED: FRACTIONAL ± 1/64 DECIMAL .XX ± .015 DECIMAL .XXX ± .005 ANGLES ± 0°-30' SURFACE FINISH √ = 125 √	DO NOT SCALE THIS DRAWING REFER TO MACHINE ENGINEERING FOR DIMENSIONS		TITLE MACHINE LOAD RATING	
	B	CONVERT TO AUTOCAD 4/8/97 JAT		MATERIAL		PART NO. 03400B18001	
				HEAT TREAT		Reed Machinery, Inc. 10A New Bond Street Worcester, MA 01606 USA	
				SCALE	DRAWN BY HARTFORD		
				DATE 9/2/86	CHECKED BY		

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES					REMARKS
	BHN	Rc		#6	#8	#10	#12	1/4	
LEADRITE #6 CARTRIDGE BRASS	121 188	— —	56,000 56,300	2	2	2	2	2	REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
PHOS. BRONZE 8% MUELLER 88	126 115	— —	57,000 56,300	2	2	2	1-7/8	1-3/4	
11ST, 17S, 24S ALUMINUM	133-137	—	61-68,000	2	2	1-7/8	1-5/8	1-1/2	
SAE 1015	130	—	67,000	2	2	1-7/8	1-5/8	1-1/2	
SAE 1112 & 1114 OLYMPIC "A" BRASS	200 197	13 —	90,000 90,000	2	1-7/8	1-5/8	1-1/2	1-3/8	
NAVAL BRASS	156	—	77,000						
MONEL	229	—	103,000						
EVERDURE 1010	198	—	99,000						
SAE 1025	160	—	80,000	2	1-3/4	1-1/2	1-3/8	1-1/4	
SAE 3120 & 1144	190-225	11-20	80-105,000	1-7/8	1-1/2	1-3/8	1-1/4	1-1/8	
SAE 4615	190	11	90,000						
#347 STAINLESS	171	—	88,000						
SAE 1040	215	17	106,000						
SAE 1095 DRILL ROD	230	20	115,000						
SAE 1335	230	21	110,000						
SAE 3140	210	16	106,000						
SAE 3312	225	20	104,000						
SAE 4140	230	21	106,000	1-1/2	1-3/8	1-1/4	1	7/8	
SAE 6150	205	16	102,000						
SAE 8620	225	20	103,000						
SAE 8642	200	13	100,000						
#416 STAINLESS	219	18	97,000						
#430 STAINLESS	222	19	106,000						
SAE 1095 DRILL ROD	255	25	128,000						REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
SAE 4340	230	20	112,000						
M2 H.S.S.	235	22	113,000						
18-4-1 H.S.S.	240	23	110,000	1-1/2	1-1/4	1	7/8	3/4	
#303 STAINLESS	179	—	92,000						
#304 STAINLESS	163	—	86,000						
#316 STAINLESS	148	—	83,000						
SAE 1095 DRILL ROD	285	30	145,000						
SAE 4140	310	33	161,000	1-1/4	1	7/8	7/8	3/4	
#17A STAINLESS	304	32	131,000						
SAE 1095	327	35	165,000	1	7/8	7/8	3/4	5/8	
SAE 1095	370	40	185,000	1	7/8	3/4	5/8	5/8	

MACHINE LOAD RATING BY MAT'L & THD. LENGTH FOR #4-600 THREAD ROLLER

MACHINE LOAD RATING BY MATERIAL & FINISH									
CROSS REFERENCES		A	CADAM	9/3/86	FRIES	DO NOT SCALE THIS DRAWING REFER TO MACHINE ENGINEERING FOR DIMENSIONS		TITLE	MACHINE LOAD RATING
		B	CONVERT TO AUTOCAD	4/8/97	JAT	MATERIAL		PART NO.	03403B23001
						HEAT TREAT		Reed Machinery, Inc. 10A New Bond Street Worcester, MA 01606 USA	
						SCALE			
						DATE 9/2/86			
						DRAWN BY HARTFORD			
						CHECKED BY			
</									

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES											
	BHN	Rc		#6-MS	#6-RP	#8-MS	#8-RP	#10-MS	#10-RP	#12-MS	#12-RP	1/4-MS	1/4-RP	5/16-MS	3/8-MS
LEADRITE #6 CARTRIDGE BRASS	121 188	— —	56,000 56,300	2-1/2	2-1/2	2-1/2	2-1/2	2-1/2	2-1/4	2-1/2	2	2-1/2	1-3/4	2-1/2	
PHOS. BRONZE 8% MUELLER 88 11ST, 17S, 24S AL	126 115 133-137	— — —	57,000 56,300 61-68,000	2-1/2	2-1/2	2-1/2	2-1/4	2-1/2	2	2-1/2	1-3/4	2-1/2	1-1/2	2-1/2	
SAE 1015	130	—	67,000	2-1/2	2-1/4	2-1/2	2	2-1/2	1-3/4	2-1/2	1-1/2	2-1/2	1-1/4	2-1/4	1-1/4
SAE 1112 & 1114 OLYMPIC "A" BRASS NAVAL BRASS MONEL EVERDURE 1010	200 197 156 229 198	13 — — — —	90,000 90,000 77,000 103,000 99,000	2-1/2	2	2-1/2	1-3/4	2-1/2	1-1/2	2-1/2	1-1/4	2-1/2	1-1/4	2	1-1/8
SAE 1025	160	—	80,000	2-1/2	2	2-1/2	1-3/4	2-1/2	1-1/2	2-1/2	1-1/4	2-3/8	1	2	1-1/8
SAE 3120 & 1144 SAE 4615 #347 STAINLESS	190-225 190 171	11-20 11 —	80-105,000 90,000 88,000	2-1/2	1-3/4	2-1/2	1-1/2	2-1/2	1-1/4	2-1/4	1-1/4	2	1	1-5/8	7/8
SAE 1040 SAE 1095 (D.R.) SAE 1335 SAE 3140 SAE 3312 SAE 4140 SAE 6150 SAE 8620 SAE 8642 #416 STAINLESS #430 STAINLESS	215 230 230 210 225 230 205 225 200 219 222	17 20 21 16 20 21 16 20 13 18 19	106,000 115,000 110,000 106,000 104,000 106,000 102,000 103,000 100,000 97,000 106,000	2-1/2	1-1/2	2-1/2	1-1/4	2-3/16	1	2	1	1-3/4	7/8	1-7/16	3/4
SAE 1095 (D.R.) SAE 4340 M2 H.S.S. 18-4-1 H.S.S. #303 STAINLESS #304 STAINLESS #316 STAINLESS	255 230 235 240 179 163 148	25 20 22 23 — — —	128,000 112,000 113,000 110,000 92,000 86,000 83,000	2-3/8	1-1/4	2-1/8	1	1-7/8	15/16	1-11/16	7/8	1-1/2	3/4	1-1/4	11/16
SAE 1095 (D.R.) SAE 4140	285 310	30 33	145,000 161,000	2-1/16	1	1-13/16	15/16	1-5/8	13/16	1-1/2	3/4	1-5/16	5/8	1-1/8	5/8
SAE 1095	327	35	165,000	1-15/16	1	1-5/8	13/16	1-1/2	3/4	1-3/8	11/16	1-1/4	5/8	1-1/16	9/16
SAE 1095	370	40	185,000	1-11/16	7/8	1-1/8	3/4	1-3/8	11/16	1-1/4	5/8	1-1/8	9/16	1	9/16
SAE 4140	415	44	195,000	1-9/16	3/4	1-3/8	11/16	1-1/4	5/8	1-1/8	9/16	1-1/16	1/2	15/16	1/2

MACHINE LOAD RATING BY MAT'L & THD. LENGTH FOR #10-400 THREAD ROLLER

CROSS REFERENCES	A	CADAM 9/3/86 FRIES	TOLERANCES FOR MACHINED DIMS. UNLESS OTHERWISE SPECIFIED: FRACTIONAL ± 1/64 DECIMAL .XX ± .015 DECIMAL .XXX ± .005 ANGLES ± 0°-30' SURFACE FINISH √ = 125 √	DO NOT SCALE THIS DRAWING REFER TO MACHINE ENGINEERING FOR DIMENSIONS		TITLE	MACHINE LOAD RATING	
	B	CONVERT TO AUTOCAD 4/9/97 JAT		MATERIAL	PART NO.		03500B80001	
				HEAT TREAT			Reed Machinery, Inc. 10A New Bond Street Worcester, MA 01606 USA	
				SCALE	DRAWN BY HARTFORD			
				DATE 9/2/86	CHECKED BY			

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES					REMARKS
	BHN	Rc		1/4 ø	5/16 ø	3/8 ø	7/16 ø	1/2 ø	
LEADRITE #6 CARTRIDGE BRASS	121 188	— —	56,000 56,300	3	3	3	2-5/8	2	REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
PHOS. BRONZE 8% MUELLER 88	126 115	— —	57,000 56,300	3	3	2-3/4	2-3/8	1-3/4	
11ST, 17S, 24S ALUMINUM	133-137	—	61-68,000	3	2-3/4	2-1/2	2-1/8	1-1/2	
SAE 1015	130	—	67,000	3	2-3/4	2-1/2	2-1/8	1-1/2	
SAE 1112 & 1114 OLYMPIC "A" BRASS	200 197	13 —	90,000 90,000	3	2-1/2	2-1/4	1-7/8	1-7/16	
NAVAL BRASS	156	—	77,000						
MONEL	229	—	103,000						
EVERDURE 1010	198	—	99,000						
SAE 1025	160	—	80,000	2-3/4	2-1/4	2	1-5/8	1-3/8	
SAE 3120 & 1144	190-225	11-20	80-105,000	2-1/2	2	1-3/4	1-1/2	1-5/16	
SAE 4615	190	11	90,000						
#347 STAINLESS	171	—	88,000						
SAE 1040	215	17	106,000	2-1/4	1-3/4	1-1/2	1-1/4	1-1/4	
SAE 1095 DRILL ROD	230	20	115,000						
SAE 1335	230	21	110,000						
SAE 3140	210	16	106,000						
SAE 3312	225	20	104,000						
SAE 4140	230	21	106,000						
SAE 6150	205	16	102,000						
SAE 8620	225	20	103,000						
SAE 8642	200	13	100,000						
#416 STAINLESS	219	18	97,000						
#430 STAINLESS	222	19	106,000						
SAE 1095 DRILL ROD	255	25	128,000	2	1-1/2	1-1/4	1-3/16	1-1/8	
SAE 4340	230	20	112,000						
M2 H.S.S.	235	22	113,000						
18-4-1 H.S.S.	240	23	110,000						
#303 STAINLESS	179	—	92,000						
#304 STAINLESS	163	—	86,000						
#316 STAINLESS	148	—	83,000						
SAE 1095 DRILL ROD	285	30	145,000	1-3/4	1-3/8	1-3/16	1-1/8	1	
SAE 4140	310	33	161,000						
#17A STAINLESS	304	32	131,000						
SAE 1095	327	35	165,000	1-1/2	1-1/4	1-1/8	1	7/8	
SAE 1095	370	40	185,000	1-3/8	1-1/8	1	7/8	3/4	

MACHINE LOAD RATING BY MAT'L & THD. LENGTH FOR #20-225 THREAD ROLLER

CROSS REFERENCES	A	CADAM 9/3/86 FRIES	TOLERANCES FOR MACHINED DIMS. UNLESS OTHERWISE SPECIFIED: FRACTIONAL ± 1/64 DECIMAL .XX ± .015 DECIMAL .XXX ± .005 ANGLES ± 0°-30' SURFACE FINISH √ = 125 √	DO NOT SCALE THIS DRAWING REFER TO MACHINE ENGINEERING FOR DIMENSIONS		TITLE MACHINE LOAD RATING	
	B	CONVERT TO AUTOCAD 4/9/97 JAT		MATERIAL		PART NO. 03202B00043	
				HEAT TREAT		Reed Machinery, Inc. 10A New Bond Street Worcester, MA 01606 USA	
				SCALE	DRAWN BY HARTFORD		
				DATE 9/2/86	CHECKED BY		

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES					REMARKS
	BHN	Rc		1/2 Ø	9/16 Ø	5/8 Ø	11/16 Ø	3/4 Ø	
LEADRITE #6 CARTRIDGE BRASS	121 188	— —	56,000 56,300	4	3-9/16	3-3/16	2-7/8	2-11/16	REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
PHOS. BRONZE 8% MUELLER 88 11ST, 17S, 24S ALUMINUM	126 115 133-137	— — —	57,000 56,300 61-68,000	3-1/2	3-1/8	2-13/16	2-9/16	2-5/16	
SAE 1015	130	—	67,000	3	2-11/16	2-7/16	2-3/16	2	
SAE 1112 & 1114 OLYMPIC "A" BRASS	200 197	13 —	90,000 90,000	2-7/8	2-9/16	2-5/16	2-1/16	1-15/16	
NAVAL BRASS	156	—	77,000						
MONEL	229	—	103,000						
EVERDURE 1010	198	—	99,000						
SAE 1025	160	—	80,000	2-3/4	2-7/16	2-3/16	2	1-13/16	
SAE 3120 & 1144	190-225	11-20	80-105,000	2-5/8	2-5/16	2-1/8	1-7/8	1-3/4	
SAE 4615	190	11	90,000						
#347 STAINLESS	171	—	88,000						
SAE 1040	215	17	106,000	2-1/2	2-1/4	2	1-13/16	1-11/16	
SAE 1095 DRILL ROD	230	20	115,000						
SAE 1335	230	21	110,000						
SAE 3140	210	16	106,000						
SAE 3312	225	20	104,000						
SAE 4140	230	21	106,000						
SAE 6150	205	16	102,000						
SAE 8620	225	20	103,000						
SAE 8642	200	13	100,000						
#416 STAINLESS	219	18	97,000						
#430 STAINLESS	222	19	106,000						
SAE 1095 DRILL ROD	255	25	128,000	2-1/4	2	1-13/16	1-5/8	1-1/2	
SAE 4340	230	20	112,000						
M2 H.S.S.	235	22	113,000						
18-4-1 H.S.S.	240	23	110,000						
#303 STAINLESS	179	—	92,000						
#304 STAINLESS	163	—	86,000						
#316 STAINLESS	148	—	83,000						
SAE 1095 DRILL ROD	285	30	145,000	2	1-3/4	1-5/8	1-7/16	1-5/16	
SAE 4140	310	33	161,000						
#17A STAINLESS	304	32	131,000						
SAE 1095	327	35	165,000	1-3/4	1-9/16	1-3/8	1-1/4	1-3/16	
SAE 1095	370	40	185,000	1-1/2	1-3/16	1-1/8	1-1/16	1	

MACHINE LOAD RATING BY MAT'L & THD. LENGTH FOR #40-140 THREAD ROLLER

CROSS REFERENCES	A	CADAM 9/3/86 FRIES	TOLERANCES FOR MACHINED DIMS. UNLESS OTHERWISE SPECIFIED:	DO NOT SCALE THIS DRAWING REFER TO MACHINE ENGINEERING FOR DIMENSIONS		TITLE	MACHINE LOAD RATING
	B	CONVERT TO AUTOCAD 4/9/97 JAT	FRACTIONAL ± 1/64 DECIMAL .XX ± .015 DECIMAL .XXX ± .005 ANGLES ± 0°-30° SURFACE FINISH √ = 125 √	MATERIAL		PART NO.	03900B18001
				HEAT TREAT		Reed Machinery, Inc. 10A New Bond Street Worcester, MA 01606 USA	
				SCALE	DRAWN BY HARTFORD		
				DATE 9/2/86	CHECKED BY		

MATERIAL	HARDNESS		ULT. TENS. PSI	ALLOWABLE THREAD LENGTH IN INCHES						REMARKS
	BHN	Rc		5/8	3/4	7/8	1	1-1/16	1-1/8	
LEADRITE #6 CARTRIDGE BRASS	121 188	- -	56,000 56,300	5-1/2	5-1/2	5-1/2	5-1/2	5-1/2	5-1/2	REDUCE LENGTH CAPACITY 50% FOR ROLLED POINT SCREWS AND 25% FOR POINT FORM SCREWS ALL SIZES
PHOS. BRONZE 8% MUELLER 88	126 115	- -	57,000 56,300	5-1/2	5-1/2	5-1/2	5-1/2	5-3/8	4-13/16	
11ST, 17S, 24S ALUMINUM	133-137	-	61-68,000							
SAE 1015	130	-	67,000	5-1/2	5-1/2	5-1/2	5-3/8	5	4-7/16	
SAE 1112 & 1114 OLYMPIC "A" BRASS	200 197	13 -	90,000 90,000							
NAVAL BRASS	156	-	77,000	5-1/2	5-1/2	5-3/16	4-11/16	4-1/4	3-13/16	
MONEL	229	-	103,000							
EVERDURE 1010	198	-	99,000							
SAE 1025	160	-	80,000	5-1/2	5-1/2	5	4-1/2	4-1/8	3-11/16	
SAE 3120 & 1144	190-225	11-20	80-105,000							
SAE 4615	190	11	90,000	5-3/8	4-11/16	4-1/8	3-11/32	3-7/16	3-1/8	
#347 STAINLESS	171	Ⓒ	88,000							
SAE 1040	215	17	106,000							
SAE 1095 DRILL ROD	230	20	115,000							
SAE 1335	230	21	110,000							
SAE 3140	210	16	106,000							
SAE 3312	225	20	104,000							
SAE 4140	230	21	106,000	5	4-1/4	3-3/4	3-7/16	3-1/8	2-3/4	
SAE 6150	205	16	102,000							
SAE 8620	225	20	103,000							
SAE 8642	200	13	100,000							
#416 STAINLESS	219	18	97,000							
#430 STAINLESS	222	19	106,000							
SAE 1095 DRILL ROD	255	25	128,000							
SAE 4340	230	20	112,000							
M2 H.S.S.	235	22	113,000							
18-4-1 H.S.S.	240	23	110,000	4-1/4	3-11/16	3-5/16	3	2-3/4	2-1/2	
#303 STAINLESS	179	-	92,000							
#304 STAINLESS	163	-	86,000							
#316 STAINLESS	148	-	83,000							
SAE 1095 DRILL ROD	285	30	145,000							
SAE 4140	310	33	161,000							
#17A STAINLESS	304	32	131,000	3-3/4	3-3/8	3	2-11/16	2-1/2	2-5/16	
SAE 1095	327	35	165,000	3-1/2	3	2-13/16	2-1/2	2-3/8	2-3/16	
SAE 1095	370	40	185,000	3-3/16	2-7/8	2-5/8	2-7/16	2-1/4	2-1/16	

MACHINE LOAD RATING BY MAT'L & THD. LENGTH FOR 60-100 THREAD ROLLER

CROSS REFERENCES		TOLERANCES FOR MACHINED DIMS. UNLESS OTHERWISE SPECIFIED:		DO NOT SCALE THIS DRAWING REFER TO MACHINE ENGINEERING FOR DIMENSIONS		TITLE
A	REVISED 8-14-84 PAB	FRACTIONAL	± 1/64	MATERIAL		MACHINE LOAD RATING
B	WAS 1321,000 9/3/86 FRIES	DECIMAL .XX	± .015	HEAT TREAT		
C	WAS - 9/3/86 FRIES	DECIMAL .XXX	± .005	SCALE	DRAWN BY BAUGHMAN	PART NO. 03700B23001
D	CONVERT TO AUTOCAD 4/9/97 JAT	ANGLES	± 0°-30'	DATE 8-3-84	CHECKED BY	
		SURFACE FINISH	√ = 125 √			

Reed
Machinery, Inc.
10A New Bond Street
Worcester, MA 01606
USA