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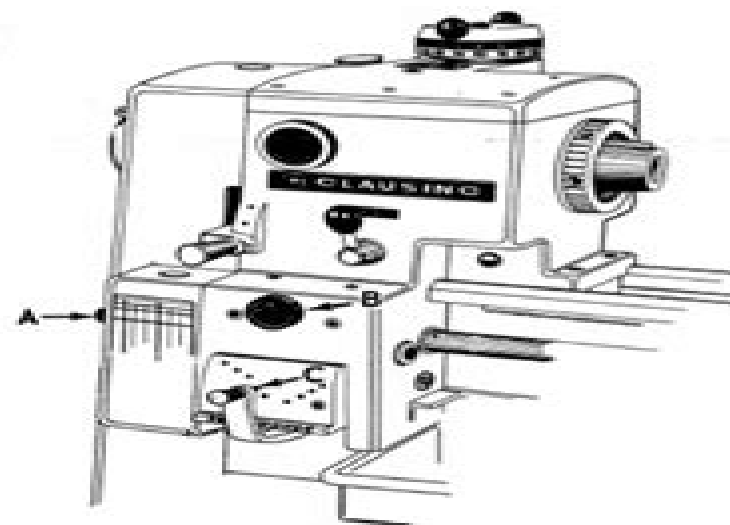
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	SLIDE GEAR IN			SLIDE GEAR OUT		
	B	C	A	B	C	A
1	4	8	16	32	64	128
	.0367	.0183	.0092	.0046	.0022	.0011
2	4 1/2	9	18	36	72	144
	.0326	.0163	.0081	.0041	.0020	.00094
3	5	10	20	40	80	160
	.0293	.0147	.0073	.0036	.0018	.00092
4	5 1/2	11	22	44	88	176
	.0267	.0134	.0066	.0033	.0017	.00083
5	5 3/4	11 1/2	23	46	92	184
	.0255	.0127	.0063	.0031	.0016	.00079
6	7	14	28	56	112	224
	.0209	.0105	.0052	.0026	.0013	.00065
7	6 3/4	13 1/2	27	54	108	216
	.0218	.0109	.0054	.0027	.00136	.00068
8	6 1/2	13	26	52	104	208
	.0226	.0113	.0056	.0028	.0014	.0007
9	6	12	24	48	96	192
	.0244	.0122	.0061	.003	.0015	.00076



LEGEND

A. GEAR SHIFTER HANDLE changes ratio between spindle and lead screw. There are two positions - IN and OUT. Do not shift while spindle is turning.

B. GEAR SHIFTER KNOB has three positions - B, C or A. Engaged position is vertical. If knob doesn't shift easily, place lead screw direction lever in neutral (center position), and turn sliding gear handle until knob can be engaged - do not force.

C. GEAR SHIFTER LEVER. To shift, pull out on handle, drop lever, slide to position desired, raise lever and push in handle to engage lock pin. If thread-feed selector handle does not slide easily, turn sliding gear shifter handle (A) while shifting.

CROSS FEED 1/2 OF LONGITUDINAL

Clausing Model 110 Lathe Manual

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