

## **DETERMINING LATHE SPINDLE THREAD SIZE**

(to find the correct NOVA insert adaptor)

Refer to the insert/adaptor chart (last page) to see if your lathe is listed.

If listed make a note of the SKU: \_\_\_\_\_ (example IDNS, IENS, etc)

If not listed, look in your manual or sales literature to find the thread size.

**Make a note of these:**

**Machine make:**

**Machine model thread size (if known):**

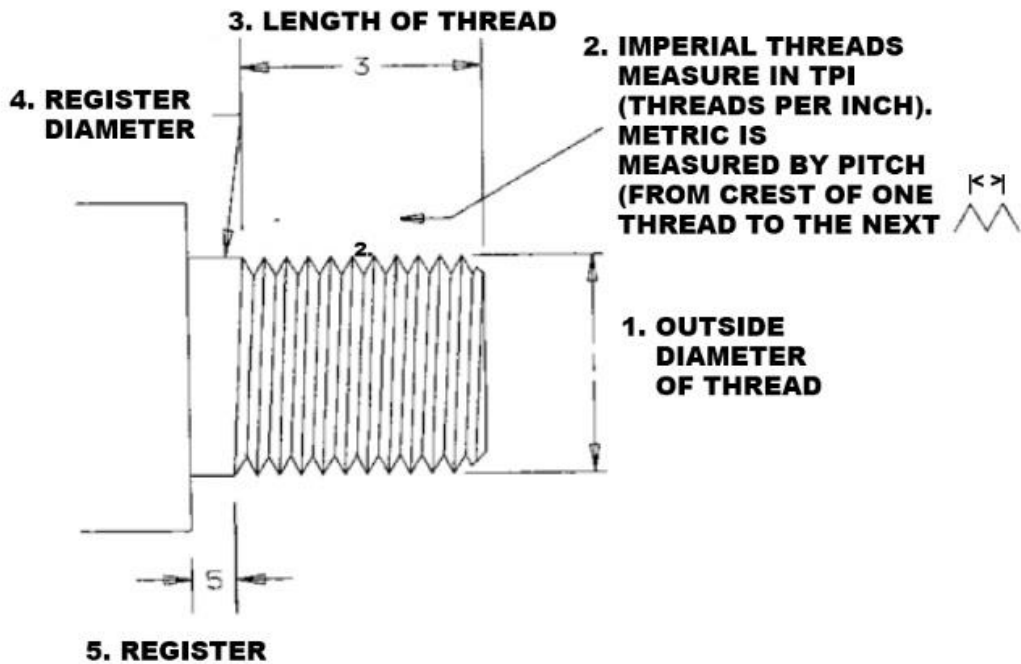
**Inboard thread (LH - left hand or RH right hand or both:**

(Look at our insert/adaptor chart to find your size)

If you don't have a manual, contact your supplier to get a copy of your manual and find out your spindle size. If they don't have the info. you can call your manufacturer. (Then look at our insert/adaptor chart on the last page to find your size).

If you have reliable information for your spindle thread size but there is no match on the chart, you may have an unusual lathe that NOVA doesn't have an adaptor for. You will need to purchase a blank chuck or a blank insert/adaptor and get it threaded to your requirements.

If you can't find the information on your spindle thread size you will need to take some measurements on your lathe spindle (next page). You'll only need to do these measurements if you can't find the info anywhere else.



**TAKE THESE MEASUREMENTS:**

1. Outside diameter of thread:
2. Pitch of thread:
3. Length of thread:
4. Register diameter:
5. Register length:

**Caution:**

Ensure that the thread on the adapter and lathe spindle has the exact same pitch and standard. Even if the thread size is the same there are different standards of threads, e.g. UNC/UNF and BSW. If mismatching standard threads are used it may cause damage to both lathe and chuck therefore you will have to know the thread of the spindle accurately.

**Quickly distinguish between Unified (UNC or UNF) and British (BSF or BSW) standards:**

FLAT TOP = 60° angle (UNC, UNF, Metric threads) VS. ROUND TOP = 55° angle: BSW, BSF, Whitworth

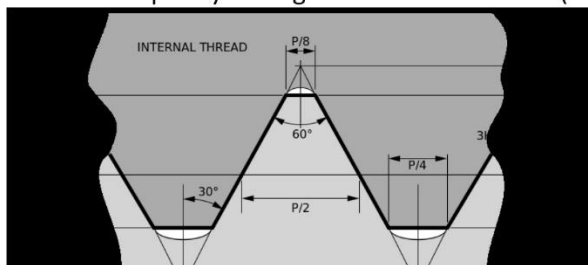


Figure 1: Unified Standard

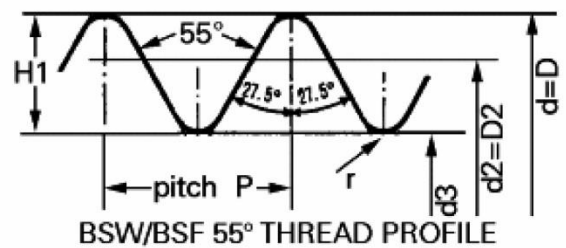


Figure 2: British Standard

SKU	THREAD DIAMETER	THREAD PITCH	THREAD DIRECTION	STANDARD	COMPATIBLE LATHES	SET SCREW
I2NS	M20	2			Tyme Cub	
I3NS	M20	1.5			Electra Beckum, Multico Sumaro	
I6NS	¾"			Plain bore		M6
I7NS	1 1/8"	8TPI		UN		
I8NS	7/8"	12TPI	LH	NS		
I9NS	3/4"	16TPI	RH		W 6mm register	
IANS	3/4"	14TPI	RH	BSP	TL1000 (pre 1986)	
IBNS	3/4"	14TPI	LH	BSP	TL1000 (pre 1986)	
ICNS	1"	10TPI	RH	BSF	TL1000, Woodfast/Durden	
IDNS	1"	8TPI	RH	UNC	Delta, Rockwell, Golding, General, NOVA Comet (North America), Mercury	
IENS	1"	12TPI	RH	UNF	Myford ML8, Turnstyler	
IFNS	5/8"			Plain bore	Shopsmith	
IHNS	3/4"	10TPI	RH	BSW	Rockwell Homecraft	
IINS	M24	M24	RH		B-Line Arundel K600/K450	
IJNS	1 1/8"	12TPI	RH	BSW	Myford Mystro Masterlathe (NZ)	
IKNS	M18	M18	RH		Elu DB 180	
ILNS	1 1/4"	8TPI	RH	UNS	NOVA Galaxi, NOVA Saturn, NOVA DVR 3000, NOVA XP, NOVA 1624 and 1624 II (North America), Laguna Revo	M6
IMNS	1"	10TPI	LH	BSF	TL1000, Woodfast/Durden	
INNS			Blank insert	Can be threaded to 28mm or 1 7/64"		
IONS	1 1/8"	7TPI	RH	BSW	Morton	
IQNS	M30	3.5	RH		TL1500/3000/Comet (Euro & S.Hemisphere) Woodfast	
IRNS	1"	8TPI	RH		Jet 1221 Lathe	
ISNS	5/8"			Plain bore	Shopsmith Pro V and Power Pro	M6
ITNS	1"	8TPI	RH and LH dual thread		NOVA Mercury Mini	
IUNS	1 1/8"	12TPI	RH	UNF	Taiwanese lathes	
IVNS	7/8"	14TPI	RH	NF		
IWNS	M25	2	RH	UNS	Tyme Avon ('83 on) and Classic Tanner SD165, Selbix Springwood, Sorby, Cotech	
IXNS	1"	8TPI	RH		Designed for Comet II Midi Lathe, features lock for the reverse function.	M6
IYNS	1 1/4"	8TPI	RH		For lathes that don't have reverse turning ability	