

Carriage Feed Rates Jet 9x20 BD-920N

Gearing 40/80/40

Gear (a)	16	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0047	
2	0.0041	
3	0.0039	
4	0.0037	
5	0.0034	
6	0.0032	
7	0.0031	
8	0.0029	
9	0.0027	

Gearing 40/80/40

Gear (a)	24	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0070	
2	0.0062	
3	0.0059	
4	0.0056	
5	0.0051	
6	0.0049	
7	0.0047	
8	0.0043	
9	0.0040	

Gearing 40/80/40

Gear (a)	28	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0082	
2	0.0072	
3	0.0069	
4	0.0065	
5	0.0059	
6	0.0057	
7	0.0054	
8	0.0050	
9	0.0047	

Gearing 40/80/40

Gear (a)	30	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0087	
2	0.0078	
3	0.0074	
4	0.0070	
5	0.0064	
6	0.0061	
7	0.0058	
8	0.0054	
9	0.0050	

Gearing 40/80/40

Gear (a)	36	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0105	
2	0.0093	
3	0.0088	
4	0.0084	
5	0.0076	
6	0.0073	
7	0.0070	
8	0.0065	
9	0.0060	

Gearing 40/80/40

Gear (a)	40	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0116	
2	0.0104	
3	0.0098	
4	0.0093	
5	0.0085	
6	0.0081	
7	0.0078	
8	0.0072	
9	0.0067	

Gearing 40/80/40

Gear (a)	42	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0122	
2	0.0109	
3	0.0103	
4	0.0098	
5	0.0089	
6	0.0085	
7	0.0082	
8	0.0075	
9	0.0070	

Gearing 40/80/40

Gear (a)	45	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0131	
2	0.0116	
3	0.0110	
4	0.0105	
5	0.0095	
6	0.0091	
7	0.0087	
8	0.0081	
9	0.0075	

Gearing 40/80/40

Gear (a)	60	<i>127</i>
Gear (b)	<i>120</i>	60
Lever	Feed (IPR)	
1	0.0175	
2	0.0155	
3	0.0147	
4	0.0140	
5	0.0127	
6	0.0122	
7	0.0116	
8	0.0108	
9	0.0100	

NOTE: All combinations were not tested use at your own risk every effort regarding accuracy has been taken but no guarantees regarding accuracy stated or implied.

Carriage Feed Rates Jet 9x20 BD-920N

Gearing 40/80/40

Gear (a)	16	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0035
2	0.0031
3	0.0029
4	0.0028
5	0.0025
6	0.0024
7	0.0023
8	0.0022
9	0.0020

Gearing 40/80/40

Gear (a)	24	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0052
2	0.0047
3	0.0044
4	0.0042
5	0.0038
6	0.0036
7	0.0035
8	0.0032
9	0.0030

Gearing 40/80/40

Gear (a)	28	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0061
2	0.0054
3	0.0051
4	0.0049
5	0.0044
6	0.0043
7	0.0041
8	0.0038
9	0.0035

Gearing 40/80/40

Gear (a)	30	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0066
2	0.0058
3	0.0055
4	0.0052
5	0.0048
6	0.0046
7	0.0044
8	0.0040
9	0.0037

Gearing 40/80/40

Gear (a)	36	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0079
2	0.0070
3	0.0066
4	0.0063
5	0.0057
6	0.0055
7	0.0052
8	0.0048
9	0.0045

Gearing 40/80/40

Gear (a)	40	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0087
2	0.0078
3	0.0074
4	0.0070
5	0.0064
6	0.0061
7	0.0058
8	0.0054
9	0.0050

Gearing 40/80/40

Gear (a)	42	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0092
2	0.0082
3	0.0077
4	0.0073
5	0.0067
6	0.0064
7	0.0061
8	0.0056
9	0.0052

Gearing 40/80/40

Gear (a)	45	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0098
2	0.0087
3	0.0083
4	0.0079
5	0.0071
6	0.0068
7	0.0066
8	0.0060
9	0.0056

Gearing 40/80/40

Gear (a)	60	<i>127</i>
Gear (b)	<i>120</i>	80

Lever	Feed (IPR)
1	0.0131
2	0.0116
3	0.0110
4	0.0105
5	0.0095
6	0.0091
7	0.0087
8	0.0081
9	0.0075

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Carriage Feed Rates Jet 9x20 BD-920N

Gearing 40/80/40

Gear (a)	16	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0023	
2	0.0021	
3	0.0020	
4	0.0019	
5	0.0017	
6	0.0016	
7	0.0016	
8	0.0014	
9	0.0013	

Gearing 40/80/40

Gear (a)	24	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0035	
2	0.0031	
3	0.0029	
4	0.0028	
5	0.0025	
6	0.0024	
7	0.0023	
8	0.0022	
9	0.0020	

Gearing 40/80/40

Gear (a)	28	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0041	
2	0.0036	
3	0.0034	
4	0.0033	
5	0.0030	
6	0.0028	
7	0.0027	
8	0.0025	
9	0.0023	

Gearing 40/80/40

Gear (a)	30	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0044	
2	0.0039	
3	0.0037	
4	0.0035	
5	0.0032	
6	0.0030	
7	0.0029	
8	0.0027	
9	0.0025	

Gearing 40/80/40

Gear (a)	36	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0052	
2	0.0047	
3	0.0044	
4	0.0042	
5	0.0038	
6	0.0036	
7	0.0035	
8	0.0032	
9	0.0030	

Gearing 40/80/40

Gear (a)	40	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0058	
2	0.0052	
3	0.0049	
4	0.0047	
5	0.0042	
6	0.0041	
7	0.0039	
8	0.0036	
9	0.0033	

Gearing 40/80/40

Gear (a)	42	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0061	
2	0.0054	
3	0.0051	
4	0.0049	
5	0.0044	
6	0.0043	
7	0.0041	
8	0.0038	
9	0.0035	

Gearing 40/80/40

Gear (a)	45	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0066	
2	0.0058	
3	0.0055	
4	0.0052	
5	0.0048	
6	0.0046	
7	0.0044	
8	0.0040	
9	0.0037	

Gearing 40/80/40

Gear (a)	60	<i>127</i>
Gear (b)	<i>120</i>	120
Lever	Feed (IPR)	
1	0.0087	
2	0.0078	
3	0.0074	
4	0.0070	
5	0.0064	
6	0.0061	
7	0.0058	
8	0.0054	
9	0.0050	

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Carriage English Thread Rates Jet 9x20 BD-920N

Gearing 40/80/40

Gear (a)	80	127
Gear (b)	127	20
Lever	TPI	
1	4	
2	4.5	
3		
4	5	
5	5.5	
6		
7	6	
8	6.5	
9	7	

Gearing 40/80/40

Gear (a)	60	127
Gear (b)	127	30
Lever	TPI	
1	8	
2	9	
3	9.5	
4	10	
5	11	
6	11.5	
7	12	
8	13	
9	14	

Gearing 40/80/40

Gear (a)	60	127
Gear (b)	127	60
Lever	TPI	
1	16	
2	18	
3	19	
4	20	
5	22	
6	23	
7	24	
8	26	
9	28	

Gearing 40/80/40

Gear (a)	30	127
Gear (b)	127	60
Lever	TPI	
1	32	
2	36	
3	38	
4	40	
5	44	
6	46	
7	48	
8	52	
9	56	

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Carriage Metric Thread Rates Jet 9x20 BD-920N

Gearing 40/80/40

Gear (a)	30	127
Gear (b)	120	60
Lever	Pitch	
1	0.75	
2		
3		
4		
5		
6		
7	0.5	
8		
9		

Gearing 40/80/40

Gear (a)	28	127
Gear (b)	120	60
Lever	Pitch	
1	0.7	
2		
3		
4		
5		
6		
7		
8		
9		

Gearing 40/80/40

Gear (a)	30	127
Gear (b)	120	45
Lever	Pitch	
1	1	
2		
3		
4	0.8	
5		
6		
7		
8		
9		

Gearing 40/80/40

Gear (a)	30	127
Gear (b)	120	30
Lever	Pitch	
1	1.5	
2		
3		
4		
5		
6		
7	1	
8		
9		

Gearing 40/80/40

Gear (a)	30	127
Gear (b)	120	36
Lever	Pitch	
1	1.25	
2		
3		
4	1	
5		
6		
7		
8		
9		

Gearing 40/80/40

Gear (a)	42	127
Gear (b)	120	36
Lever	Pitch	
1	1.75	
2		
3		
4		
5		
6		
7		
8		
9	1	

Gearing 40/80/40

Gear (a)	60	127
Gear (b)	120	30
Lever	Pitch	
1	3	
2		
3		
4		
5		
6		
7	2	
8		
9		

Gearing 40/80/40

Gear (a)	60	127
Gear (b)	120	36
Lever	Pitch	
1	2.5	
2		
3		
4	2	
5		
6		
7		
8		
9		

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