INDEXING HEAD - 40:1 RATIO

INDEXING IN DEGREES

40 complete turns of the index crank are required to turn the spindle 360 degrees. Therefore one complete turn of the index crank equals:

$$\frac{360}{40} = 9 \text{ degrees}$$

An indexing plate with 18 holes may be used to index in degrees.

$$\text{18 hole index plate} = \frac{18}{9} = 2 \text{ holes per degree}$$

GOP 1-15-16

INDEXING HEAD - 40:1 RATIO

INDEXING BY NUMBER OF DIVISIONS

Required number of circle divisions becomes a fraction of 40 and the indexing calculations is made with the following formula:

$$\text{Index crank turns} = \frac{40}{N}$$

Example: Calculate indexing for 8 divisions: $\frac{40}{8} = 5$ full turns of the crank handle

Example: Calculate indexing for 27 divisions:

$\frac{40}{27} = 1$ full turns of the crank handle plus $\frac{13}{27}$ fractional turn. Install a 27 hole indexing plate and use 13 holes.