

## TRUE ELLIPSE ...PREFORMING INSTRUCTIONS BY THE MICROMETER HEIGHT ADJUSTMENT METHOD

Table 72 - 2

## MICROMETER HEIGHT ADJUSTMENT FOR 72 INDEX

		Micrometer Height to be ADDED to Width					
Ellipse Size (mm)	Width (in.)	4 x 6	5 x 7	6 x 8	7 x 9	8 x 10	9 x 11
		0.1575	0.1968	0.2362	0.2756	0.3150	0.3543
INDEX SETTING							
36	72	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000
35 - 37	- 01 - 71	0.0004	0.0004	0.0003	0.0003	0.0003	0.0003
34 - 38	- 02 - 70	0.0015	0.0014	0.0014	0.0014	0.0013	0.0013
33 - 39	- 03 - 69	0.0032	0.0031	0.0030	0.0030	0.0029	0.0029
32 - 40	- 04 - 68	0.0056	0.0054	0.0053	0.0052	0.0051	0.0050
31 - 41	- 05 - 67	0.0083	0.0081	0.0079	0.0078	0.0077	0.0076
30 - 42	- 06 - 66	0.0115	0.0112	0.0110	0.0108	0.0107	0.0106
29 - 43	- 07 - 65	0.0148	0.0145	0.0143	0.0141	0.0140	0.0139
28 - 44	- 08 - 64	0.0182	0.0179	0.0177	0.0175	0.0173	0.0172
27 - 45	- 09 - 63	0.0216	0.0213	0.0211	0.0209	0.0208	0.0207
26 - 46	- 10 - 62	0.0249	0.0246	0.0244	0.0243	0.0241	0.0240
25 - 47	- 11 - 61	0.0280	0.0278	0.0276	0.0275	0.0273	0.0273
24 - 48	- 12 - 60	0.0309	0.0307	0.0305	0.0304	0.0303	0.0302
23 - 49	- 13 - 59	0.0334	0.0332	0.0331	0.0330	0.0329	0.0329
22 - 50	- 14 - 58	0.0355	0.0354	0.0353	0.0352	0.0352	0.0351
21 - 51	- 15 - 57	0.0372	0.0371	0.0370	0.0370	0.0369	0.0369
20 - 52	- 16 - 56	0.0384	0.0383	0.0383	0.0383	0.0383	0.0383
19 - 53	- 17 - 55	0.0391	0.0391	0.0391	0.0391	0.0391	0.0391
18	54	0.0394	0.0394	0.0394	0.0394	0.0394	0.0394

General Instructions: First cut alternately at 36 and 72 until the desired width (W) is attained. Note the width (either inches or millimeters) and the micrometer setting (in inches). Move the index to the next setting and add the appropriate height (from the table) before cutting the facet.

NOTE: All tables using 72 INDEX calculated by Robert H Jong.  
All tables using 96 INDEX calculated by Norman W Steele.