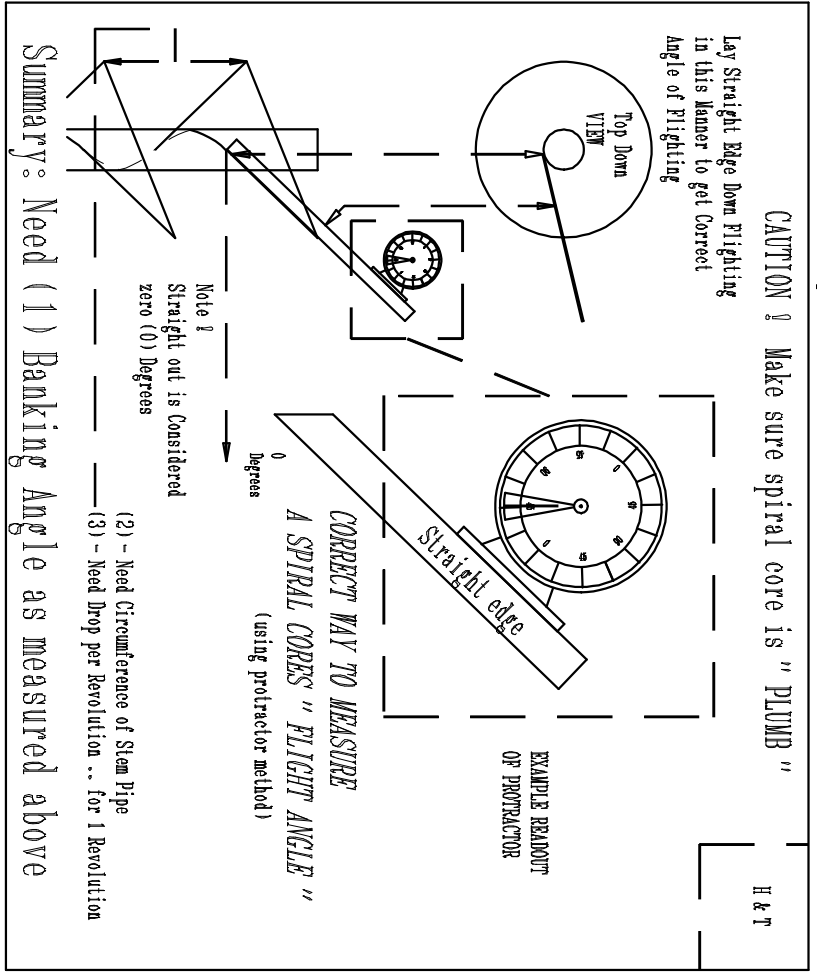
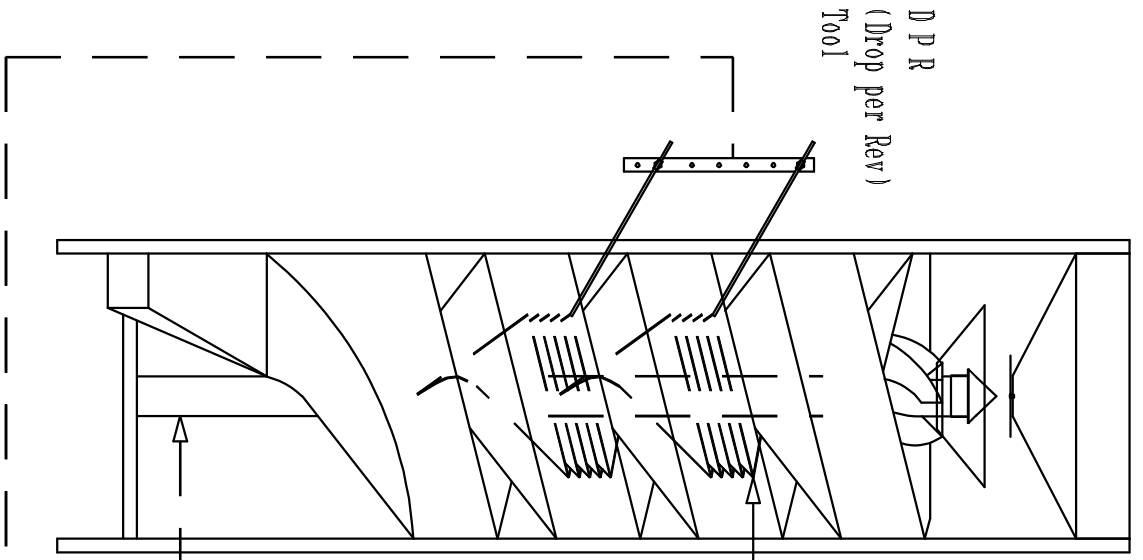


A Word About . . .

“ ANGLES ”

Note! These (3) Measurements are needed in order for us at H & T to Duplicate you core Parameters

Note! To Measure Banking on an "OPEN Spiral" Use "... TOP Flight" (1)



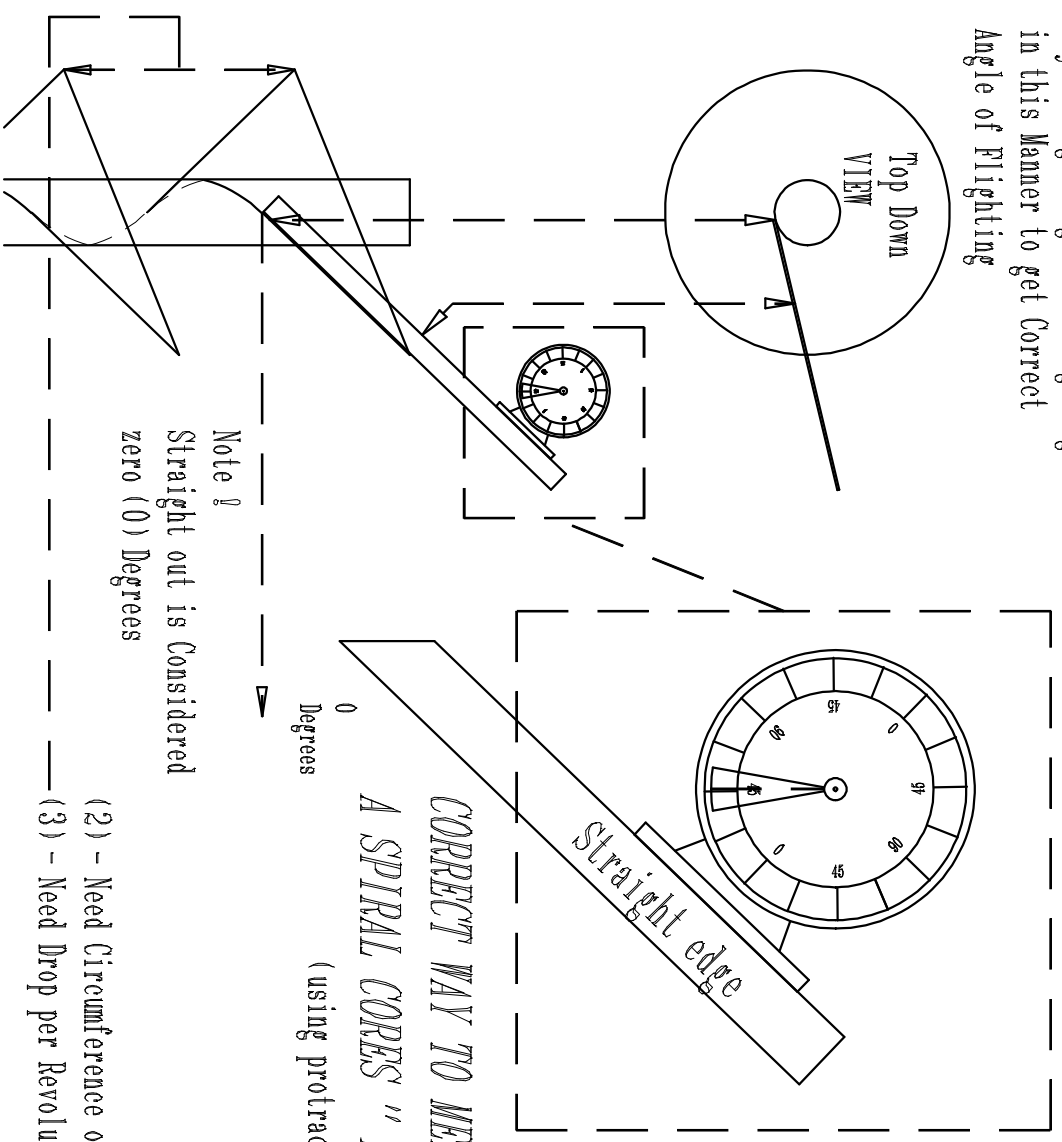
Note! Use special DPR Tool to measure length between Flighting

- (2) Circumference of Stem Pipe
- (3) Drop per Revolution of Flighting (Inches)

CAUTION ! Make sure spiral core is " PLUMB "

H & T

Lay Straight Edge Down Flighting
in this Manner to get Correct
Angle of Flighting



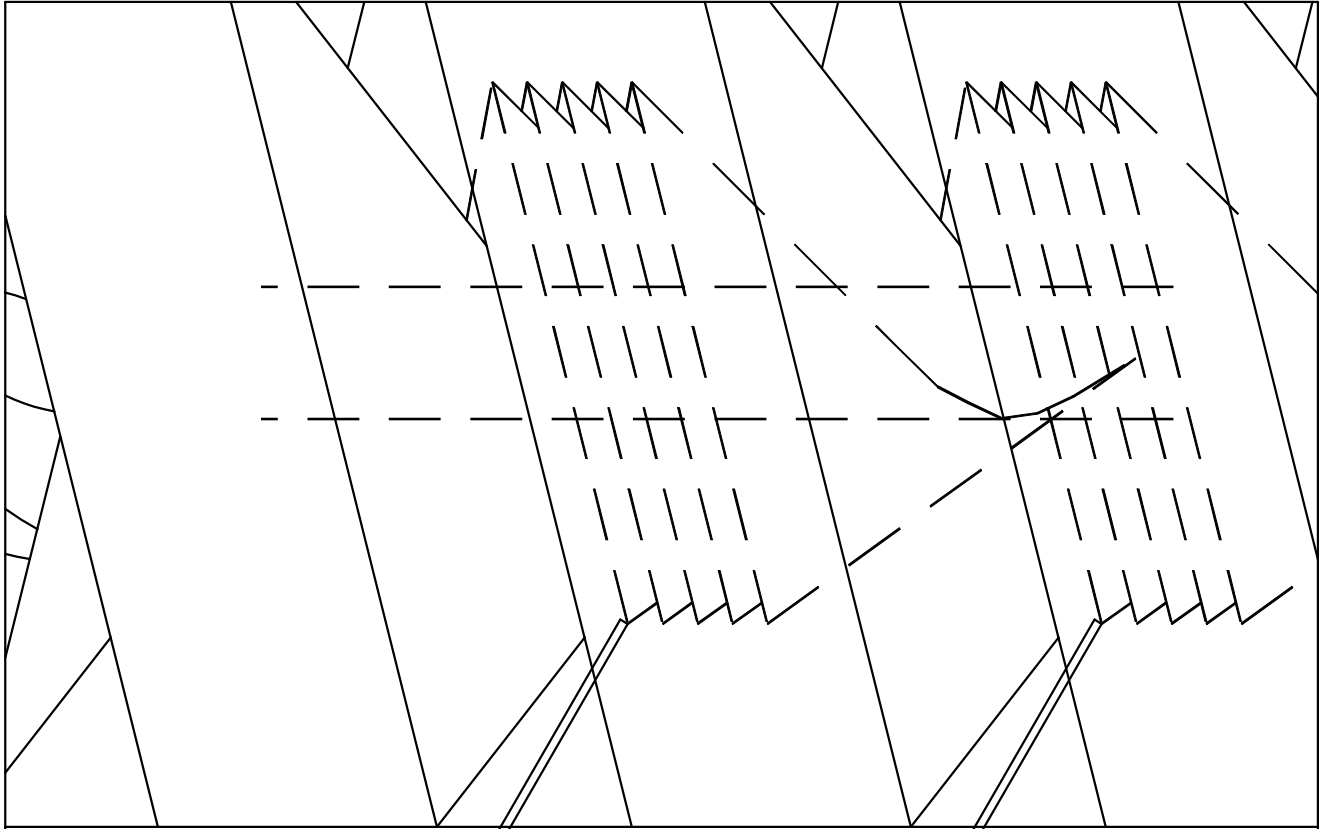
EXAMPLE READOUT
OF PROTRACTOR

CORRECT WAY TO MEASURE
A SPIRAL CORES " FLIGHT ANGLE "
(using protractor method)

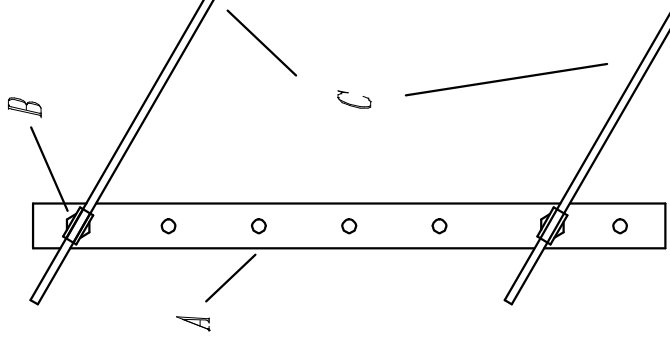
Note !
Straight out is Considered
zero (0) Degrees

- (2) - Need Circumference of Stem Pipe
- (3) - Need Drop per Revolution .. for 1 Revolution

Summary: Need (1) Banking Angle as measured above



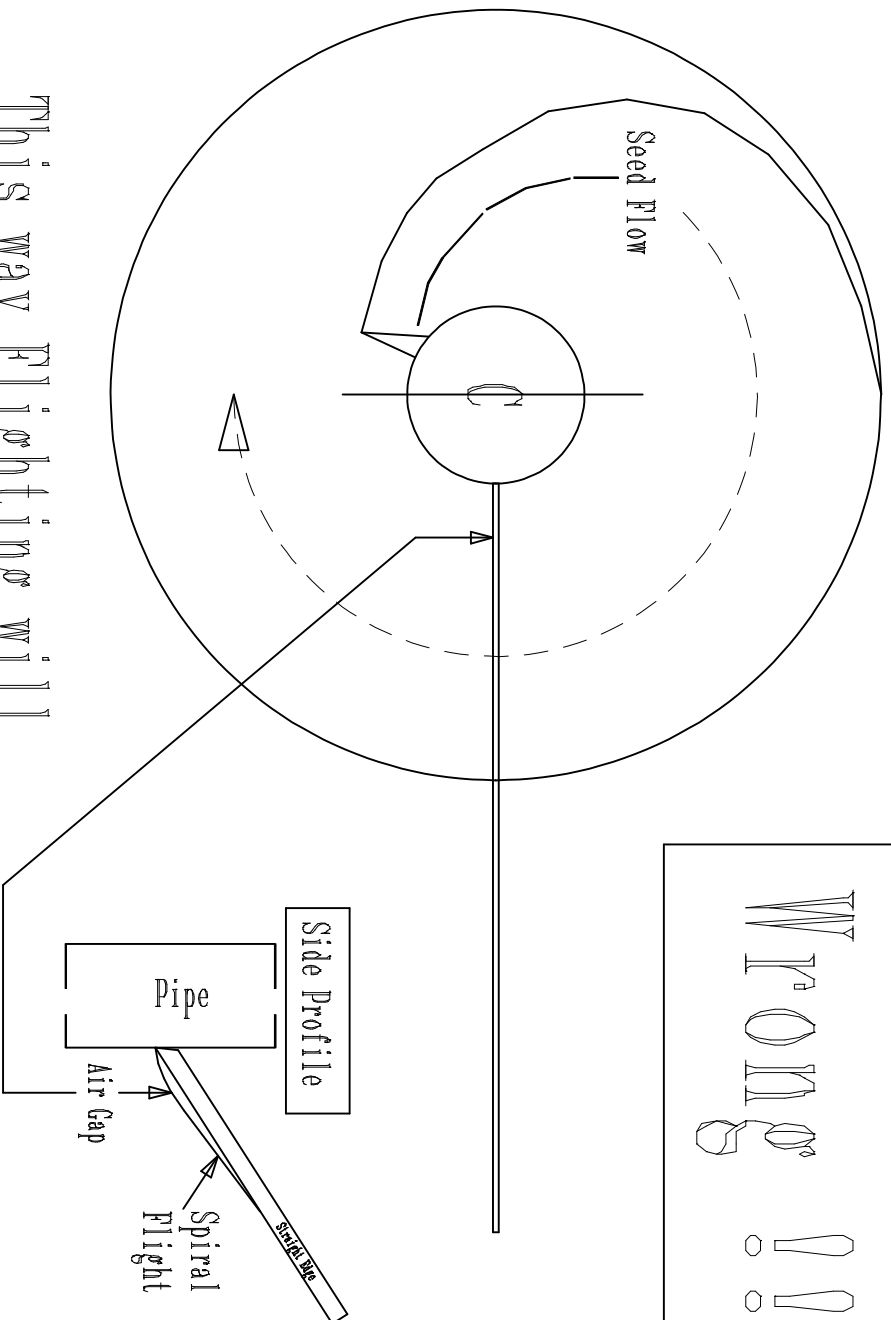
*Home made
" Drop per Revolution "
Tool*



- A - 1" x 1" sq. tubing*
- B - Small " Bolt with Wing Nut "
welded to a " Long 3/16" Nut "
to " Screw in Ahead"*
- C - 3/16" Allthread approx 14" Long*

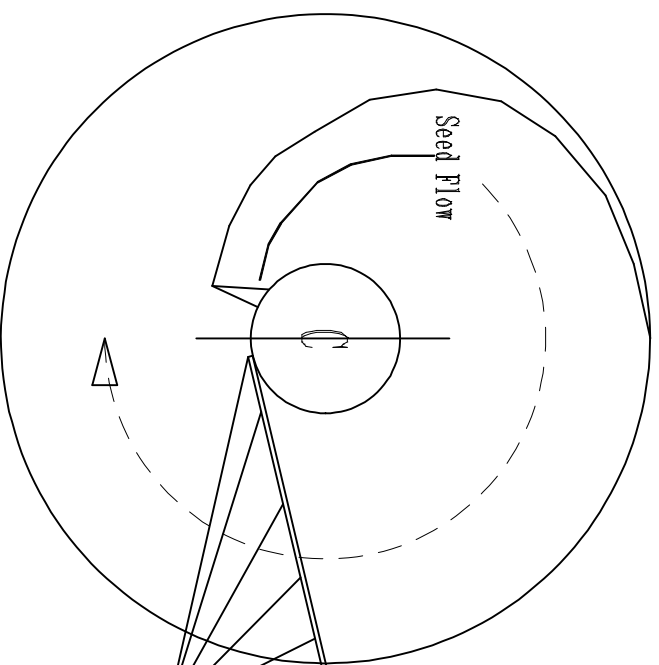
Top Down View #1 Flight

Wrong !!



This way Flighting will
Curve away from Straight edge !

Top Down View #1 Flight



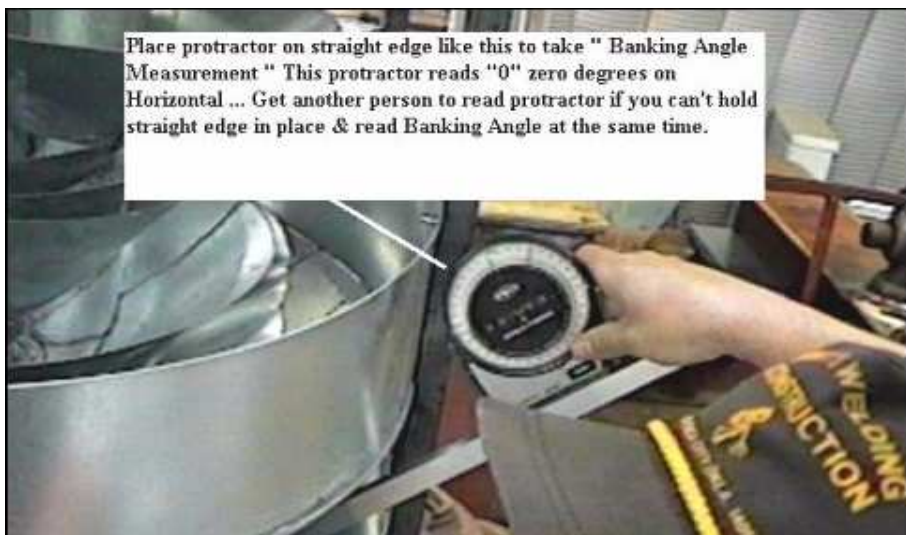
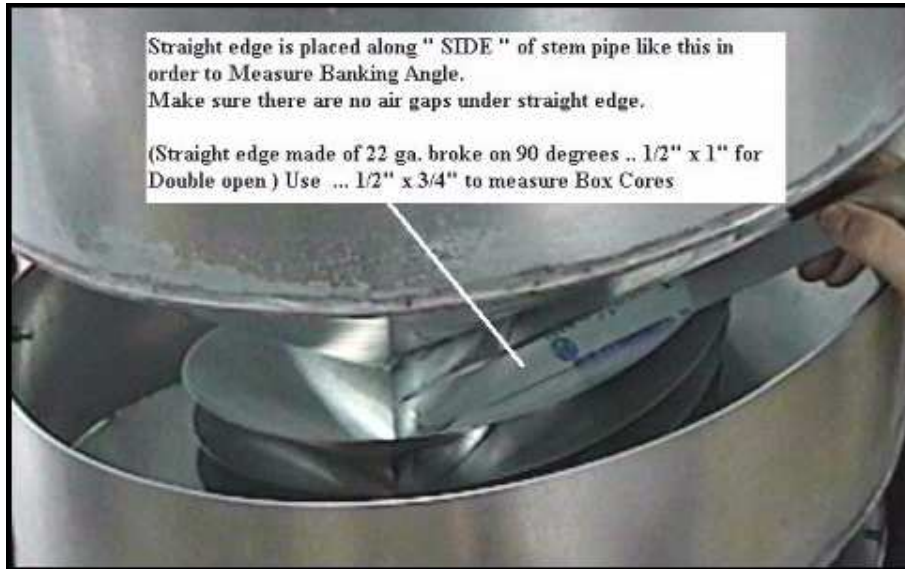
Right ?

There will be no
Air Gaps under Straight edge
When layed this way !

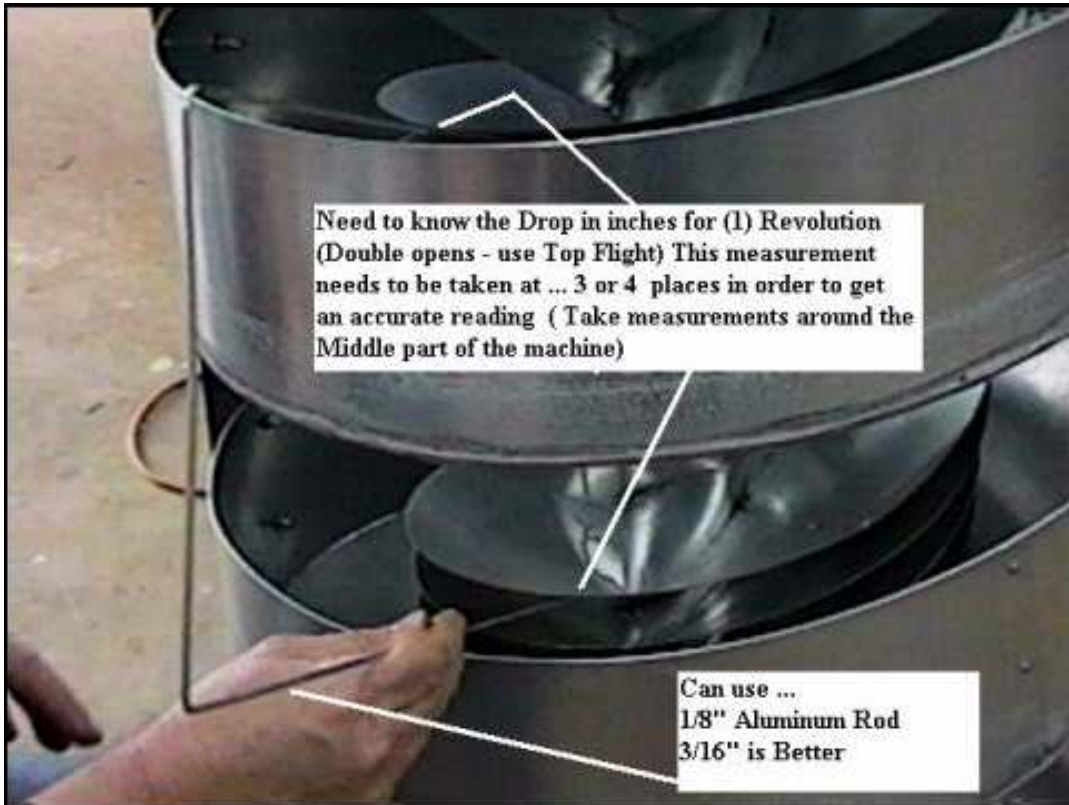
This way Flighting will
form a straight line !

Thus a " True Banking Angle will be Found "

Measuring the Banking Angle



Measuring the Drop per Revolution



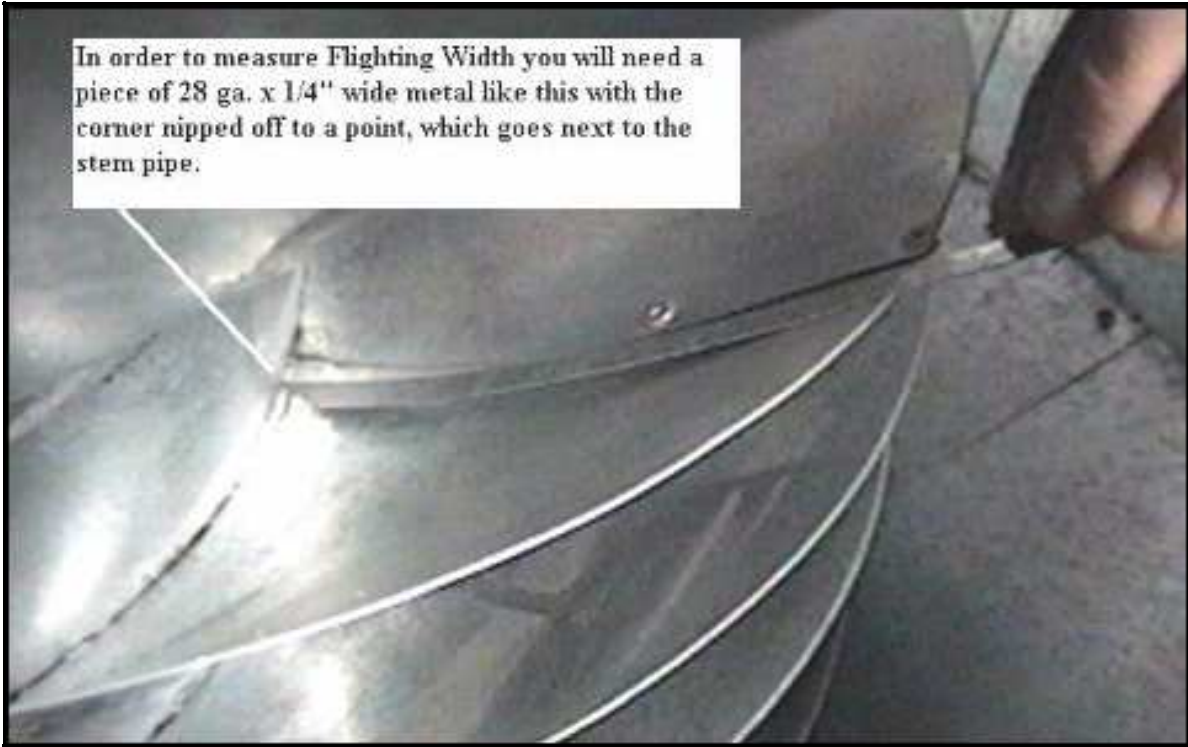
Measuring the Circumference of the Stem Pipe



We need an Accurate Stem Pipe Circumference Measurement. One of the best ways to do this is to use a 28 ga. x 1/4 " wide metal Wrap Around Overlap & Mark. Then straighten wrap around out & measure with a tape measurer.

Measuring the Width of the Flighting

In order to measure Flighting Width you will need a piece of 28 ga. x 1/4" wide metal like this with the corner ripped off to a point, which goes next to the stem pipe.



Curve the 28 ga. metal strip along the curve of the flighting seam (where flighting is attached to each other) making sure the point of the strip is next to pipe & mark strip at the outer edge of the Flighting. This is the width of your Flighting

