



Twist	Piece	Number	d	d'	d''	twist
12 each way	a	24	$2' 7\frac{5}{16}"$	$2' 6\frac{3}{8}"$	$1\frac{1}{4}"$	$77\frac{1}{2}^\circ$
" " "	b	24	$2' 6\frac{3}{8}"$	$2' 5\frac{7}{16}"$	"	$82\frac{1}{2}$
" " "	c	24	$2' 5\frac{15}{16}"$	$2' 5"$	"	$87\frac{1}{2}^\circ$
	d	2	$4\frac{7}{16}"$	$3\frac{1}{2}"$	$1\frac{1}{2}"$	$62\frac{1}{2}^\circ$
	e	2	$3\frac{7}{8}"$	$2\frac{15}{16}"$	"	$82\frac{1}{2}^\circ$
	f	2	$4"$	$3\frac{1}{16}"$	"	$77\frac{1}{2}^\circ$
	g	2	$4\frac{3}{4}"$	$3\frac{13}{16}"$	"	$57\frac{1}{2}^\circ$
	h	2	$5\frac{1}{8}"$	$4\frac{3}{16}"$	"	$52\frac{1}{2}^\circ$
	i	2	$4\frac{1}{16}"$	$3\frac{1}{8}"$	"	$72\frac{1}{2}^\circ$
	j	2	$3\frac{7}{8}"$	$2\frac{15}{16}"$	"	$87\frac{1}{2}^\circ$
	k	2	$4\frac{1}{4}"$	$3\frac{5}{16}"$	"	$67\frac{1}{2}^\circ$
	l	2	$5\frac{5}{8}"$	$4\frac{1}{16}"$	"	$47\frac{1}{2}^\circ$
	m	8	$1' 6\frac{9}{16}"$	$1' 5\frac{5}{8}"$	$1"$	$72\frac{1}{2}^\circ$
	n	8	$1' 5\frac{13}{16}"$	$1' 4\frac{7}{8}"$	"	$77\frac{1}{2}^\circ$
	o	8	$1' 5\frac{5}{16}"$	$1' 4\frac{3}{8}"$	"	$82\frac{1}{2}^\circ$
	p	8	$1' 5\frac{11}{16}"$	$1' 4\frac{1}{8}"$	"	$87\frac{1}{2}^\circ$
	q	8	$1' 6\frac{7}{16}"$	$1' 5\frac{1}{2}"$	"	$67\frac{1}{2}^\circ$
	r	8	$1' 5\frac{7}{16}"$	$1' 4\frac{1}{2}"$	"	$72\frac{1}{2}^\circ$
	s	8	$1' 4\frac{3}{4}"$	$1' 3\frac{13}{16}"$	"	$77\frac{1}{2}^\circ$
	t	8	$1' 4\frac{5}{16}"$	$1' 3\frac{3}{8}"$	"	$82\frac{1}{2}^\circ$
	u	8	$1' 4\frac{1}{16}"$	$1' 3\frac{1}{8}"$	"	$87\frac{1}{2}^\circ$

drill only one end