

Wide speed range

The four-speed pole-changing motor is coupled directly to the driving box which incorporates a lever-operated, two-speed 'Multigrip' clutch to provide eight spindle speeds. By changing pick-off gears a further eight speeds can be provided making a total of sixteen. Four link-type vee-ropes transmit the drive to the headstock.

The standard speed range is suitable for most turning and threading requirements on mild steels and non-ferrous materials. If the machine is to be used exclusively on high-tensile steels involving threading, a special low-speed range can be supplied at no extra cost if specified at time of order.

Hard-wearing base

The diagonally-braced bed has 'FLAMARD'-hardened guiding surfaces to ensure long life. Three-point base support obviates special levelling on installation.

Traversing saddle

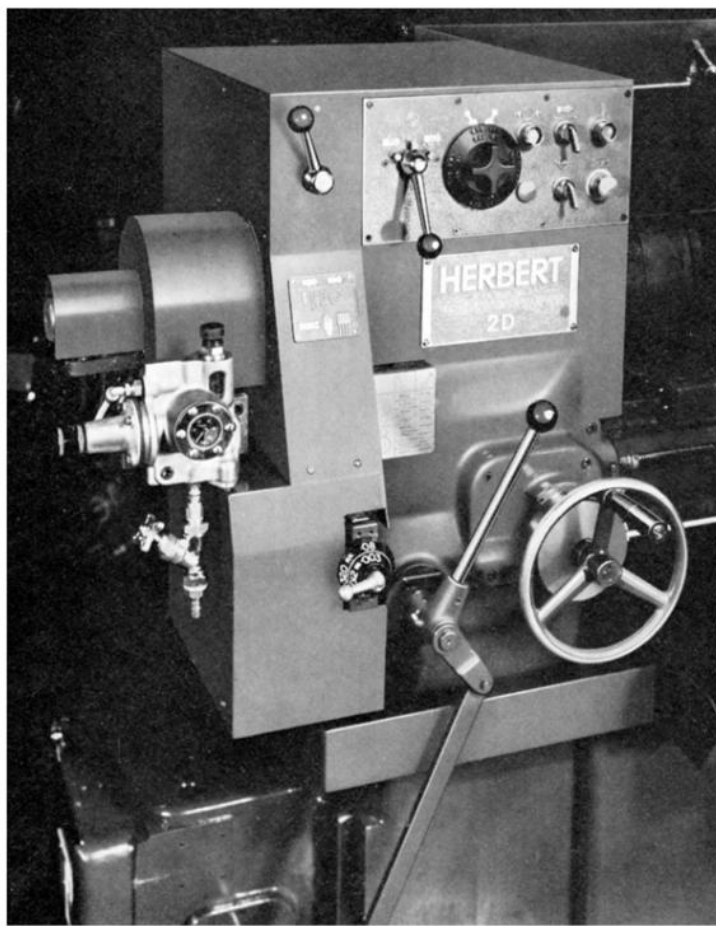
The saddle carries a forged-steel cross slide and can be clamped in any position over its longitudinal travel by an adjustable lever. The saddle-operating handwheel is mounted on the base of the headstock and incorporates an accurate metric indicator collar and adjustable fingers. Six adjustable dead stops, selected by a star wheel, are also provided for the longitudinal movement.

The saddle of the long-bed version is provided with three rates of power feed towards the headstock.

Feed is engaged by use of a lever close to the saddle control handwheel and six adjustable trip and dead stops are provided.

The robust cross slide is fitted with an openside rear toolpost and, at the front, a quick-acting, self-indexing square turret which is unclamped, indexed and reclamped by a forward and reverse movement of the handle.

The handwheel controlling the transverse motion is fitted with a large metric-graduated dial which can be set in relation to the screw by slackening the knurled collar in the centre of the wheel. The dial is fitted with coloured pointers for recording settings and adjustable-screw dead stops for use in each direction are located below the hinged cover at the rear of the slide. The slide can be clamped by a lock screw.



Six-sided versatility

The capstan slide can be operated by pilot wheel and three rates of power feed.

Six adjustable, self-selecting automatic trip and dead stops are provided which are adjustable over the full stroke and fully protected from swarf.

The automatic indexing feature of the turret can be disengaged to allow rotation by hand in either direction when required. This permits a slightly longer working stroke.

The front edge of the capstan slide is fitted with an easily-read, metric-graduated scale for use with an adjustable pointer fixed to the rear of the capstan apron.

Safe interruption

The Herbert 'Chiprupter' fitted to this machine enables the operator to control the length of continuous turnings produced by chipstream-type tools. The device consists of a spring-loaded plate clutch fitted to the feed shaft and operated by use of the long lever conveniently positioned to the right of the capstan-slide apron. The device also provides ample protection against feedshaft overloading.

The basic machine

All switchgear is built into the machine. The four-speed flanged motor is totally enclosed and fan cooled. Standard equipment includes an emergency stop button on the headstock control panel and a motor-driven coolant pump with fittings for 415 volts 3-phase, 50 Hz supply.