

Extra Equipment

41 mm (1½ in) capacity **hand-operated dead-length bar chuck** and **automatic bar feed** with 'Multibore' collet for 38 to 41 mm (1½ to 1¾ in) diameter bar and revolving holder complete with bushes.

Autobar chuck, 41 mm (1½ in) capacity, air-operated dead-length type for use with standard 2.4 m (8 ft) **weight-operated** or 3.6 m (12 ft) **electrically-operated bar feed** units. Automatically actuated from a turret-mounted, combined operation-plate and bar stop supplied, the chuck can also be lever operated. Equipment includes collet for 38 to 41 mm (1½ to 1¾ in) diameter bar and a revolving holder with bushes.

150 mm (6 in) or 190 mm (7½ in) **Coventry Concentric 3-jaw chuck** with one set of reversible jaws and telescopic circular chuck guard.

150 mm (6 in) or 190 mm (7½ in) **Herbert all-steel air-operated 3-jaw chuck** with one set of reversible jaws, air cylinder with guard and Herbert monobloc control unit.

A **monobloc air control** with variator is available. This permits the pre-selection of high or low gripping pressure.

190 mm (7½ in) **Herbert all-steel, air-operated, 2-jaw chuck** with guard, one set of standard soft jaws, 156 mm (6¼ in) air cylinder with guard and Herbert monobloc control unit.

190 mm (7½ in) **Herbert all-steel type 'L' air-operated, special-purpose, 2-jaw chuck** (for work requiring large jaw movement and comparatively light grip) with guard, one set of standard soft jaws, 190 mm (7½ in) air cylinder with guard and Herbert monobloc control unit.

A **safety pressure switch** is supplied with all air chucks.

Overhead support bar for use with 2 and 3-jaw chucks.

Low-voltage lighting equipment (25 or 50 volts).

Dual metric/imperial graduated dial and indicator.

Internal coolant supply through capstan.

Set of **belt-adjusting tools.**

Recommended Tools

The following tooling is available and recommended for use on this machine. For comprehensive details of a wide range of tooling see "Herbert Turret Lathe Tooling" available on request.

One 16 × 203 mm (⅝ × 8 in) boring bar with two Microbore units.
Two boring bar holders, 25 mm (1 in) bore, 83 mm (3¼ in) long.
One centring and facing tool.
Two knee turning tools each with steel holder for 13 mm (½ in) square-section tool and supporting bush.
Two 16 × 280 mm (⅝ × 11 in) boring bars, 13 mm (½ in) diameter pilot.
Two standard split bushes, 25 mm (1 in) o.d. × 16 mm (⅝ in) bore.
One floating reamer holder, No. 2 M.T. bore.
One No. 2 M.T. socket, 25 mm (1 in) o.d.
One die and tap holder.
One steady bush, 13 mm (½ in) dia. bore, for 150 mm (6 in) Coventry chuck.
One liner for 150 mm (6 in) Coventry chuck.
One Ardoloy R.H. turning and facing tool.
One Ardoloy offset cut-off tool.
One Ardoloy R.H. turning tool.
One Ardoloy R.H. undercutting and chamfering tool.
One Ardoloy straight turning tool for knee toolholder.
One Ardoloy cranked turning tool for knee toolholder.
Two Ardoloy single-ended boring tools.
One Cam-set turning tool 19 mm (¾ in) square.
One Cam-set facing tool 19 mm (¾ in) square.
One Cut-kost straight turning tool 13 mm (½ in) square for knee toolholder.
One Cut-kost cranked turning tool 13 mm (½ in) square for knee toolholder.
Multibore collets for bar from 9.5 to 40 mm (⅜ to 1½ in) diameter, square bar up to 28.5 mm (1⅛ in) and hexagonal bar up to 35 mm (1⅛ in) across flats.
Split supporting bushes (stationary) for use in the bar feed unit.
Revolving holder with needle-roller bearings for use in the bar feed unit.
Split supporting bushes for use in the revolving holder to support round, square or hexagonal bar.
Note: Split supporting bushes are not required for bar above 25 mm (1 in) diameter, 16 mm (⅝ in) square or 22 mm (⅞ in) hexagon across flats.
One adjustable stop.
One chipstream box tool.
One inverted roller steady box tool 25 mm (1 in) shank.
One roller steady ending tool.
One roller steady centring tool.
One dead centre.
One ½ in Coventry C.H.S. diehead.
Ground thread dies, for ½ in C.H.S. diehead.