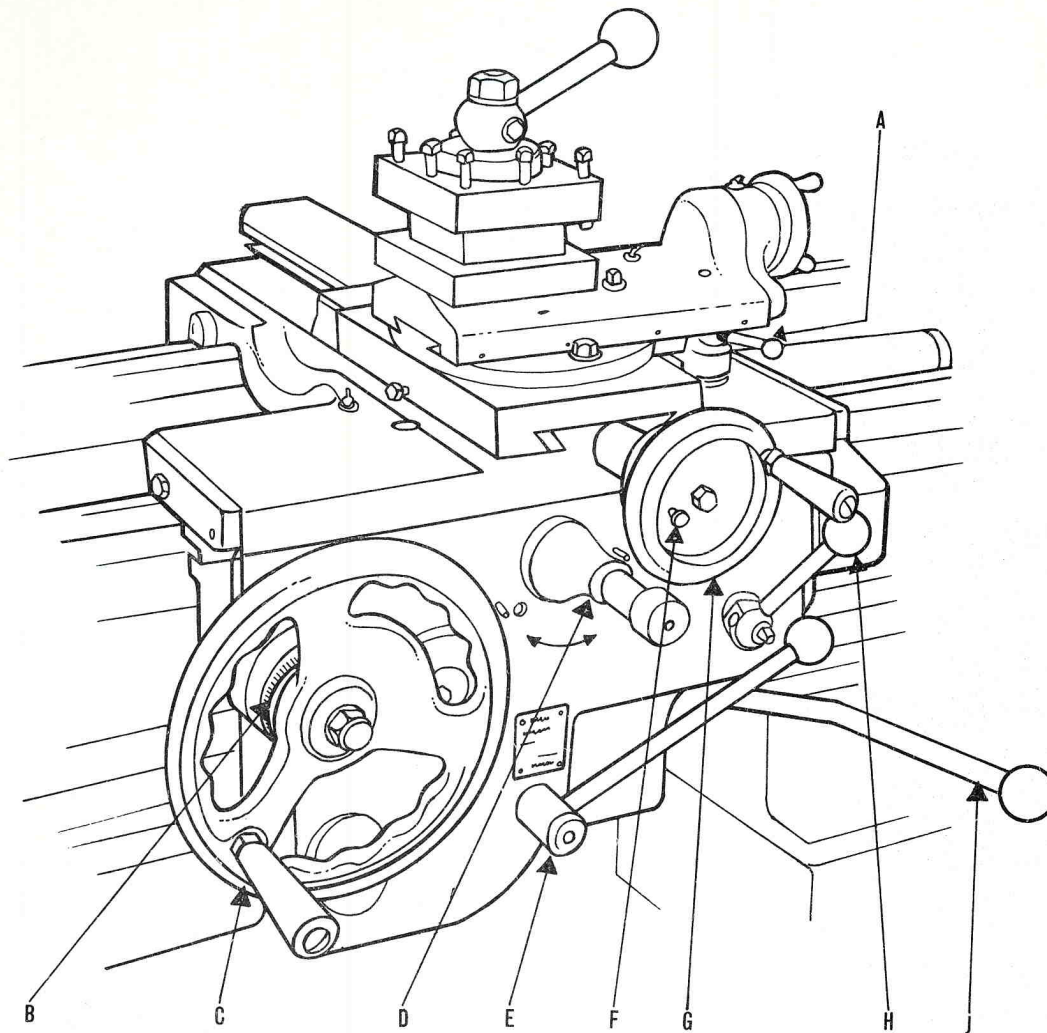


7.1 APRON



Do not operate the apron before reading the lubricating instructions. Section 3.

For selection of feeds from the gearbox see section 5.

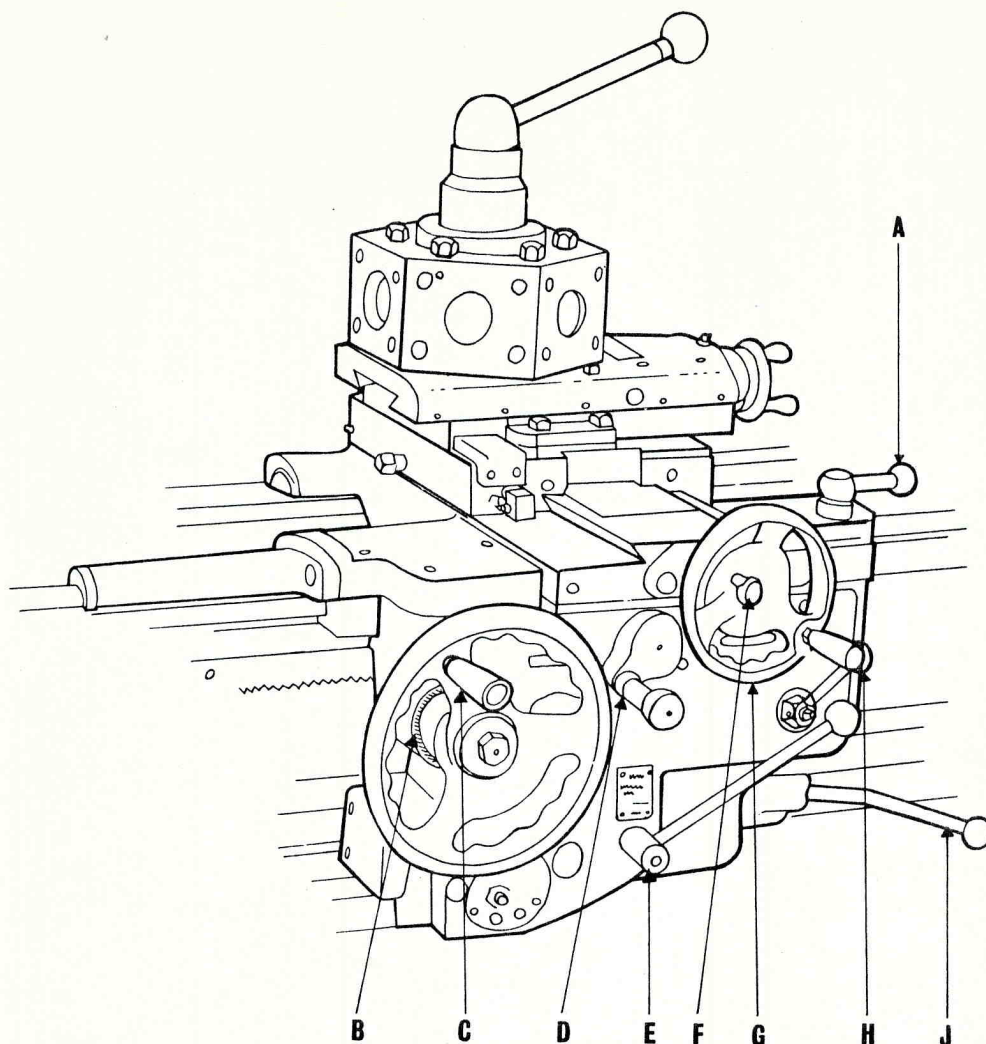
Manual movement of the apron along the bed is by means of the handwheel 'C'. Ensure that the trip lever 'E' is in the trip position and the leadscrew nut operating lever 'H' is in the disengaged position as shown.

For length measurement the dial 'B' may be set to zero, it is graduated 64 divisions each division representing $1/64$ " ; thus one revolution of the handwheel gives one inch of travel. The cross slide is traversed by the handwheel 'G'. The cross feed dial may be set to zero by releasing the screw 'F'. The dial is graduated 200 divisions each division representing .001" movement of the tool or .002" alteration in the diameter of the workpiece.

Longitudinal or cross feed selection is made by lever 'D'. To operate, pull the lever out to disengage the locating plunger. When the cross feed is engaged the saddle should be clamped to the bed by lever 'A'.

The feed engage and trip lever 'E' is interlocked with the leadscrew nut operating lever 'H'. Clutch engagement lever 'J' travels with the apron and is additional to lever 'B' Section 4.1.

7.1 APRON



Do not operate the apron before reading the lubricating instructions. Section 3.

For selection of feeds from the gearbox see section 5.

Manual movement of the apron along the bed is by means of the handwheel 'C'. Ensure that the trip lever 'E' is in the trip position and the leadscrew nut operating lever 'H' is in the dis-engaged position as shown.

For length measurement the dial 'B' may be set to zero, it is graduated 64 divisions each division representing $1/64$ " ; thus one revolution of the handwheel gives one inch of travel. The cross slide is traversed by the handwheel 'G'. The cross feed dial may be set to zero by releasing the screw 'F'. The dial is graduated 200 divisions each division representing $.001$ " movement of the tool or $.002$ " alteration in the diameter of the workpiece.

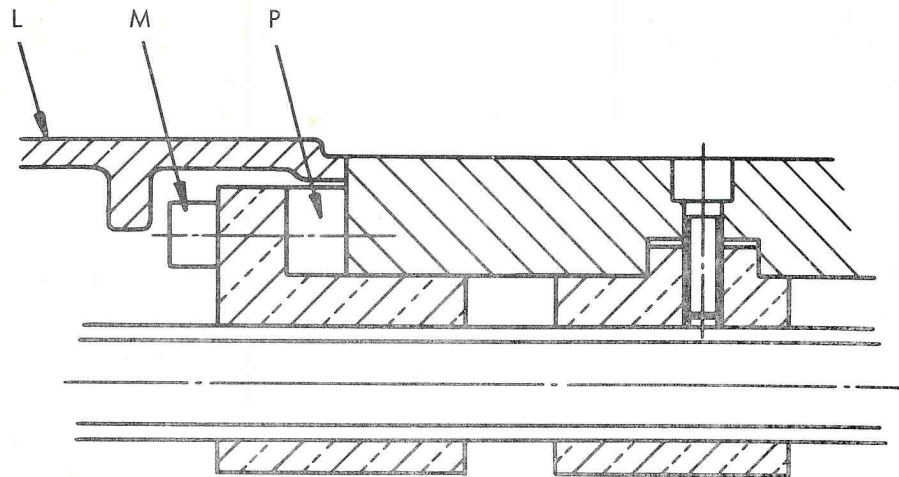
Longitudinal or cross feed selection is made by lever 'D'. To operate, pull the lever out to disengage the locating plunger. When the cross feed is engaged the saddle should be clamped to the bed by lever 'A'.

The feed engage and trip lever 'E' is interlocked with the leadscrew nut operating lever 'H'. Clutch engagement lever 'J' travels with the apron and is additional to lever 'B' Section 4.1.

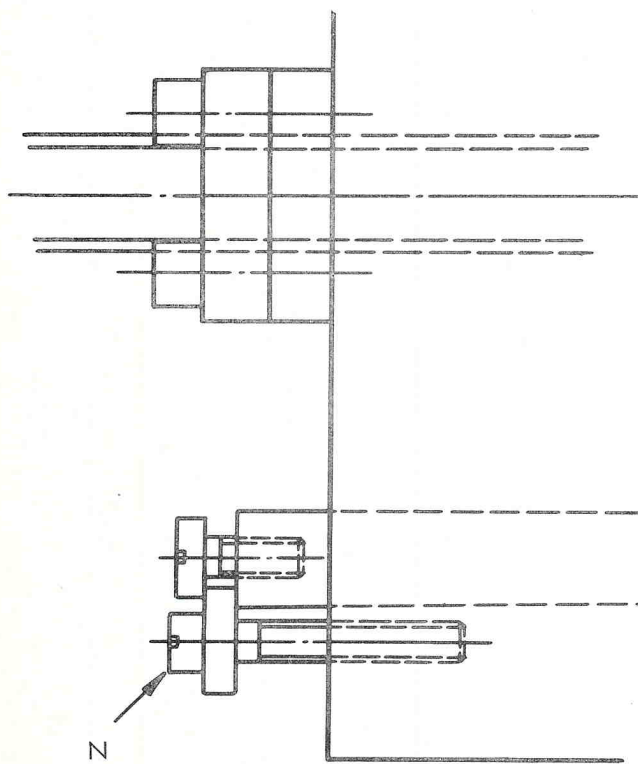
7.2 SADDLE

The saddle should not be moved before reading the lubricating instructions. Section 3. Wipers are fitted on the end of the saddle wings and on the cover at the rear of the cross slide, it is advisable to remove these periodically to clean them. To re-assemble, use a light pressure to force the springing edge of the wiper down onto the bed or slideway, simultaneously tightening the retaining screws.

The wipers should be checked regularly and renewed when necessary.



SECTION THROUGH CROSS SLIDE SCREW NUTS.



PLAN VIEW OF CROSS SLIDE.

Two saddle screw nuts are fitted and provision made for adjustment to minimise the backlash. This adjustment being carried out as follows:-

Measure the backlash by means of the cross slide dial.

Remove the cover 'L' at the rear of the cross slide. Release the two Allen fixing screws 'M' and lift off the slotted plate 'P'. Grind the plate to give the required adjustment and replace.

When a taper turning attachment is fitted, the backlash between the key and keyway of the telescopic joint must be taken into account.

On lathes supplied with a Hydraulic Copying unit, only one nut is fitted and the above procedure does not apply.

A taper slip is provided for the adjustment of the cross slide guides.

The slip is adjusted by screw 'N' which is held in position by a locking screw. The screw being situated under cover 'L'.