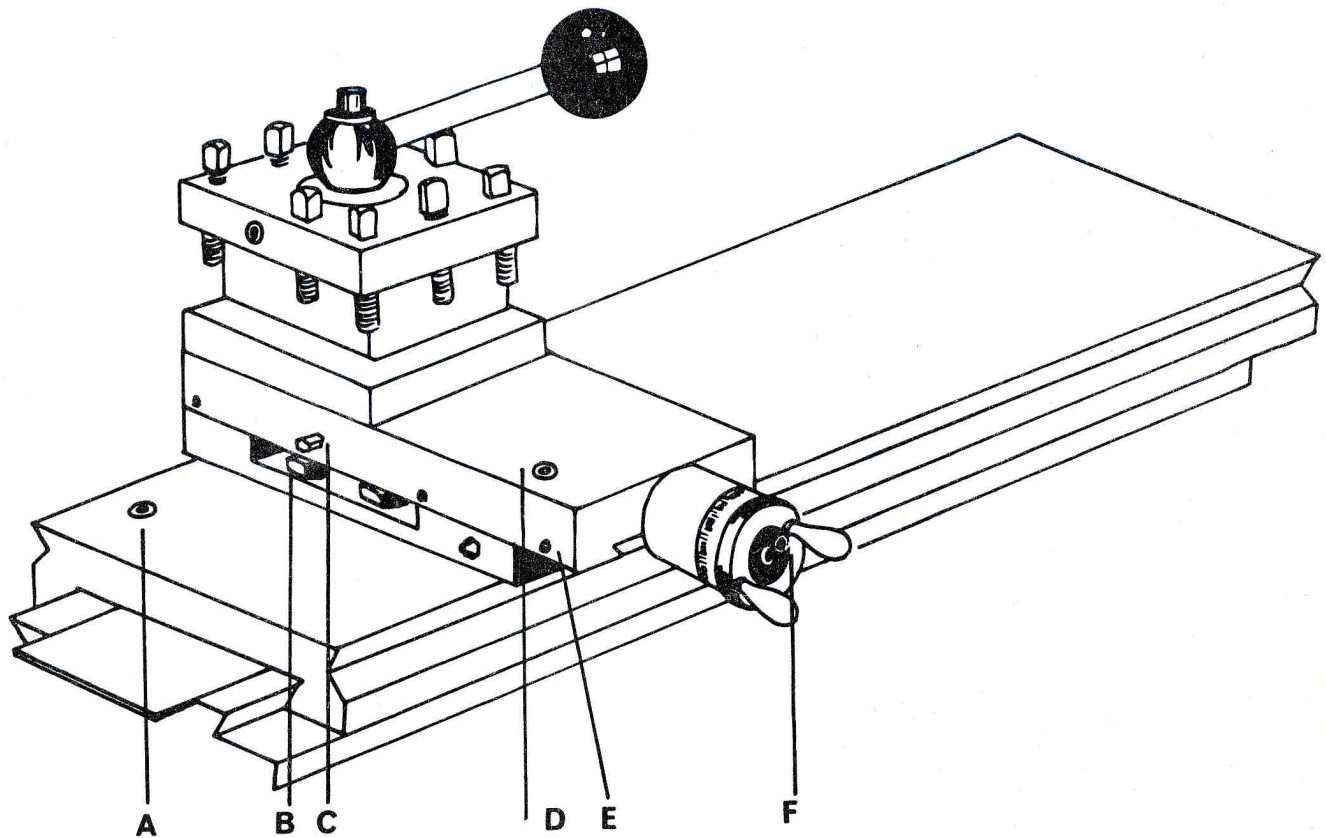


## 8.1 COMPOUND SLIDES



The tool slide can be swivelled to any angle by releasing the two hexagon nuts 'B'. The angle being indicated on the top of the cross slide.

The tool slide can be fitted with dual dials, one reading in inches the other millimetres. They can be set to zero and locked in position by screw 'F'. The inch dial is divided into 200 divisions, each one represents  $.001''$  movement of tool or  $.002''$  alteration to workpiece diameter, whilst the metric dial is divided into 250 divisions each one represents  $.02$  mm. movement of tool or  $.04$  mm. alteration to workpiece diameter.

When taking heavy or intermittent cuts, the cross slide can be locked to the saddle by the screw 'A'. For facing cuts or drilling, the tool slide can be locked by the sq. headed screw 'C'.

A slip is provided for the adjustment of the tool slide guides.

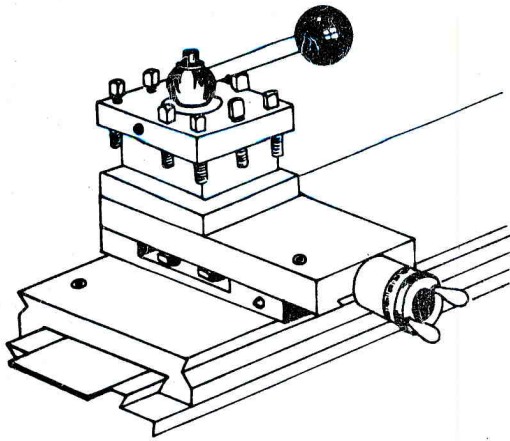
To effect this adjustment it is necessary to raise the square turret, for types 1709 & 2112. To do this, rotate the turret lever in an anti-clockwise direction until sufficient clearance between turret and slide is gained enabling screws to be adjusted.

Release the screws 'D' on the top of the slide, adjust the slip by means of the screws 'E' then re-lock the screws 'D'.

Replace the square turret.

## 8.2 TOOL SLIDES

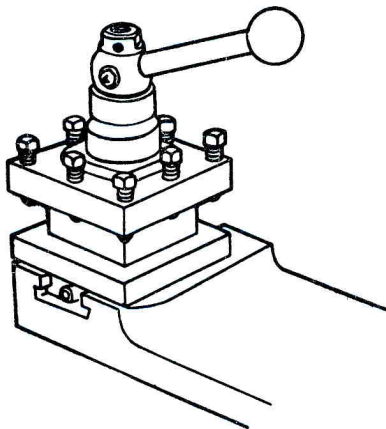
### SQUARE TURRET



The square turret is designed to operate on four stations, but it can also be locked in intermediate positions if required.

To rotate the turret move the lever in an anti-clockwise direction, this will unlock and lift the turret from its locating plunger. It can then be rotated by hand in either direction to the required tool position. The lever can be made to lock in any convenient position by adjusting the nut on top of the locking bolt.

The tool size and dimensions of the turret are given on the capacity chart section 1.4.

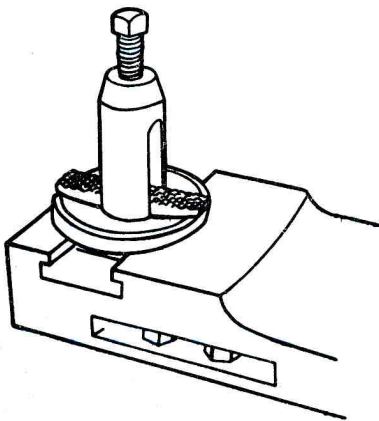


### DETACHABLE SQUARE TURRET

This type of square turret is mounted on a tee slotted tool slide and is designed to operate on twelve stations.

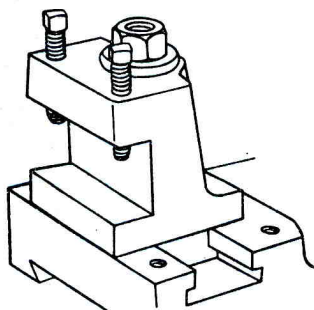
To rotate the turret move the lever in an anti-clockwise direction, this will unlock the turret and release the locating plunger. It can then be rotated by hand to the required tool position.

To lock the turret move the lever in a clockwise direction.



### SINGLE TOOL POST

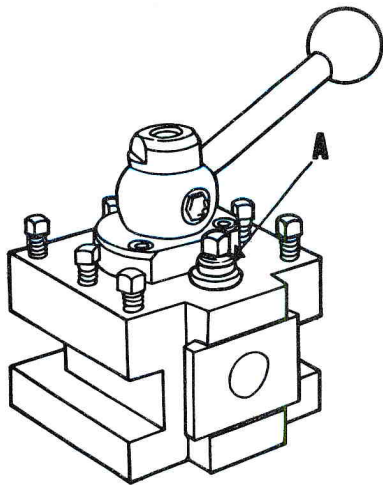
This type of toolholder is mounted on a tee slotted tool slide. The tool post can be clamped in any position across the width of the slide. The tool and the tool post being locked simultaneously by the square head screw.



### SWIVELLING TOOLHOLDER

This type of toolholder is mounted on a tee slotted tool slide. The toolholder can be clamped in any position across the width of the slide by means of the hexagon nut, it can also be swivelled to any angle.

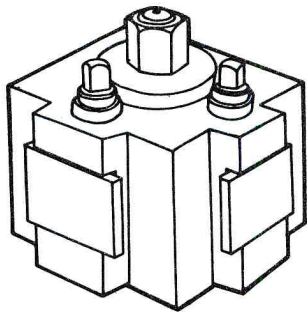
## 8.21 TOOL SLIDES continued



### SQUARE TURRET WITH ONE FACE FOR INTERCHANGEABLE TOOLHOLDERS.

This type of square turret gives four stations and provides three normal tool positions with one face to suit interchangeable toolholders. The toolholders being locked in position by means of the square head screw 'A'.

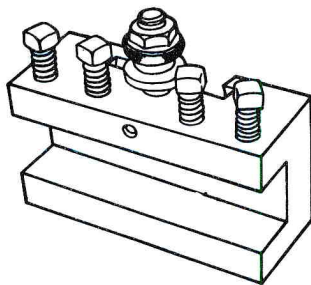
The turret operates in the same way as the square turret. See Section 8.2.



### TOOLBLOCK FOR INTERCHANGEABLE TOOLHOLDERS.

This type of toolblock gives two stations and has two faces to suit interchangeable toolholders.

To rotate the toolblock, release the hexagon nut, lift the knurled locating plunger and turn the block by hand through 90°. Replace the plunger and lock the hexagon nut.

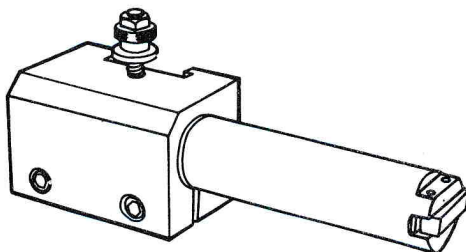


### INTERCHANGEABLE TOOLHOLDERS.

The tools are set in the normal way and it is only necessary to change the toolholders. The correct level of the tool is set by means of a screwed collar and locknut.

The toolholder for drilling is positioned by a fixed stop.

Three types of toolholder are available.

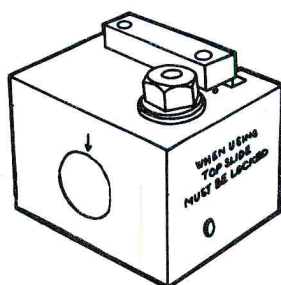


### TOOLHOLDER FOR TURNING AND FACING TOOLS.

Tool size 1" deep x  $\frac{3}{4}$ " wide x 5" long.

### TOOLHOLDER FOR BORING BARS.

Bore size 1.500" dia.



### TOOLHOLDER FOR DRILLING.

When using this type the tool slide must be locked. See section 8.1.

Bore size 1.500" dia.