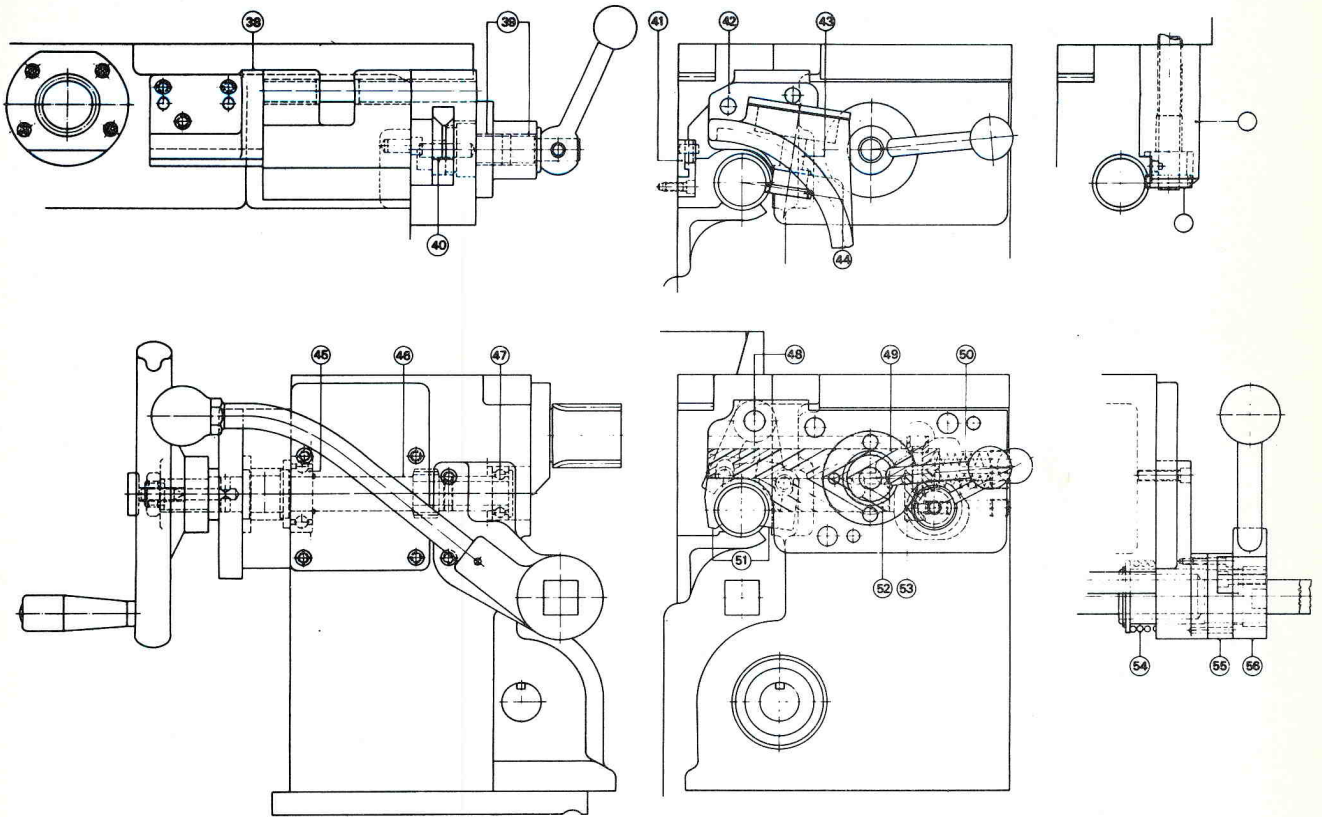


11.51 SPARE PARTS LIST FOR APRON continued

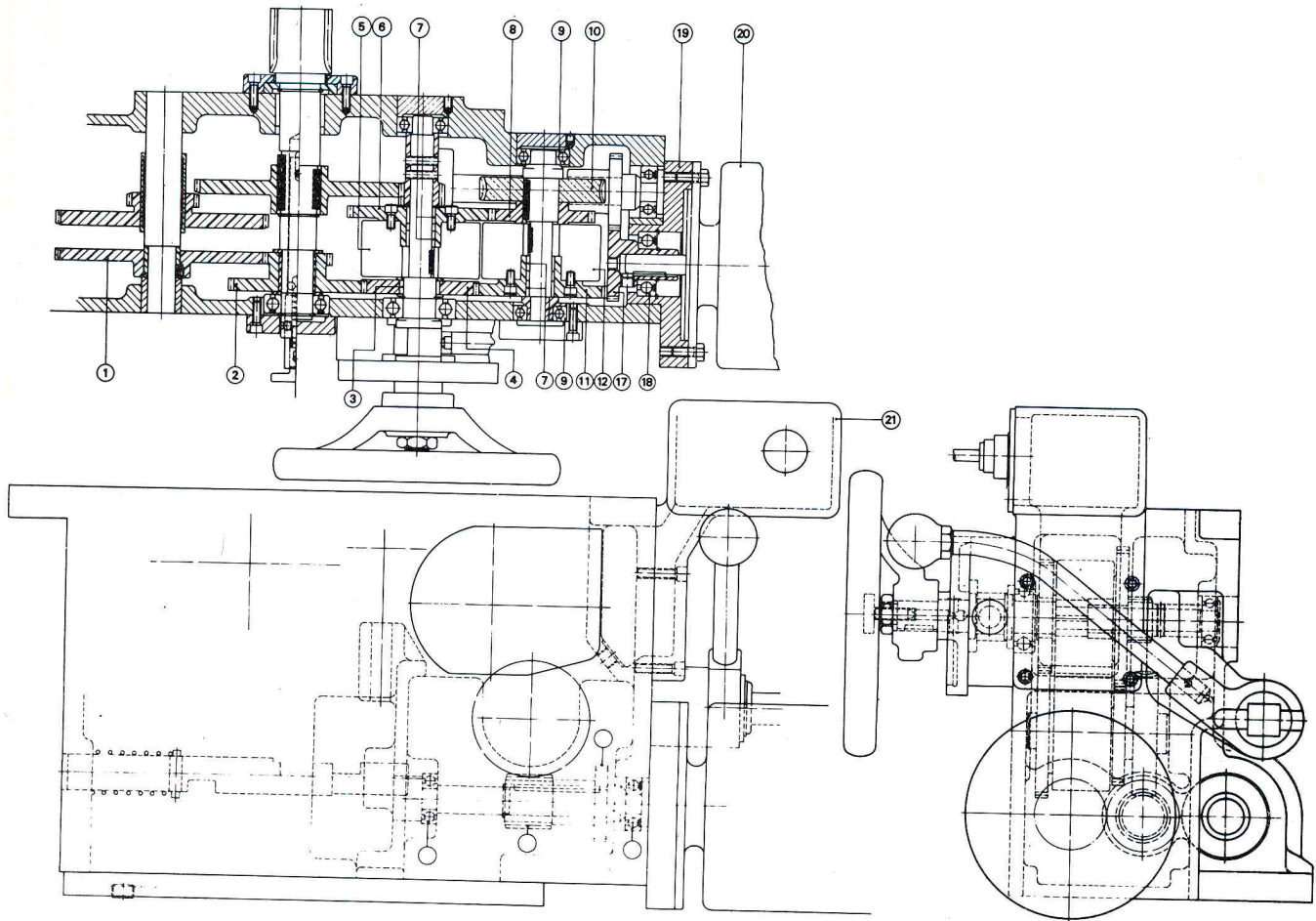


PLEASE STATE MACHINE SERIAL NO. SHEET NUMBER AND ITEM NUMBER.

ALL FIXING SCREWS ARE STD. WHITWORTH OR B. S. F. THREAD.

- | | |
|--|---|
| <ol style="list-style-type: none"> 1. Weston oilseal W.200 112 50 R4. 2. Special key. 1603-034. 3. Weston oilseal W.225,150,37, R4. 4. Torrington Bearing B.2420. 5. Dowty 'O' ring P.P.52B.8. 6. Torrington bearing N.T.A.3244 & thrust race T.R.C. 3244. 7. Feed reverse shaft in worm box. 8. Double gear on feed shaft sleeve. 9. Gear on feed reverse shaft in worm box. 10. Torrington bearing F.1816. 11. Compo bush SN.009 x 1" long. 12. Gear on worm. 13. Worm. 14. Gear shifter for worm box. 15. Worm wheel. 16. Gear in worm wheel. 17. Feed change shaft. 18. Worm box operating shaft. 19. Dowty 'O' ring P. P. 73. B1. 20. Spring No. 115. 21. Dowty 'O' ring P. P. 51. B9. 22. Sliding double gear. 23. Dowty 'O' ring P. P. 51. B.13. 24. Sliding gear on rack pinion shaft. 25. Torrington bearing B.2016. 26. Rack pinion shaft (standard). 27. Rack pinion shaft (when fitted with handwheel dis-engagement). 28. Operating knob. | <ol style="list-style-type: none"> 29. R & M bearing L. J. 25. W. S. R. 30. Feed selector die. 31. Feed selector gear. 32. Feed selector shaft. 33. Spring No. 123. 34. Trip shaft (standard). 35. Trip shaft (when long stops fitted). 36. Pump plunger. 37. Pump plunger spring. 38. Thrust bracket for leadscrew nuts. 39. Compo bush SN.066 x 1½" long. 40. Torrington bearing B.66. 41. L. H. and R. H. stop blocks for auto-nut threading trip. 42. Thread indicator bracket. 43. S/c dial bush. 44. S/c indicator wheel. 45. R & M bearing L. J. 1. 46. Hand racking shaft (when non Q. P. T. and non-dual dials). 47. R & M bearing L. J. 17. 48. Pivot bar for leadscrew nuts. 49. Upper nut operating rod. 50. Spring No. 21. 51. Leadscrew nuts. 52. Lower nut operating rod. 53. Interlocking piece. 54. Spring 1703-076. 55. Gate for boss. 56. Start and stop boss. |
|--|---|

11.52 SPARE PARTS LIST FOR APRON Q.P.T.

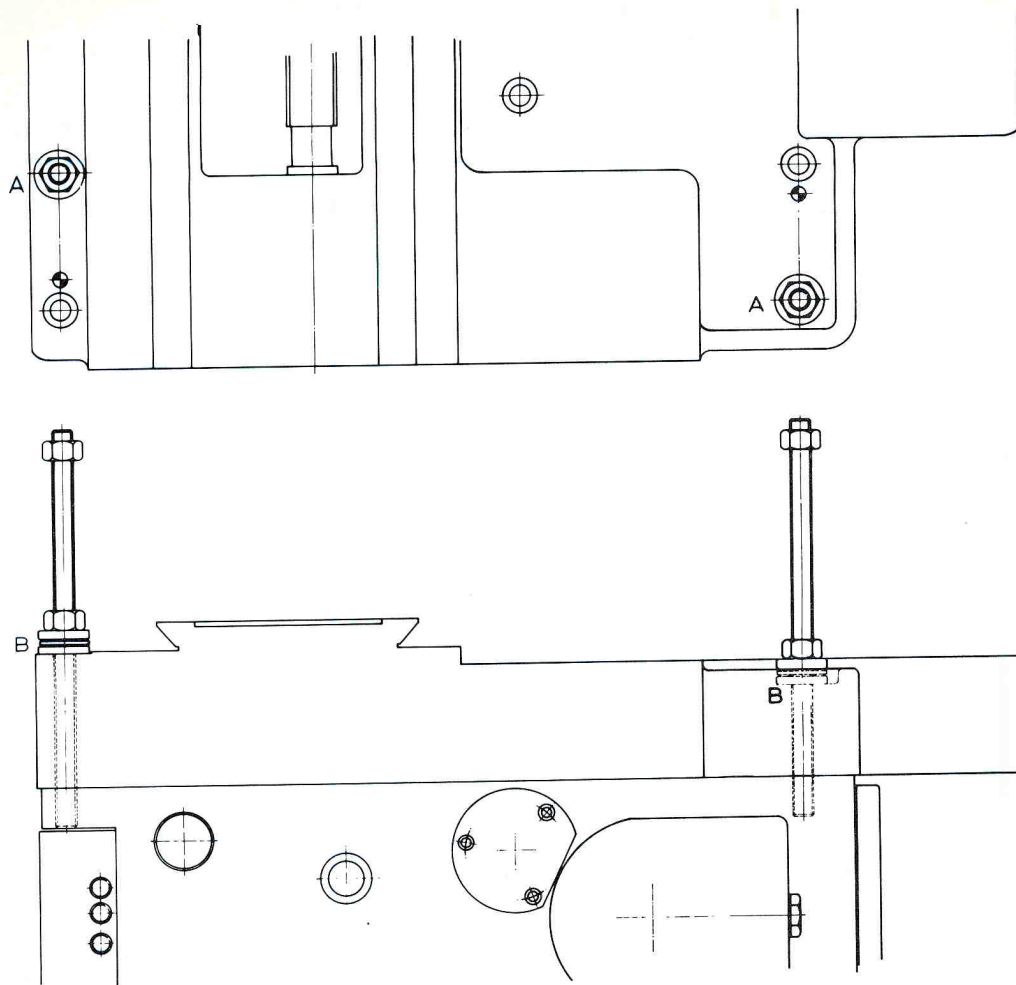


PLEASE STATE MACHINE SERIAL NUMBER, SHEET NUMBER AND ITEM NUMBER.

ALL FIXING SCREWS ARE STD. WHITWORTH OR B.S.F. THREAD

- | | | | |
|-----|-----------------------------------|-----|----------------------------------|
| 1. | 78T intermediate gear. | 12. | Matrix clutch M. S. 3,5/16. |
| 2. | Double gear on rack pinion shaft. | 13. | R & M bearing L.J. 17. |
| 3. | Torrington bearing B.167. | 14. | Worm. |
| 4. | 42T gear. | 15. | R & M bearing M. J. 15. W. S. R. |
| 5. | Matrix clutch MS. 3,5/16. | 16. | 27T gear on worm shaft. |
| 6. | 44T gear on clutch. | 17. | 27T motor pinion. |
| 7. | Torrington bearing B. 118. | 18. | R & M bearing L. J. 25. W. S. R. |
| 8. | 31T gear on wormwheel shaft. | 19. | Q. P. T. motor base plate. |
| 9. | R & M bearing XXLJ. 20. | 20. | Q. P. T. motor. |
| 10. | Wormwheel. | 21. | Q. P. T. switch box. |
| 11. | 48T gear on matrix clutch. | | |

11.53 APRON ASSEMBLY



INSTRUCTIONS FOR LOWERING THE APRON

Remove the tail end bracket.

Disconnect the leadscrew, the feed shaft and the clutch operating shaft and withdraw the shafts toward the tailstock.

To disconnect the leadscrew remove the spring pin connecting the leadscrew and socket, (part No. 9. Section 11.3), remove the gearbox lid and release the allen fixing screw on the end of the leadscrew. Should difficulty be encountered in withdrawing the leadscrew from the socket, engage the leadscrew nuts and hand traverse the apron along the bed. To disconnect the feed shaft, remove the spring pin from the right hand side of the slip coupling.

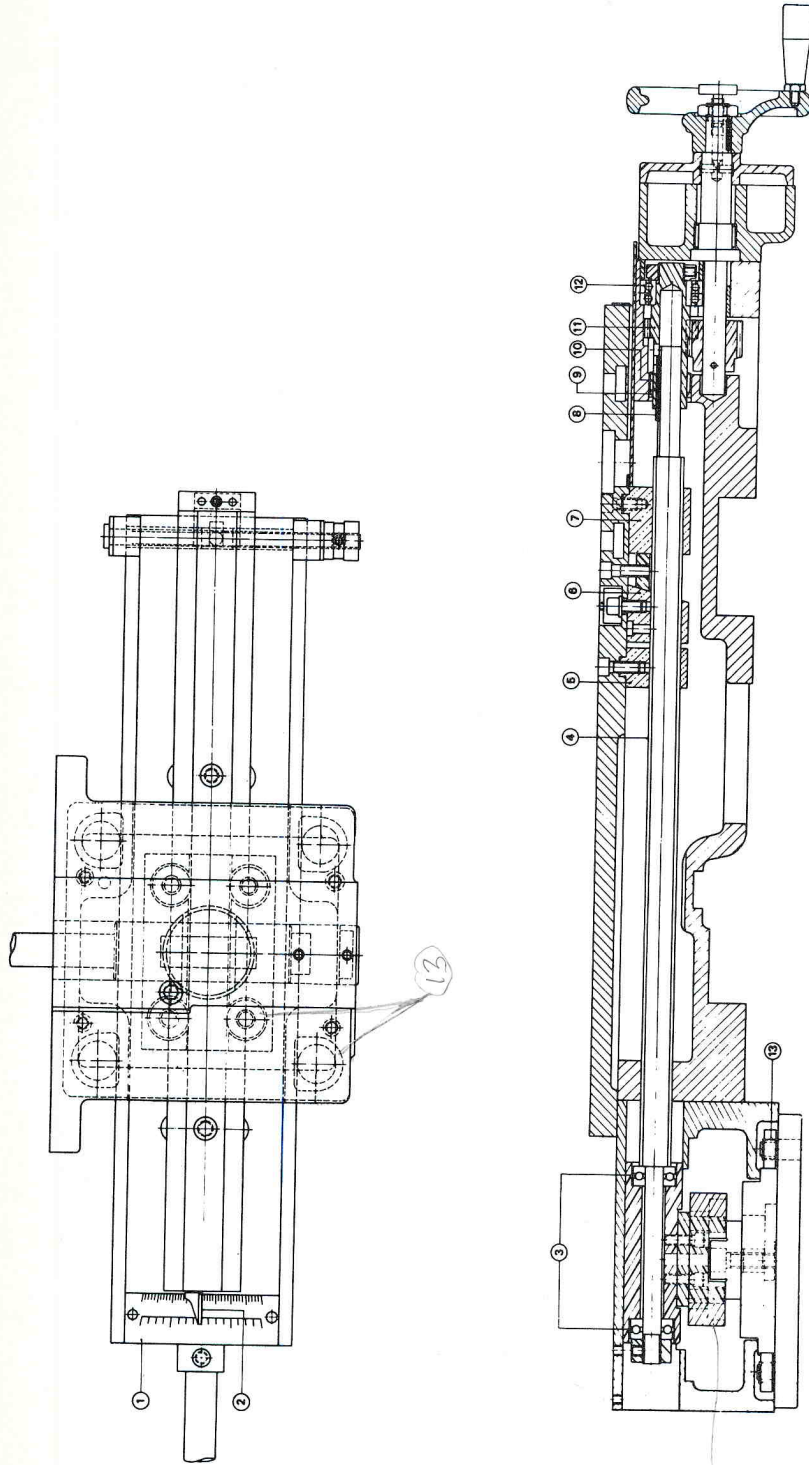
Remove the two extreme fixing screws 'A' and fit two $\frac{1}{2}$ " whit. jacking screws as shown. The three remaining fixing screws may now be removed.

The apron can then be lowered by means of the hexagon nuts on the jacking screws, the load being taken by the thrust races 'B'. It is advisable to lower the apron onto blocks placed in the lathe trough.

To replace the apron, the above procedure is reversed.

When replacing the feed shaft care must be taken to align the keyway in the shaft with the key in the worm.

11.6 SPARE PARTS LIST FOR TAPER TURNING



1. Index plate.
2. Pointer.
3. Bearing Hoff. W.5/8.
4. Cross slide screw.
5. ~~Backlash~~ *eliminator. CLAMP BLOCK FOR TAPER TURNING*
6. Tapered nut for cross slide.
7. Tongued nut for cross slide.
8. Stem key.
9. INA oilseal G.28,35,4.
10. Torrington bearing F.2816.
11. Pinion Shaft.
12. R & M bearing L.D.J.T.25.
13. Torrington needle bearing F.1210.

TMA-HK1210

ALL FIXING SCREWS ARE STD. WHITWORTH OR B.S.F. THREAD