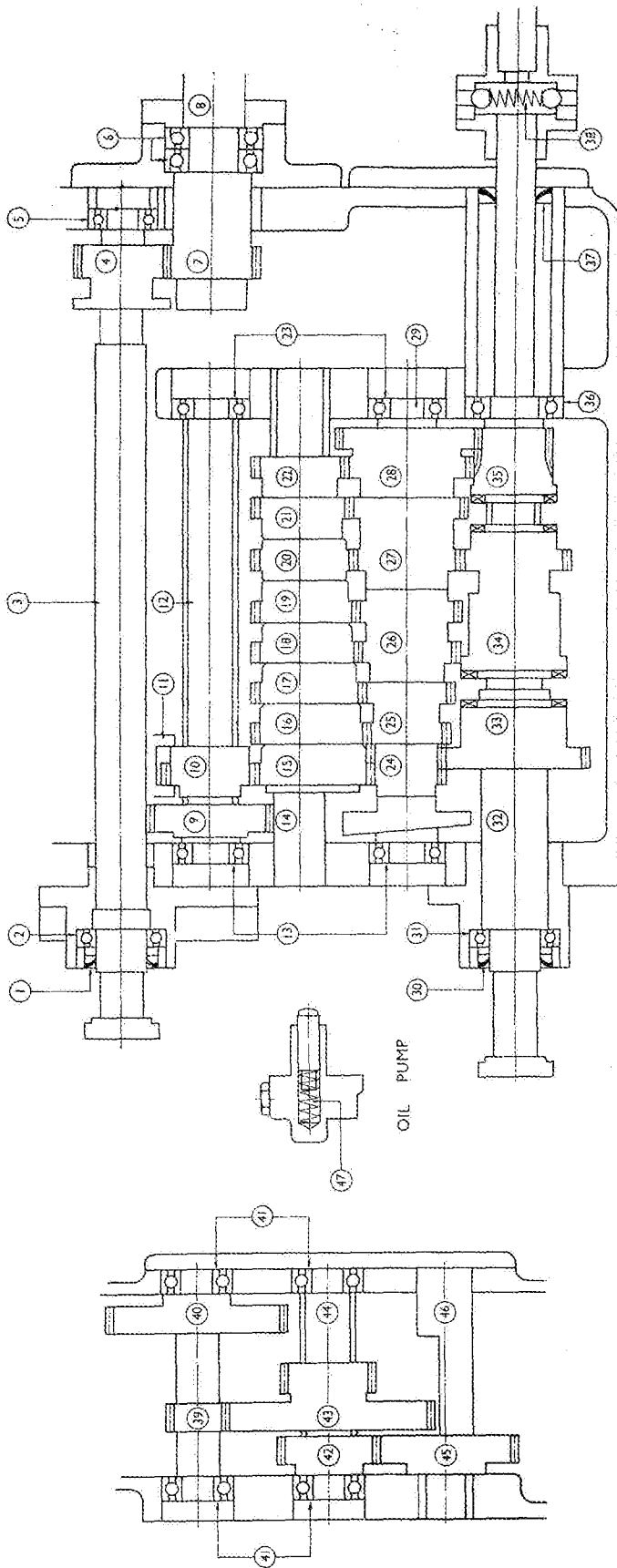


# SPARE PARTS LIST FOR TOTALLY ENCLOSED GEARBOX



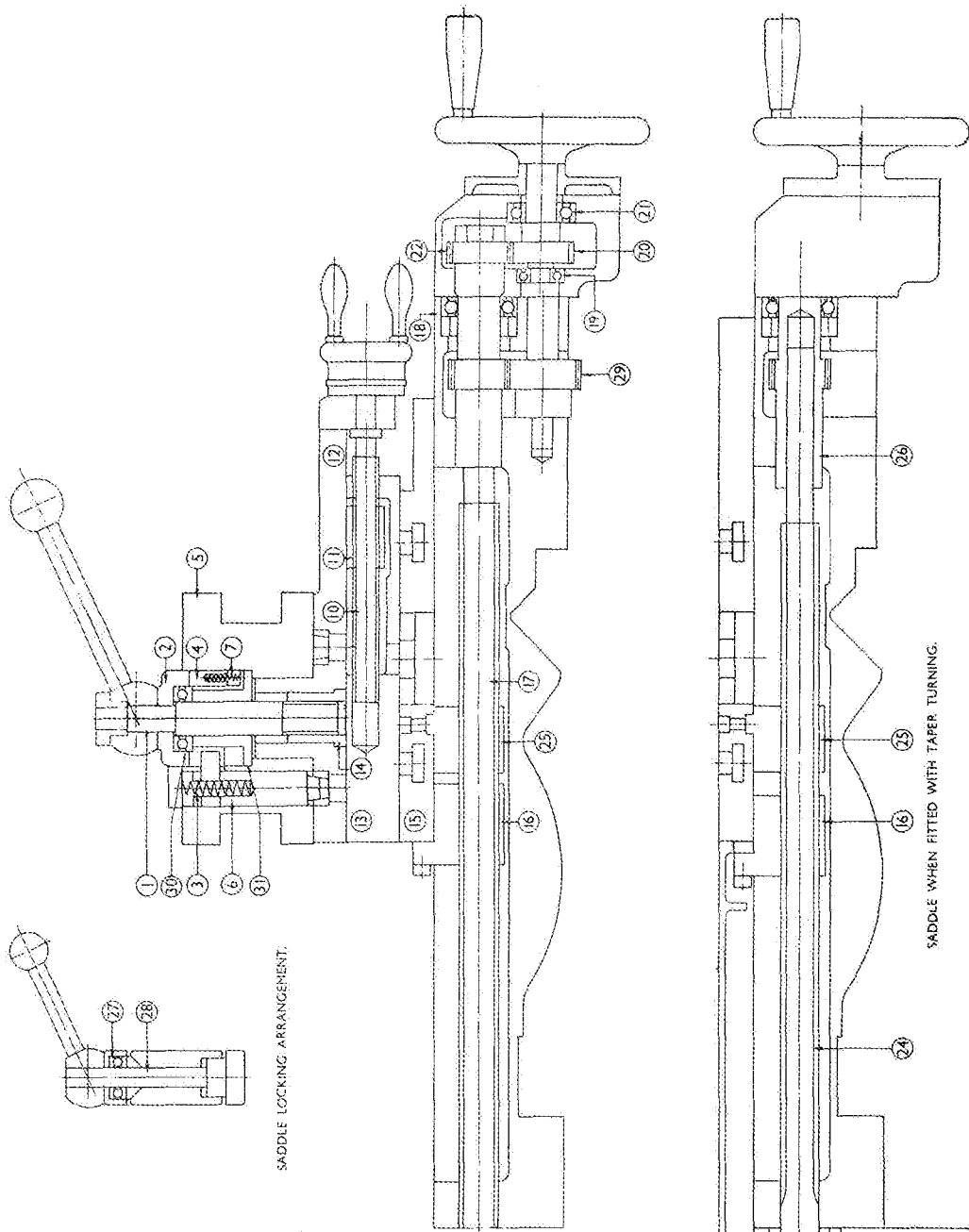
END GEARBOX

SCREW CUTTING GEARBOX

- 1. Gitsaal 237 162 31.
- 2. Hoff. X.L.S.11—R. & M. X.L.J.11.
- 3. 5th shaft.
- 4. 23T. 8D.P. gear on 5th shaft.
- 5. Hoff. L.S.10—R. & M. L.J.1.
- 6. Hoff. 140A.C.—R. & M. L.J.T.40. specially paired & preloaded, back to back.
- 7. 23T. 8D.P. gear on leadscrew.
- 8. Leadscrew.
- 9. 30T. 8D.P. gear on 1st shaft.
- 10. 20T. 7D.P. sliding gear on 1st shaft.
- 11. 20T. sliding gear shifter.
- 12. 1st shaft.
- 13. Hoff. 130—R. & M. L.J.30.
- 14. 2nd shaft.
- 15. 26T. 7D.P. gear on 2nd shaft.
- 16. 25T. 7D.P. " " " "
- 17. 24T. 7D.P. " " " "
- 18. 23T. 7D.P. " " " "
- 19. 22/22 1/2 7D.P. " " " "
- 20. 22T. 7D.P. " " " "
- 21. 21T. 7D.P. " " " "
- 22. 20T. 7D.P. " " " "
- 23. Hoff. L.S.11—R. & M. L.J.11.
- 24. 16T. 7D.P. gear on 3rd shaft.
- 25. 18T. & 20T. double gear on 3rd shaft.
- 26. 22T. & 23T. " " " "
- 27. 24T. & 26T. " " " "
- 28. 28T. & 32T. gears on 3rd shaft.
- 29. 3rd shaft.
- 30. Gitsaal 237 162 31.
- 31. Hoff. X.L.S.11—R. & M. X.L.J.11.
- 32. 4th shaft.
- 33. 32T. 7D.F. gear on 4th shaft.
- 34. 24T. 7D.P. " " " "
- 35. 16T. 7D.P. " " " "
- 36. Hoff. 140—R. & M. L.J.40.
- 37. Gitsaal 244 125 43.
- 38. Spring in slip coupling.
- 39. 13/14T. 8D.P. pinion shaft.
- 40. 44T. 8D.P. gear on pinion shaft.
- 41. Hoff. L.S.10—R. & M. L.J.1.
- 42. 24T. 8D.P. gear on spline shaft.
- 43. 52T. & 22T. 8D.P. double gear.
- 44. Spline shaft.
- 45. Intermediate gear.
- 46. Intermediate shaft.
- 47. Pump plunger spring.

# SPARE PARTS LIST FOR SADDLE AND SQUARE TURRET ON COMPOUND REST

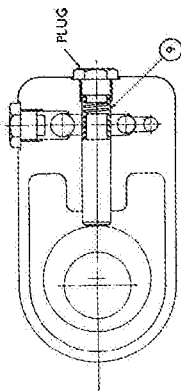
PLEASE QUOTE SHEET No. AND ITEM No.



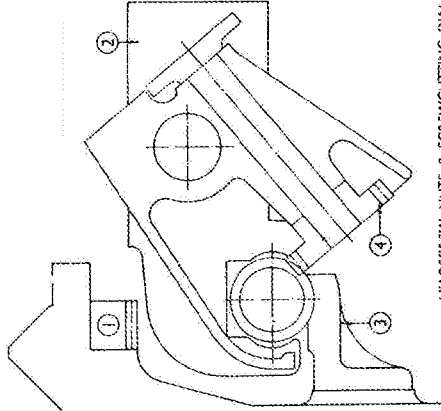
1. Turret locking bolt.
2. Ratchet.
3. Locating plunger spring.
4. Ratchet plunger.
5. Square turret.
6. Locating plunger.
7. Ratchet plunger spring.
10. Comp. rest screw.
11. Comp. rest screw nut.
12. Turret slide.
13. Swivel slide.
14. Turret locking nut.
15. Bottom slide.
16. Saddle screw nut.
17. Saddle screw.
18. Hoff. 130 C.D.S. .002 in. clearance.
19. Hoff. L.S.7.—R. & M. L.J. $\frac{3}{8}$ .
20. Handwheel pinion shaft.
21. Hoff. L.S.10.—R. & M. L.J.1.
22. 20T. 10D.P. gear on saddle screw.
23. Hoff. W. $\frac{3}{8}$ —R. & M. L.T. $\frac{3}{8}$ .
24. Taper turning saddle screw.
25. Tongued saddle screw nut.
26. Pinion shaft.
27. Hoff. W. $\frac{3}{8}$ —R. & M. L.T. $\frac{3}{8}$ .
28. Saddle lock bolt.
29. Saddle intermediate gear.
30. Thrust race.
31. Thrust ring.

# SPARE PARTS LIST FOR APRON

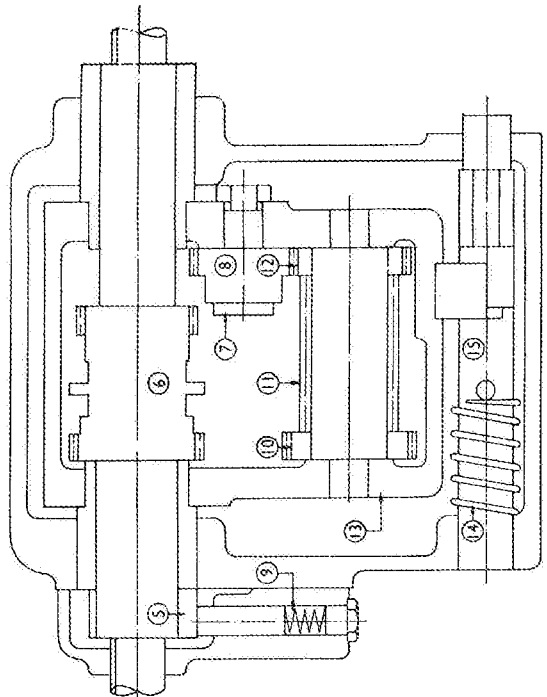
ALL GEARS ARE 20° PRESS ANGLE



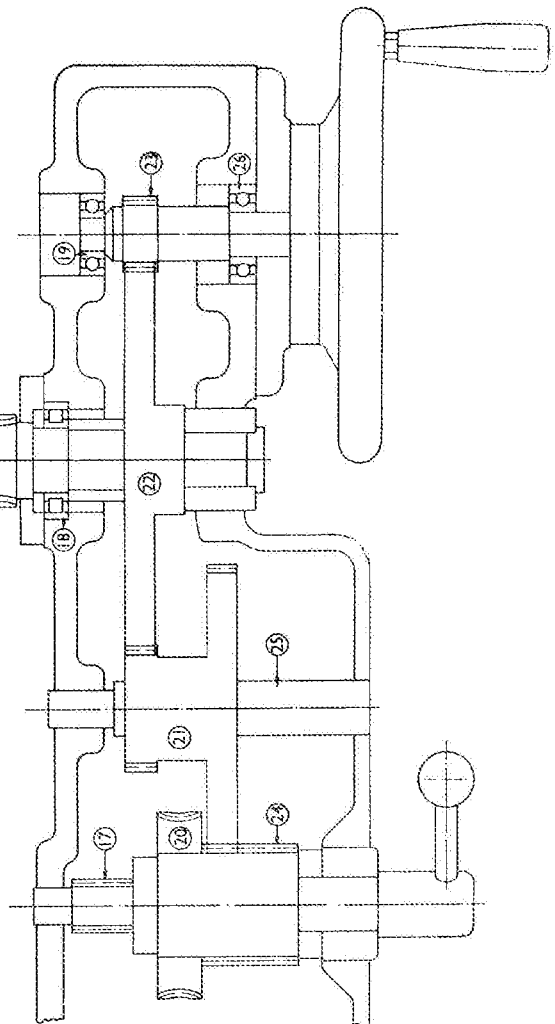
OIL PUMP



LEADSCREW NUTS & SCREW CUTTING DIAL

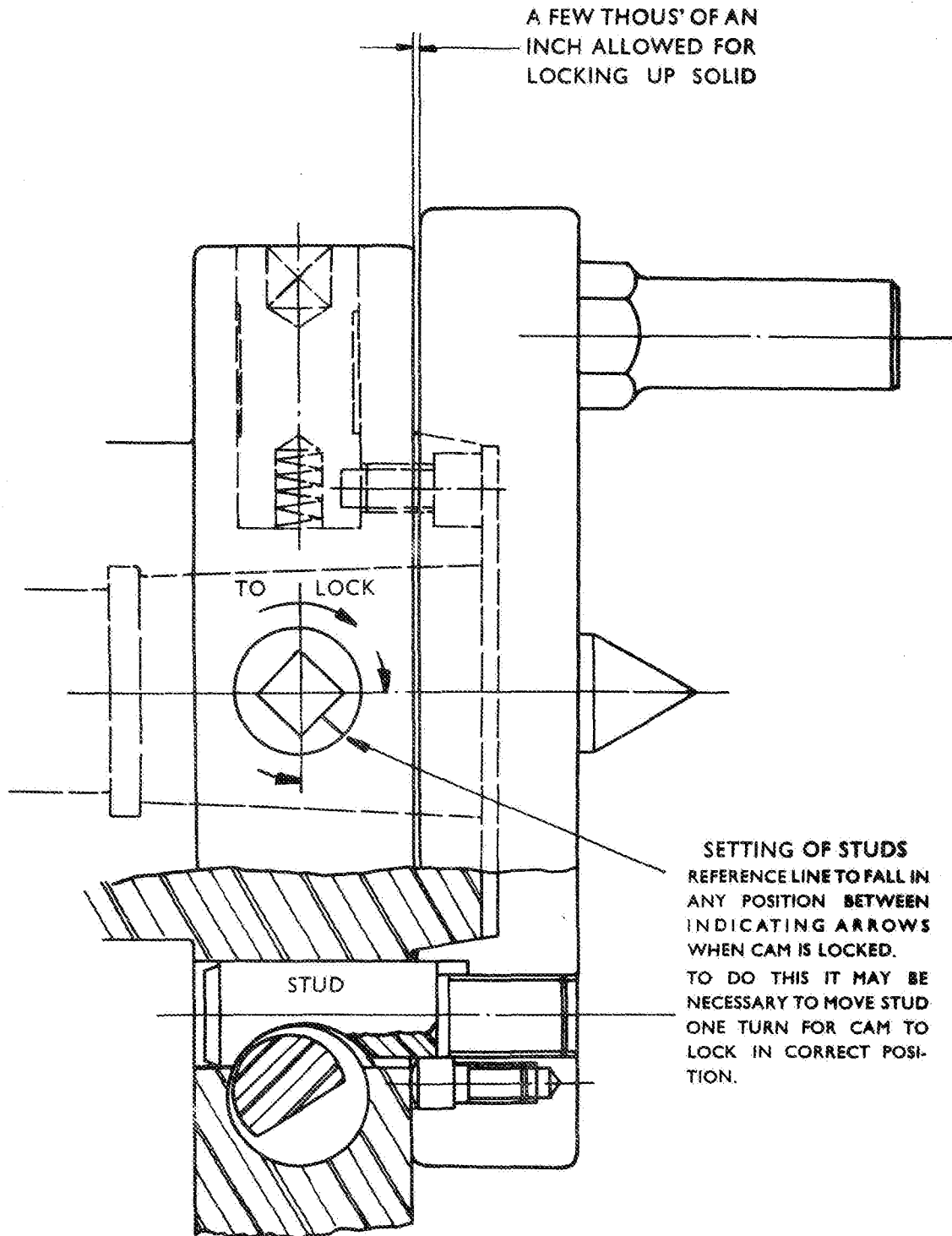


PUMP, WORM BOX & TRIP MOTION



1. Rack.
2. Leadscrew nuts.
3. Leadscrew support bracket.
4. Thread indicator wheel.
5. Pump eccentric.
6. 29T. & 26T. 10D.P. sliding gear.
7. Reverse pinion stud.
8. Intermediate reverse pinion 23T. 10D.P.
9. Pump plunger spring.
10. 79T. 10D.P. gear on worm.
11. Feed worm.
12. 26T. 10D.P. gear on worm.
13. Worm box.
14. Spring on trip shaft.
15. Sliding trip shaft.
16. Rack pinion shaft.
17. Feed reverse operating shaft.
18. Hoff. R.X.L.S. 1 1/2 ---R. & M. X.L.R. 1 1/2
19. Hoff. L.S. 8 ---R. & M. L.J. 3/8
20. 36T. 9D.P. worm wheel.
21. 27T. & 65T. 10D.P. sliding gear.
22. 80T. 10D.P. gear.
23. Racking shaft.
24. 26T. 10D.P. pinion.
25. Shaft for 27T. & 65T. sliding gear.
26. Hoff. L.S. 10 ---R. & M. L.J. 1.

# AMERICAN SPINDLE NOSE TYPE D.I.



A FEW THOUS' OF AN  
INCH ALLOWED FOR  
LOCKING UP SOLID

TO LOCK

**SETTING OF STUDS**  
REFERENCE LINE TO FALL IN  
ANY POSITION BETWEEN  
INDICATING ARROWS  
WHEN CAM IS LOCKED.  
TO DO THIS IT MAY BE  
NECESSARY TO MOVE STUD  
ONE TURN FOR CAM TO  
LOCK IN CORRECT POSI-  
TION.

STUD

TO LOCK

FIRST GIVE LIGHT LOCK TO EACH CAM IN  
TURN, THEN FOLLOW ROUND WITH FULL LOCK

# TABLE OF CUTTING SPEEDS

Dia. in Inches	METRES PER MINUTE																			Dia. in Inches	Dia. in Millimetres																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
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1/4	307	384	461	515	569	623	677	731	785	839	893	947	1001	1055	1109	1163	1217	1271	1325	1379	1433	1487	1541	1595	1649	1703	1757	1811	1865	1919	1973	2027	2081	2135	2189	2243	2297	2351	2405	2459	2513	2567	2621	2675	2729	2783	2837	2891	2945	2999	3053	3107	3161	3215	3269	3323	3377	3431	3485	3539	3593	3647	3701	3755	3809	3863	3917	3971	4025	4079	4133	4187	4241	4295	4349	4403	4457	4511	4565	4619	4673	4727	4781	4835	4889	4943	4997	5051	5105	5159	5213	5267	5321	5375	5429	5483	5537	5591	5645	5699	5753	5807	5861	5915	5969	6023	6077	6131	6185	6239	6293	6347	6401	6455	6509	6563	6617	6671	6725	6779	6833	6887	6941	6995	7049	7103	7157	7211	7265	7319	7373	7427	7481	7535	7589	7643	7697	7751	7805	7859	7913	7967	8021	8075	8129	8183	8237	8291	8345	8399	8453	8507	8561	8615	8669	8723	8777	8831	8885	8939	8993	9047	9101	9155	9209	9263	9317	9371	9425	9479	9533	9587	9641	9695	9749	9803	9857	9911	9965	10019	10073	10127	10181	10235	10289	10343	10397	10451	10505	10559	10613	10667	10721	10775	10829	10883	10937	10991	11045	11099	11153	11207	11261	11315	11369	11423	11477	11531	11585	11639	11693	11747	11801	11855	11909	11963	12017	12071	12125	12179	12233	12287	12341	12395	12449	12503	12557	12611	12665	12719	12773	12827	12881	12935	12989	13043	13097	13151	13205	13259	13313	13367	13421	13475	13529	13583	13637	13691	13745	13799	13853	13907	13961	14015	14069	14123	14177	14231	14285	14339	14393	14447	14501	14555	14609	14663	14717	14771	14825	14879	14933	14987	15041	15095	15149	15203	15257	15311	15365	15419	15473	15527	15581	15635	15689	15743	15797	15851	15905	15959	16013	16067	16121	16175	16229	16283	16337	16391	16445	16499	16553	16607	16661	16715	16769	16823	16877	16931	16985	17039	17093	17147	17201	17255	17309	17363	17417	17471	17525	17579	17633	17687	17741	17795	17849	17903	17957	18011	18065	18119	18173	18227	18281	18335	18389	18443	18497	18551	18605	18659	18713	18767	18821	18875	18929	18983	19037	19091	19145	19199	19253	19307	19361	19415	19469	19523	19577	19631	19685	19739	19793	19847	19901	19955	20009	20063	20117	20171	20225	20279	20333	20387	20441	20495	20549	20603	20657	20711	20765	20819	20873	20927	20981	21035	21089	21143	21197	21251	21305	21359	21413	21467	21521	21575	21629	21683	21737	21791	21845	21899	21953	22007	22061	22115	22169	22223	22277	22331	22385	22439	22493	22547	22601	22655	22709	22763	22817	22871	22925	22979	23033	23087	23141	23195	23249	23303	23357	23411	23465	23519	23573	23627	23681	23735	23789	23843	23897	23951	24005	24059	24113	24167	24221	24275	24329	24383	24437	24491	24545	24599	24653	24707	24761	24815	24869	24923	24977	25031	25085	25139	25193	25247	25301	25355	25409	25463	25517	25571	25625	25679	25733	25787	25841	25895	25949	26003	26057	26111	26165	26219	26273	26327	26381	26435	26489	26543	26597	26651	26705	26759	26813	26867	26921	26975	27029	27083	27137	27191	27245	27299	27353	27407	27461	27515	27569	27623	27677	27731	27785	27839	27893	27947	28001	28055	28109	28163	28217	28271	28325	28379	28433	28487	28541	28595	28649	28703	28757	28811	28865	28919	28973	29027	29081	29135	29189	29243	29297	29351	29405	29459	29513	29567	29621	29675	29729	29783	29837	29891	29945	29999	30053	30107	30161	30215	30269	30323	30377	30431	30485	30539	30593	30647	30701	30755	30809	30863	30917	30971	31025	31079	31133	31187	31241	31295	31349	31403	31457	31511	31565	31619	31673	31727	31781	31835	31889	31943	31997	32051	32105	32159	32213	32267	32321	32375	32429	32483	32537	32591	32645	32699	32753	32807	32861	32915	32969	33023	33077	33131	33185	33239	33293	33347	33401	33455	33509	33563	33617	33671	33725	33779	33833	33887	33941	33995	34049	34103	34157	34211	34265	34319	34373	34427	34481	34535	34589	34643	34697	34751	34805	34859	34913	34967	35021	35075	35129	35183	35237	35291	35345	35399	35453	35507	35561	35615	35669	35723	35777	35831	35885	35939	35993	36047	36101	36155	36209	36263	36317	36371	36425	36479	36533	36587	36641	36695	36749	36803	36857	36911	36965	37019	37073	37127	37181	37235	37289	37343	37397	37451	37505	37559	37613	37667	37721	37775	37829	37883	37937	37991	38045	38099	38153	38207	38261	38315	38369	38423	38477	38531	38585	38639	38693	38747	38801	38855	38909	38963	39017	39071	39125	39179	39233	39287	39341	39395	39449	39503	39557	39611	39665	39719	39773	39827	39881	39935	39989	40043	40097	40151	40205	40259	40313	40367	40421	40475	40529	40583	40637	40691	40745	40799	40853	40907	40961	41015	41069	41123	41177	41231	41285	41339	41393	41447	41501	41555	41609	41663	41717	41771	41825	41879	41933	41987	42041	42095	42149	42203	42257	42311	42365	42419	42473	42527	42581	42635	42689	42743	42797	42851	42905	42959	43013	43067	43121	43175	43229	43283	43337	43391	43445	43499	43553	43607	43661	43715	43769	43823	43877	43931	43985	44039	44093	44147	44201	44255	44309	44363	44417	44471	44525	44579	44633	44687	44741	44795	44849	44903	44957	45011	45065	45119	45173	45227	45281	45335	45389	45443	45497	45551	45605	45659	45713	45767	45821	45875	45929	45983	46037	46091	46145	46199	46253	46307	46361	46415	46469	46523	46577	46631	46685	46739	46793	46847	46901	46955	47009	47063	47117	47171	47225	47279	47333	47387	47441	47495	47549	47603	47657	47711	47765	47819	47873	47927	47981	48035	48089	48143	48197	48251	48305	48359	48413	48467	48521	48575	48629	48683	48737	48791	48845	48899	48953	49007	49061	49115	49169	49223	49277	49331	49385	49439	49493	49547	49601	49655	49709	49763	49817	49871	49925	49979	50033	50087	50141	50195	50249	50303	50357	50411	50465	50519	50573	50627	50681	50735	50789	50843	50897	50951	51005	51059	51113	51167	51221	51275	51329	51383	51437	51491	51545	51599	51653	51707	51761	51815	51869	51923	51977	52031	52085	52139	52193	52247	52301	52355	52409	52463	52517	52571	52625	52679	52733	52787	52841	52895	52949	53003	53057	53111	53165	53219	53273	53327	53381	53435	53489	53543	53597	53651	53705	53759	53813	53867	53921	53975	54029	54083	54137	54191	54245	54299	54353	54407	54461	54515	54569	54623	54677	54731	54785	54839	54893	54947	55001	55055	55109	55163	55217	55271	55325	55379	55433	55487	55541	55595	55649	55703	55757	55811	55865	55919	55973	56027	56081	56135	56189	56243	56297	56351	56405	56459	56513	56567	56621	56675	56729	56783	56837	56891	56945	56999	57053	57107	57161	57215	57269	57323	57377	57431	57485	57539	57593	57647	57701	57755	57809	57863	57917	57971	58025	58079	58133	58187	58241	58295	58349	58403	58457	58511	58565	58619	58673	58727	58781	58835	58889	58943	58997	59051	59105	59159	59213	59267	59321	59375	59429	59483	59537	59591	59645	59699	59753	59807	59861	59915	59969	60023	60077	60131	60185	60239	60293	60347	60401	60455	60509	60563	60617	60671	60725	60779	60833	60887	60941	60995	61049	61103	61157	61211	61265	61319	61373	61427	61481	61535	61589	61643	61697	61751	61805	61859	61913	61967	62021	62075	62129	62183	62237	62291	62345	62399	62453	62507	62561	62615	62669	62723	62777	62831	62885	62939	62993	63047	63101	63155	63209	63263	63317	63371	63425	63479	63533	63587	63641	63695	63749	63803	63857	63911	63965	64019	64073	64127	64181	64235	64289	64343	64397	64451	64505	64559	64613	64667	64721	64775	64829	64883	64937	64991	65045	65099	65153	65207	65261	65315	65369	65423	65477	65531	65585	65639	65693	65747	65801	65855	65909	65963	66017	66071	66125	66179	66233	66287	66341	66395	66449	66503	66557	66611	66665	66719	66773	66827	66881	66935	66989

# METRIC CONVERSION TABLES

1 METRE = 39.370113 INCHES

## INCHES TO MILLIMETRES

## FRACTIONS

Inch			M/m.	Inch			M/m.	Inch			M/m.
$\frac{1}{16}$	$\frac{1}{16}$	$\frac{1}{64}$	0.15625	$\frac{3}{8}$	$\frac{11}{32}$	$\frac{23}{64}$	3.4375	$\frac{1}{4}$	$\frac{23}{64}$	$\frac{67}{128}$	6.71875
	$\frac{1}{8}$	$\frac{2}{64}$	0.3125		$\frac{13}{32}$	$\frac{25}{64}$	3.59375		$\frac{25}{64}$	$\frac{71}{128}$	7.03125
$\frac{1}{8}$	$\frac{3}{16}$	$\frac{3}{64}$	0.46875	$\frac{7}{16}$	$\frac{15}{32}$	$\frac{27}{64}$	4.0625	$\frac{3}{8}$	$\frac{27}{64}$	$\frac{79}{128}$	7.8125
	$\frac{1}{4}$	$\frac{4}{64}$	0.625		$\frac{17}{32}$	$\frac{29}{64}$	4.21875		$\frac{29}{64}$	$\frac{83}{128}$	8.125
$\frac{3}{16}$	$\frac{5}{16}$	$\frac{5}{64}$	0.78125	$\frac{1}{2}$	$\frac{19}{32}$	$\frac{31}{64}$	4.53125	$\frac{7}{8}$	$\frac{31}{64}$	$\frac{91}{128}$	8.96875
	$\frac{3}{8}$	$\frac{6}{64}$	0.9375		$\frac{21}{32}$	$\frac{33}{64}$	4.6875		$\frac{33}{64}$	$\frac{95}{128}$	9.375
$\frac{1}{2}$	$\frac{7}{8}$	$\frac{7}{64}$	1.09375	$\frac{5}{8}$	$\frac{23}{32}$	$\frac{35}{64}$	4.84375	$\frac{15}{16}$	$\frac{35}{64}$	$\frac{101}{128}$	10.000
	$\frac{15}{16}$	$\frac{15}{64}$	1.25		$\frac{25}{32}$	$\frac{37}{64}$	5.15625		$\frac{37}{64}$	$\frac{105}{128}$	10.4375
$\frac{5}{8}$	$\frac{13}{16}$	$\frac{13}{64}$	1.40625	$\frac{3}{4}$	$\frac{27}{32}$	$\frac{39}{64}$	5.3125	$\frac{1}{2}$	$\frac{39}{64}$	$\frac{109}{128}$	10.875
	$\frac{11}{8}$	$\frac{11}{64}$	1.5625		$\frac{29}{32}$	$\frac{41}{64}$	5.46875		$\frac{41}{64}$	$\frac{113}{128}$	11.3125
$\frac{3}{4}$	$\frac{9}{8}$	$\frac{9}{64}$	1.71875	$\frac{7}{8}$	$\frac{31}{32}$	$\frac{43}{64}$	5.625	$\frac{15}{8}$	$\frac{43}{64}$	$\frac{117}{128}$	11.75
	$\frac{17}{8}$	$\frac{17}{64}$	1.875		$\frac{33}{32}$	$\frac{45}{64}$	5.78125		$\frac{45}{64}$	$\frac{121}{128}$	12.1875
$\frac{7}{8}$	$\frac{15}{8}$	$\frac{15}{64}$	2.03125	$\frac{15}{8}$	$\frac{35}{32}$	$\frac{47}{64}$	5.9375	$\frac{19}{8}$	$\frac{47}{64}$	$\frac{125}{128}$	12.625
	$\frac{13}{4}$	$\frac{13}{64}$	2.1875		$\frac{37}{32}$	$\frac{49}{64}$	6.09375		$\frac{49}{64}$	$\frac{129}{128}$	13.0625
$\frac{15}{8}$	$\frac{11}{4}$	$\frac{11}{64}$	2.34375	$\frac{19}{8}$	$\frac{39}{32}$	$\frac{51}{64}$	6.25	$\frac{23}{8}$	$\frac{51}{64}$	$\frac{133}{128}$	13.5
	$\frac{23}{8}$	$\frac{23}{64}$	2.5		$\frac{41}{32}$	$\frac{53}{64}$	6.40625		$\frac{53}{64}$	$\frac{137}{128}$	13.9375
$\frac{17}{8}$	$\frac{13}{4}$	$\frac{13}{64}$	2.65625	$\frac{23}{8}$	$\frac{43}{32}$	$\frac{55}{64}$	6.5625	$\frac{27}{8}$	$\frac{55}{64}$	$\frac{141}{128}$	14.375
	$\frac{21}{4}$	$\frac{21}{64}$	2.8125		$\frac{45}{32}$	$\frac{57}{64}$	6.71875		$\frac{57}{64}$	$\frac{145}{128}$	14.8125
$\frac{19}{8}$	$\frac{15}{4}$	$\frac{15}{64}$	2.96875	$\frac{27}{8}$	$\frac{47}{32}$	$\frac{59}{64}$	6.875	$\frac{31}{8}$	$\frac{59}{64}$	$\frac{149}{128}$	15.25
	$\frac{25}{4}$	$\frac{25}{64}$	3.125		$\frac{49}{32}$	$\frac{61}{64}$	7.03125		$\frac{61}{64}$	$\frac{153}{128}$	15.6875
$\frac{21}{8}$	$\frac{17}{4}$	$\frac{17}{64}$	3.28125	$\frac{31}{8}$	$\frac{51}{32}$	$\frac{63}{64}$	7.1875	$\frac{35}{8}$	$\frac{63}{64}$	$\frac{157}{128}$	16.125
	$\frac{19}{4}$	$\frac{19}{64}$	3.4375		$\frac{53}{32}$	$\frac{65}{64}$	7.34375		$\frac{65}{64}$	$\frac{161}{128}$	16.5625

## UNITS

Inches	10	20	30	40	50	60	70	80	90	100
0	254.0	508.0	762.0	1016.0	1270.0	1524.0	1778.0	2032.0	2286.0	2540.0
1	25.4	279.4	533.4	787.4	1041.4	1295.4	1549.4	1803.4	2057.4	2311.4
2	50.8	304.8	558.8	812.8	1066.8	1320.8	1574.8	1828.8	2082.8	2336.8
3	76.2	330.2	584.2	838.2	1092.2	1346.2	1600.2	1854.2	2108.2	2362.2
4	101.6	355.6	609.6	863.6	1117.6	1371.6	1625.6	1879.6	2133.6	2387.6
5	127.0	381.0	635.0	889.0	1143.0	1397.0	1651.0	1905.0	2159.0	2413.0
6	152.4	406.4	660.4	914.4	1168.4	1422.4	1676.4	1930.4	2184.4	2438.4
7	177.8	431.8	685.8	939.8	1193.8	1447.8	1701.8	1955.8	2209.8	2463.8
8	203.2	457.2	711.2	965.2	1219.2	1473.2	1727.2	1981.2	2235.2	2489.2
9	228.6	482.6	736.6	990.6	1244.6	1498.6	1752.6	2006.6	2260.6	2514.6

## MILLIMETRES TO INCHES

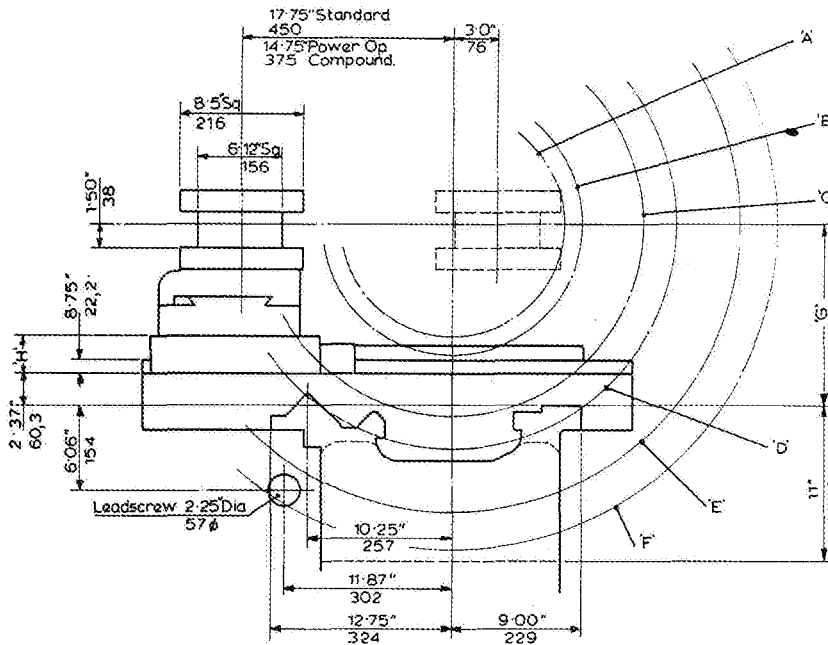
## UNITS

M/m.	10	20	30	40	50	60	70	80	90
0	0.39370	0.78740	1.18110	1.57480	1.96851	2.36221	2.75591	3.14961	3.54331
1	0.3937	0.7874	1.1811	1.5748	1.9685	2.3622	2.7559	3.1496	3.5433
2	0.7874	1.5748	2.3622	3.1496	3.9370	4.7244	5.5118	6.2992	7.0866
3	1.1811	2.3622	3.5433	4.7244	5.9055	7.0866	8.2677	9.4488	10.6300
4	1.5748	3.1496	4.7244	6.2992	7.8740	9.4488	11.0236	12.5984	14.1733
5	1.9685	3.9370	5.9055	7.8740	9.8425	11.8110	13.7795	15.7165	17.6535
6	2.3622	4.7244	7.0866	9.4488	11.8110	14.1733	16.5354	18.4095	20.1518
7	2.7559	5.5118	8.2677	10.6300	12.5984	15.1181	17.4032	19.3032	21.2992
8	3.1496	6.2992	9.4488	11.8110	14.1733	16.5354	18.4095	20.7803	22.4410
9	3.5433	7.0866	10.6300	13.7795	16.5354	18.4095	20.7803	22.4410	23.2284

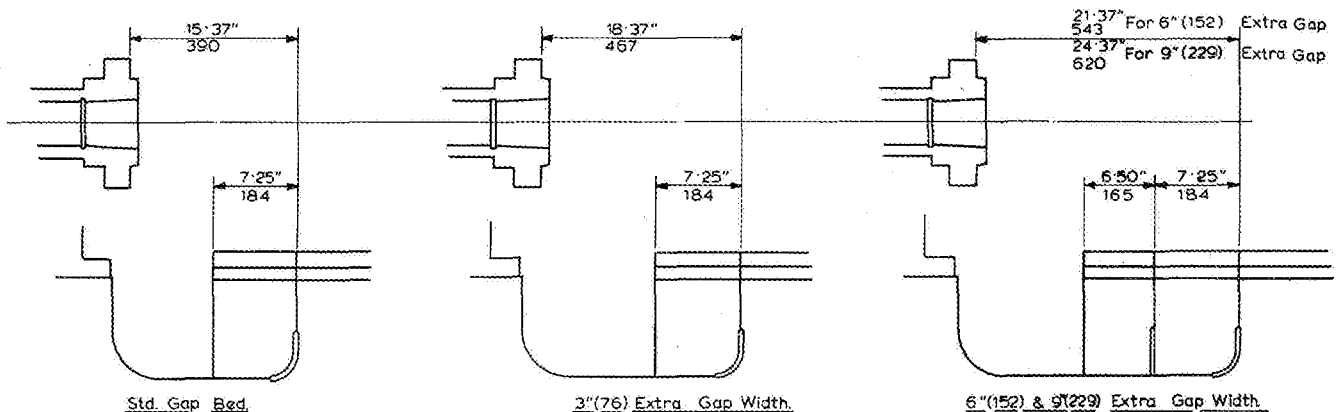
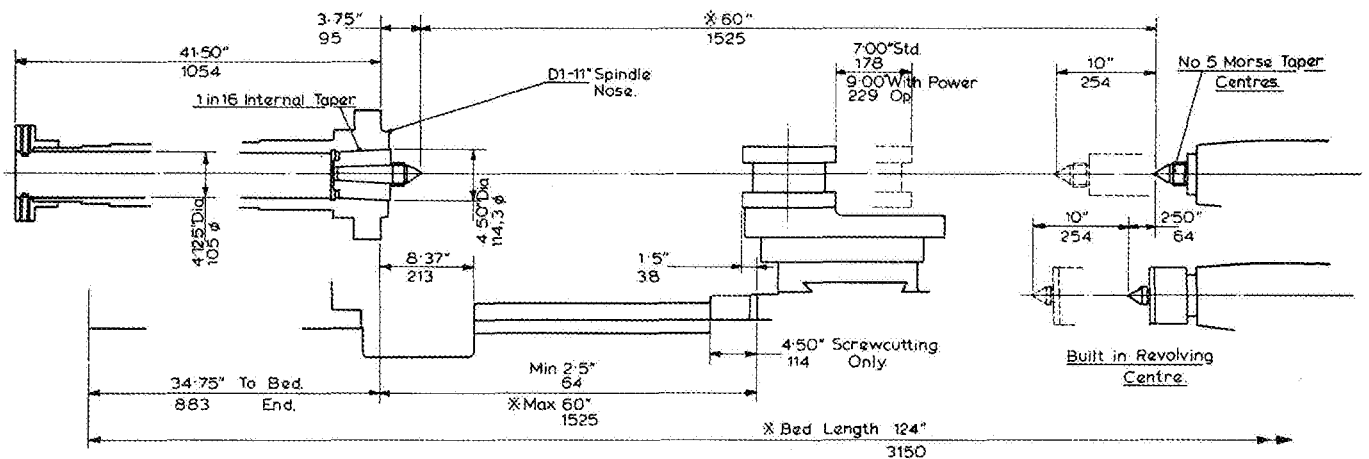
  

M/m.	100	200	300	400	500	600	700	800	900
0	3.93701	7.87402	11.8110	15.7480	19.6851	23.6221	27.5591	31.4961	35.4331
10	3.9370	7.8740	11.8110	15.7480	19.6851	23.6221	27.5591	31.4961	35.4331
20	7.8740	15.7480	23.6221	31.4961	39.3701	47.2442	55.1181	62.9922	70.8663
30	11.8110	23.6221	35.4331	47.2442	59.0552	70.8663	82.6774	94.4885	106.3000
40	15.7480	31.4961	47.2442	62.9922	78.7402	94.4885	110.2363	125.9844	141.7325
50	19.6851	39.3701	59.0552	78.7402	98.4253	118.1103	137.7954	157.1655	176.5356
60	23.6221	47.2442	70.8663	94.4885	118.1103	141.7325	165.3546	184.0957	201.5188
70	27.5591	55.1181	82.6774	106.3000	125.9844	151.1811	174.0327	193.0328	212.9929
80	31.4961	62.9922	94.4885	118.1103	141.7325	165.3546	184.0957	207.8039	224.4110
90	35.4331	70.8663	106.3000	137.7954	165.3546	184.0957	207.8039	224.4110	23.2284

# Capacities for 22 25 and 30xs Centre Lathes

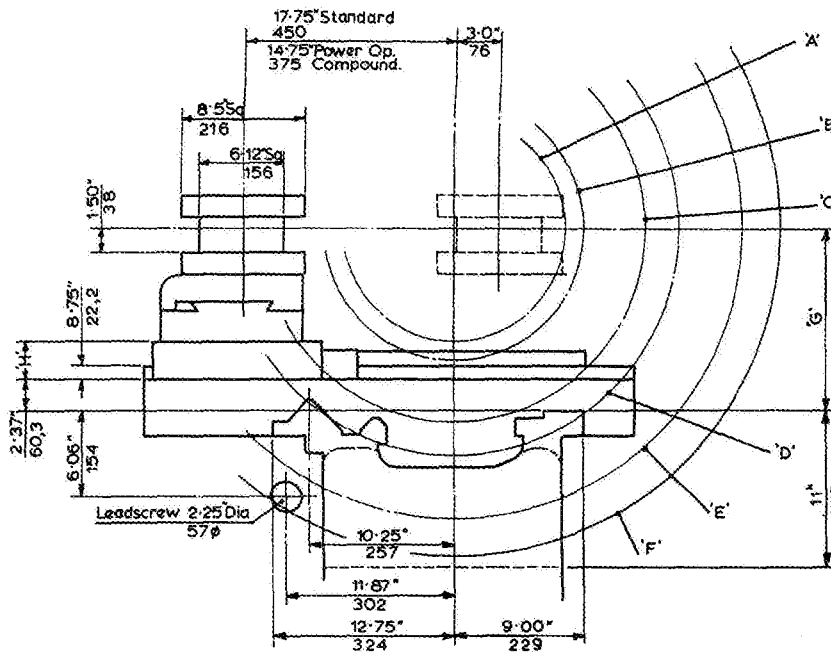


LATHE TYPE		22	25	30XS
Swing Over Saddle Guard	'A'	12.75" 320	15.75" 400	20.75" 530
Swing Over Saddle (Guard Removed)	'B'	15.25" 390	18.25" 460	23.25" 590
Swing Over Bed Shears	'C'	24.25" 615	27.25" 690	32" 810
Swing For 8" in Front of Spindle (Straight Bed Only)	'D'	29.50" 750	32.25" 820	37" 940
Swing in Gap (Gap Beds Only)	'E'	39" 990	41.50" 1050	45.75" 1160
Swing in Gap (Non Screwcutting)	'F'	43.50" 1105	46.50" 1180	51.50" 1310
Centre Height (Over Rear Shear)	'G'	11" 279,4	12.50" 317,5	15" 381
Cross Slide Thickness. Standard	'H'	2.125" 53,98	2.625" 66,68	5.125" 130,18
Power Op. Compound		—	2.125" 53,98	4.625" 117,48

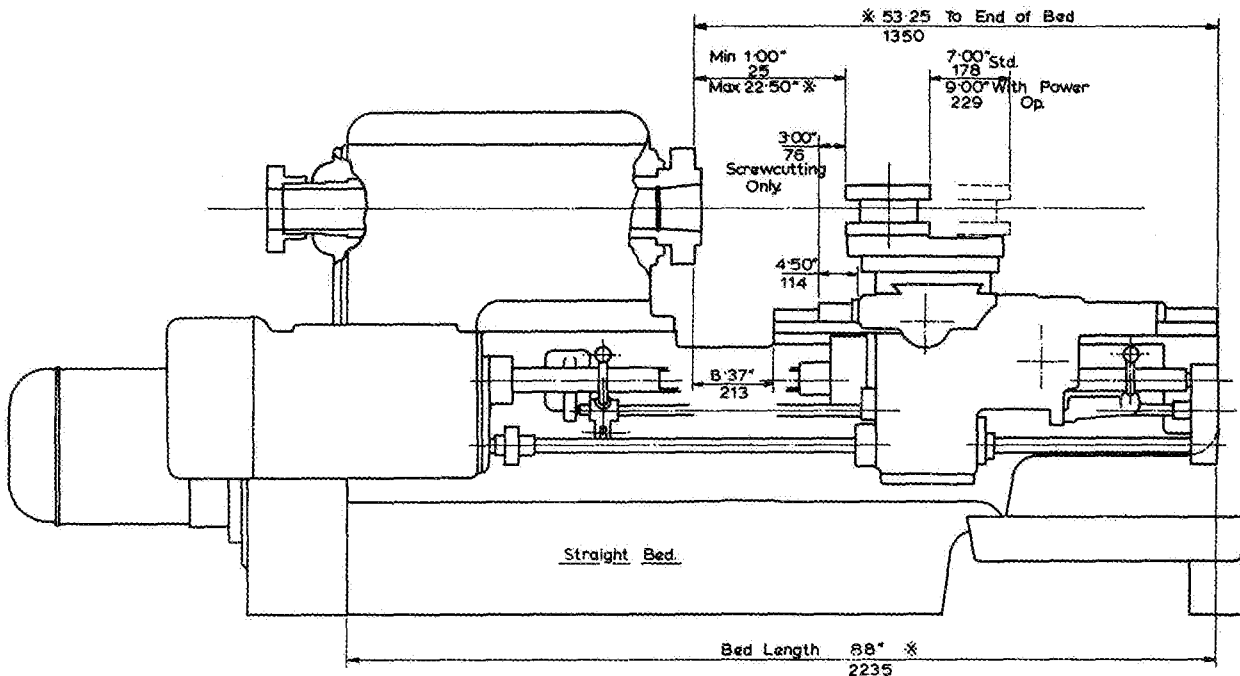


\* Dimensions Given Are for Shortest Bed Length 60" (1525) Between Centres Straight Bed & Std. Gap Only  
For Extra Gap Widths These Dimensions Will Increase Equivalent To The Gap Extension.

# Capacities for 25c and 30XSC Chucking Lathes



LATHE TYPE		25C	30XSC
Swing Over Saddle Guard	'A'	15.75" 400	20.75" 530
Swing Over Saddle (Guard Removed)	'B'	18.25" 460	23.25" 590
Swing Over Bed Shears	'C'	27.25" 690	32" 810
Swing For 8" in Front of Spindle (Straight Bed Only)	'D'	32.25" 820	37" 940
Swing in Gap (Gap Beds Only)	'E'	41.50" 1050	45.75" 1160
Swing in Gap (Non Screwcutting)	'F'	46.50" 1180	51.50" 1310
Centre Height (Over Rear Shear)	'G'	12.50" 317.5	15" 381
Cross Slide Thickness, Standard	'H'	2.625" 66.68	5.125" 130.18
Power Op. Compound		2.125" 53.98	4.625" 117.48



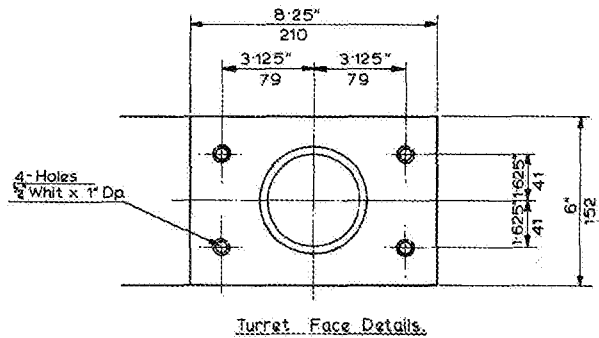
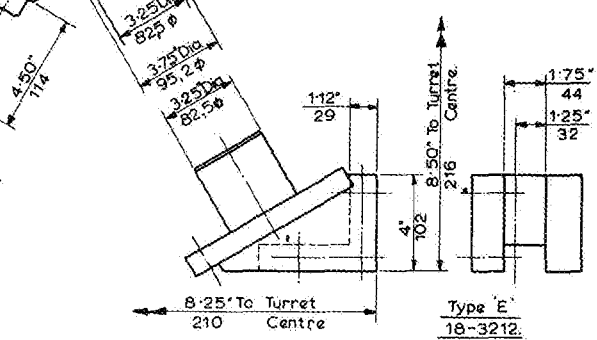
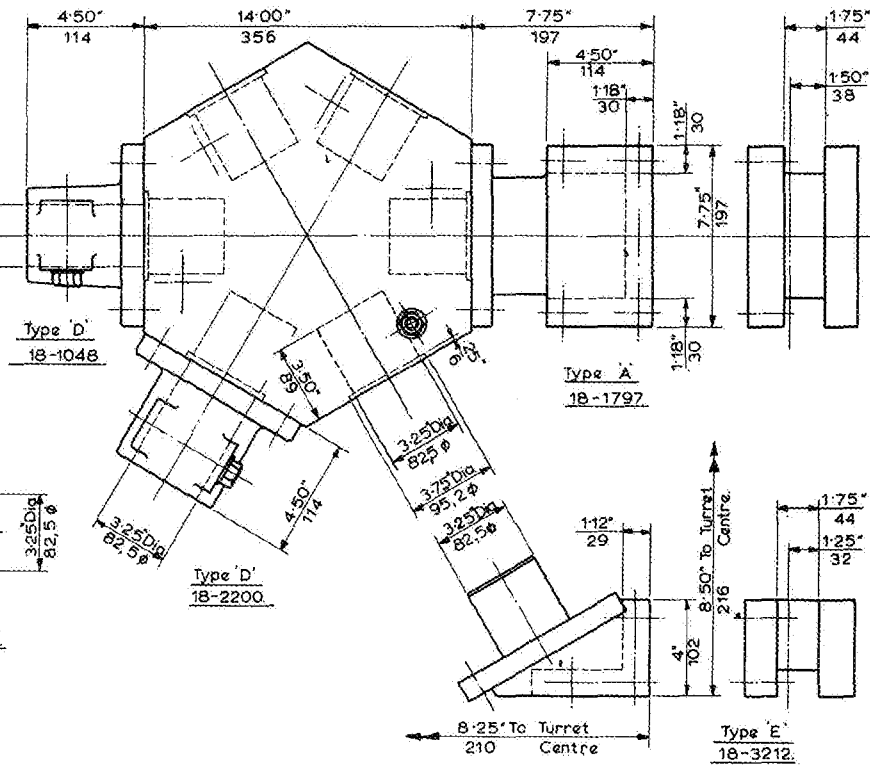
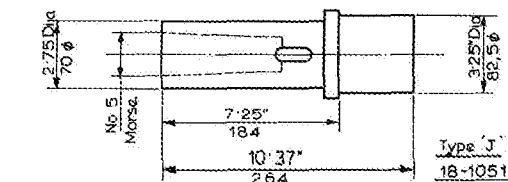
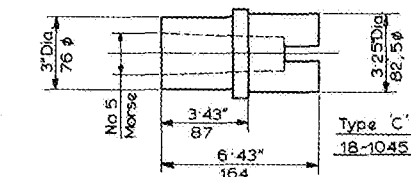
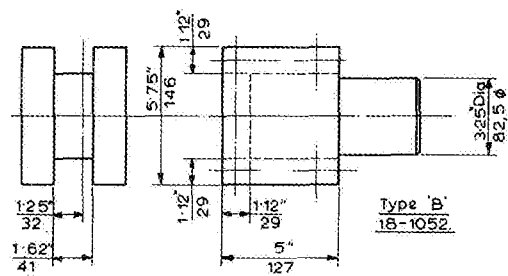
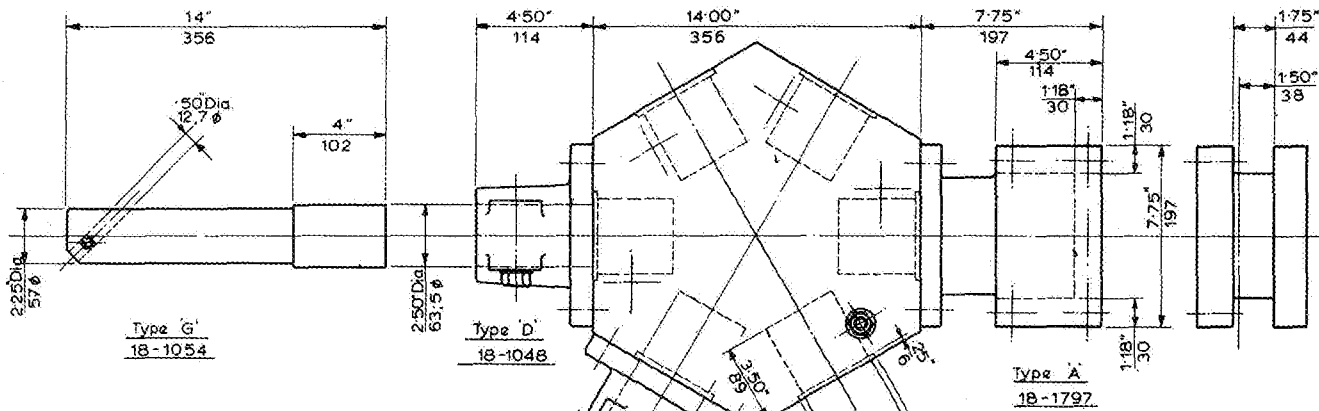
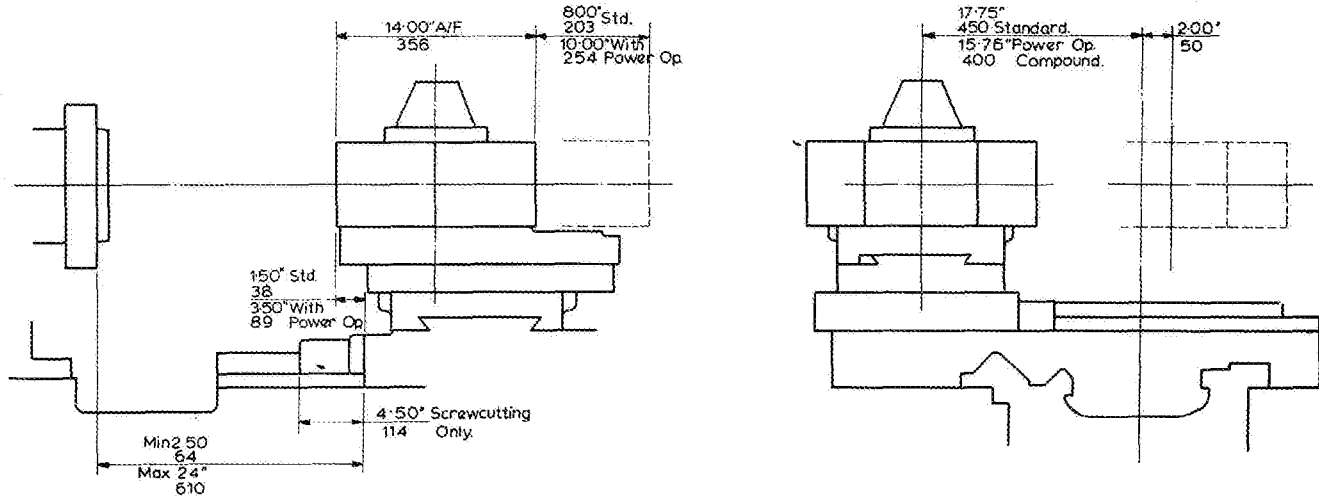
Standard and 3" (76) Extended Gaps Available As Type 25 and 30XS Centre Lathes.

\* Dimensions are for Straight Bed and Standard Gap Only. For the 3" (76) Extended Gap These Dimensions Will Increase by 3" (76).

Spindle Details are as Type 22, 25 and 30XS Centre Lathes

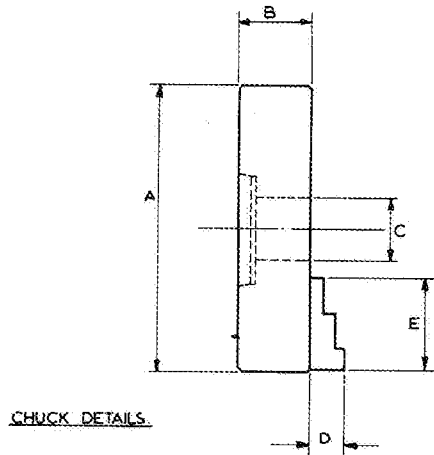
When Hexagon Turret Supplied Capacities are Modified see Page 18.

# Hexagon Turret Capacities for 25c and 30xsc

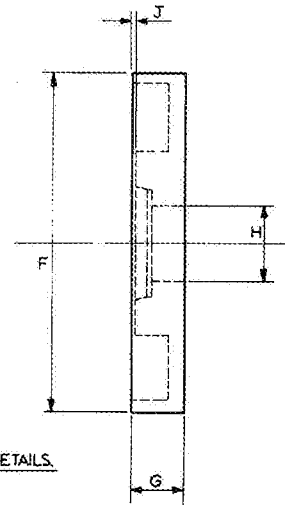


# Chucks and Faceplates

## CHUCKS & FACEPLATES



CHUCK DETAILS.



FACEPLATE DETAILS.

TYPE	A	B	C	D	E	MAX RPM
22" Dia. Pratt 4-JAW Independent	22" 560	4.250" 105	5.0" 127	2.625" 67	5.562" 141	770
26" Dia. Pratt. 4 JAW Independent	26" 660	5.0" 127	5.5" 140	3.25" 83	6.625" 168	620
15" Dia. Pratt. Tudor 3-JAW Self Centring	15" 380	4.437" 113	4.437" 113	2.125" 54	3.687" 94	930
18" Dia. Pratt. 3-JAW Self Centring	18" 460	3.968" 100	4.625" 118	2.093" 53	5.875" 149	930

Size	F	G	H	J
24"	24" 610	3.375" 86	5.250" 133	0.625" 16
36"	36" 915	3.375" 86	5.250" 133	0.625" 16
40"	40" 1015	3.375" 86	5.250" 133	0.625" 16

## MAXIMUM LOADS.

Weight on Solid Centres 6160 lbs.  
2795 kgs.

Weight on Built in Roter Bearing Centre 3360 lbs.  
1525 kgs.

Note. Weights Between Centres can be increased by 25% if Supported by Stationary Steady.

Weight in Chuck. 2240 lbs.  
1015 kgs.

C of G. 6" (152mm) Maximum from Chuck Face.

Maximum Drill Thrust on Saddle. Regular Duty 1700 lbs.  
770 kgs.  
Occasional Duty 3000 lbs.  
1360 kgs.

## SPINDLE NOSE & BACKPLATE DETAILS.

