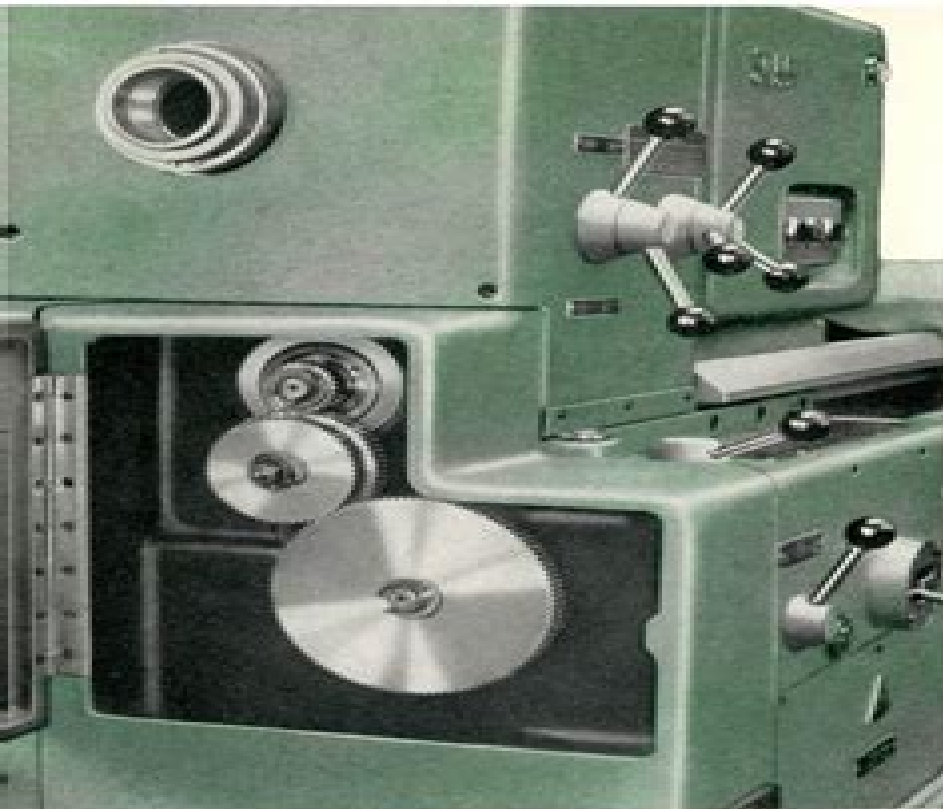




Change gears

The threading box

has a universal conception for cutting metric, Whitworth module and Diametral Pitch threads. For each type of thread to be cut a corresponding set of change gears is used. Threads and feeds are easily set by hand-operated levers which are operated according to a chart affording easy orientation.

The apron

is designed as an enclosed unit; at its front side there is a hand-operated lever for disengaging and engaging the lead screw; there is further a directional lever to control the longitudinal feed of the carriage and the transverse movements of the toolslide; finally, there is a hand wheel to operate the longitudinal feed of the carriage.

The lever which controls the multi-disc clutch of the gear-box is situated at the right of the apron and is secured against accidental displacement.

The engagements of the feed rod and of the lead screw are interlocked. The apron is equipped with a safety device which automatically disengages the feed in case of an overload, returning the directional lever to its neutral position.

The slides

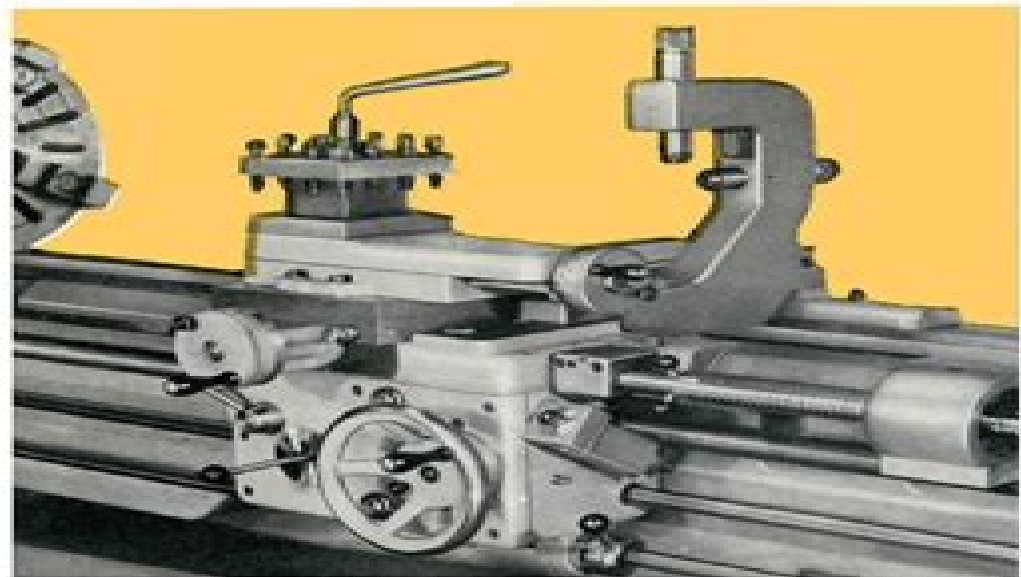
are adapted for the clamping of attachments and accessories supplied as optional equipment.

The longitudinal carriage travels on prismatic guideways protected by guards with wipers attached to the carriage. The play in the carriage guideways is taken up by a taper gib. The carriage can be locked to the slideways of the bed by the tightening of screws.

The cross slide is mounted in prismatic guideways, the backlash of which can be taken up by a taper gib. The power feed of the cross slide is controlled either by a directional lever on the apron or by a hand wheel equipped with an indexing ring. The latter can be released by a nut, adjusted at will and again locked in position.

The swivelling upper carriage is moved by a hand wheel with an indexing ring. Play in its guideways is taken up by a taper gib. The upper surface of the carriage carries a toolpost, easily adjustable by a lever by which it is locked in position.

SN 55 lathe with thread indicator



Tos Sn 4c Manual Lathe

James Lukin



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