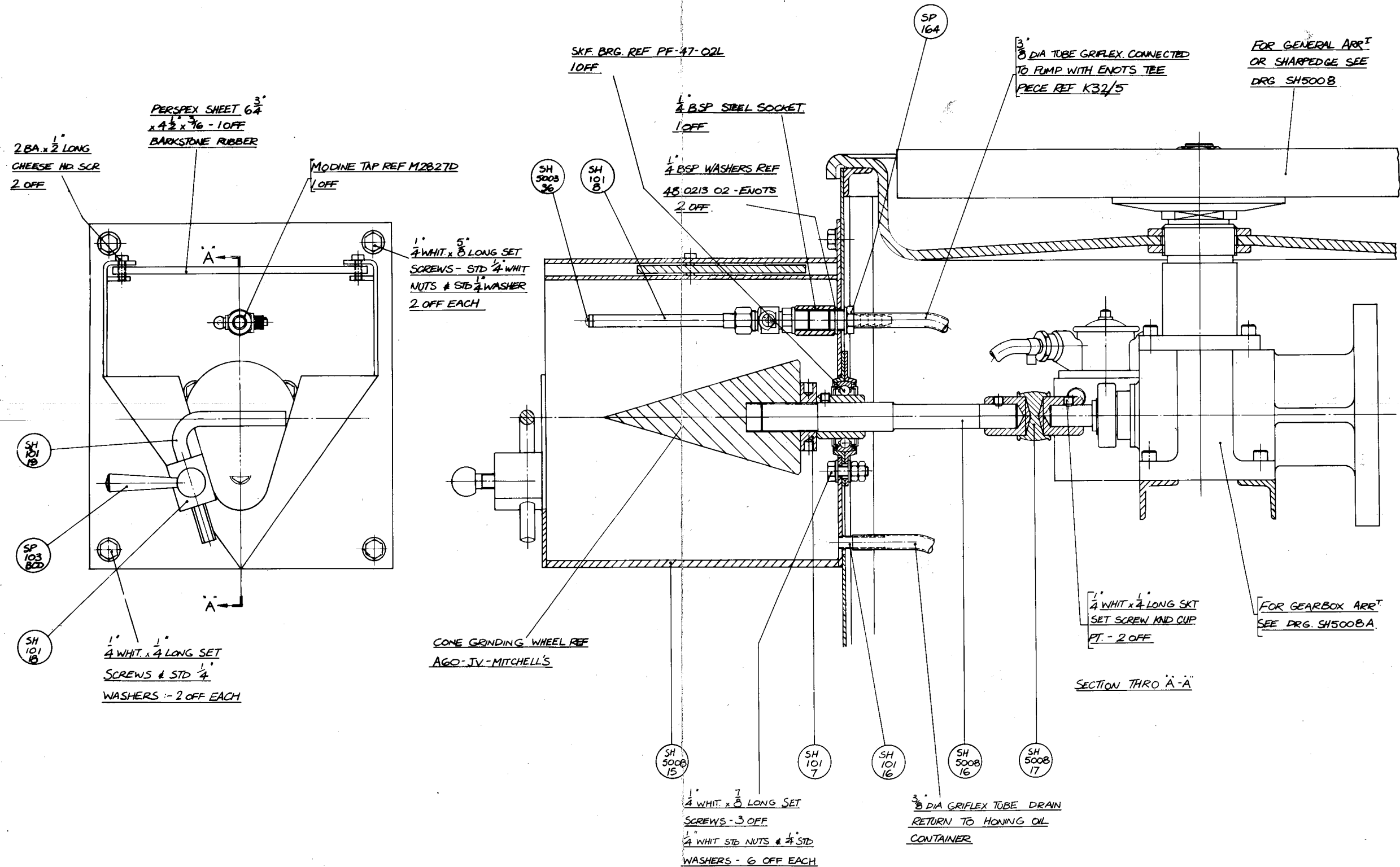
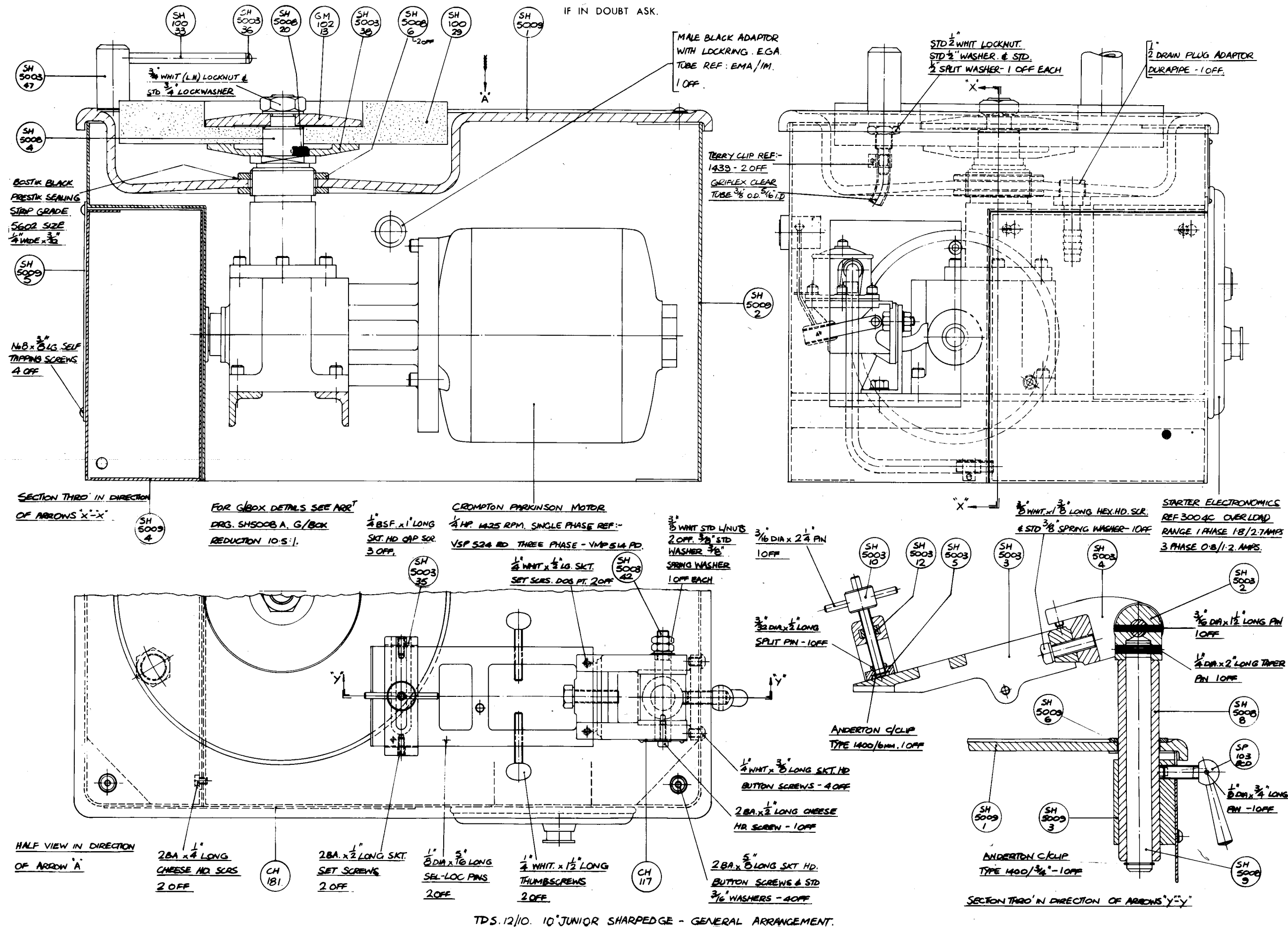
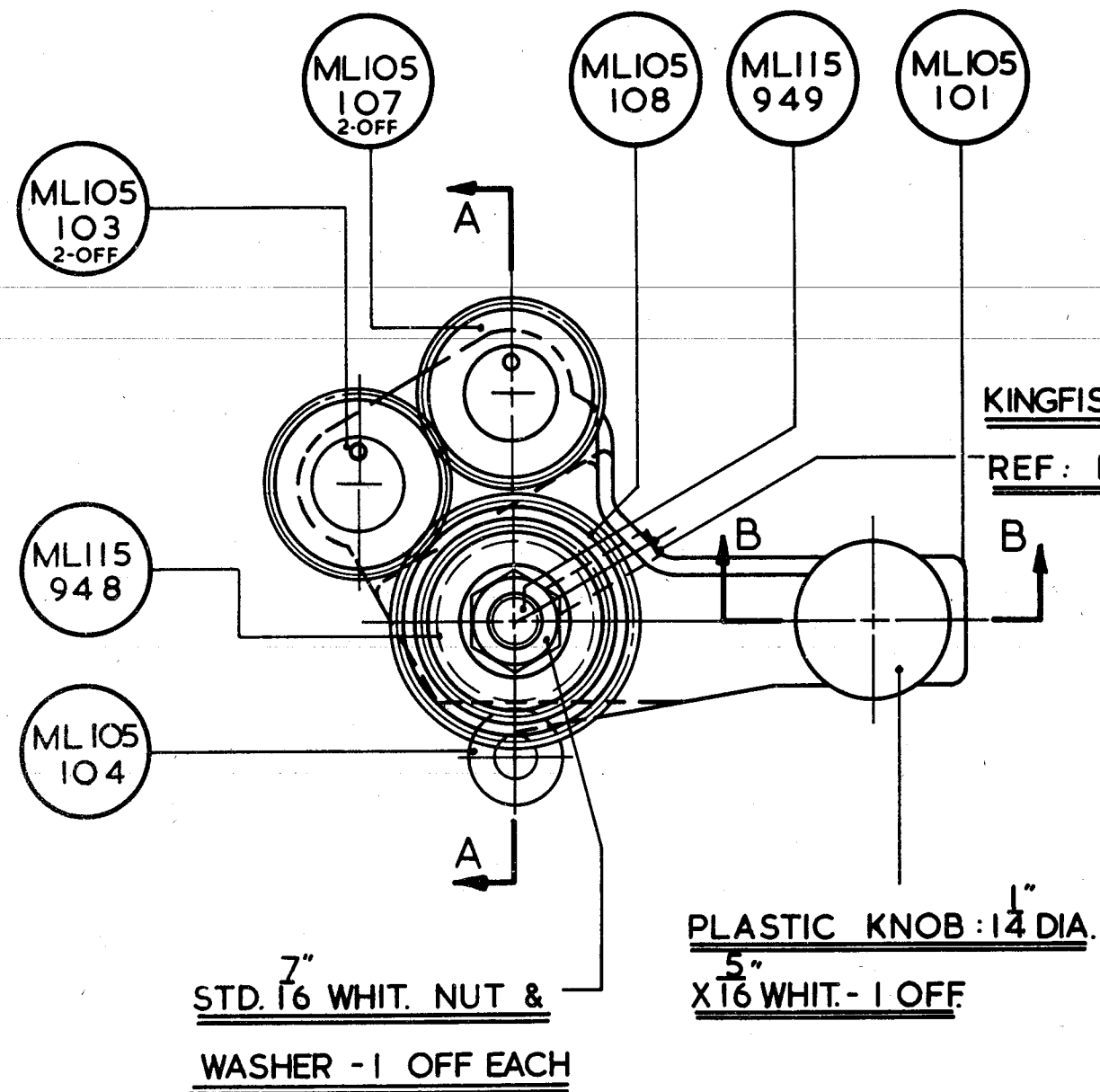


IF IN DOUBT ASK.



TDS 12/16 16 SHARPEDGE - INTERNAL GOUGE ATTACHMENT ARRANGEMENT.

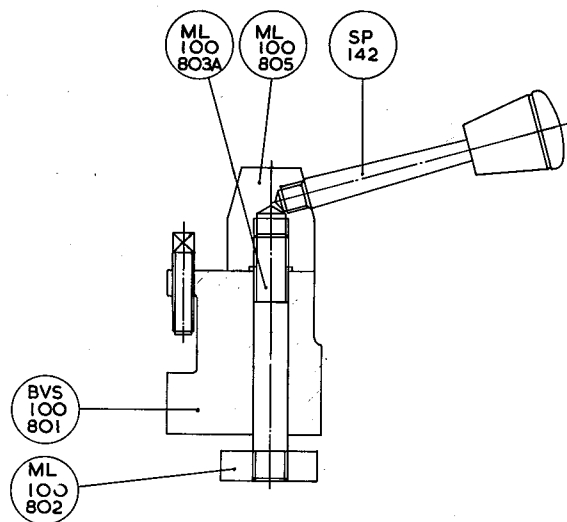




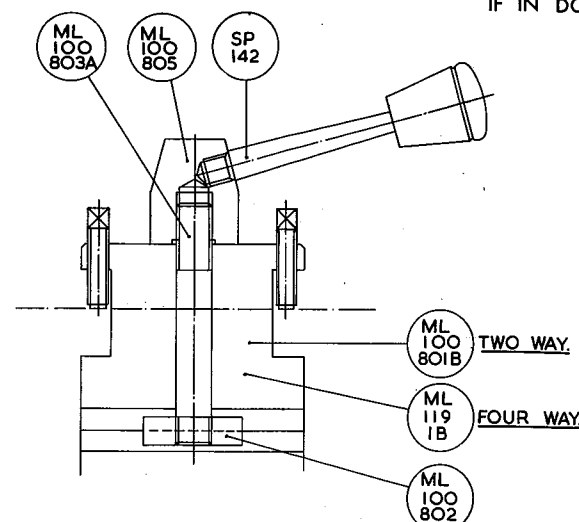
T.D.S. 1/1 G.B. 5" 'VICEROY' G.B. LATHE
REVERSING BRACKET ARRANGEMENT

DRG. No.

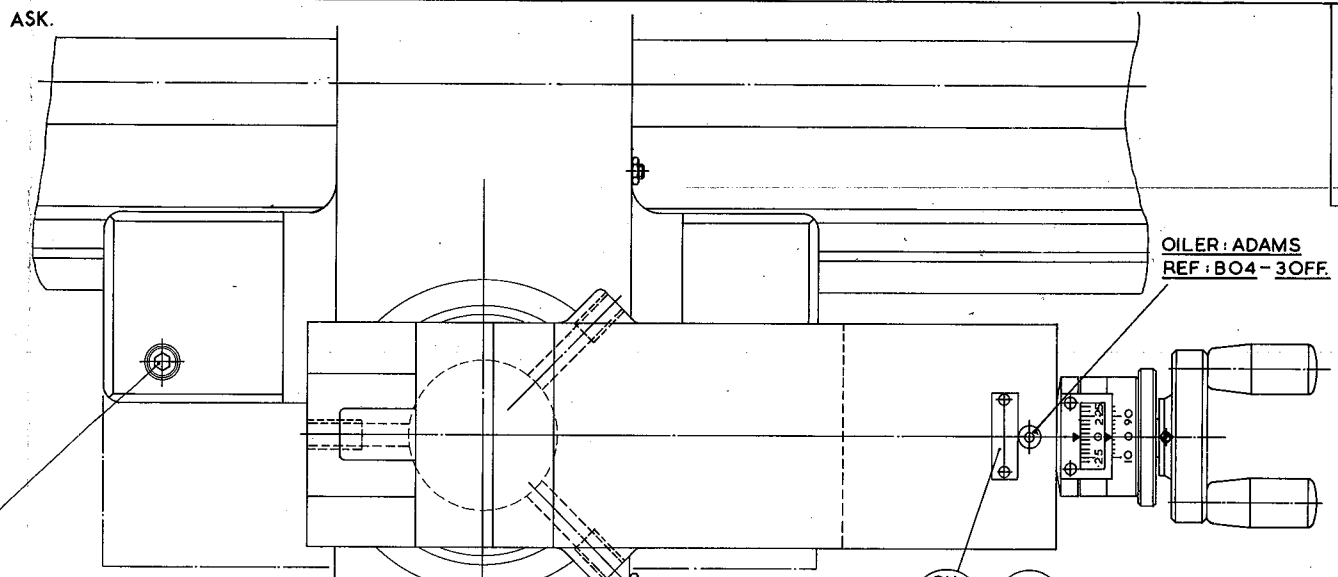
IF IN DOUBT ASK.



SINGLE WAY TOOLPOST.



TOOL SLIDE 280 BVS.



OILER ADAMS
REF: BO4 - 3 OFF.

RIVETS REF 201-080551-00
BLACK-8 OFF.

5" 16 WHIT. X 1 1/4 LONG SKT. HD.
CAP. SCREWS - 2 OFF.

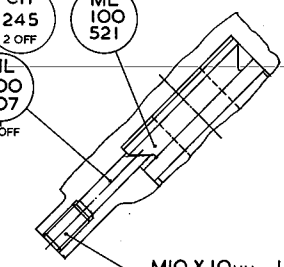
STD. BVS 100 503A 2 OFF
USA. BVS 100 503 2 OFF

3MM. DIA. X 30MM. LONG
GROOVED PIN - 2 OFF.

ELESA HANDWHEEL REF.
MD 80 FP - 1 OFF.

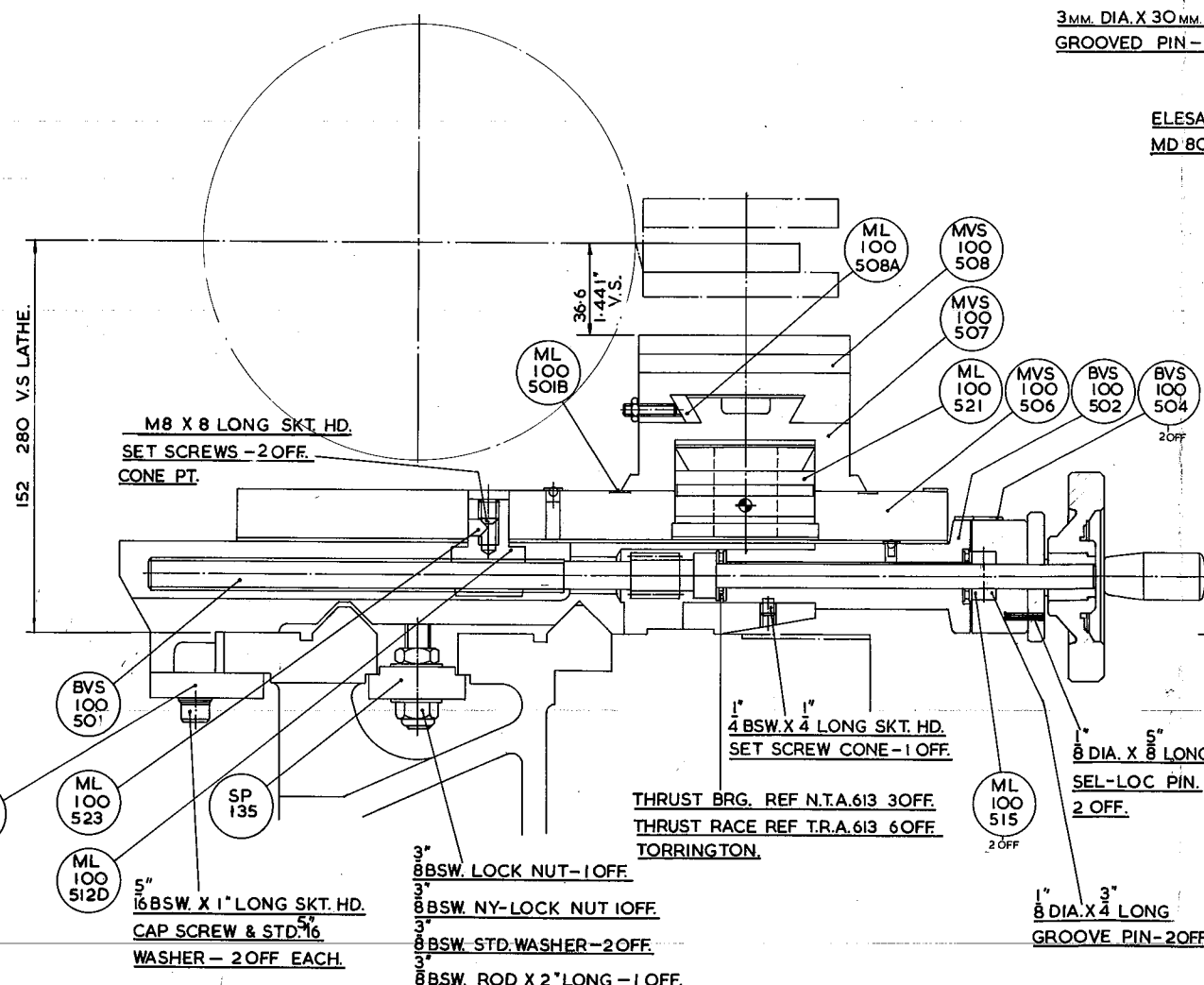
7" 2 B.A. X 8 LONG SKT. HD.
SET SCREW CONE PT. &
2 B.A. LOCKNUTS - 6 OFF.
EACH.

CH 245 2 OFF
ML 100 507 3 OFF



M10 X 10MM. LONG SKT.
HD. SET SCREW DOG PT.
3 OFF.

ELESA HANDWHEEL.
REF: MD 63 FP - 1 OFF.



M8 X 8 LONG SKT. HD.
SET SCREWS - 2 OFF.
CONE PT.

ML 100 501B

ML 100 508A MVS 100 508
MVS 100 507
ML 100 521 MVS 100 506
BVS 100 502 BVS 100 504 2 OFF

3" 16 DIA. X 1 1/2 LONG
GROOVE PIN - 1 OFF.

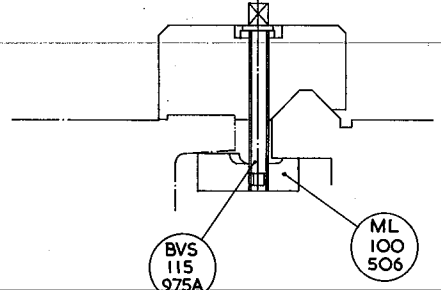
ML 100 504

ML 100 511B BVS 100 506

BVS 100 507 BVS 100 505 2 OFF

CURVED WASHER
REF: SU-10 - 2 OFF.

M4 X 5MM. LONG SKT. HD.
SET SCREW - CONE PT. - 1 OFF.



BVS 115 975A

ML 100 506

THRUST BRG. REF N.T.A.613 3 OFF.
THRUST RACE REF T.R.A.613 6 OFF.
TORRINGTON.

1" 4 BSW. X 4 LONG SKT. HD.
SET SCREW CONE - 1 OFF.

1" 8 DIA. X 5/8 LONG
SEL-LOC. PIN.
2 OFF.

ML 100 515 2 OFF

1" 8 DIA. X 3/4 LONG
GROOVE PIN - 2 OFF.

3" 8 BSW. LOCK NUT - 1 OFF.
3" 8 BSW. NY-LOCK NUT 1 OFF.
3" 8 BSW. STD. WASHER - 2 OFF.
3" 8 BSW. ROD X 2" LONG - 1 OFF.

5" 16 BSW. X 1" LONG SKT. HD.
CAP SCREW & STD. 1/16
WASHER - 2 OFF EACH.

MVS 100 513 ML 100 523 SP 135 ML 100 512D

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROY 280 BVS. LATHE - SADDLE ARRANGEMENT.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^{\circ}$ 3 PLACE DECIMAL $\pm .005^{\circ}$
FRACTIONAL $\pm .010^{\circ}$ 4 PLACE DECIMAL $\pm .0005^{\circ}$

MATL.
MATL. SIZE
No. REQD.
MACHINE AT "V"
GRIND AT "G"

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
R.D.				7. 7. 78.	FULL.

DRAWING No. BVS.100/500

No.	DESCRIPTION	CHKD.	APPD.	DATE
	ALTERATIONS			

IF IN DOUBT ASK.

DRONWALL COOLANT FITTINGS.
REF: 25/4440/00. 1 OFF.

FEMALE ELBOW ADAPTOR
ENOTS REF:34 0328 17 - 2 OFF.

COOLANT CAPACITY

	LITRES	UK. GAL	US. GAL
CABINET	10.6	2.3	2.8
BENCH	"	"	"

DRG. No.

REDUCING BUSH.
1/4-3/8 B.S.P. 1 OFF.

COOLANT PUMP
REF: EMU 50/A 150_{MM}
OR EMU 60/A 150_{MM}

HEX SET SCREW
M6 - 16 LONG - 2 OFF
M6 - NUT - 2 OFF
M6 - WASHER - 4 OFF

PLUG : ADAM
REF: NP. 50.G. - 1 OFF.

SKT HD CAP SCREWS.
M5 - 16 LONG. 2 OFF.

MALE/FEMALE BEND
1/2 BSP 1 OFF

CABINET TYPE

BENCH TYPE

TUBING
GRIFLEX CLEAR PLASTIC
1/2" BORE 18" LONG & 23" LONG.

DURAPIPE
HOSE ADAPTOR
REF: 157 102 10
2 OFF

No.	DESCRIPTION	CHKD.	APPD.	DATE
	ALTERATIONS			

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

280 VS LATHE

COOLANT SYSTEM

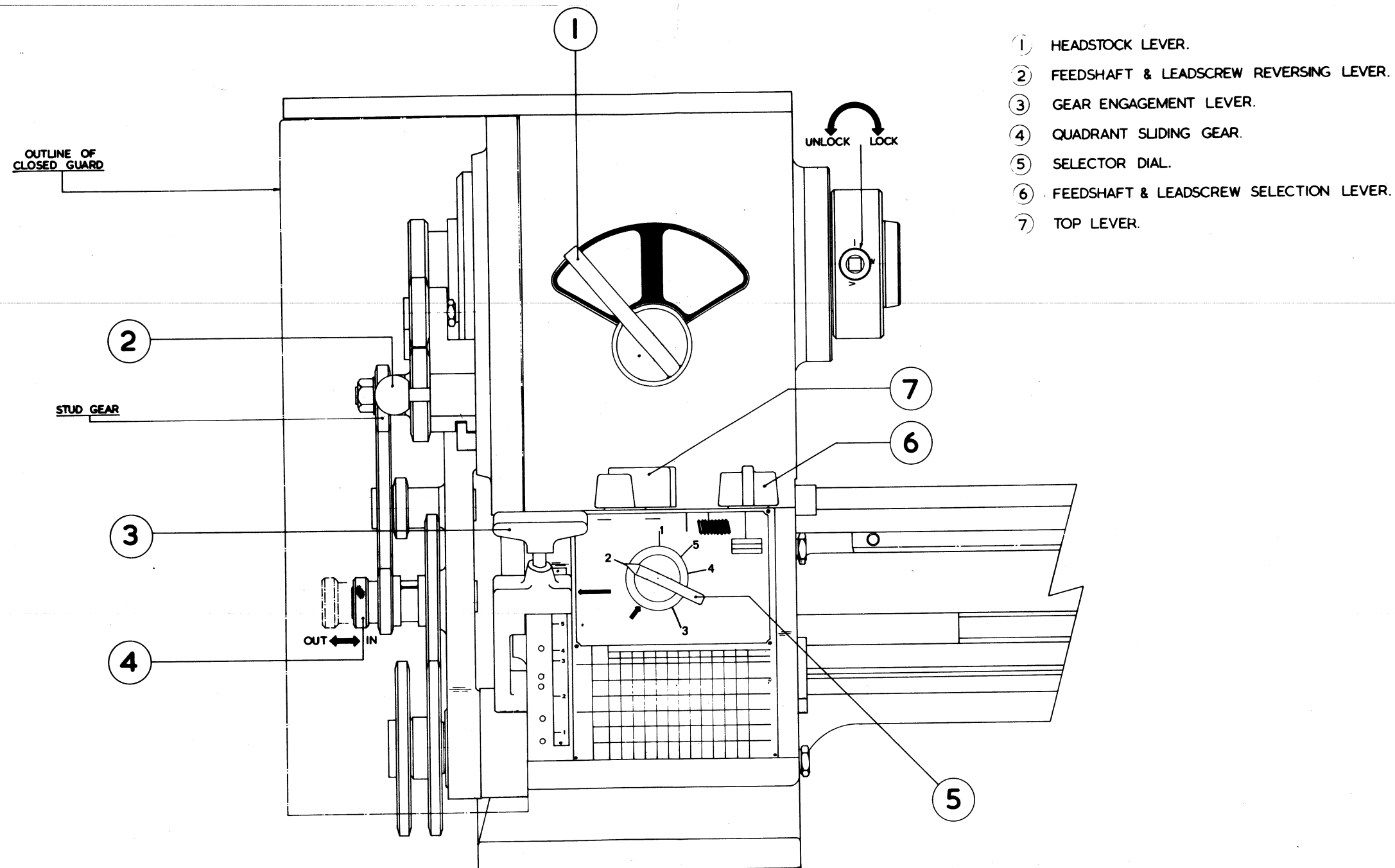
LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
FRACTIONAL $\pm .010"$ 4 PLACE DECIMAL $\pm .0005"$

MATL.
MATL. SIZE
No. REQD.
MACHINE AT $\nabla \nabla$
GRIND AT 'G'

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
1/1				29.6.78	



DRAWING No.BVS100/200A

GEAR BOX OPERATING INSTRUCTIONS FOR 'VICEROY' 280 VS. GB. LATHE.



- ① HEADSTOCK LEVER.
- ② FEEDSHAFT & LEADSCREW REVERSING LEVER.
- ③ GEAR ENGAGEMENT LEVER.
- ④ QUADRANT SLIDING GEAR.
- ⑤ SELECTOR DIAL.
- ⑥ FEEDSHAFT & LEADSCREW SELECTION LEVER.
- ⑦ TOP LEVER.

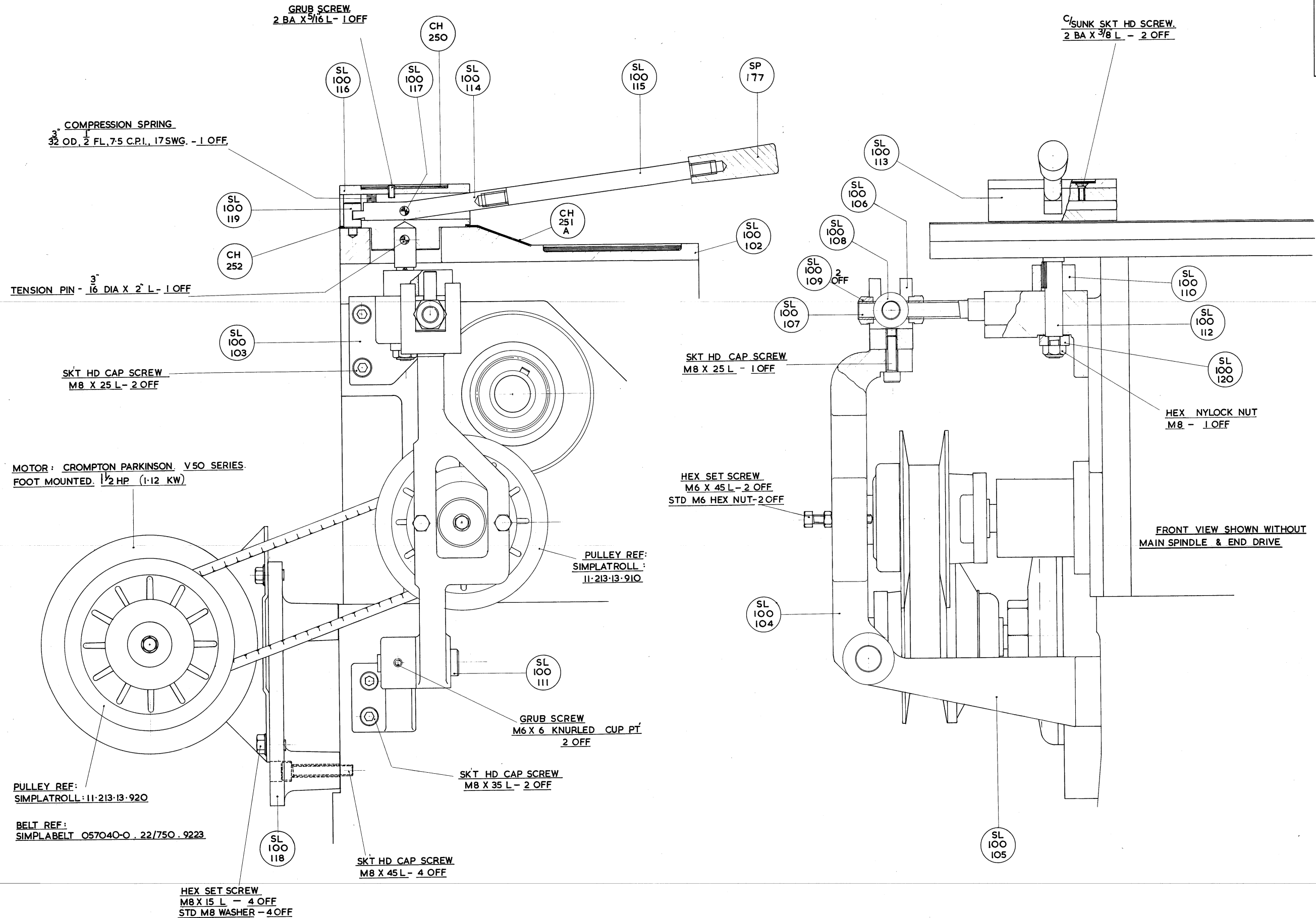
- (A) HEADSTOCK LEVER (ITEM 1) TO SELECT HIGH RANGE OR LOW RANGE OF SPINDLE SPEEDS. OPERATE WHEN MACHINE SPINDLE IS STATIONARY. IT MAY BE NECESSARY TO OSCILLATE CHUCK BY HAND IF ENGAGEMENT IS NOT COMPLETE FIRST TIME.
- (B) FOR THE SELECTION OF FEEDS REQUIRED, SEE CHART ON FRONT OF GEARBOX.
- (C) MOVE QUADRANT SLIDING GEAR (ITEM 4) TO EITHER IN OR OUT POSITION DEPENDING ON FEED SELECTED.
- (D) START LATHE. MOVE ENGAGEMENT LEVER (ITEM 3) TO NEUTRAL POSITION, MARKED 'N' ON GEAR ENGAGEMENT CHART.
- (E) SET SELECTOR DIAL (ITEM 5) TO POSITION REQUIRED ON FEED CHART. THE DIAL WILL NOT MOVE UNLESS GEAR ENGAGEMENT LEVER (ITEM 3) IS IN NEUTRAL 'N'.

- (F) MOVE GEAR ENGAGEMENT LEVER (ITEM 3) TO CORRECT NUMBERED POSITION SHOWN ON GEAR ENGAGEMENT LEVER CHART, CORRESPONDING TO THE SELECTOR DIA (ITEM 5) NUMBER SELECTED.
- (G) MOVE TOP LEVER (ITEM 7) TO EITHER LEFT - CENTRE - RIGHT POSITION FOR FEED REQUIRED AS INDICATED ON GEARBOX FEED CHART. WHEN LATHE IS RUNNING.
- (H) FEEDSHAFT & LEADSCREW SELECTION LEVER ITEM 6 SHOULD BE MOVED TO EITHER F/SHAFT  - NEUTRAL - L/SCREW  AS DESIRED. WHEN LATHE IS RUNNING.
- (J) TRAVERSE REVERSING LEVER (ITEM 2) IS A QUICK METHOD OF REVERSING THE DIRECTION OF POWER FEED.

NOTE: THE LATHE CANNOT BE STARTED UNTIL END DRIVE GUARD IS CLOSED.

IF IN DOUBT ASK.

DRG. No.



DESCRIPTION			CHKD.	APPD.	DATE
ALTERATIONS					

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

280 SYNCHRO METAL LATHE

SPEED CONTROL

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^{\circ}$ 3 PLACE DECIMAL $\pm .005^{\circ}$
FRACTIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$

MATL.
MATL. SIZE
No. REQD.
MACHINE AT 177
GRIND AT 'G'

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV				17-1-80	

DRAWING No. SL100/100.