

## DENFORD MACHINE TOOLS.

NOTICE OF MODIFICATION TO MANUFACTURED PART. MVS. 100/701.

Request for mod.by	Name.	Date.	Sign.	Pattern Mod.	Parts List.✓
	I. VICKERY.	19.9.77.		YES/NO	Arret. ✓

Nature of request:

D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
Mod. No.	Copies issued to :-	D.O., W.O., Insp., Fitting. Stores.	No. of copies		
2421/77.		Final Fitting. M/c. Shop.	5.		

Drg. No.

Details of Modification.

MVS.  
100/701.

5" &amp; 280VS. LATHE. TAILSTOCK BODY.

1- M18 HOLE ADDED TO TAKE MVS. 100/712  
CLAMP HANDLE STOP.

Remarks.

Checked.

I. VICKERY

## DENFORD MACHINE TOOLS.

NOTICE OF MODIFICATION TO MANUFACTURED PART.

MVS 100/702

Request for mod.by	Name. G.H. PNOZD.	Date. 15-9-77	Sign.	Pattern Mod. YES/NO	Parts List. Artt.
Nature of request: INCREASE WIDTH OF CORED HOLE IN FRONT OF SHOE TO CLEAR CLAMP.					
D.O. Job issued.	Date. 15-9-77	Sign. MM	Job completed.	Date. 15-9-77	Sign. MM
Mod. No. 2420/77	Copies issued to :-	D.O., W.O., Insp., Fitting, Stores. Mill, Fitting, W/o, Shop.			No. of copies 2

Fig. No. MVS 100/702	Details of Modification. ALTER CORED SLOT IN FRONT OF SHOE FROM 1" WIDE TO 1 1/4" WIDE
Remarks.	Checked. MM.

## DENFORD MACHINE TOOLS.

NOTICE OF MODIFICATION TO MANUFACTURED PART.

MVS:100/701

Request for mod.by	Name. D.O.	Date. 11-7-77	Sign. I. VICKERY	Pattern Mod. YES/NO	Parts List. Asst.
Nature of request: TO MAKE SLOT IN TAILSTOCK SO THAT TAILSTOCK BODY AND TAILSTOCK SHOE CASTING ALIGN AT THE REAR.					
D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
Mod. No. 2396/77	Copies issued to :-	D.O., W.O., Insp., Fitting, Stores. P <del>mill</del> Fitting. M/c. Shop.			No. of copies 4

Org. No.	Details of Modification.
MVS:100 701	<u>280VS - TAILSTOCK BODY</u>  THE 32 WIDE SLOT HAS BEEN MOVED 3 TO THE REAR, SO THAT THE 148.25/147.75 DIMENSION FROM THE NOSE FACE IS NOW 99 FROM THE CASTING REAR.
Remarks.	TAILSTOCK SHOE REMAINS THE SAME.
	Checked. I. Vickery

## DENFORD MACHINE TOOLS.

NOTICE OF MODIFICATION TO MANUFACTURED PART. TAILSTOCK BARREL

Request for mod.by	Name.	Date.	Sign.	Pattern Mod.	Parts List.
	W.	D.O.	J. Viceroy	YES/NO	Amnt.

Nature of request:

MODIFY TO ACCOMMODATE IMPERIAL  
GRADUATIONS.

D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
	29.3.77	W.		29.3.77	W.

Mod. No.	Copies issued to :-	D.O., W.O., Insp., Fitting, Stores.	No. of copies
2366/77.		F. mill, Fitting. M/c. Shop.	3

Org. No.

Details of Modification.

MVS  
100/705VICEROY 5" #280VS - TAILSTOCK BARRELTHE MILLED FLAT WAS ~~60~~ mm LONG IS IS  
NOW 80 mm LONG. 75.THIS IS SO A GRADUATED RULE 3" LONG  
MAY BE ENGRAVED FOR IMPERIAL LATHES.

Remarks.

Checked.

J. Viceroy

## DENFORD MACHINE TOOLS.

## NOTICE OF MODIFICATION TO MANUFACTURED PART. MVS100/701

Request for mod. by	Name.	Date.	Sign.	Pattern Mod.	Parts List. ✓
	B. KELLET.	RD.	22.11.78.	YES/NO	Art. ✓

Nature of request: PLEASE DELETE TAILSTOCK BARREL WIPER  
~~PLATE~~ PLATE. DELETE ONE OILER IN TOP OF  
 BODY.

D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
	22.11.78.	RD.		22.11.78	RD.
Mod. No.	Copies issued to	D.O., W.O., Insp., Fitting, Stores, <del>Special Fitting</del> M/c. Shop. (PM)	No. of copies		
2640/78.			6		

Drg. No.	Details of Modification.
MVS100/701	<p><u>TAILSTOCK BODY.</u></p> <p>250 MM DIMENSION NOW READS 256.          35 " " " " 41.          10 " " " " 16.          45 " " " " 51          80 " REF. " " " 86 MM REF.</p> <p>4 HOLES DRILL &amp; TAP M6 ARE NOW DELETED.          1 HOLE DRILL LETTER "C" DIA X 80MM DINS.          FROM THE END IS NOW DELETED FROM THE          DRAWING.</p>
MVS100/702	<p><u>TAILSTOCK BARREL WIPER PLATE.</u></p> <p>THIS COMPONENT IS NOW OBSOLETE.</p> <p>FEEL WASHER 35 I.D. X 41 O.D. 3 THICK          IS NOW OBSOLETE.</p> <p>CENTRE OILER IS NOW OBSOLETE.</p>
MVS100/708	<p><u>BARREL CLAMP LEVER.</u></p> <p>THIS COMPONENT IS NOW OBSOLETE &amp; IS          REPLACED BY MVS115/979B.</p>
Remarks.	<div>Checked,</div> <div>RD</div>

## DENFORD MACHINE TOOLS.

NOTICE OF MODIFICATION TO MANUFACTURED PART.

MVS.100/704

Request for mod.by	Name. J. RUSSELL	Date. 24.10.78	Sign. <i>J. Russell</i>	Pattern Mod. YES/NO	Parts List. Arrt. ✓
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Nature of request:

TO MODIFY MVS.100/704 AND STANDARDIZE  
ON SP.176. MAKING SP.177 OBSOLETE.

D.O. Job issued.	Date. 25.10.78	Sign. IV.	Job completed.	Date. 25.10.78	Sign. IV.
Mod. No. 2620/78	Copies issued to :-	D.O., W.O., Insp., Fitting. Stores. - Mill, Fitting. M/c. Shop.			No. of copies 5

Drg. No. MVS.100/704	Details of Modification. <p>280VS LATHE - CLAMPING HANDLE</p> <p>THE THREAD WAS M10 x 15 LONG.</p> <p>THE BAR IS NOW TURNED DOWN TO 8.00/7.92 MM DIA AND THREADED M8.</p> <p>THIS WILL ALLOW SP176 TO BE USED INSTEAD OF SP177 WHICH IS NOW OBSOLETE.</p>
Remarks.	Checked. <i>I. Vickery</i>

## DENFORD MACHINE TOOLS.

NOTICE OF MODIFICATION TO MANUFACTURED PART.

MVS. 100/702

Request for mod.by	Name.	Date.	Sign.	Pattern Mod.	Parts List.
	D.O.	19.7.78	I. Vickery	YES/NO	Arzt. ✓

Nature of request:

TO INCREASE CORE TO  
CLEAR CLAMPING STUD.

D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
	19.7.78	10.		19.7.78	10.
Mod. No.	Copies issued	D.O., W.O., Insp., Fitting. - Stores.			No. of copies
2568/78	4	F. mill. Fitting. M/c. Shop.			4

Drg. No.	Details of Modification.
MVS. 100/702	<p>280 VS LATHE - TAILSTOCK BODY.</p> <p>THE <math>\frac{3}{4}</math>" DIMENSION TO THE <math>\frac{1}{4}</math>" WIDE CORE IS NOW <math>\frac{5}{8}</math>" THUS MAKING THE CORE <math>1\frac{3}{8}</math>" WIDE.</p>
Remarks.	Checked. I. Vickery

## DENFORD MACHINE TOOLS.

NOTICE OF MODIFICATION TO MANUFACTURED PART. MVS100/701

Request for med. by	Name.	Date.	Sign.	Pattern Mod.	Parts List.
	B. VAINES	16.2.78	D.W. Vaines	YES/NO	Amst.

Nature of request: PLEASE ADD MACHINING  
TO SIDE OF CASTING FACE (FOR DATUM)

D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
	16.2.78	RD		16.2.78	RD

Mod. No.	Copies issued to :-	D.O., W.O., Insp., Fitting. Stores.	No. of copies
2504/78		Mach. Fitting. M/c. Shop.	4

g. No.	Details of Modification.
MVS100/701	<u>VICE ROY 280VS. LATHE :- TAILSTOCK BODY.</u> MACHINING SYMBOLS ADDED TO DRAWING, (ON THE SIDE WITH THE 50MM PAD) 43 MM REFERENCE DIMENSION DELETED. 47 MM DIMENSION ADDED TO DRAWING.
Remarks.	Checked. RD



## DENFORD MACHINE TOOLS.

NOTICE OF MODIFICATION TO MANUFACTURED PART. MVS100/707 &amp; PDI-124.

Request for mod.by	Name.	Date.	Sign.	Pattern Mod.	Parts Int.
	INSPECTION	20.1.78	J. Japp	YES/NO	

## Nature of request:

RECESS TOO DEEP FOR LOCITE,  
PLEASE AMEND TO  $-.002$   
 $-.004$

D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
	20.1.78	RD		20.1.78	RD
Mod. No.	Copies issued to:-	D.O., W.O., Insp., Fitting, Shaws, Mill, Fitting, M/c. Shop.			No. of copies
2489/78					3.

Fig. No.	Details of Modification.
MVS100/707	VICEROY VARI-SPEED LATHE - TAILSTOCK NUT. 24.75 MM DIA NOW READS 24.95 MM 24.90 DIA.
PDI-124	VICEROY DRILLING MACHINE - SPLINE INSERT. .865" DIA NOW READS <del>.875</del> " DIA. <del>.871</del> " DIA. .871" .869" DIA.
Remarks.	Checked. RD

NOTICE OF MODIFICATION TO MANUFACTURED PART. BVS.

Request for mod. by	Name.	Date.	Sign.	Pattern Mod.	Parts List. ✓
	B. KELLET.	27.3.79.	RD.	<del>YES</del> /NO	Arret. ✓
Nature of request: <u>PLEASE AMEND ALL SHAPES ON BVS</u> <u>LATHE, TO SUIT THE GLEBA HANDLES &amp; HANDWHEELS.</u>					
D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
	27.3.79.	RD.		27.3.79.	RD.
Mod. No.	Copies issued to:	D.O., W.O., Insp., Fitting. Stores.			No. of copies
2721/79.		<del>At the Fitting.</del> M/c. Shop.			5.

Fig. No.	Details of Modification.
BVS100/117	<u>SHIFTER GEAR SHAFT.</u> THIS REPLACES BVS100/117. MVS100/113 THIS COMPONENT IS NOW OBS.
BVS100/508	<u>SPACER.</u> THIS COMPONENT IS NOW OBSOLETE.
BVS100/706	<u>TAILSTOCK SCREW.</u> THIS COMPONENT REPLACES MVS100/706.
MVS100/701	<u>CLAMPING HANDLE.</u> THIS COMPONENT IS NOW OBSOLETE.
SP170	<u>HANDWHEEL</u> THIS COMPONENT IS NOW OBSOLETE.
SP176	<u>HANDWHEEL HANDLE.</u> THIS COMPONENT IS NOW OBSOLETE.
SP171A	<u>LOCKING STUD.</u> THIS COMPONENT REPLACES SP171.
Remarks.	THIS MODIFICATION TO START WHEN OLD STOCK OF HANDLES HAVE RUN OUT.
	Checked. RD.

NOTICE OF MODIFICATION TO MANUFACTURED PART. BVS LATHE.

Request for mod. by	Name.	Date.	Sign.	Pattern Mod. YES/NO	Parts List. Arzt.
	B. KELET.				

Nature of request: SEE SHEET (1).

D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
Mod. No.	Copies issued to:	D.O., W.O., Insp., Fitting. Stores. <del>W.O., Insp., Fitting.</del> M/c. Shop.			No. of copies
2721/79					5

g. No.	Details of Modification.
BVS110/307	HANDWHEEL PINION. THIS COMPONENT REPLACES ML110/307.
BVS110/326	SCREWCUTTING LEVER BOSS. THIS COMPONENT REPLACES ML110/326C.
BVS110/342	FEED BOSS THIS COMPONENT REPLACES MVS110/342.
BVS105/105	LOCATING PIN PLUNGER. THIS REPLACES MVS105/105.
BVS115/915	DOG GEAR CHANGE LEVER SHAFT. THIS COMPONENT REPLACES ML115/915.
BVS115/916	DOG GEAR CHANGE LEVER BUSH. THIS COMPONENT REPLACES ML115/916.
BVS115/952	SELECTOR DIAL SHAFT. THIS COMPONENT REPLACES MVS115/952.
BVS115/993	GEAR CHANGE LEVER PLUNGER. THIS COMPONENT REPLACES ML115/993.
Remarks.	Checked. RJD

## NOTICE OF MODIFICATION TO MANUFACTURED PART. BVS LATHE.

Request for mod. by	Name. B. KELLET.	Date.	Sign.	Pattern Mod. YES/NO	Parts List. Arrt.
Nature of request: SEE SHEET (1)					
D.O. Job issued.	Date.	Sign.	Job completed.	Date.	Sign.
Mod. No. 2721/79.	Copies issued to:	D.O., W.O., Insp., Fitting. Stores. <del>Pattern Fitting.</del> M/c. Shop.			No. of copies 5.

g. No.	Details of Modification.
	THESE COMPONENTS LISTED BELOW ARE NOW OBSOLETE :- MVS 115/955, MVS 115/979 A, MVS 115/979 B, MVS 115/1002, CH 223 A, CH 223 B & CH 223/C.
SP180	STUD. THIS COMPONENT REPLACES SP182.
<del>BVS</del> 115/982	SLIDING BEAR TRIP LEVER. THIS COMPONENT REPLACES MVS 115/982.
BVS 114/5A	LOCATING PIN PLUNGER. RENUMBERED BVS 114/5A WAS BVS 114/5. 5/16" WHIT. NOW READS M18.
BVS 115/913	DOG BEAR TRIP LEVER. THIS REPLACES MVS 115/913.
BVS 100/226	COOLANT PIPE BRACKET. THIS REPLACES MVS 100/226.
Remarks.	Checked. R.D.

## DENFORD MACHINE TOOLS.

## NOTICE OF MODIFICATION TO MANUFACTURED PART.

MVS:100/701

Request for mod.by	Name. G.H.DENFORD	Date. 8.10.80.	Sign.	Pattern Mod. YES/NO	Parts List. Arret.
Nature of request: TO GIVE CLEARANCE IN TAILSTOCK BODY FOR TOP & SWIVEL SLIDE.					
D.O. Job issued.	Date. 9.10.80.	Sign. W.	Job completed.	Date. 9.10.80	Sign. W.
Mod. No. 2811/80	Copies issued to:-	D.O., W.O., Insp., Fitting. <del>Stores.</del> <del>Small Fitting.</del> M/c. Shop. Pat Miller			No. of copies 4

Drg. No.	Details of Modification.
MVS 100/701	<p>METAL LATHE - TAILSTOCK BODY</p> <p>FROM THE OPERATORS SIDE OF THE TAILSTOCK A STEP 6MM AND THEN A RISE AT 30° IS NOW TO BE, A STEP OF 15MM AND A RISE AT 20°.</p> <p>THE CORE HAS BEEN AMENDED TO MAINTAIN A 10MM WALL</p>
Remarks.	Checked. J. Vickery