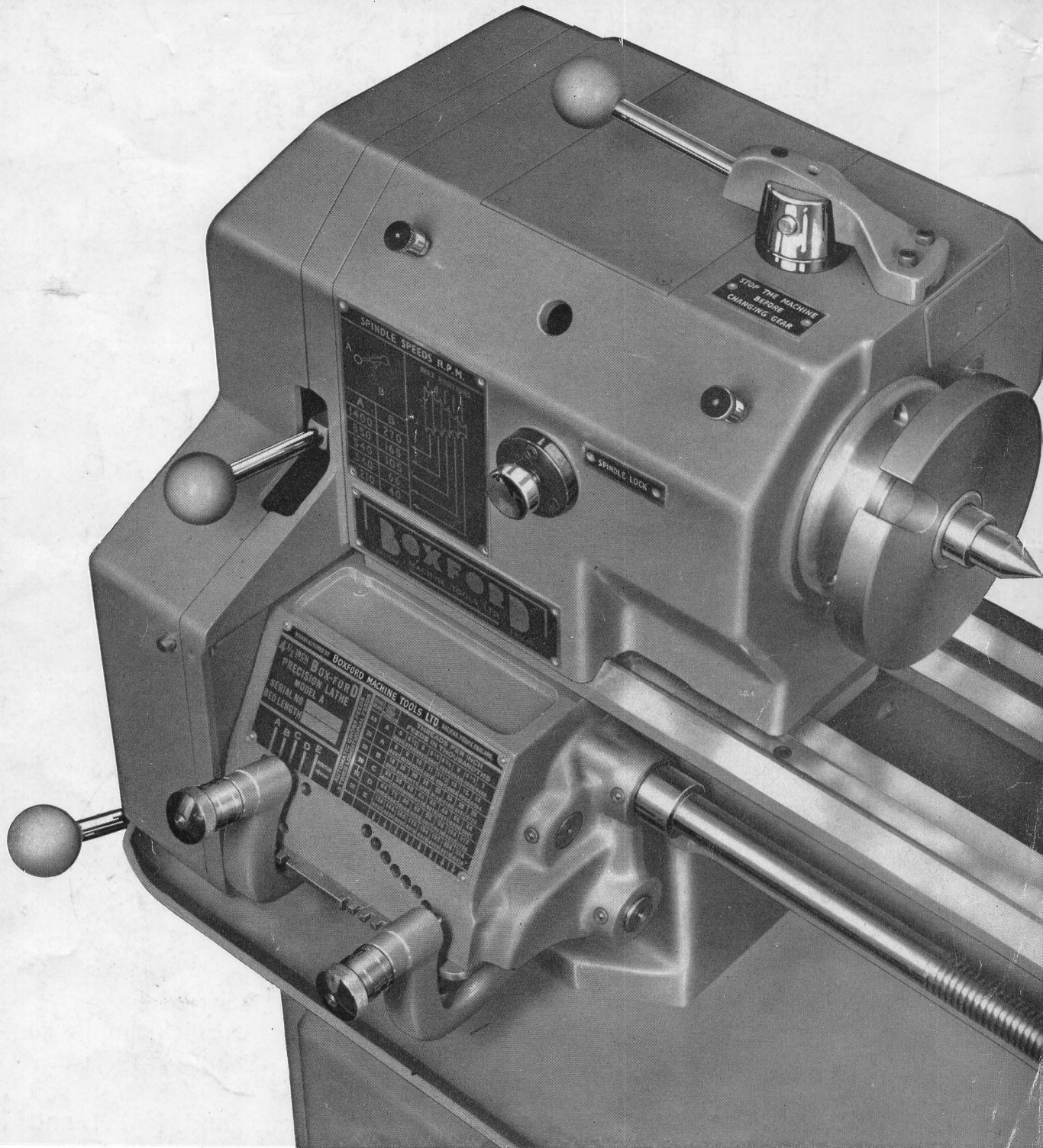


BOXFORD

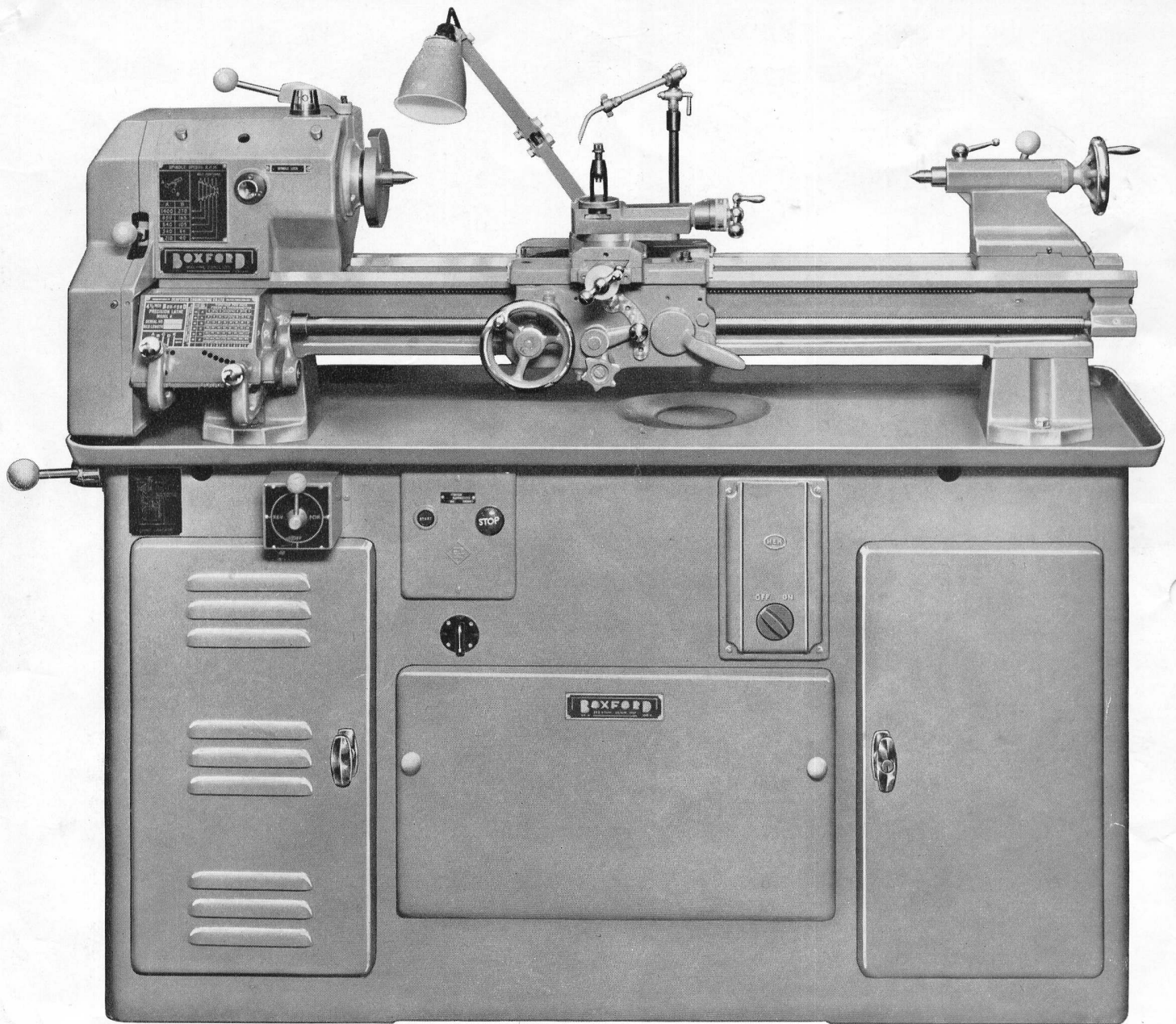
MARK II



**9" SWING (4 $\frac{1}{2}$ " CENTRES)
PRECISION UNDERNEATH DRIVE LATHE**

BOXFORD

MARK II



MODEL AUD
MARK II

as illustrated above with Norton type quick change gearbox and fully automatic apron.

MODEL BUD
MARK II

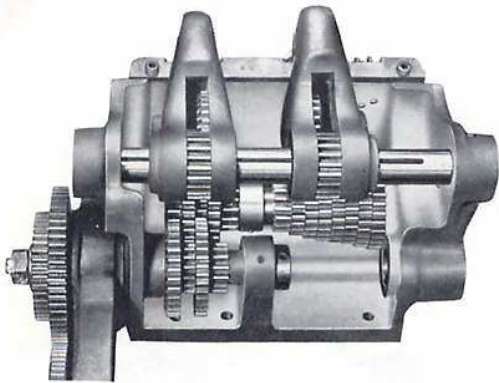
with change wheels for threads and feeds, and fully automatic apron.

MODEL CUD
MARK II

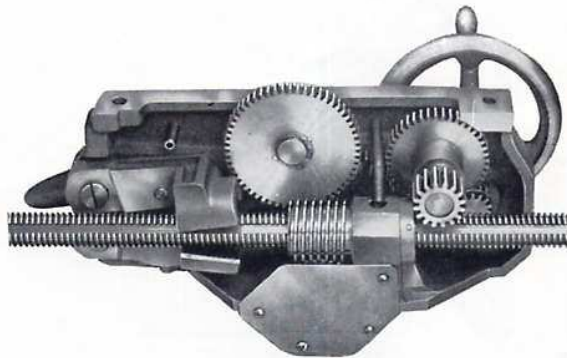
with change wheels for threads and feeds. Plain apron with longitudinal power feed only. Cross feeds hand operated.

BOXFORD

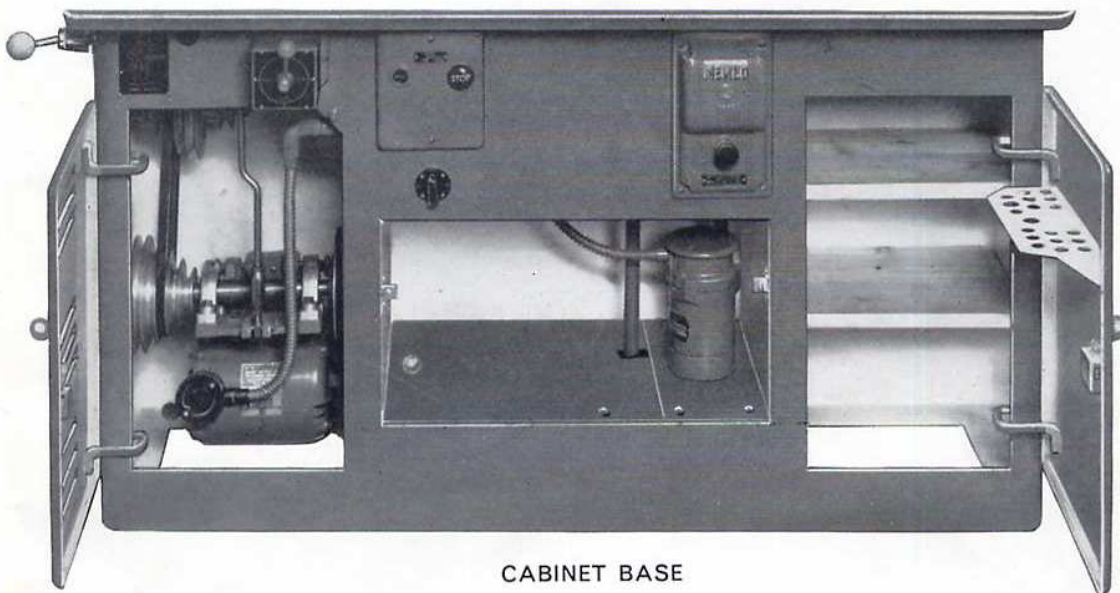
MARK II



NORTON TYPE GEARBOX



AUTOMATIC APRON



CABINET BASE

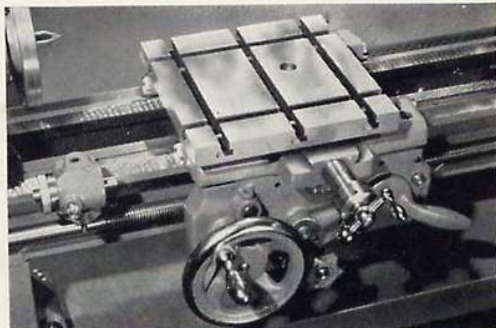


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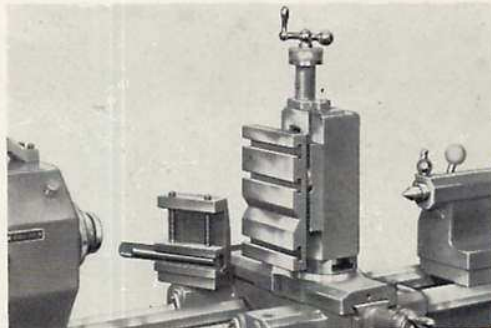
NS AND WEIGHTS

Range of threads						
MODEL 'AUD' (Norton Gearbox)	4 — 224 t.p.i.	
MODELS 'BUD' & 'CUD'	4 — 160 t.p.i.	
Range of longitudinal feeds						
MODEL 'AUD' (48)0015" — .0853"	0,038 — 2,17 mm.
MODEL 'BUD' (26)0021" — .0155"	0,053 — 0,394 mm.
MODEL 'CUD' (10)0063" — .0156"	0,160 — 0,397 mm.
Range of cross feeds						
MODEL 'AUD' (48)0004" — .0252"	0,010 — 0,640 mm.
MODEL 'BUD' (23)001" — .0046"	0,025 — 0,117 mm.
MODEL 'CUD'	Hand operated	
Motor horsepower		0,75
Weight of 'AUD' (22" between centres)	610 lbs.	276 kgs.
Shipping case dimensions	59" × 28" × 53"	150 × 71 × 135 cm.
Weight packed for shipment	830 lbs.	376 kgs.

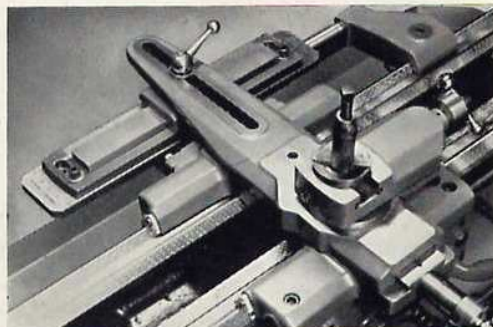
ATTACHMENTS



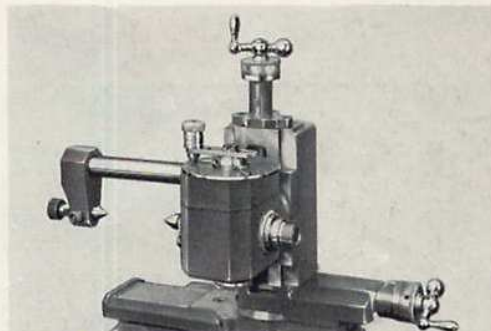
1. **BORING TABLE.** Removal of the cross-slide permits easy mounting of this boring table on to which a variety of work can be clamped.



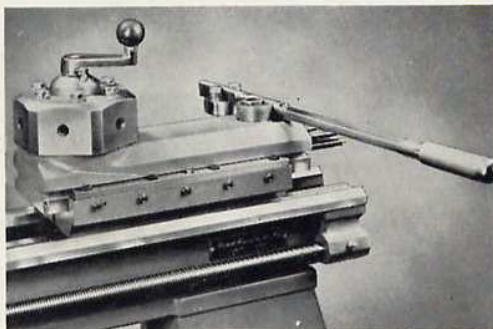
2. **COMPOUND MILLING ATTACHMENT.** Mounted on the cross-slide has both vertical and horizontal movement and can be fitted with a 'T' slotted table (as illustrated) or with a vice as shown on left.



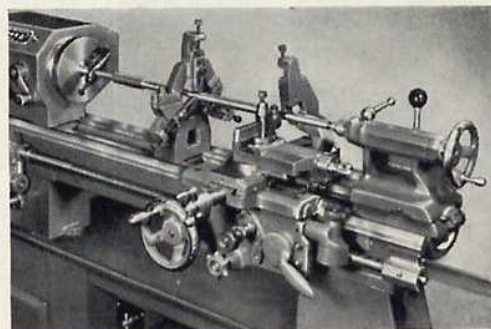
3. **TAPER TURNING ATTACHMENT.** This is fixed by a bracket to the rear vee of the lathe bed and provides quick adjustment for tapers up to 20° inclusive.



4. **DIVIDING HEAD MILLING ATTACHMENT.** Spur gearcutting, angular milling, spline milling, keyseating, graduating and all other regular dividing head milling can be performed on this attachment which mounts on the top-slide.



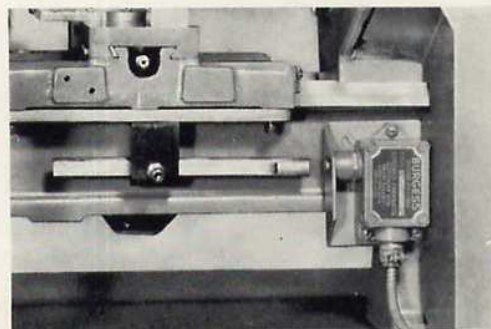
5. **TURRET HEAD.** Mounted firmly on to the lathe bed the 6-station automatic indexing turret head provides for rapid machining to production requirements.



6. **FIXED AND TRAVELLING STEADIES.** The fixed steady is mounted on and clamped to the bed, the travelling steady is mounted on the side of the saddle by means of the two screws provided.



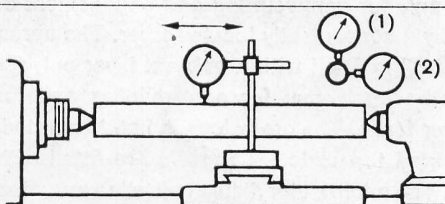
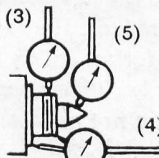
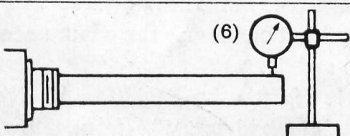
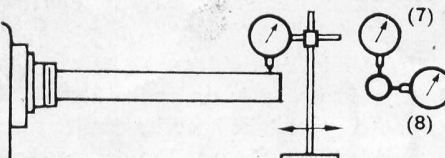
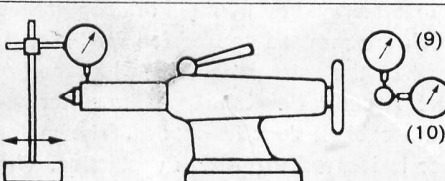
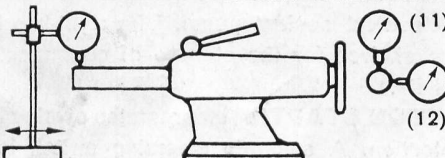
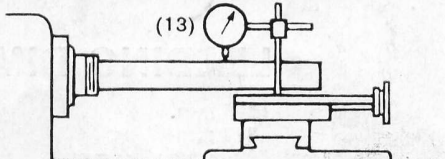
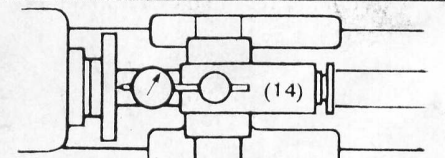
7. **COLLET ATTACHMENT.** Square, round or hexagon collets can be supplied with this draw-in type collet attachment.



8. **SADDLE LIMIT SWITCH.** Fitted to the rear of the lathe bed this electrical limit switch is actuated by an adjustable bar stop mounted on the saddle. It prevents the saddle being traversed too close to the headstock and avoids damage to chucks and tooling.

TYPICAL INSPECTION CERTIFICATE

MODEL AUD MARK II

	TEST DIAGRAM	TEST TO BE APPLIED MODEL "AUD"	GAUGES, METHODS AND TOLERANCES	INSPECTOR'S REPORT
HEADSTOCK and BED		(1) AXIS OF CENTRES PARALLEL WITH BED II, VERTICAL PLANE	15" STATIONARY MANDREL 0 TO +.002" AT TAILSTOCK	.001"
		(2) DITTO HORIZONTAL PLANE	DITTO 0 TO +.001" AT TAILSTOCK. IN DIRECTION OF TOOL PRESSURE	.0005"
		(3) EXTERNAL DIA. TRUE	MAXIMUM ECCENTRIC ERROR .0004"	.0002"
		(4) AXIAL SLIP OR FLOAT	TEST TWO POINTS AT 180° MAXIMUM FLOAT .0004"	.0002"
		(5) CENTRE POINT TRUE	MAXIMUM ECCENTRIC ERROR .0004"	.0002"
		(6) BORE TRUE AND SIZE TO GAUGE (INTERNAL TAPER)	MANDREL 12" LONG. ONE END A GAUGE FOR SPINDLE MAXIMUM ECCENTRIC ERROR .0012"	.0006"
		(7) AXIS PARALLEL WITH BED IN VERTICAL PLANE	STATIONARY MANDREL (*SEE NOTE) 0 TO +.001" PER FT. AT FREE END OF MANDREL	.0005"
		(8) DITTO HORIZONTAL PLANE	FREE END OF MANDREL INCLINED TOWARDS TOOL PRESSURE 0 TO .001" PER FT.	.0003"
TAILSTOCK		(9) SPINDLE MOVEMENT PARALLEL WITH BED IN VERTICAL PLANE	TEST OVER CLAMPED SPINDLE CENTRE MUST RISE 0 TO .0015" IN MOVEMENT	.0002"
		(10) DITTO HORIZONTAL PLANE	TEST SIDE OF CLAMPED SPINDLE INCLINATION TOWARDS TOOL PRESSURE 0 TO .001" IN MOVEMENT	.0001"
		(11) TAPER BORE OF SPINDLE PARALLEL WITH BED IN VERTICAL PLANE	STATIONARY MANDREL 0 TO +.0015" PER FT. AT FREE END OF MANDREL	.0006"
		(12) DITTO HORIZONTAL PLANE	FREE END OF MANDREL INCLINED TOWARDS TOOL PRESSURE 0 TO .001" PER FT.	.0003"
SLIDES		(13) MOVEMENT OF TOOL SLIDE PARALLEL WITH SPINDLE IN VERTICAL PLANE	CLOCK IN TOOLPOST. TEST OVER STATIONARY MANDREL .002" IN ITS MOVEMENT	.001"
		(14) MOVEMENT OF CROSS SLIDE AT 90°	CLOCK IN TOOLPOST. TEST ACROSS BUTTON ON FACE PLATE 0 TO .0015" PER FT. DIA. CONCAVE ONLY	.0005"

*NOTE—WHEN USING STATIONARY MANDRELS, ANY ECCENTRICITY SHOULD BE SET AT 90° TO THE LINE OF TEST
The makers reserve the right to alter design, specification and prices without notice

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