Manufacture:GILDEMEISTER Mach type:LATHE
Model No:NEF 660 ID No:JHB9704M003
Serial No:1248-07427 Drawing No:1248-07427-A Sheet No:7 OF 7
Revised by DSCR-M MECHANICSBURG,Pa.
JR 070MA0-2 8/97

PARTS LIST

SYM.	AMT	DESCRIPTION	PART NO.	MAKE
CB1	1	MOTOR CIRCUIT PROTECTOR 30 A.	C370HMCP1	C.H.
X,Z L.S.'S	4	LIMIT SWITCH PRECISION	E50KL535	C.H.
T1	1	TRANSFORMER CONTROL 750 VA	TA-2-81216	ACME
T2	1	TRANSFORMER CONTROL 100 VA	TA-83220	ACME
3T	1	3 PH. GEN. PURPOSE TRANS. 9.0 KVA	76-02095H	DONGAN
MAIN DISCO.	1	DISCONNECT 100 AMP 600 VOLT	1494V-DS100	A.B.
TAILSTOCK L.S.	1	LIMIT SWITCH MINATURE	MS09S05-02	TELE.
X,Z HOME L.S.'S	4	SPECIAL PURPOSE LIMIT SWITCH	E50TD1	C.H.
M2,M3	2	INTERGAL PROTECTED STARTER	LD1LB030FC	TELE.
M1	1	REV. INTERGAL STARTER	LD5LD030FC	TELE.
M1 O.L.	1	OVERLOAD MODULE	LB1LD03M55	TELE.
M2 O.L.	1	OVERLOAD MODULE	LB1LB03P02	TELE.
M3 O.L.	1	OVERLOAD MODULE	LB1LB03P03	TELE.
	3	SINGLE PHASE R-C NETWORK	RCS1A6V	R&K ELECT.
	3	3 PHASE R-C NETWORK	RCY6A-30V	R&K ELECT.
X,Z SRVO DRIVE	2	DIGITAL AMPLIFIER	DDS2.1-W050-DA01	INDRAMAT
SERVO PWR SUP.	1	POWER SUPPLY	TVM 2.4-050	INDRAMAT
	2	10 PIN PHOENIX CONNECTORS	NPN	
	1	TVMELEC. CONNECTION ACCESSORIES	NPN	INDRAMAT
MCR	1	MACHINE TOOL RELAY	MT4640MF	FURNAS
	1	24VDC POWER SUPPLY	B50050	MK
	1	CONTROL CABNET FRAME	X-FPCA1688	HOFFMAN
	1	FRAME SHELF	X-FSH88	HOFFMAN
	1	AIR CONDITIONER 240VAC	X-AC426T88	HOFFMAN
	1	BRACKET	X-ACBB	HOFFMAN
	3	SUBPANEL	X-PP88	HOFFMAN
	1	TOP DOOR WINDOW	X-DWT88PC	HOFFMAN
	1	GRID PLATE	X-GH6P8	HOFFMAN
	1	KEYBOARD COMPARTMENT	X-KBC8	HOFFMAN
	1	SOLID BOTTOM DOOR	X-DS88	HOFFMAN
	2	PUSHBUTTON HANDLE	X-FHKPB	HOFFMAN
	1	SOLID BASE	X-B088	HOFFMAN
	2	SOLID SIDE	X-SS168	HOFFMAN
	1	FRAME SHELF	X-FSH88	HOFFMAN
	1	DISCONNECT DOOR	X-DSC168	HOFFMAN
	6	FASTNER PACKAGE	X-GFM6	HOFFMAN
9/230	1	PROCESSOR 9/SER.-32 BIT	8520-SP1	A.B.
X,Z TERMINATION PANELS	2	ENCODER TERMINATION PANELS	1771-HTE	A.B.
	2	CONNECTOR VIDEO	8520-D15M	A.B.
	2	CABLE FOR TERMINATION PANEL	8500-TPC	A.B.
	1	FIRMWARE EXECUTIVE	8520-EXEC1	A.B.
	1	FIRMWARE/CMOS OPTION PLUG	8520-S	A.B.

	1	OPTION GROUP 1-2-3-4	8520-1-2-3-4	A.B.
	1	BATTERY LITHIUM	8520-LIBAT	A.B.
PENDANT	1	MONO OPERATOR PANEL ASSEMBLY PUSHBUTTON STYLE 115/230 VAC	8520-MPA2	A.B.
	1	CONNECTOR VIDEO	8520-D15F	A.B.
	1	CONNECTOR MTB PANEL	8520-D25FS	A.B.
	1	CONNECTOR RS-232	8520-D25M	A.B.
	1	MANUAL AMP REF	8520-ARM2	A.B.
	1	MANUAL PAL REF	8520-PRM2	A.B.
	1	MANUAL LATHE USER	8520-LUM	A.B.
	1	MINI-DNC	8520-MDNC	A.B.
HPG	1	HAND PULSE GENERATOR	8500-HPG2	A.B.
HIGH DENSITY I/O BOARD	1	HIGH DENSITY I/O	8500-HDM1	A.B.
	1	CONNECTOR INPUT CONNECTIONS	8520-D37F	A.B.
	1	CONNECTOR OUTPUT CONNECTIONS	8520-D37M	A.B.
	1	CABLE FIBER OPTIC	8500-FOC5	A.B.
	2	PENDANT BASE	C-CS6BB	HOFFMAN
	1	SQUARE PENDANT	C-CS6T20	HOFFMAN
	1	JOINT SETUP	CCS6SJ	HOFFMAN
	1	PENDANT ROTATION	C-CS56RL	HOFFMAN
	1	ELBOW	CCS6EL	HOFFMAN
	1	FLANGE COUPLING	CCS6FC	HOFFMAN
	1	HANDLE PACKAGE	CCCHS	HOFFMAN

COSA CORPORATION

17 PHILIPS PARKWAY/ MONTVALE, NEW JERSEY 07645/(201) 391-0700
TELEX NUMBER: 134396 CABLE ADDRESS: COSACO MONTVALE

NID 031359
NID 031360

February 1, 1983

Trident Refit Facility
Code 210
Bremerton, WA 98315

ATT: Mr. Lloyd Harris

Dear Lloyd:

As per our phone conversation of today's date, enclosed please find a set of mechanical drawings for the N.E.F. 480.

I trust this will be of help to you. If you require any additional information, please feel free to call.

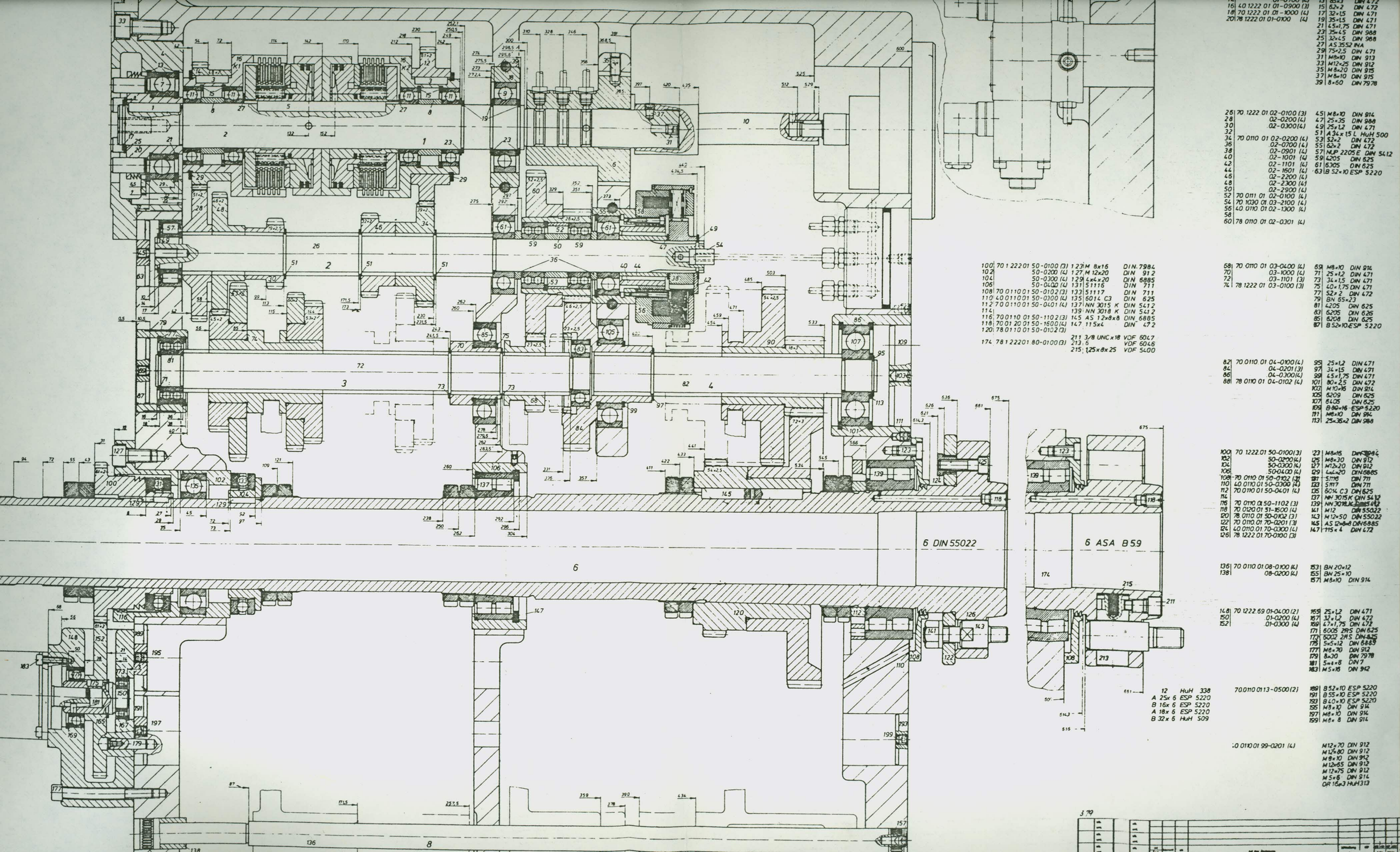
Sincerely,

COSA CORPORATION

Beat Ott
Service Manager

BO:as

Enclosure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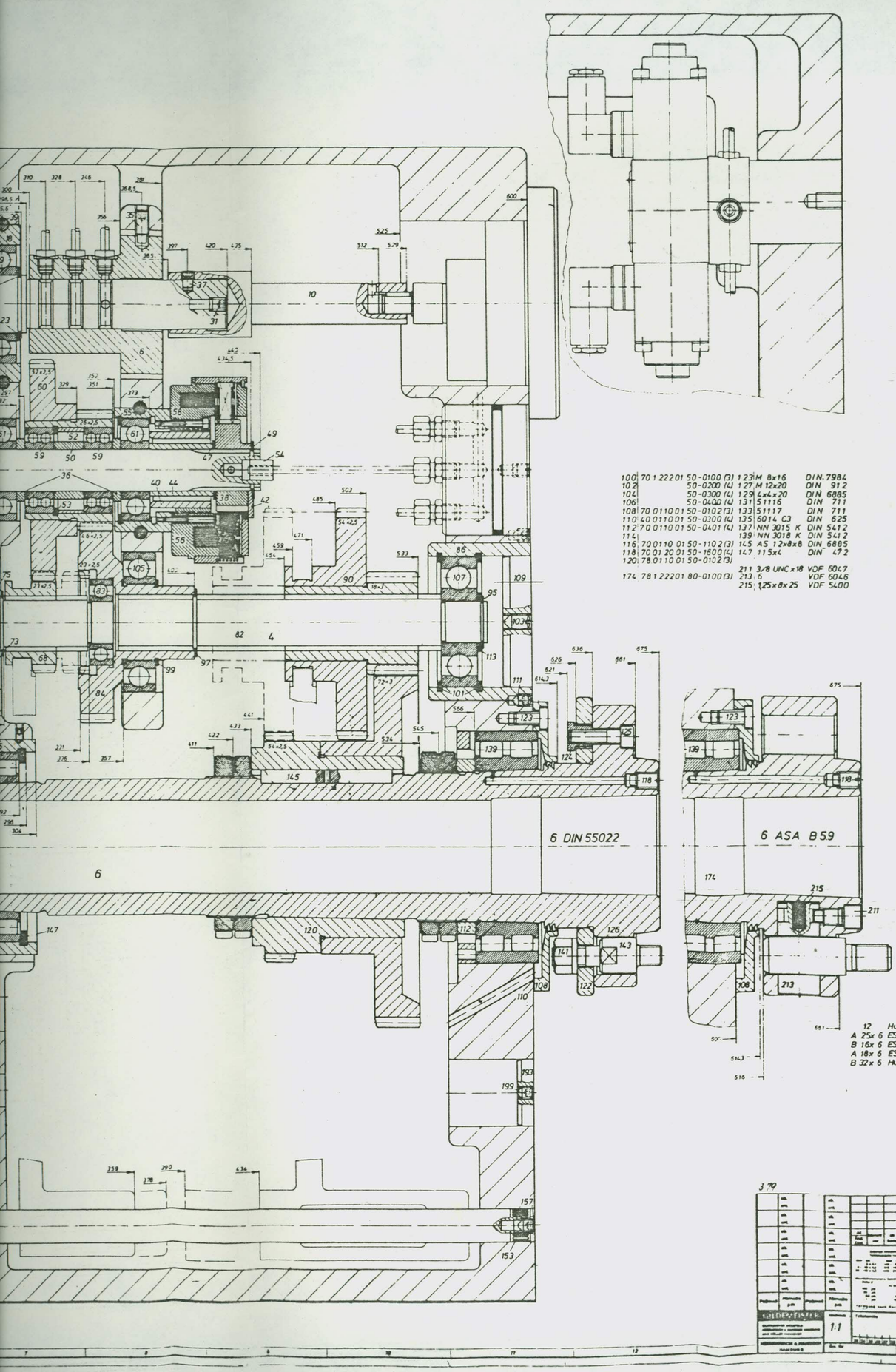
6 ASA B59



2	70 1222 01 01-0100 (2)	1	8x7x40	DI
4	01-0200 (2)	3	6x6x25	DI
6	01-0300 (4)	5	10x8x100	D
8	01-0400 (4)	7	6209 Z	D
10	01-0500 (4)	9	6207	D
12	01-0600 (4)	11	6007	D
14	01-0700 (4)	13	85x3	D
16	40 1222 01 01-0900 (3)	15	62x2	D
18	70 1222 01 01-1000 (4)	17	32x1,5	D
20	78 1222 01 01-0100 (4)	19	35x1,5	D
		21	45x1,75	D
		23	35x4,5	D
		25	32x4,5	D
		27	AS 3552	N
		29	75x2,5	D
		31	M8x10	D
		33	M12x25	D
		35	M8x20	D
		37	M8x10	D
		39	8x60	D

25	70 1222 01 02-0100 (3)	45	M8x10	D
28	02-0200 (4)	47	25x35	D
30	02-0300 (4)	49	25x1,2	D
32		51	A 34x15	L
34	70 0110 01 02-0200 (4)	53	52x2	D
36	02-0700 (4)	55	62x2	D
38	02-0901 (4)	57	MLF 2205	
40	02-1001 (4)	59	4205	D
42	02-1101 (4)	61	6305	D
44	02-1601 (4)	63	B 52x10	ES
46	02-2200 (4)			
48	02-2300 (4)			
50	02-2900 (4)			
52	70 0111 01 02-0100 (4)			
54	70 1030 01 03-2100 (4)			
56	40 0110 01 02-1300 (4)			
58				
60	78 0110 01 02-0301 (4)			

100	70 1 222 01 50-0100 (3)	123	M 8x16	DIN 7984
102	50-0200 (4)	127	M 12x20	DIN 912
104	50-0300 (4)	129	6x4x20	DIN 6885
106	50-0400 (4)	131	51116	DIN 711
108	70 0110 01 50-0102 (3)	133	51117	DIN 711
110	40 0110 01 50-0300 (4)	135	6014 C3	DIN 625
112	70 0110 01 50-0401 (4)	137	NN 3015 K	DIN 5412
114		139	NN 3018 K	DIN 5412
116	70 0110 01 50-1102 (3)	145	AS 12x8x8	DIN 6885
118	70 01 20 01 50-1600 (4)	147	115x4	DIN 472
120	78 0110 01 50-0102 (3)			
		211	3/8 UNC x 18	VDF 6047
174	78 1 22201 80-0100 (3)	213	6	VDF 6046
		215	125x8x25	VDF 5400

68	70 0110 01 03-0400 (4)	69	M8x10	D
70	03-1000 (4)	71	25x12	D
72	03-1101 (3)	73	34x1,5	D
74	78 1222 01 03-0100 (3)	75	40x1,75	D
		77	52x2	D
		79	BN 65x2	
		81	4205	D
		83	6205	D
		85	6208	D
		87	B 52x10	ES

82	70 0110 01 04-0100 (4)	95	25x1,2	
84	04-0201 (3)	97	34x1,5	
86	04-0300 (4)	99	45x1,75	
88	78 0110 01 04-0102 (4)	101	80x2,5	
		103	M 10x16	
		105	6209	
		107	6405	
		109	B 80x16	
		111	M8x10	
		113	25x35x2	

100	70 1222.01 50-0100 (3)	123	M8x16	
102	50-0200 (4)	125	M8x30	
104	50-0300 (4)	127	M12x20	
106	50-0400 (4)	129	6x6x20	
108	70 0110 01 50-0102 (3)	131	51116	
110	40 0110 01 50-0300 (4)	133	51117	
112	70 0110 01 50-0401 (4)	135	6014 C3	
114		137	NN 3015 K	
116	70 0110 01 50-1102 (3)	139	NN 3018 K	
118	70 0120 01 51-1600 (4)	141	M12	
120	78 0110 01 50-0102 (3)	143	M12x50	
122	70 0110 01 70-0201 (3)	145	AS 12x8x8	
124	40 0110 01 70-0300 (4)	147	115x4	
126	78 1222 01 70-0100 (3)			

136	70 0110 01 08-0100 (4)	153	BN 20x12	
138	08-0200 (4)	155	BN 25x10	
		157	M8x10	

148	70 1222.69 01-0400 (2)	165	25x1,2	
150	01-0200 (4)	167	32x1,2	
152	01-0300 (4)	169	47x1,75	
		171	6005 2R	
		173	6002 2R	
		175	5x5x12	
		177	M8x70	
		179	8x20	
		181	5x4x8	
		183	M5x18	

	70.0110 01 13-0500 (2)	189	B 52x10	
		191	B 55x10	
		193	B 40x10	
		195	M8x10	
		197	M8x10	
		199	M8x8	

	:0 0110 01 99-0201 (4)		M12x70	
			M12x80	
			M8x10	
			M12x65	
			M12x75	
			M5x6	
			OR 16x3	

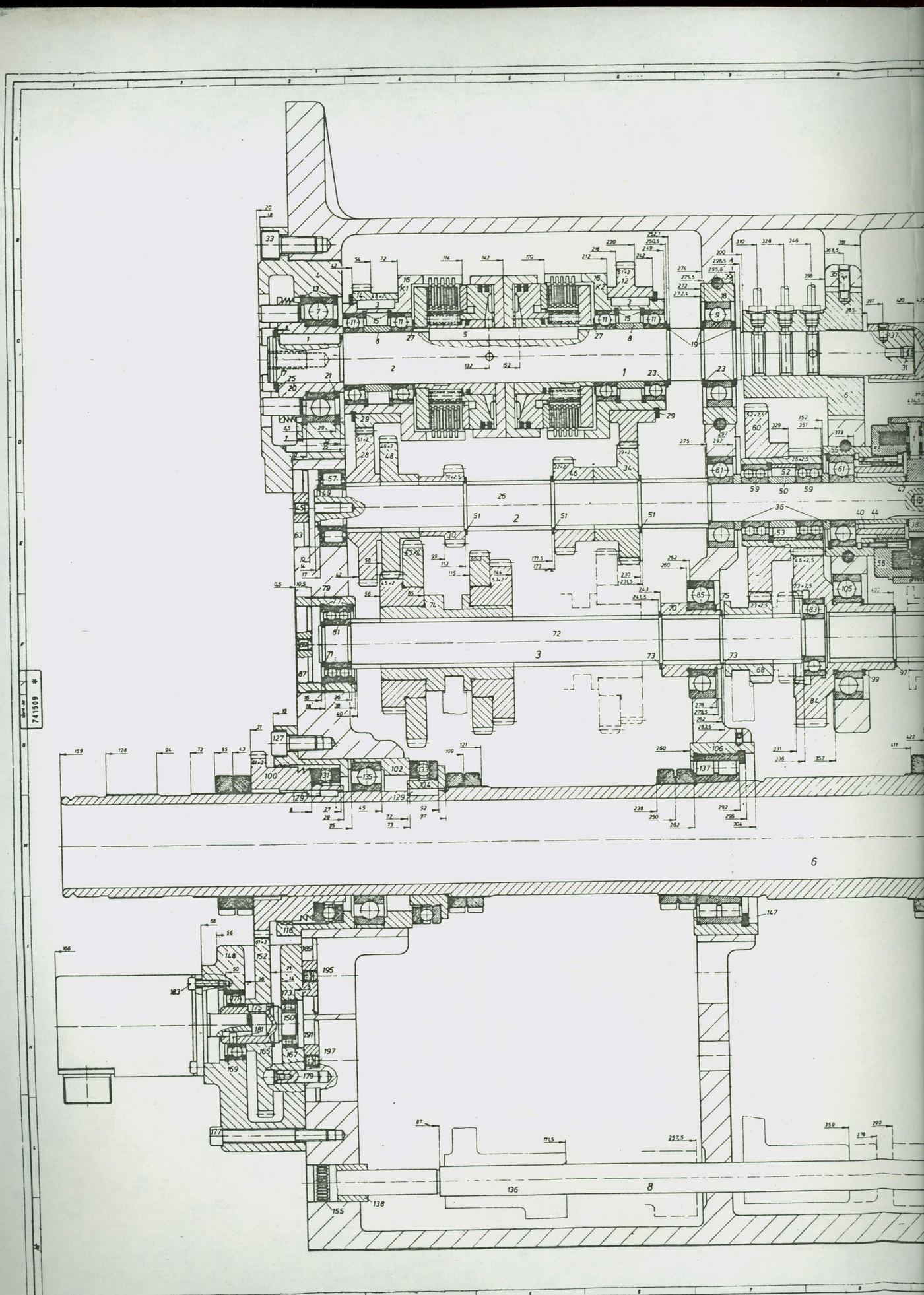
12 HuH 338
A 25x 6 ESP 5220
B 16x 6 ESP 5220
A 18x 6 ESP 5220
B 32x 6 HuH 509

3 79

GILDEMEISTER

1:1

79 1222 01.00-0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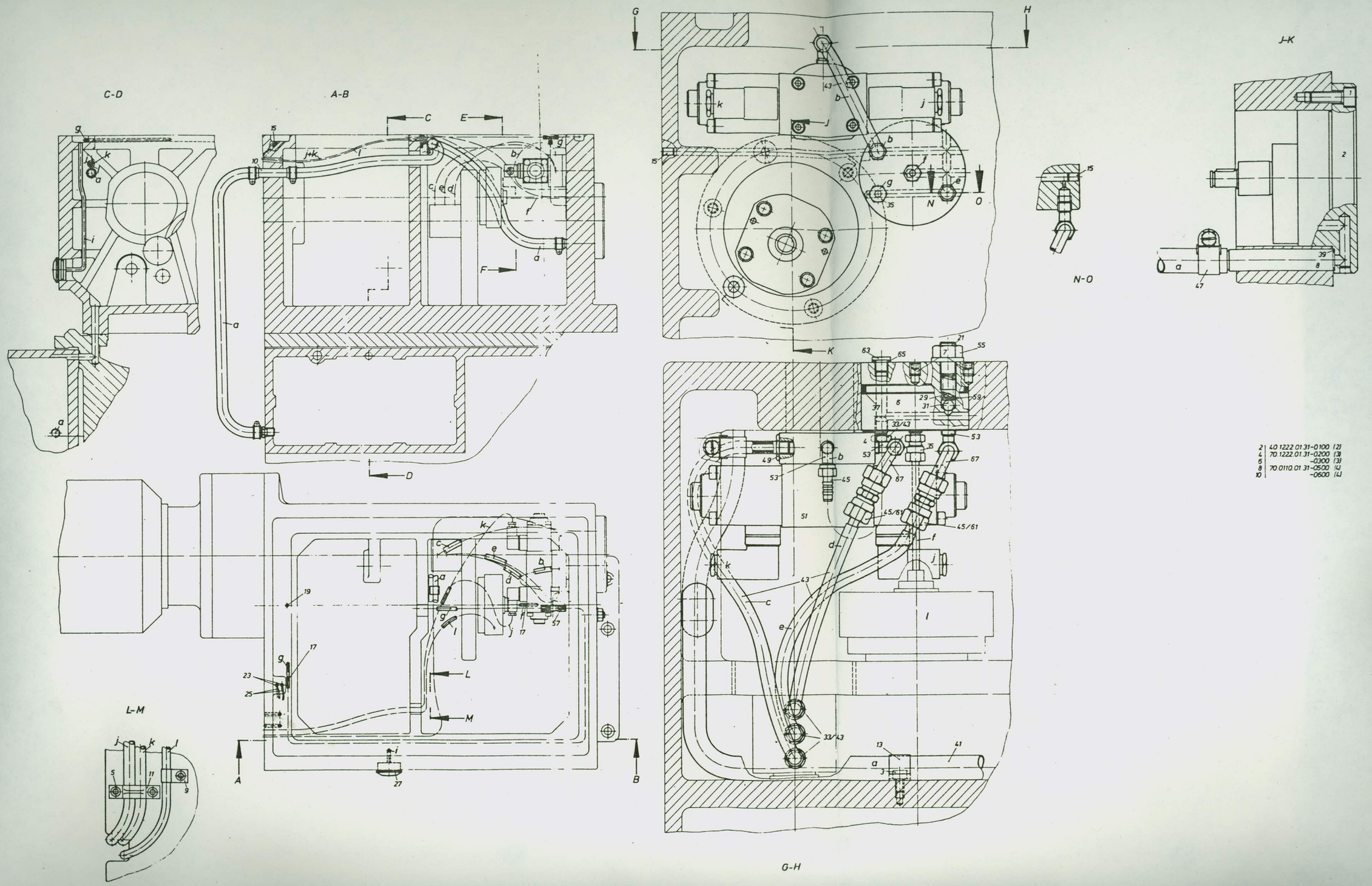
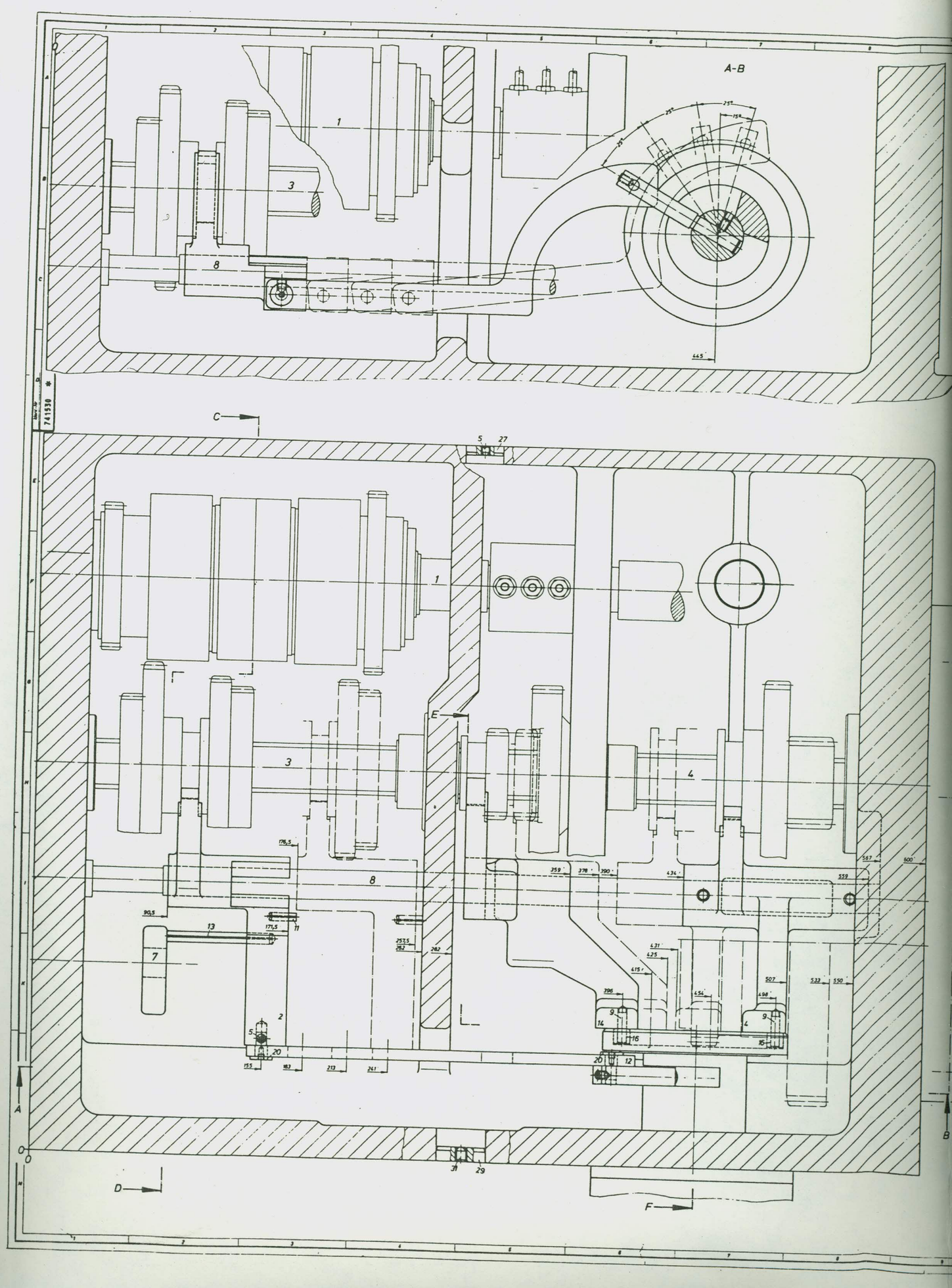


2	40 1222 01 31-0100	(2)	
4	70 1222 01 31-0200	(3)	
6	-0300	(3)	
8	70 0110 01 31-0500	(4)	
10	-0600	(4)	

1	M 8×25	DIN 912
3	M 6×10	DIN 912
5	M 4×6	DIN 912
7	M 8×10	DIN 913
9	1×6	DIN 7251
11	2×8	DIN 7251
13	1×18	DIN 7251
15	6	ESP 5222
17	S×0,75	VDF 572
19	6×1	VDF 572
21	12×25	DIN 913
23	4,5	HuH 5361
25	3×800	
27	40	VDF 574
29	1,25×8×32	VDF 540
31	6ø III	DIN 540
33	ALL 8	DIN 2353
35	ALL 5	DIN 2353
37	OR 71×4	HuH 3132
39	OR 10×3	HuH 3132
41	14,5×18,7×1000	
43	TR S×6 B	
45	BE 8-L-5	
47	S 18-12	HuH 5304
49	AG 10×1-6	
51	S6 VH 100	
53	FLL 8	DIN 2353
55	M 12	–
57	QLL 5	DIN 2353
59	A 5,3	DIN 125
61	ELL 8	DIN 2353
63	M 10×1	DIN 909
65	A 10×1,35	DIN 7603
67	8×1	VDF 572


A-B
C
E
D
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A
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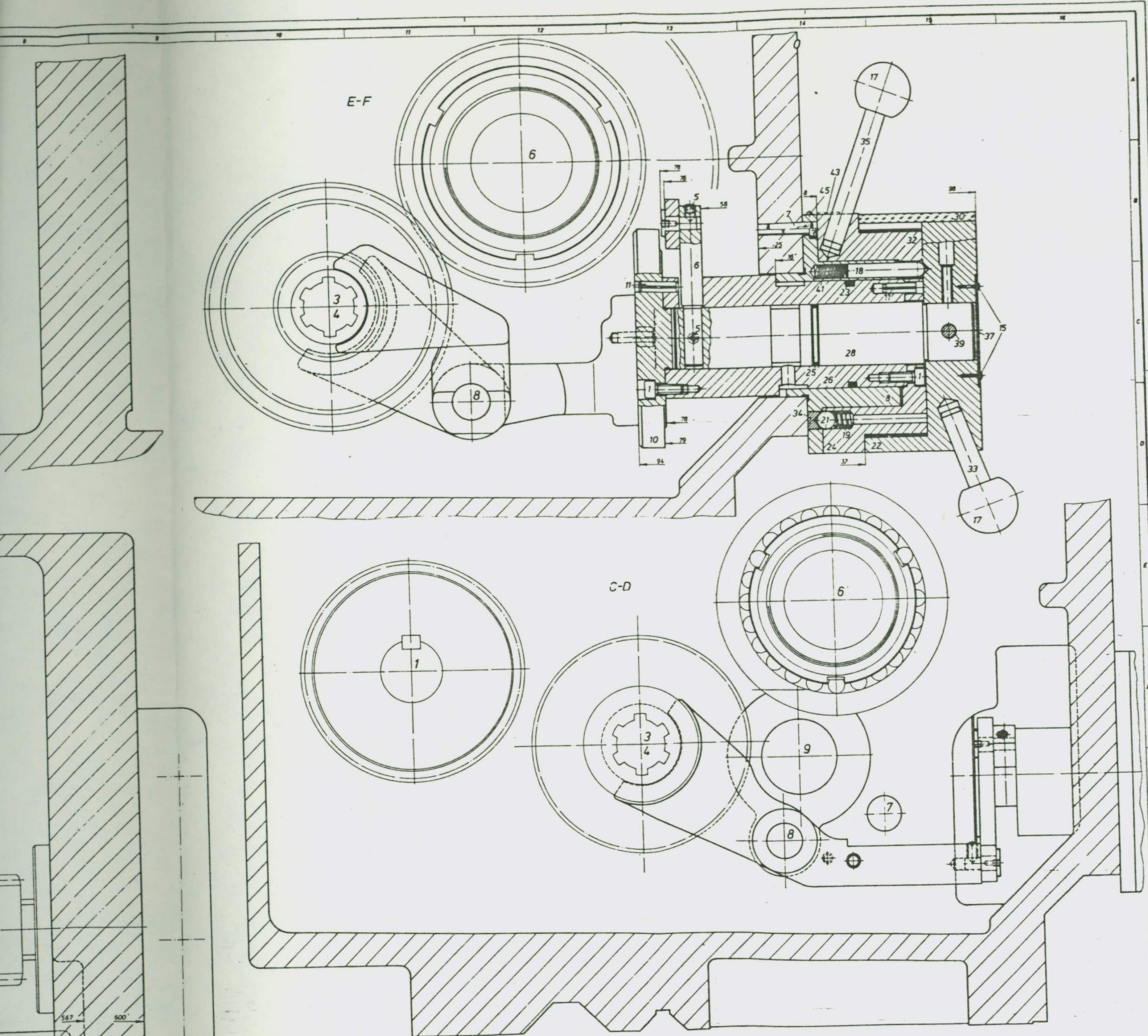
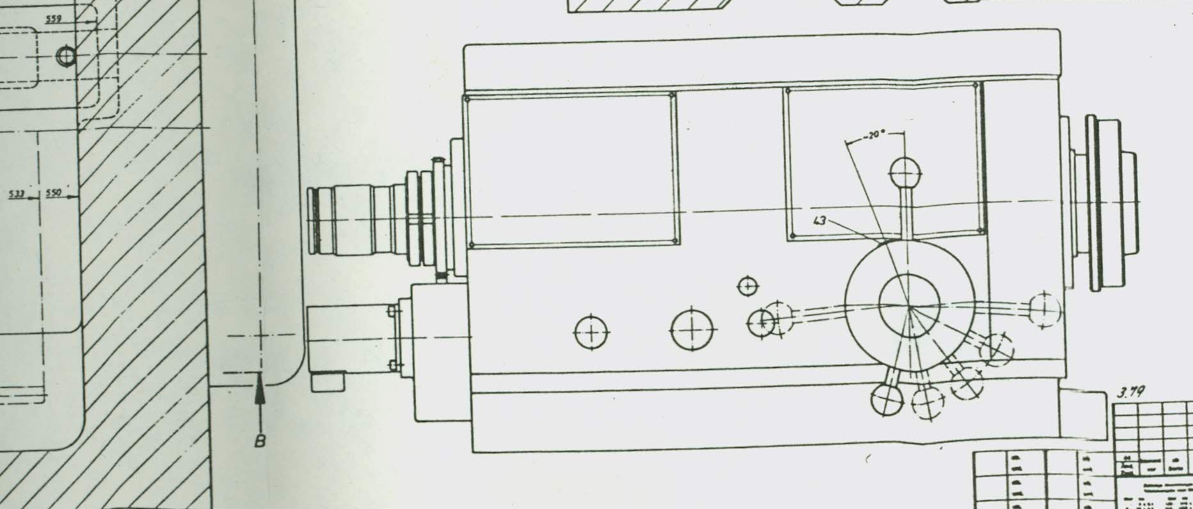
741530





2	70 0110 01 33-3900	(3)
4	-4000	(3)
6	-5300	(4)
8	5400	(3)
10	-5600	(2)
12	-5800	(3)
14	-5900	(3)
16	40 0110 01 33-3000	(4)
18	-7300	(4)
20	70 0110 04 08-0700	(4)
22	70 1222 01 33-0100	(2)
24	-0200	(3)
26	-0300	(3)
28	-0400	(4)
30	-0500	(4)
32	-0600	(2)
34	70 0120 01 21-0100	(4)

1	M6×16	DIN 912
3	M6×16	DIN 7984
5	M6×8	DIN 914
7	6×24	DIN 7978
9	6×24	DIN 6325
11	6×20	DIN 1481
13	8×70	DIN 1481
15	2×6	DIN 1476
17	KN 32	DIN 319
19	1,6×8×14	VDF 5400
21	⌀10 III	DIN 5401
23	R54×3	HuH 313
25	OR 31×2	HuH 313
27	B25×6	ESP 5220
29	B32×10	ESP 5220
31	M8×10	DIN 914
33	12×63	VDF 5323
35	12×100	VDF 5323
37	F63	VDF 5438
39	8×60	DIN 7978
41	1,25×6,3×22	VDF 5400
43	0	HuH 413
45	2×6	DIN 1476

3.79

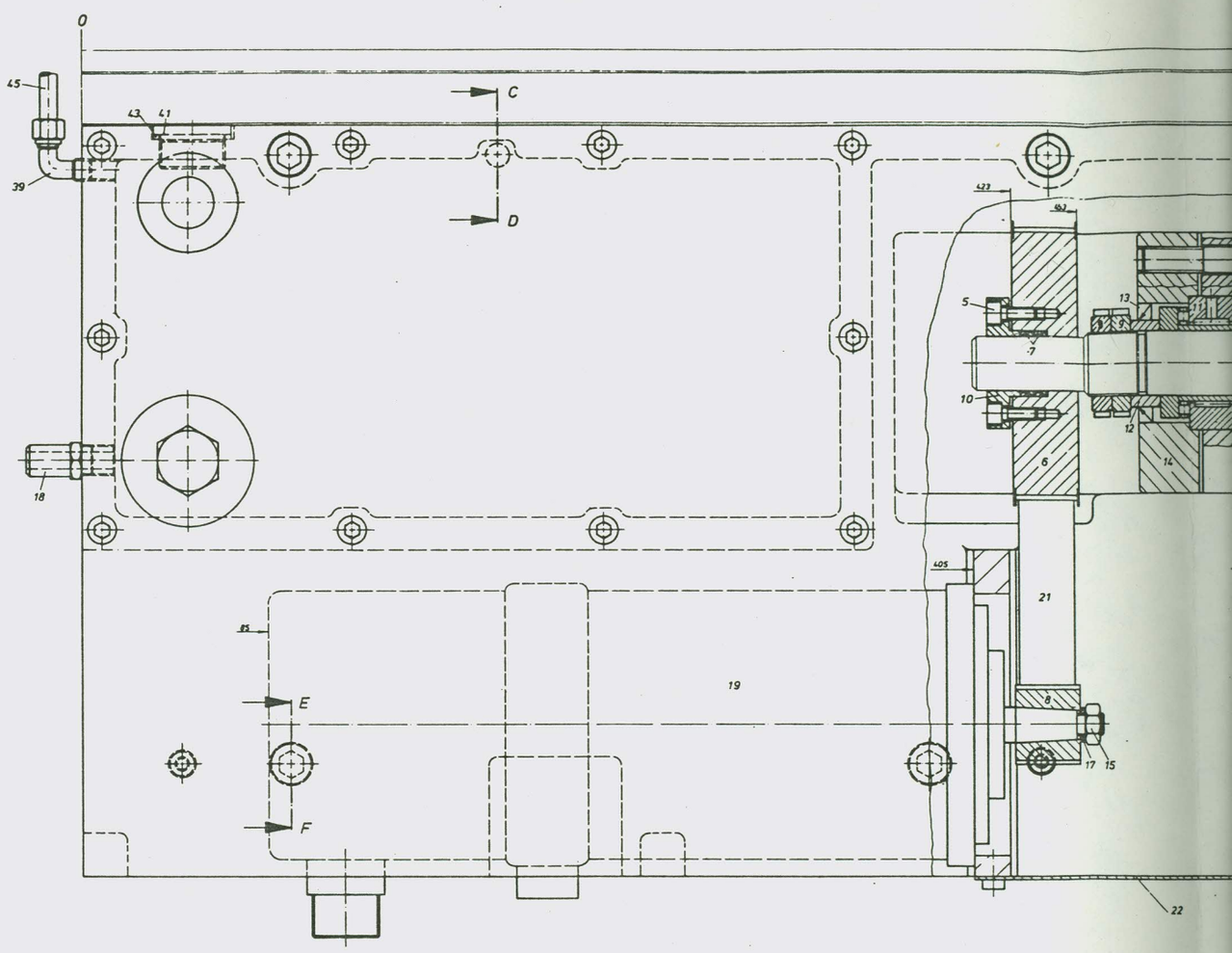
GILDEMEISTER

1:1
1:2,5

26.11.75

Serie 570

9.1222.01.33-0100



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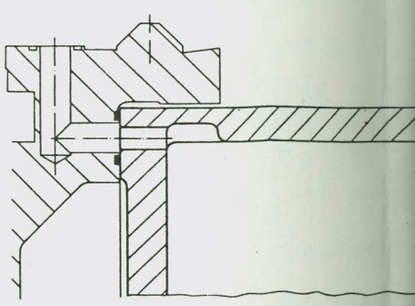

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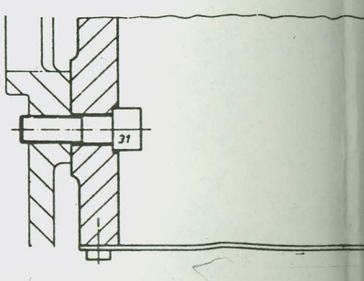
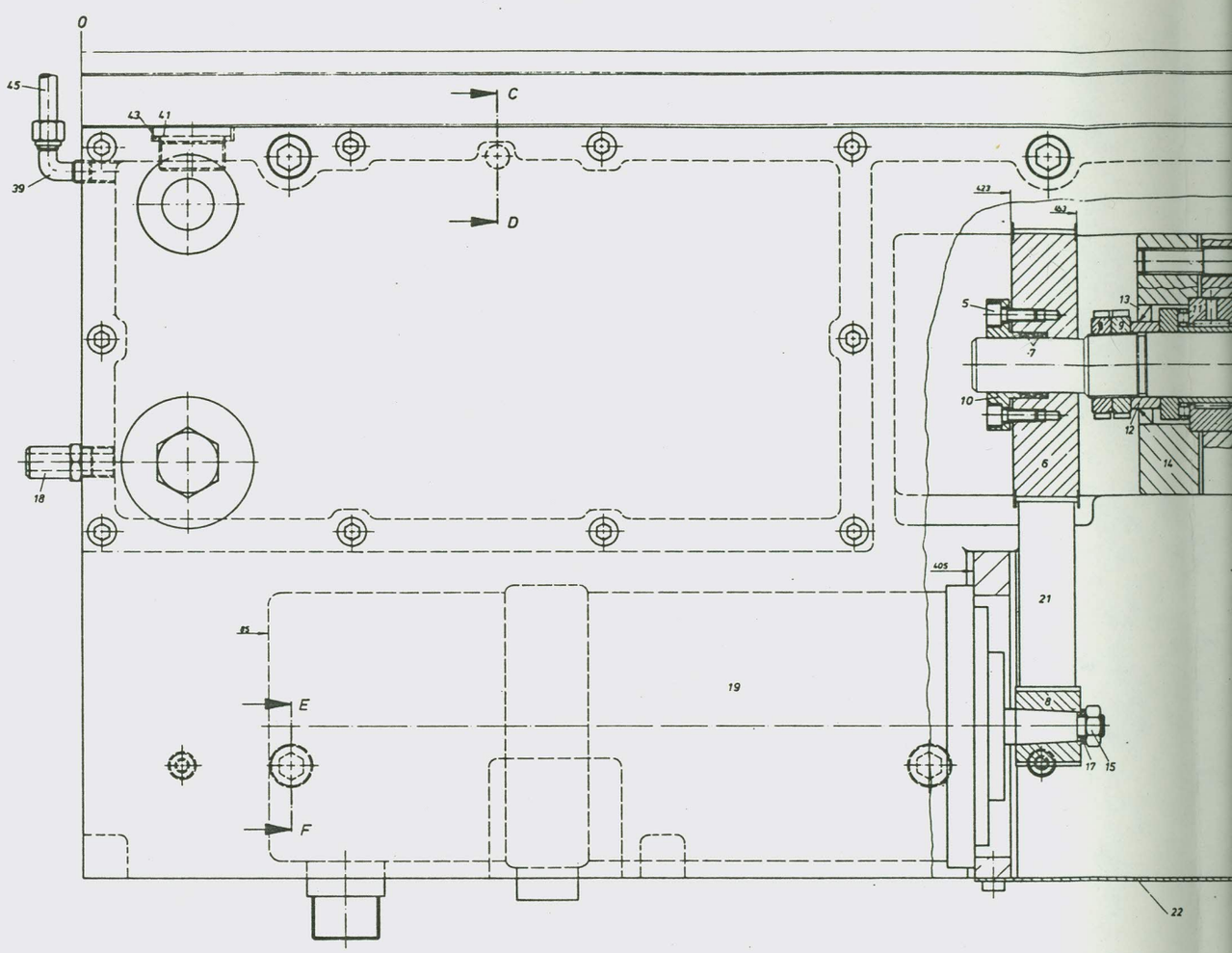


2	70.1222.02.01-0301 (0)
4	70.1222.02.01-0401 (1)
6	40.1222.02.01-0201 (3)
8	40.1222.02.01-0101 (4)
10	70.1212.02.01-0800 (4)
12	70.1222.02.01-0600 (4)
14	70.1222.02.01-0500 (3)
16	40.0110.03.01-1100 (4)
18	70.1222.02.01-0700 (4)
20	70.1212.02.01-1400 (4)
22	40.1222.02.01-0900 (4)

1	M8x25 DIN 912
3	M12x60 DIN 912
5	M6x16 DIN 912
7	25x30 RF.N 8006
9	M30x1,5 w DIN 1804
11	ZAHN 3062
13	B40x55x7 DIN 3760
15	M10 DIN 934
17	10 DIN 7980
19	DC Modell 5
21	T101&10 25 Bz
23	40 VDF 5741
25	M8x40 DIN 912
27	M8 DIN 934

31	M12x40 DIN 912
33	M12x200 DIN 912
35	10x40 DIN 7978
37	

39	FLL 8 DIN 2353
41	M30x1,5 DIN 908
43	30x36 Cu DIN 7603
45	8x1 VDF 5720
47	M6x10 DIN 7984
49	A 52x60 Cu DIN 7603



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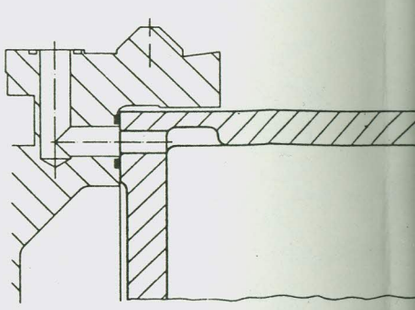

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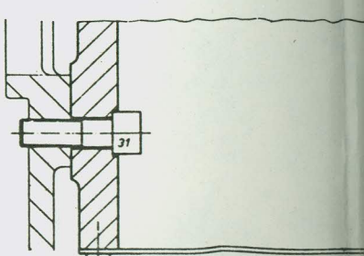
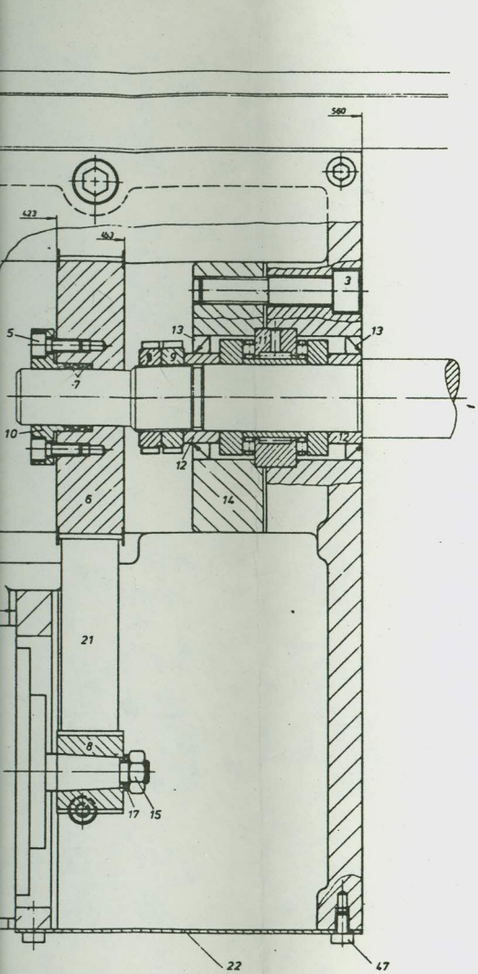


2	70.1222.02.01-0301 (0)	1	M8x25 DIN 912	39	FLL 8 DIN 2353
4	70.1222.02.01-0401 (1)	3	M12x60 DIN 912	41	M 30 x 1,5 DIN 908
6	40.1222.02.01-0201 (3)	5	M6x16 DIN 912	43	35 x 3F Cu DIN 7603
8	40.1222.02.01-0101 (4)	7	25x30 RF.M 8006	45	8 x 1 VDF 5720
10	70.1212.02.01-0600 (4)	9	M 30 x 1,5 w DIN 1804	47	M6 x 10 DIN 7984
12	70.1222.02.01-0600 (4)	11	ZARN 3062	49	A 52 x 60 Cu DIN 7603
14	70.1222.02.01-0500 (3)	13	B40x55x7 DIN 3760		
16	40.0110.03.01-1100 (4)	15	M10 DIN 934		
18	70.1222.07.01-0700 (4)	17	10 DIN 7980		
20	70.1212.02.01-1400 (4)	19	DC Modell 5		
22	40.1222.02.01-0900 (4)	21	T101610 25 Bk		
		23	40 VDF 5741		
		25	M8x40 DIN 912		
		27	M8 DIN 934		

31	M12x40 DIN 912
33	M12x200 DIN 912
35	10x40 DIN 7978
37	



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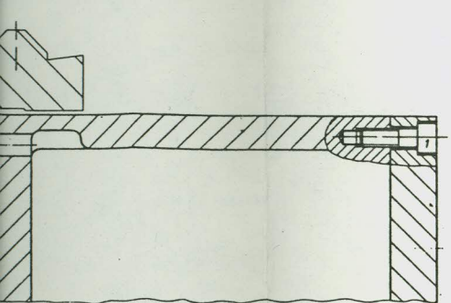

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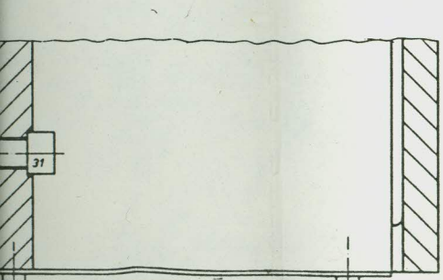

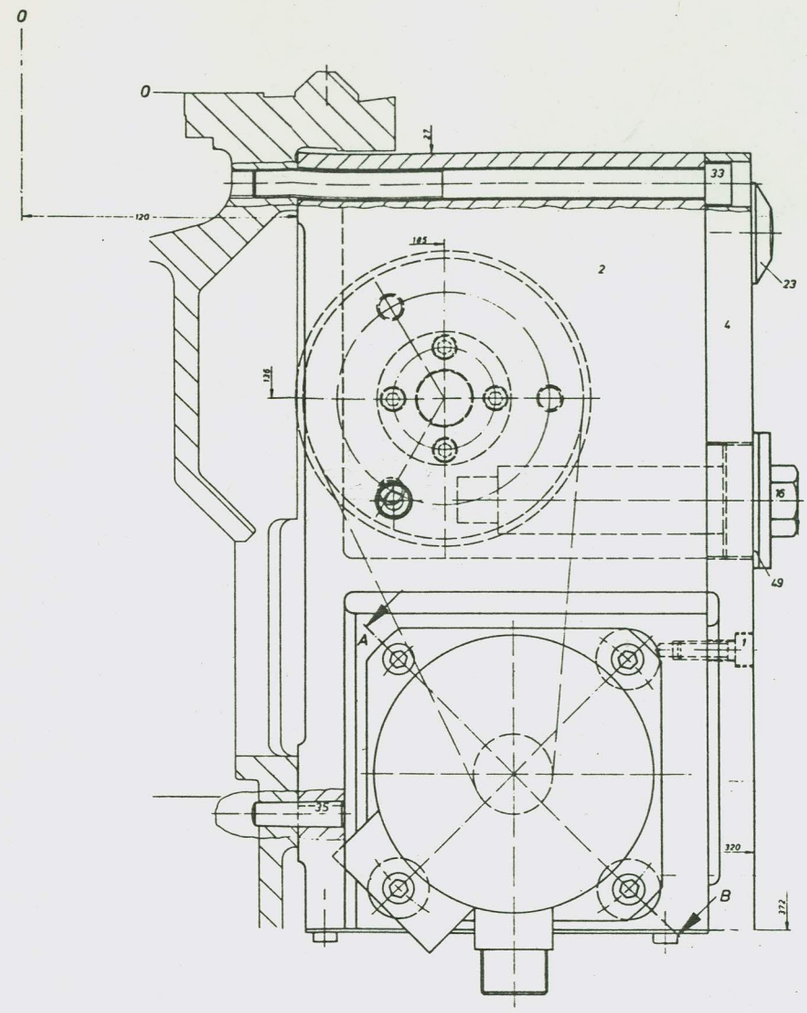

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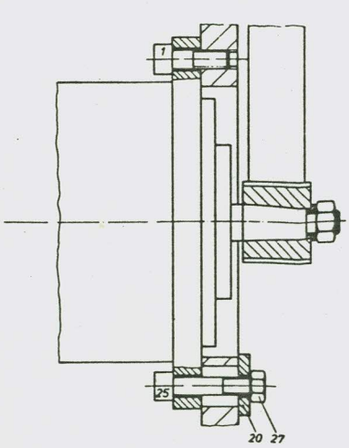

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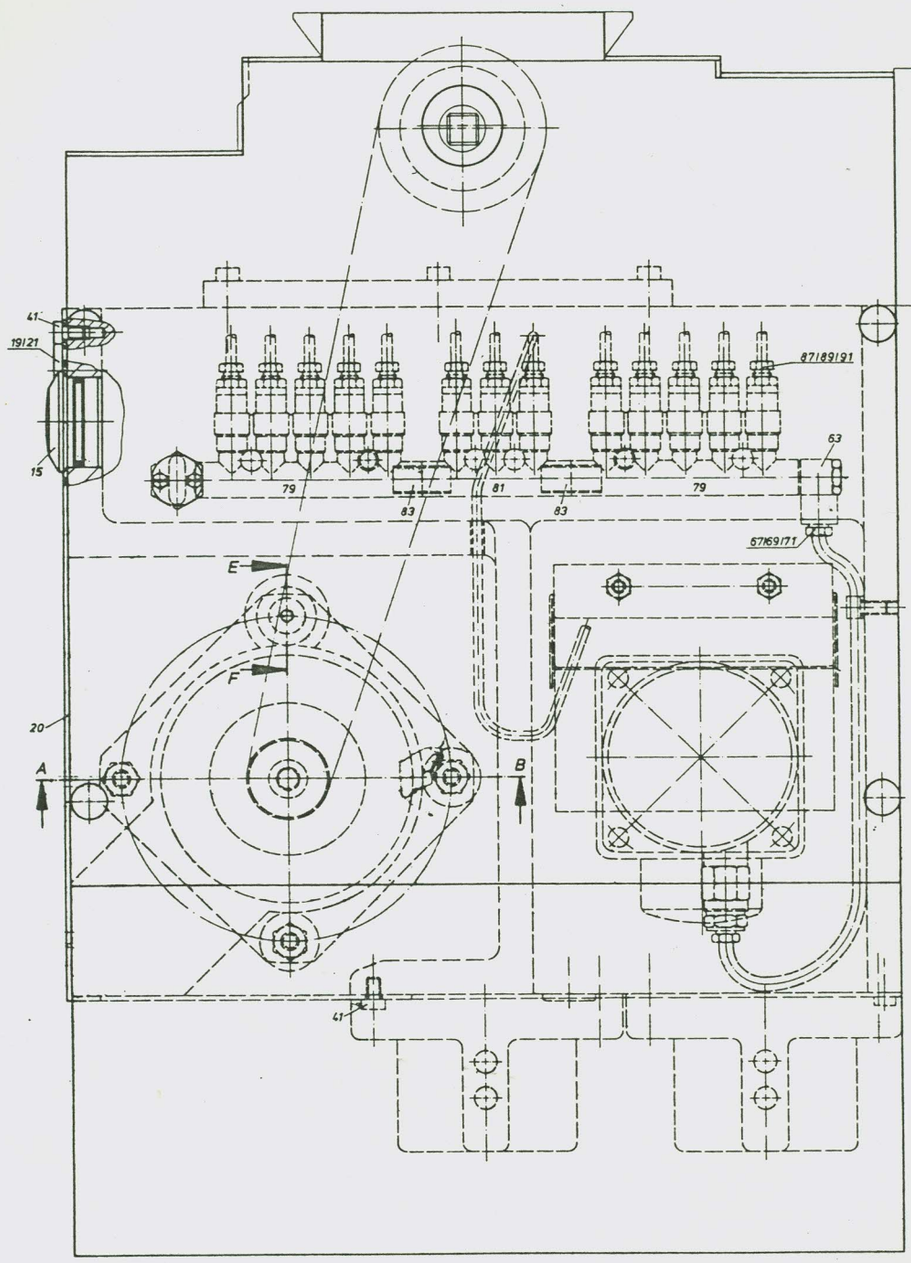
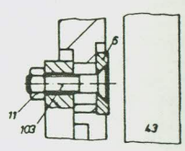
1:1

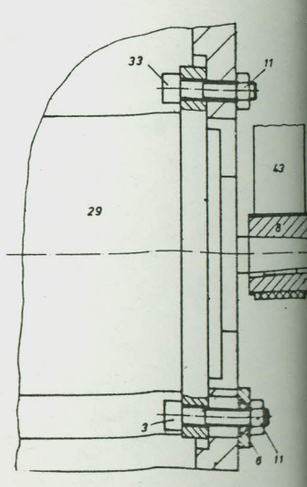
9.1222.02 [illegible]102





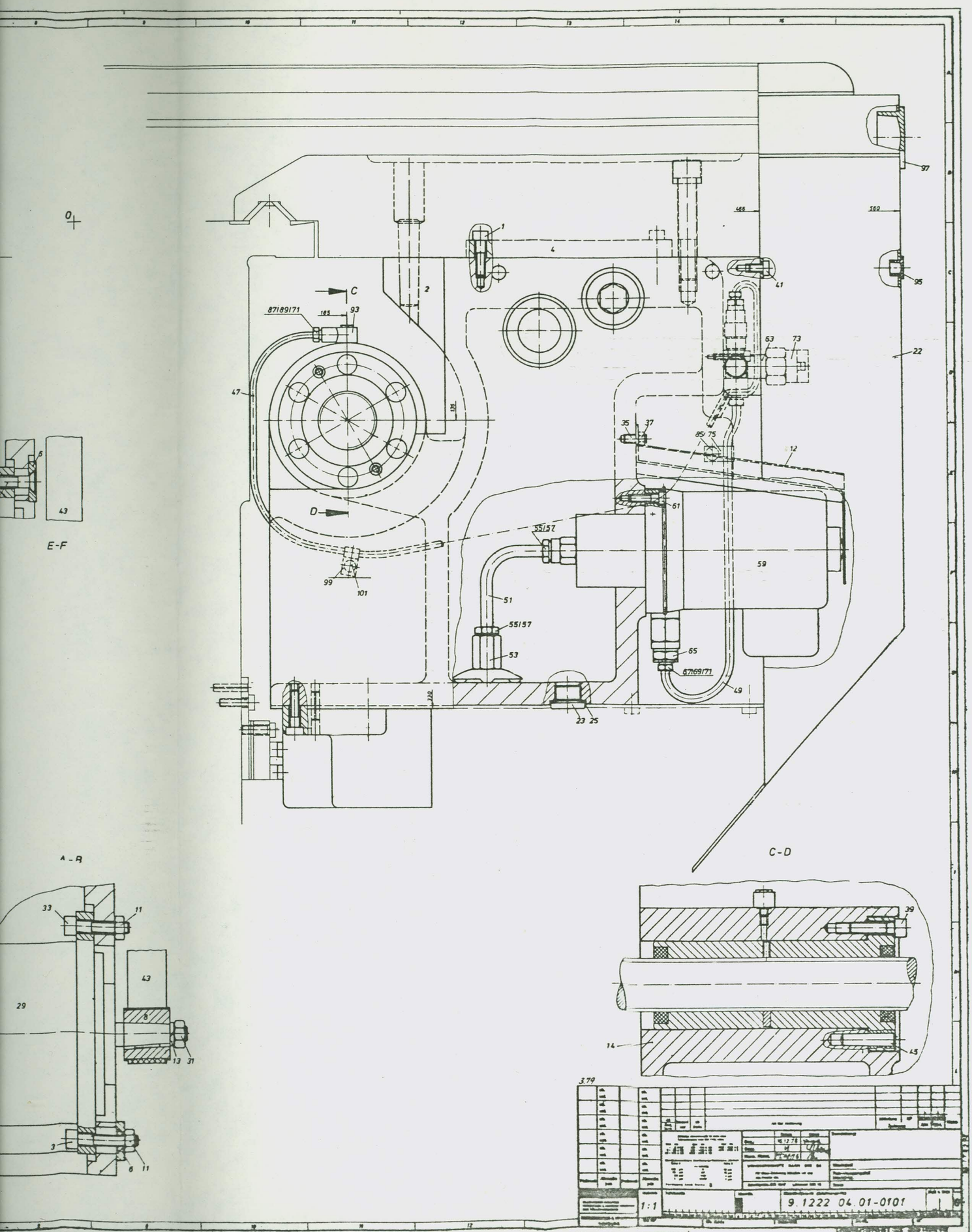
E-F

A - B



2	70.1222.04.01 - 0201 (0)	1	M6x25 DIN 912	20	40.1222.04.99 - 0101 (1)	41	M6x10 DIN 7984
4	70.1922.04.01 - 0300 (2)	3	M8x40 DIN 912 12.9	22	40.1223.04.99 - 0200 (0)	43	T101 880 25 Br
6	70.1212.02.01 - 1400 (4)	5				95	11 HuM 336
8	40.1222.02.01 - 0101 (4)	7	M8x20 DIN 915			97	36 HuM 338
10	70.1212.11.02 - 0400 (3)	9	6x20 DIN 1481				
12	40.1222.04.01 - 0400 (2)	11	M8 DIN 934				
14	70.1222.04.01 - 0202 (0)	13	10 DIN 7980				
		15	40 VDF 5741				
		17	62x2 DIN 472				
		19	M30x1.5 DIN 908				
		21	A30x36 DIN 7603				
		23	M18x1.5 DIN 908				
		25	A18x22 DIN 7603				
		27	B2 D16 DIN 43 897				
		29	DC S				
		31	M 10 DIN 934				
		33	M 8 x 35 DIN 912				
		35	M8x16 DIN 913				
		37	M8 DIN 934				
		39	M8x30 DIN 912 12.9				
		45	8x36 DIN 7978				
		103	M 8 x 35 DIN 7981				

47	4x0,75	77	M4x20 DIN 912		
49	6x1	79	345 400 - 4		
51	Rohr 8 x 1	81	343 400 - 4		
53	208 555	83	408 233		
55	408 202	85	M6x12 DIN 912		
57	408 001	87	404 611		
59	MFE 5	89	404 612		
61	M5x20 DIN 912	91	404 803		
63	506 140	93	504 182		
65	301 005	99	806 001 A		
67	406 603	101	M 5 x 10 DIN 912		
69	406 811				
71	406 612				
73	P 66 S 1/2" - 2				
75	806 010				



379

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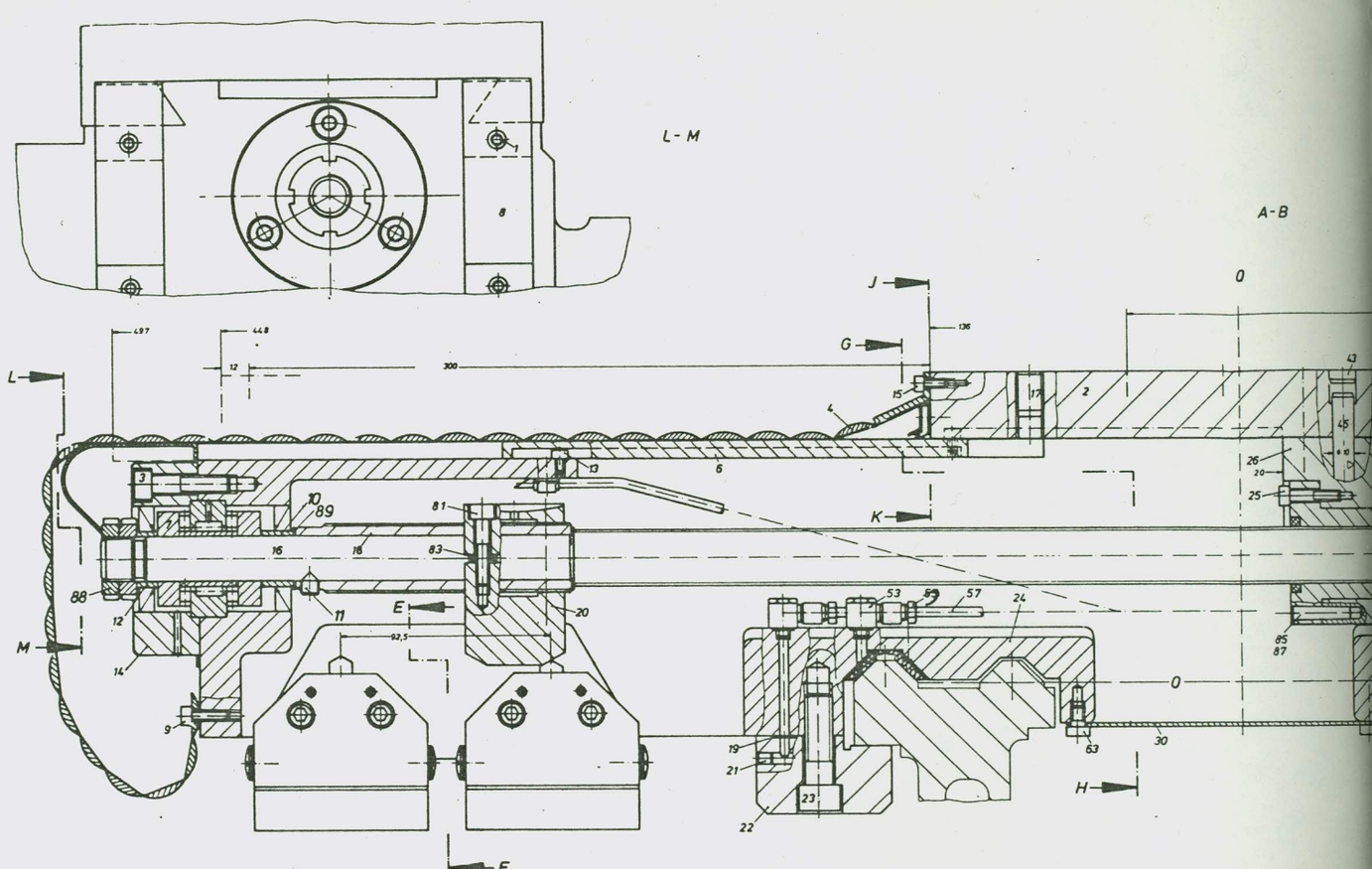
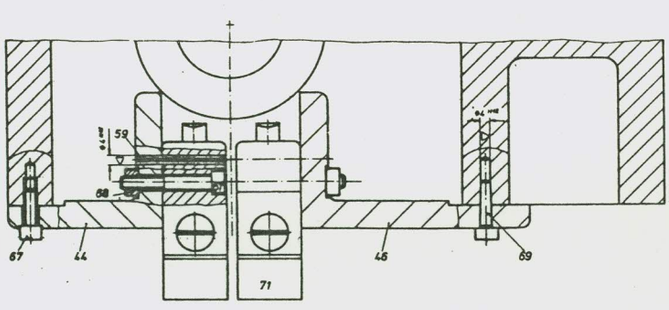
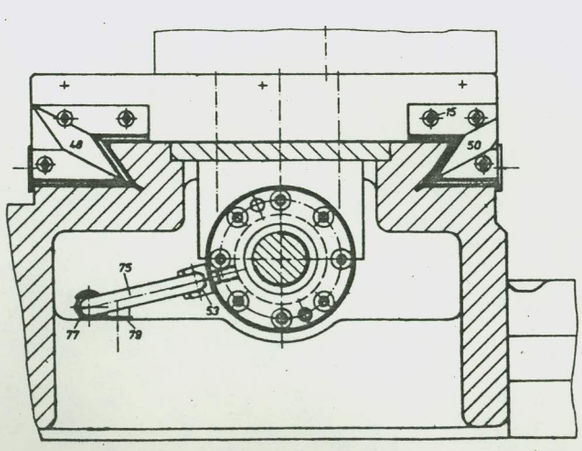
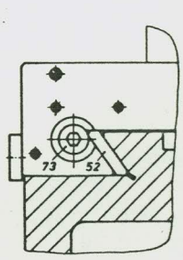
9.1222 04.01-0101



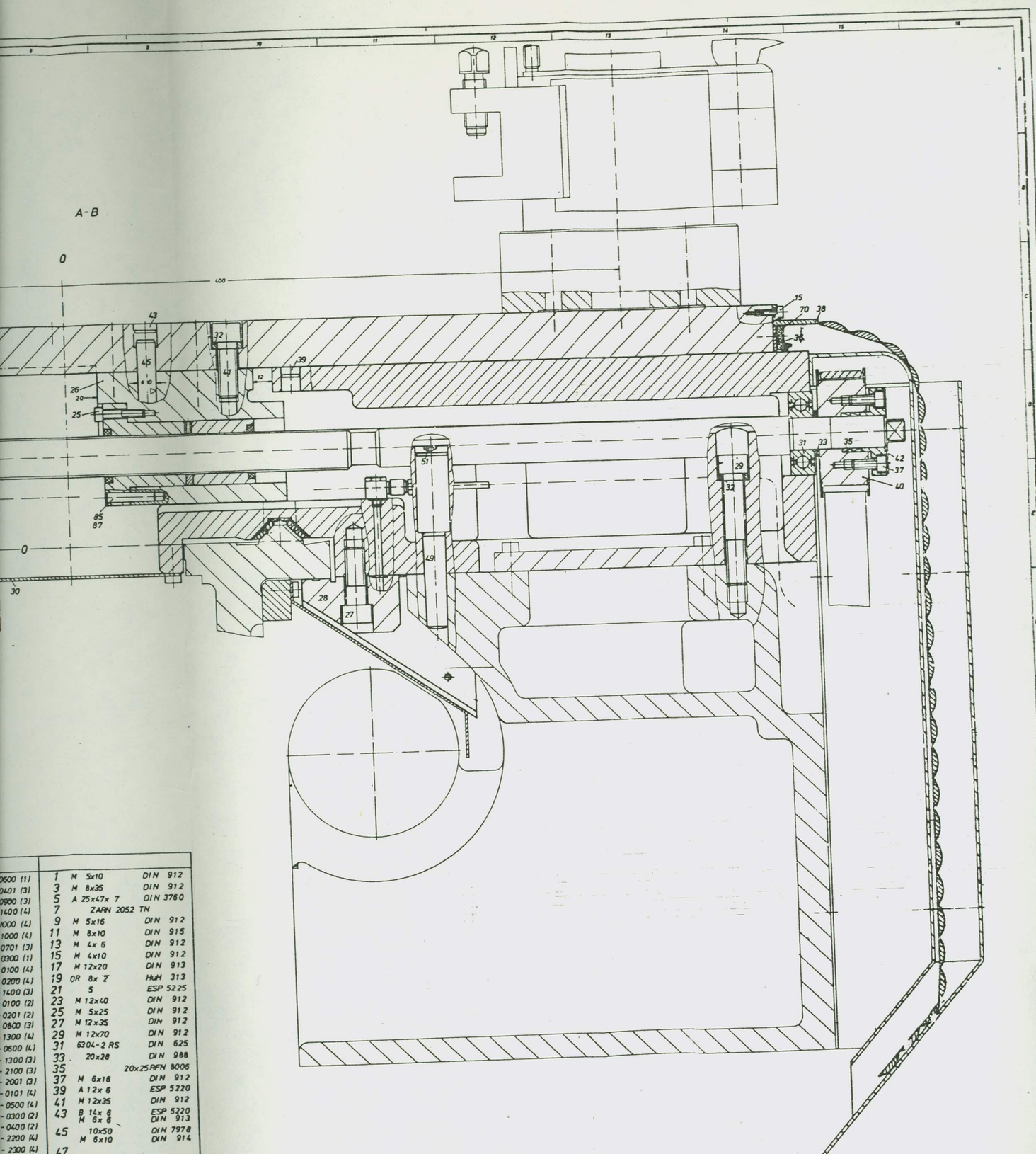






G-H

2	70.1222.11.01 - 0600 (1)		1	M 5x10	DIN 912
4	40.1222.11.01 - 0401 (3)		3	M 8x35	DIN 912
6	70.1222.11.01 - 0980 (3)		5	A 25x47x 7	DIN 3760
8	40.1222.11.01 - 1400 (4)		7	ZARN 2052 TN	
10	183--21-24101000 (4)		9	M 5x16	DIN 912
12	70.1222.11.01 - 1000 (4)		11	M 8x10	DIN 915
14	70.1222.11.01 - 0701 (3)		13	M 4x 6	DIN 912
16	40.1222.11.02 - 0300 (1)		15	M 4x10	DIN 912
18	70.1222.11.03 - 0100 (4)		17	M 12x20	DIN 913
20	70.1222.11.03 - 0200 (4)		19	OR 8x 1	HuH 311
22	70.1212.11.99 - 1400 (3)		21	5	ESP 5225
24	78.1222.11.01 - 0100 (2)		23	M 12x40	DIN 912
26	70.1222.11.02 - 0201 (2)		25	M 5x25	DIN 912
28	70.1222.11.99 - 0800 (3)		27	M 12x35	DIN 912
30	40.1222.11.01 - 1300 (4)		29	M 12x70	DIN 912
32	70.1910.11.01 - 0600 (4)		31	6304-2 RS	DIN 625
34	70.1212.11.99 - 1300 (3)		33	20x28	DIN 988
36	40.1212.11.01 - 2100 (3)		35	20x25 RFN 8001	
38	40.1212.11.01 - 2001 (3)		37	M 6x16	DIN 912
40	40.1222.11.01 - 0101 (4)		39	A 12x 6	ESP 5226
42	70.1222.11.01 - 0500 (4)		41	M 12x35	DIN 912
44	70.1222.11.03 - 0300 (2)		43	B 16x 6	ESP 5228
46	70.1222.11.03 - 0400 (2)			M 6x 6	DIN 912
48	40.1212.11.01 - 2200 (4)		45	10x50	DIN 7979
50	40.1212.11.01 - 2300 (4)			M 6x10	DIN 912
52	79.1222.11.00 - 0101 (3)		47		
	23		49	12x60	DIN 7979
68	70.1222.11.03 - 0500 (4)			M 6x 6	DIN 912
70	40.1222.11.01 - 1200 (3)		51	B 20x 6	ESP 5229
				M 6x 6	DIN 912
			53	504.162	
			55	404.611	
				404.612	
				404.603	
			57	4xQ75	
				604.001	A
				604.003	
				M 5x12	DIN 912
			59	4x40	DIN 1481
			61	M 6x40	DIN 912
			63	M 6x10	DIN 7984
			65		
			67	M 6x16	DIN 912
			69	4x20	DIN 1
			71	BNS 519-FD 80	
			73v	M 10x32	VUF 5206

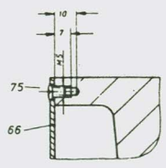


1	M 5x10	DIN 912	
3	M 8x35	DIN 912	
5	A 25x47x 7	DIN 3760	
7	ZARN 2052 TN		
9	M 5x16	DIN 912	
11	M 8x10	DIN 915	
13	M 4x 6	DIN 912	
15	M 4x10	DIN 912	
17	M 12x20	DIN 913	
19	OR 8x 2	HUH 313	
21	5	ESP 5225	
23	M 12x40	DIN 912	
25	M 5x25	DIN 912	
27	M 12x35	DIN 912	
29	M 12x70	DIN 912	
31	6304-2 RS	DIN 625	
33	20x28	DIN 988	
35	20x25 RFN 8006		
37	M 6x16	DIN 912	
39	A 12x 6	ESP 5220	
41	M 12x35	DIN 912	
43	B 14x 6	ESP 5220	
	M 6x 6	DIN 913	
45	10x50	DIN 7978	
	M 6x10	DIN 914	
47			
49	12x60	DIN 7978	
	M 6x 6	DIN 914	
51	B 20x 6	ESP 5220	
	M 6x 6	DIN 913	
53	504.162		
55	404.611		
	404.612		
	404.603		
57	4x075		
	604.001	A	
	604.003		
	M 5x12	DIN 912	
59	4x40	DIN 1481	
61	M 6x40	DIN 912	
63	M 6x10	DIN 7984	
65			
67	M 6x16	DIN 912	
69	4x20	DIN 1	
71	BNS 519-FD 80		
73	M 10x32	YUF 3018	

75	734.500/K	
77	404.010	
79	610.001	
81	M8x30	DIN 912
83	6x12	DIN 988
85	6x30	DIN 7978
87	M5x8	DIN 914
88	NM M 20-15	DIN 1804
89	PS 20x28x1	DIN 988

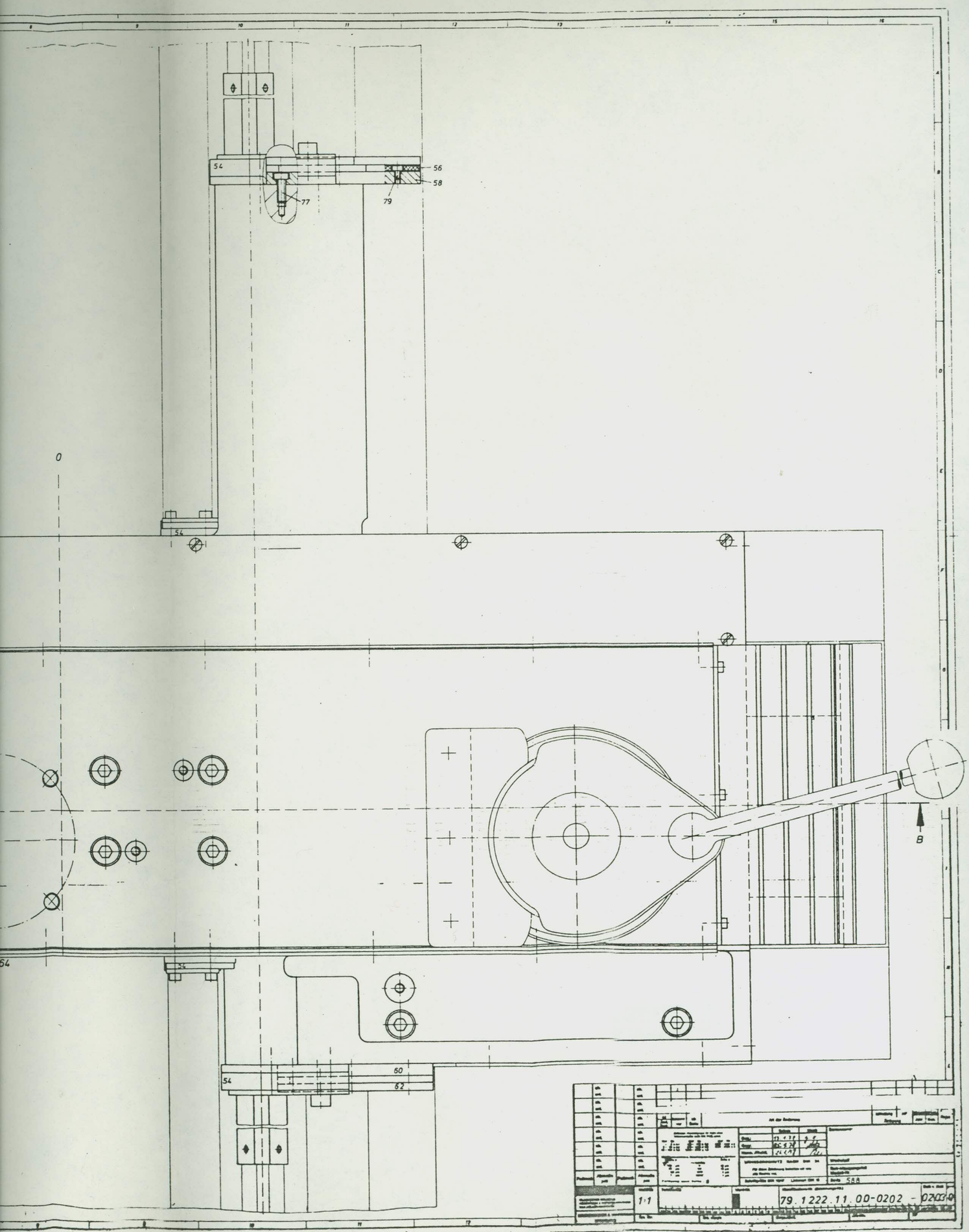
1:1

79.1 22[illegible] 11 00-0300

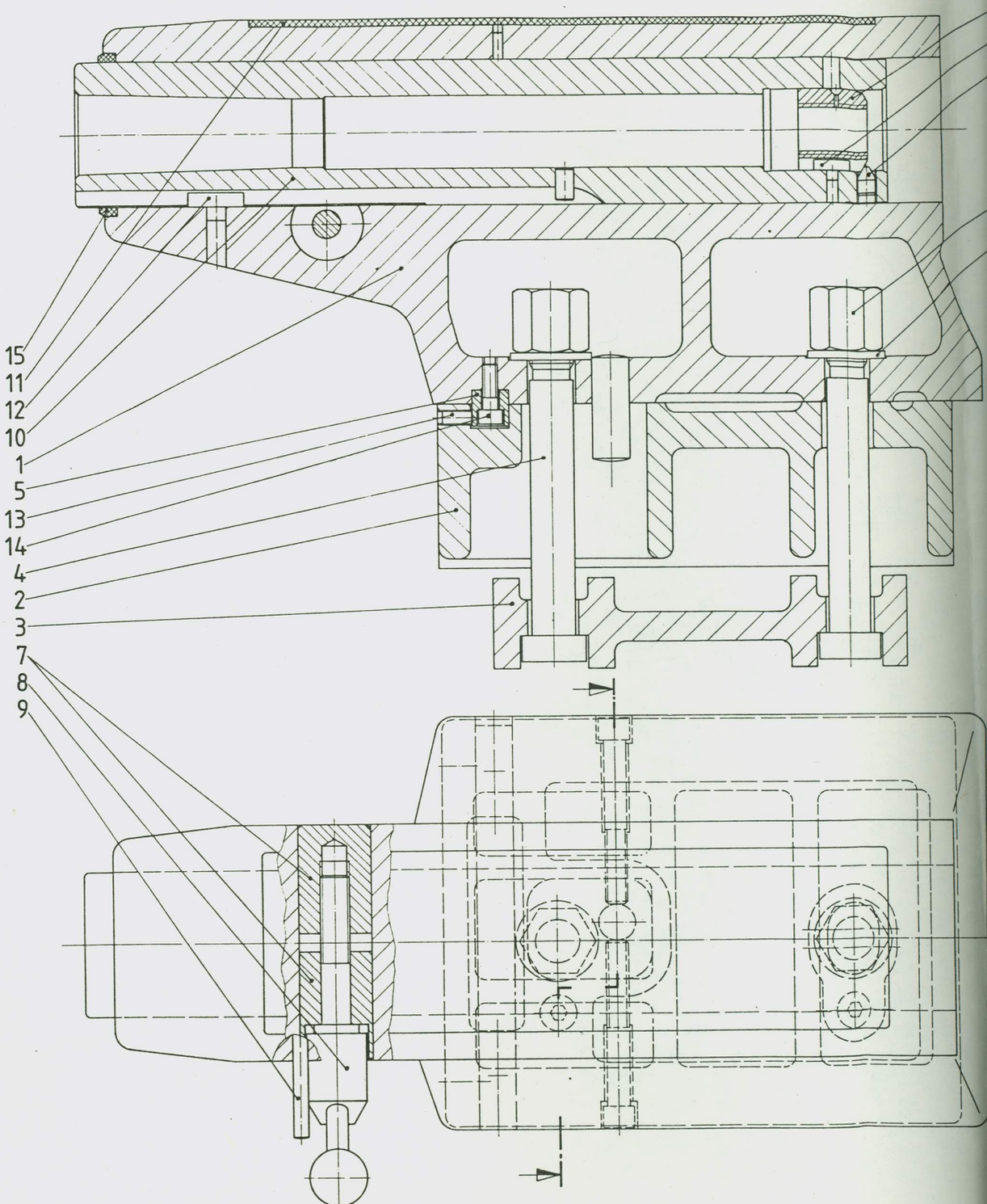


C-D

54	9.1222.11.05-0100 (2)		75	M 5x7	HuH 304
56	40.1222.11.99-0401 (4)		77	M 6x16	DIN 7984
58	70.1222.11.99-0601 (4)		79	M 4x 6	DIN 7984
60	70.1222.11.99-0501 (4)		81	M 4x10	DIN 7991
62	40.1222.11.99-0301 (4)				
64	183--21-23101000 (3)				
66	40.1222.11.99-0700 (3)				



79.1222.11.00-0202 - 02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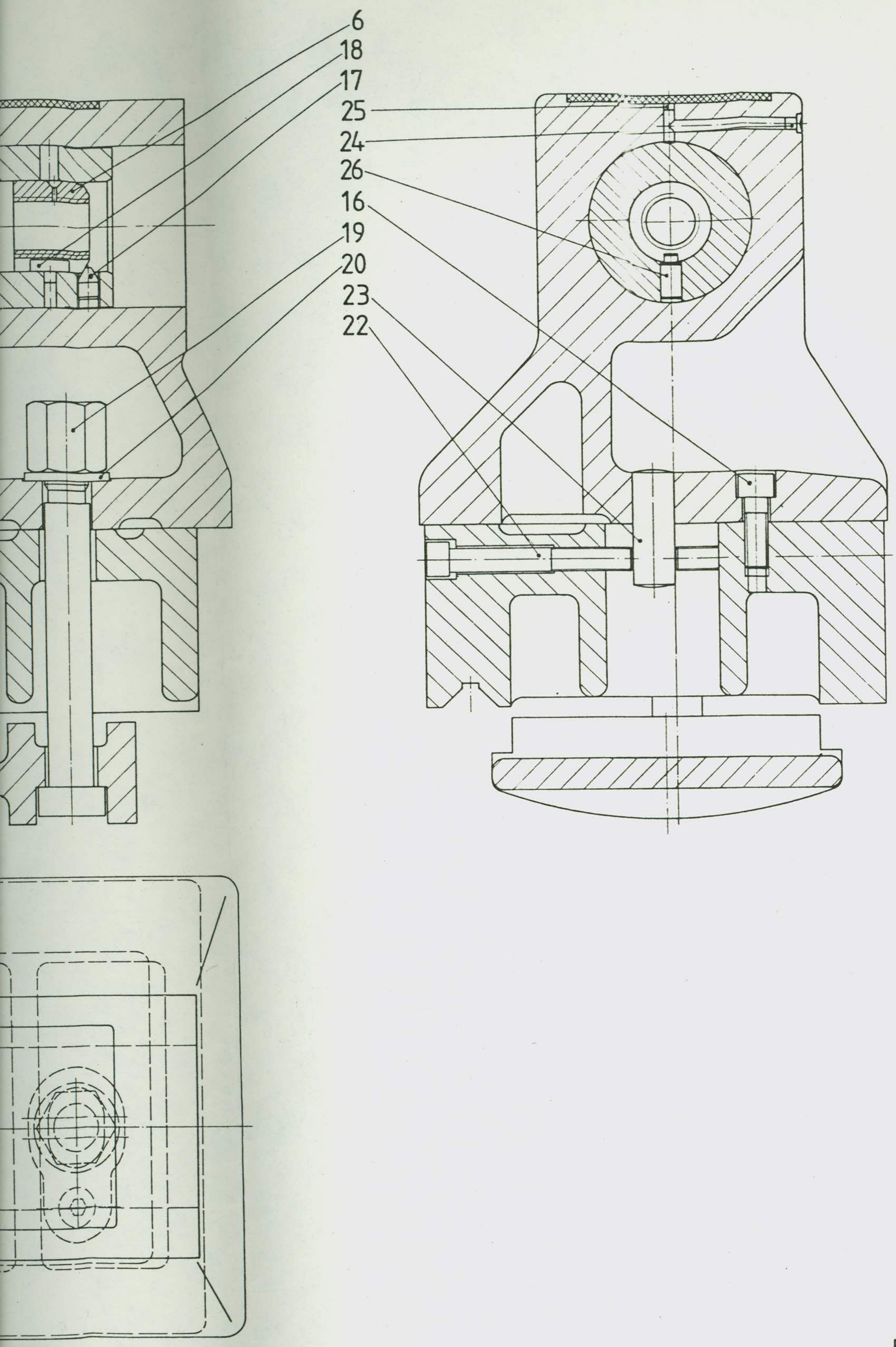
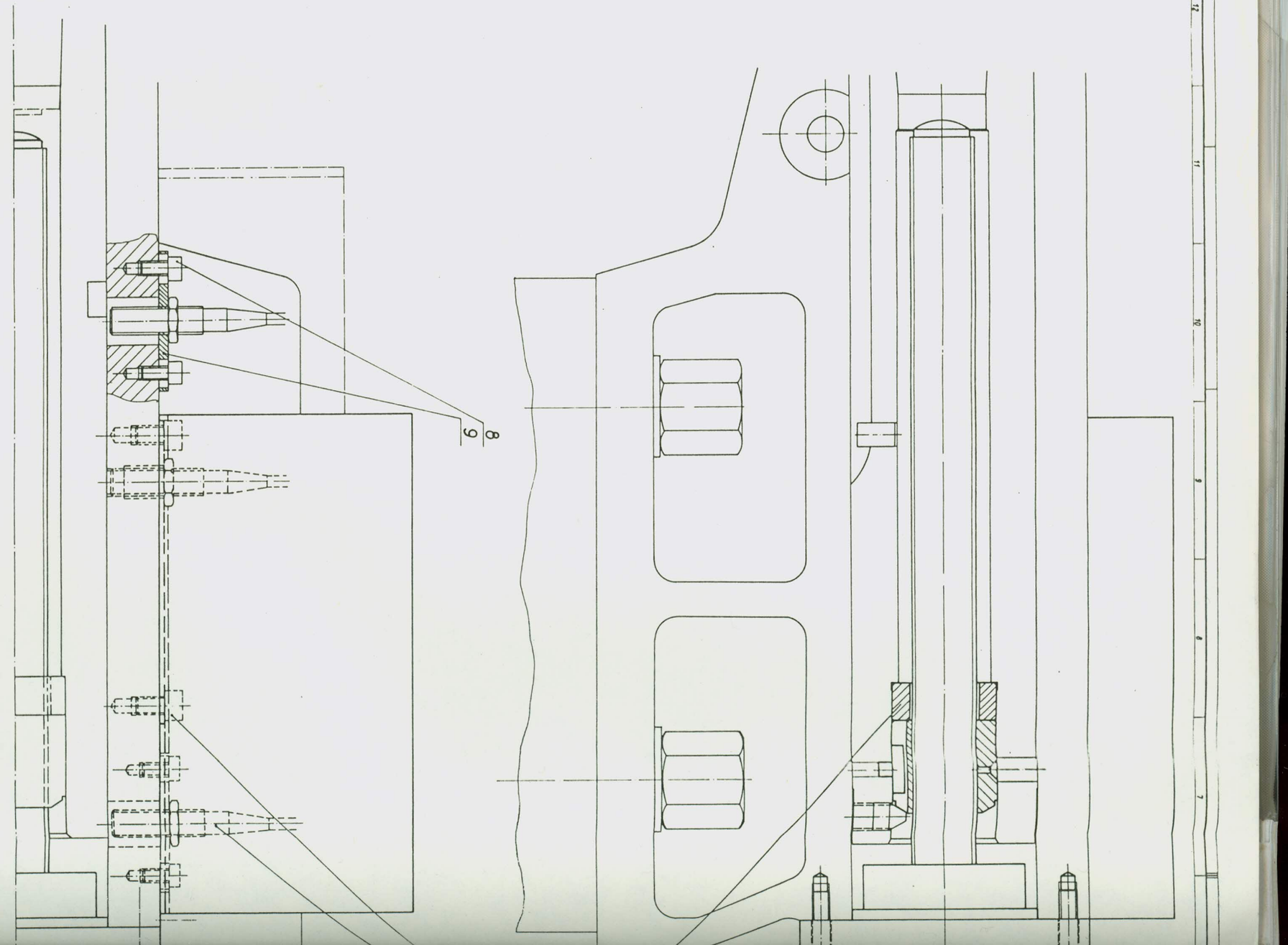
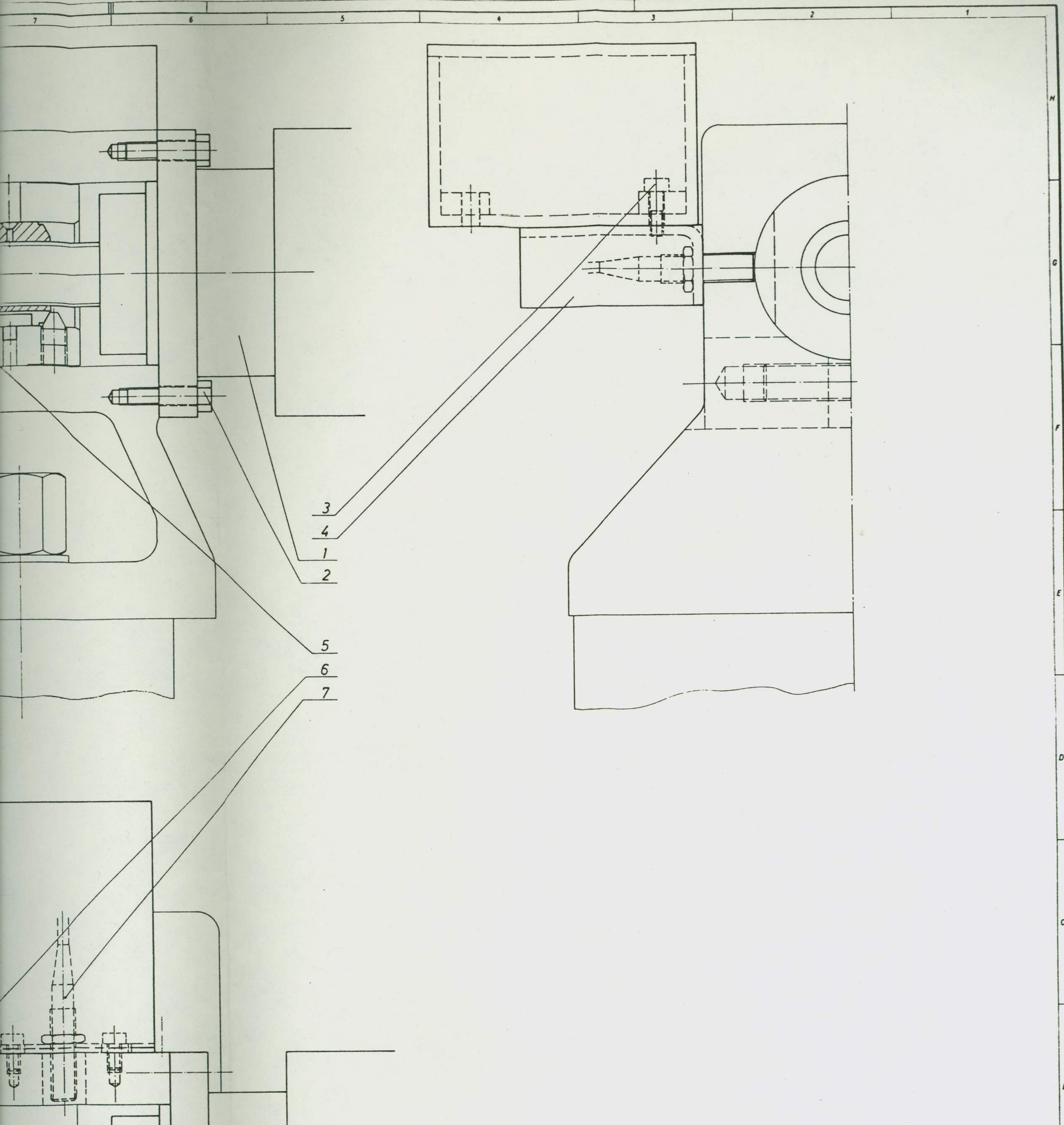


3.79

1:1

183--54.10/000





3.79

Bearbeitet	77	
Gezeichnet	28.12.	
Geprüft		
Normgepr.		

Paßmaß | Abmaße

Werkstoff

Modell-Nr.

SEP-Nr.

1:1

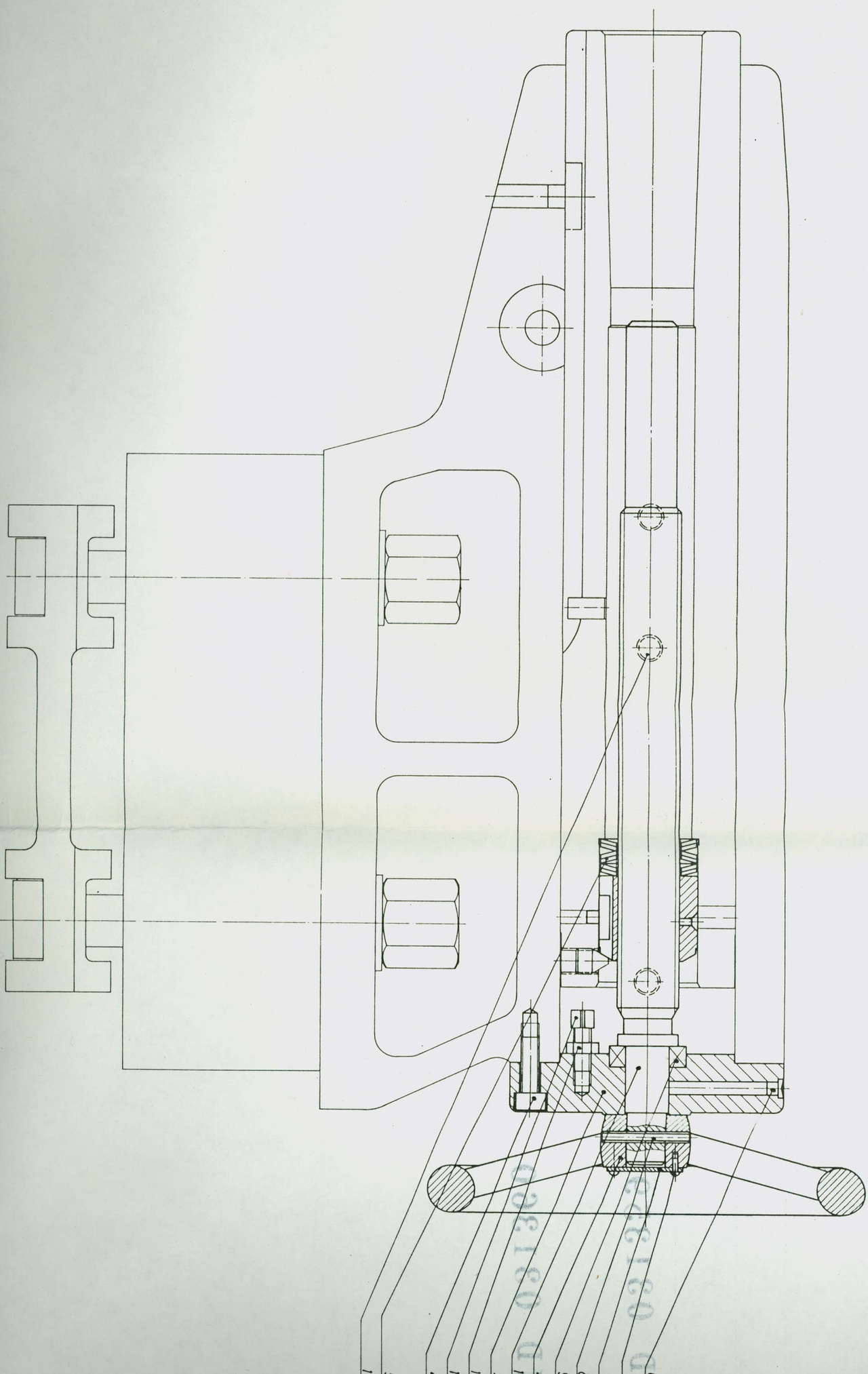
Maßstab

183--54.20/000

Ersetzt durch:

Ersatz für:

Entwickelt aus:



GILDEMEISTER	Operating instructions N.E.F. Machine data	183--59 1000/000 5.78

Technical data	N.E.F. 480	N.E.F. 660
Swing dia. above bed	480 mm	660 mm
Swing dia. above facing slide	200 mm	320 mm
Facing traverse	290 mm	400 mm
Centre distance	1000/2000 mm	1000/1500/2000 mm
Spindle speed range	31.5...2240rpm	9...1800 rpm
Ratio	1.12/1.25	1.25
Spindle speeds selected by program	2	2
Centre height above flat slideway	240 mm	325 mm
Width of bed	333 mm	450 mm
Spindle nose to DIN 55 022	6	11
Spindle dia. in front bearing	90 mm	140 mm
Spindle bore dia.	56 mm	103 mm
Quill dia.	80/MT5	100/MT5
Quill stroke	160 mm	225 mm
Drive rating	11 kW	18.5 kW(22 kW on request)
Max. main sp. torque	1120 Nm	2500 Nm
Net weight of machine	approx.2100/2600 kg	approx.5200/5500/5800 kg
Max. rapid traverse rate, longitudinal	6000 mm/min.	8000 mm/min.
Max. rapid traverse rate, transverse	5000 mm/min.	5000 mm/min.

A) A foundation of at least 300 mm depth is required. A continuous concrete floor can also be used as a foundation.

B)

RATING	
Main drive	Connection
11 kW	20 kW

C) Height of control cabinet 1810 mm

D) Overhead cable channel, max. height = 2300 mm (special version)

E) Space required for chip removal

F) Space required by machine

G) Detail D

H) Turning centre line

I) Underground cable channel 200 x 200

K) OPERATOR SIDE

L) (Standard version)

M) Detail D

N) Opening in concrete floor for cable entry into machine

O) Concrete floor

P) Cable channel 200 x 200

Q) Normal version with pressure plate

R) Max. acceptable straightness and flatness error of foundation 10 mm

S) Turning length

T) Distance between point

U) Centre pedestal

V) Number of pressure plates

W) Height of machine 1600 mm

X) Space required for operating and maintenance

Y) Foundation (minimum depth 300 mm)

Z) Size of machine pedestal

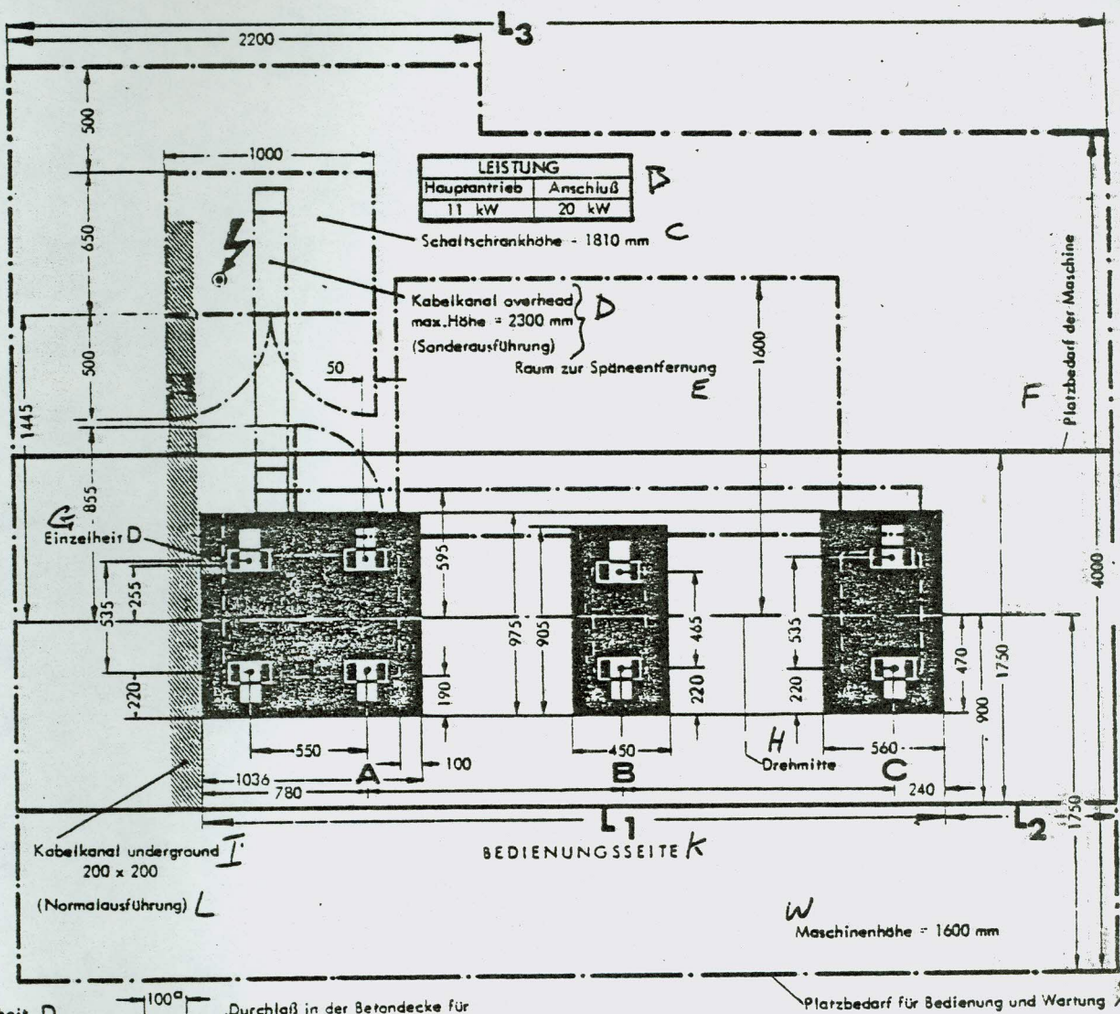
GILDEMEISTER

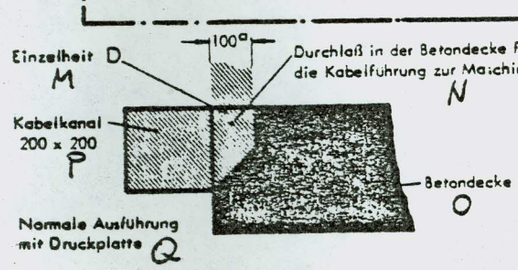
Bedienungsanleitung N.E.F.

Fundamentplan N E F 480

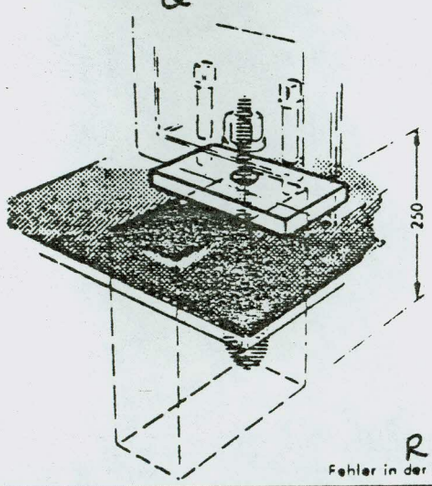
183--59
2010/000
5.78

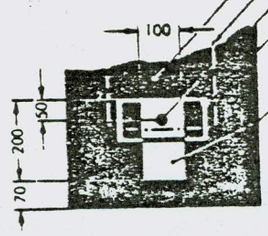
A Es wird ein Fundament benötigt, dessen Tiefe mindestens 300 mm betragen soll. Es kann auch eine durchgehende Betondecke als Fundament verwendet werden.





S Drehlänge	T Maß zwischen Punkt A	B	C	L_1	L_2	L_3	U Mittelfuß	*V Anzahl der Druckplatten
1000		1580		2600	800	4225	-	6
2000	1257		1323	3600	1050	5475	1	8





Fundament (Mindesttiefe 300 mm) Y
Größe des Maschinenfußes Z
Steinschraube M 24 x 250 DIN 529 * AA
Druckplatte 200 x 100 x 20 * AB
mit einer zentrischen Bohrung von 28 mm für die Steinschraube
Loch für Steinschraube 250 mm tief ** AC

AD
* Gehört nicht zum Lieferumfang.
** Nach dem Aufstellen der Maschine zu vergießen.
AE

Fehler in der Geradheit und Ebenheit des Fundaments max. 10 mm.

Installation

Installation of this turning machine requires a foundation of at least 300 mm thickness which must reach down to solid sub-soil. The foundation should be arranged strictly in accordance with the attached foundation plan and should be completely level and horizontal.

A special foundation may not be required but this is strictly subject to the condition that the available floor on which the machine is to be installed has a minimum load carrying capacity of 3 kg/cm^2.

Levelling and bolting-down

To obtain the designed machining accuracy of this turning machine it has to be carefully levelled on its foundation.

Initially, the machine is placed on the foundation so that it rests on the levelling bolts with steel support plates and foundation bolts in situ. Subsequently, the machine is coarsely levelled and the foundation bolts grouted in. Actual final levelling is started when the grout has set.
Acceptable deviations over full slideway capacity:

0.01 mm per 1000 mm in transverse direction.

0.02 mm per 1000 mm in longitudinal direction.

Spirit levels of adequate sensitivity are essential and these are placed on the machine bed slideway vees in longitudinal and transverse direction. Actual levelling is effected with the levelling bolts situated in the pedestals adjacent to the foundation bolts. The foundation bolts which hold the machine down should be tightened carefully so that the machine bed does not suffer distortion.

After final connection of the machine, again check the levels and readjust if necessary.

A precision machine tool requires accurate installation. Good turning results (geometrical accuracy, freedom from chatter when recessing) can only be ensured through adequately rigid connection to foundation or floor. Should users nevertheless desire to install the machine on anti-vibration mounts, full details should be obtained from the supplier in question.

Cleaning

Before taking the machine into production it is essential to remove carefully any rust preventatives and dirt from bright parts.
Moving parts must not under any circumstances be moved until all slideway surfaces and other bright surfaces are completely clean, dry and slightly oiled.
Cleaning requires a suitable medium such as paraffin. Do not use petrol or cellulose thinners. Compressed air should not be used for cleaning purposes.

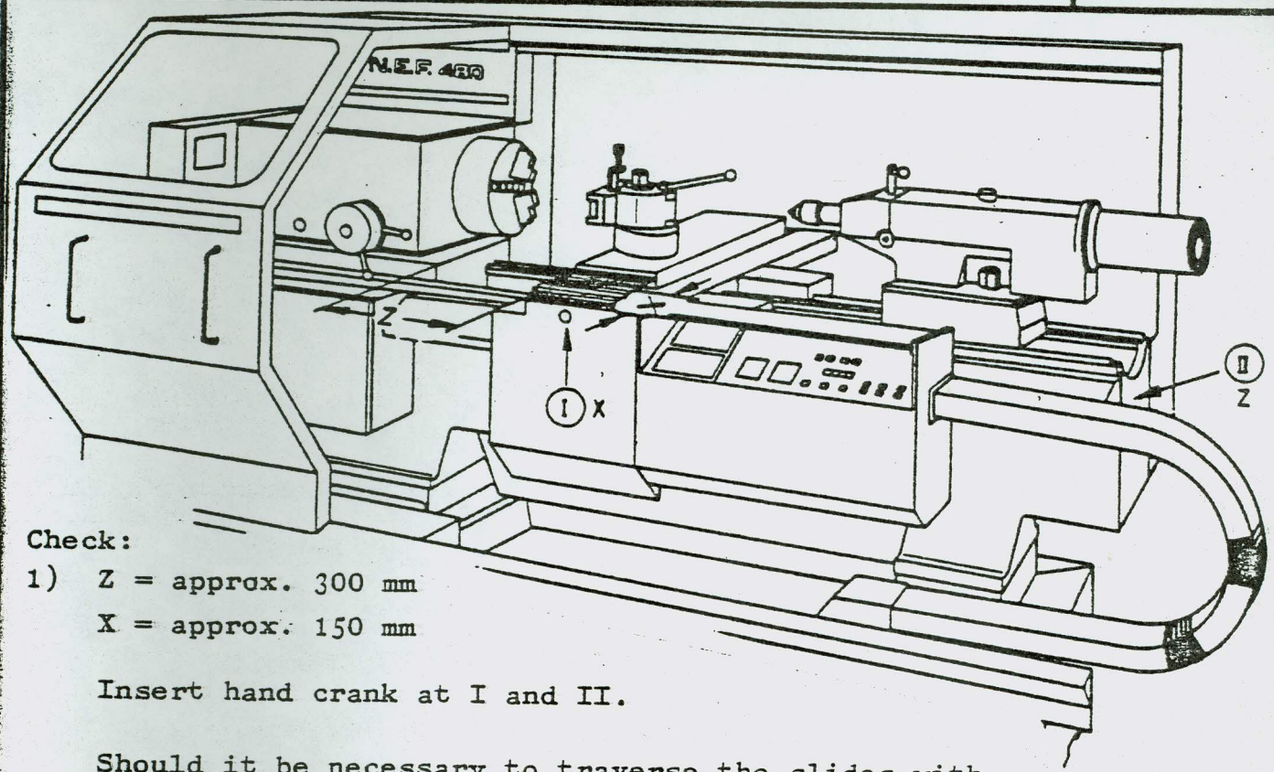
Initial starting-up

Before taking the machine into operation for the first time it is essential to take due note of the lubrication schedule and the lubrication instructions applicable to this turning machine.

The electrical system of the machine is connected to the mains supply by turning the main switch on the control cabinet to "On".

All machine traverses can be initiated either manually or automatically by the NC system. Further details on this subject appear in the programming instructions.

When starting the machine for the first time, the various functions should be checked by manual initiation. These functions are: main spindle clockwise and anti-clockwise rotation, feed and rapid traverse action in X and Z direction.



Check:

1) Z = approx. 300 mm
   X = approx. 150 mm

   Insert hand crank at I and II.

   Should it be necessary to traverse the slides with the hand crank, the plug connections 4b50 (X) and 4b51 (Z) have to be disconnected in the control cabinet.

2) Connect all cables and plug/socket connections:

   Main motor, cable 1 — wire No. 1 = R 13
   No. 2 = S 13
   No. 3 = T 13

   With star delta, cable 1a — wire No. 1 = R 14
   No. 2 = S 14
   No. 3 = T 14

3) Check frequency setting on feed amplifier (rear of control cabinet) *
   * not applicable to N.E.F. 660

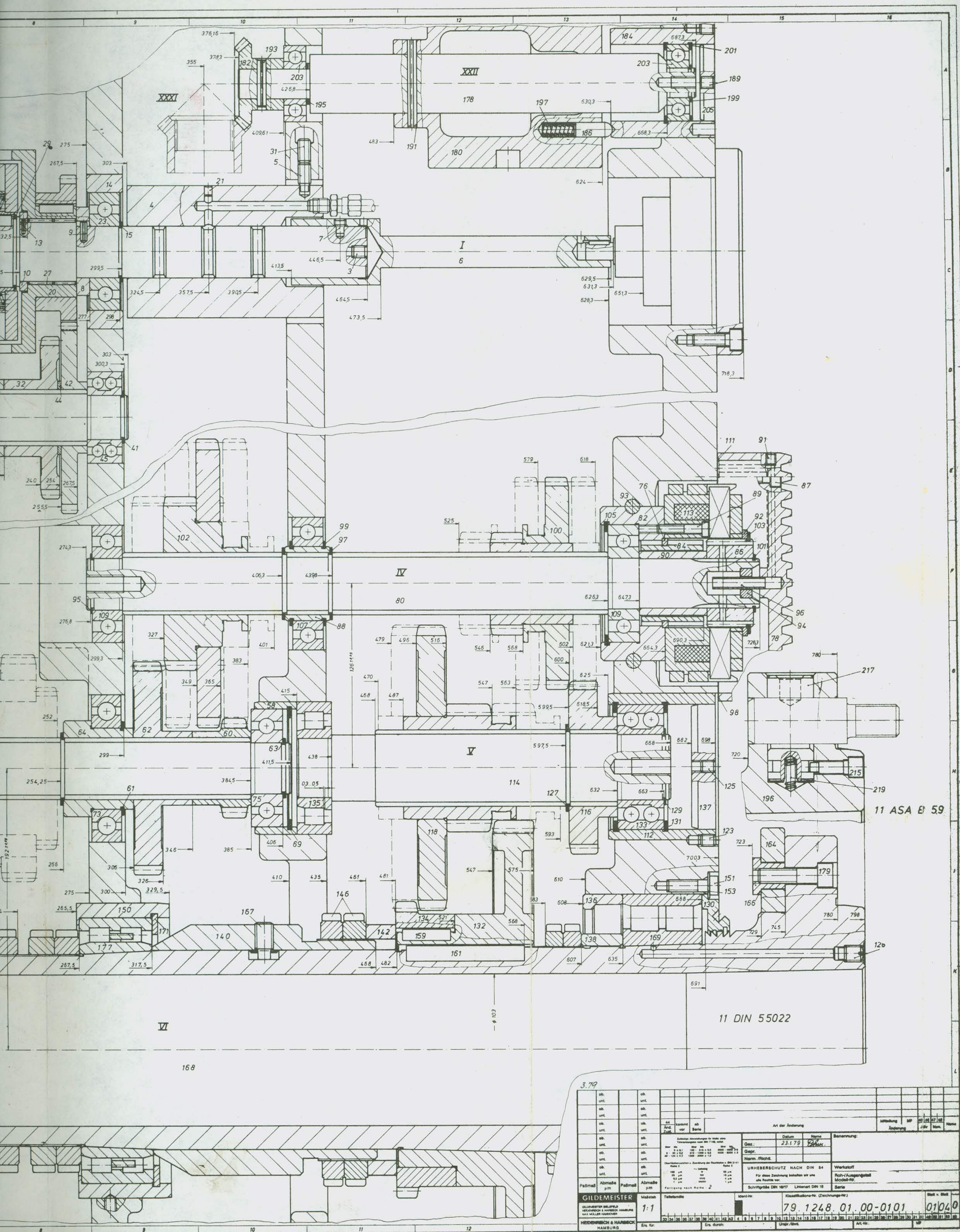
4) Make mains connection

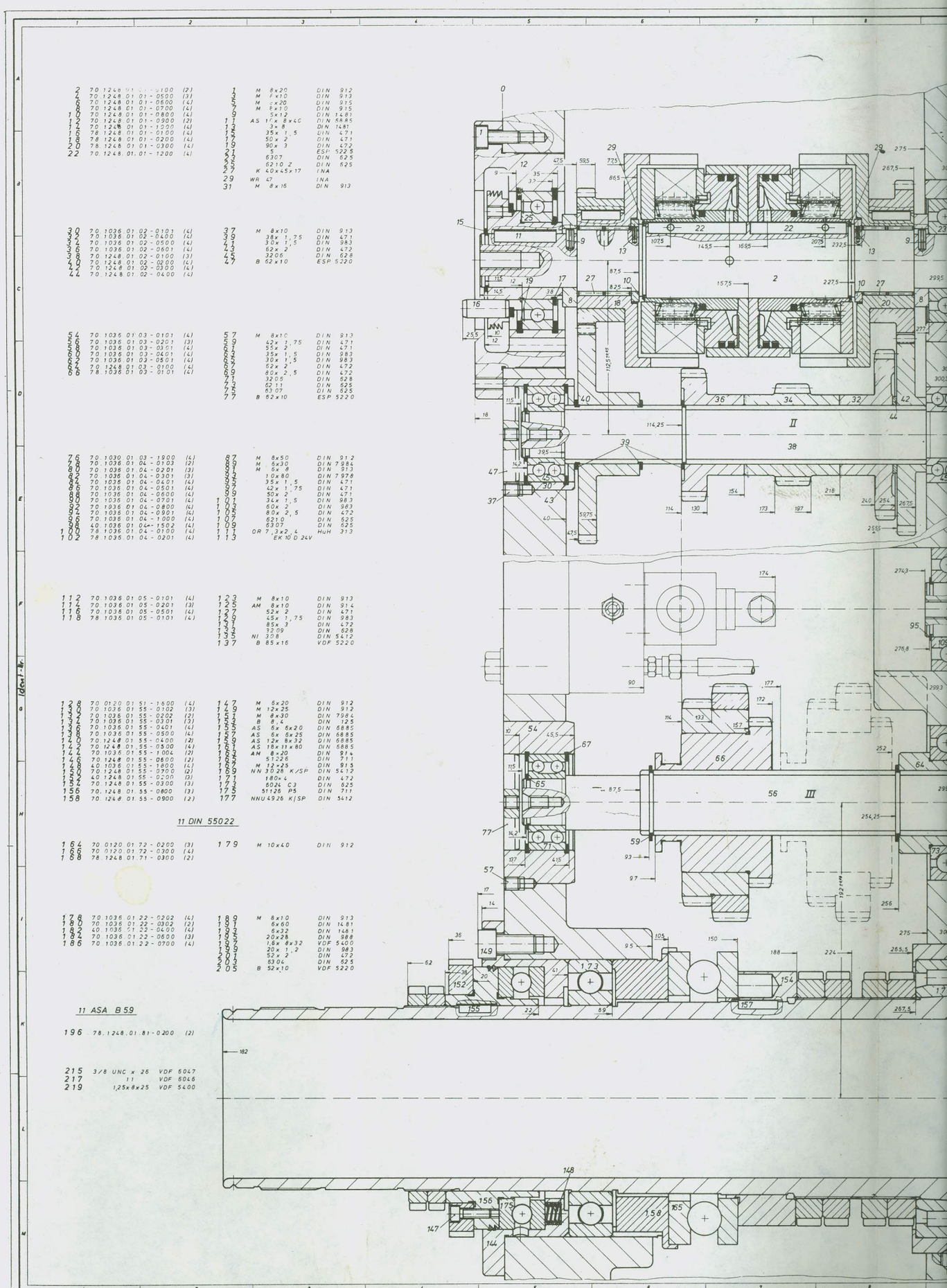
   Check mains connection for field of rotation turning clockwise.
   Measuring instrument: Rotation meter

5) a) Actuate feed stop
   b) Main switch "On"
   c) Enable data input
   d) Unlock EMERGENCY STOP button

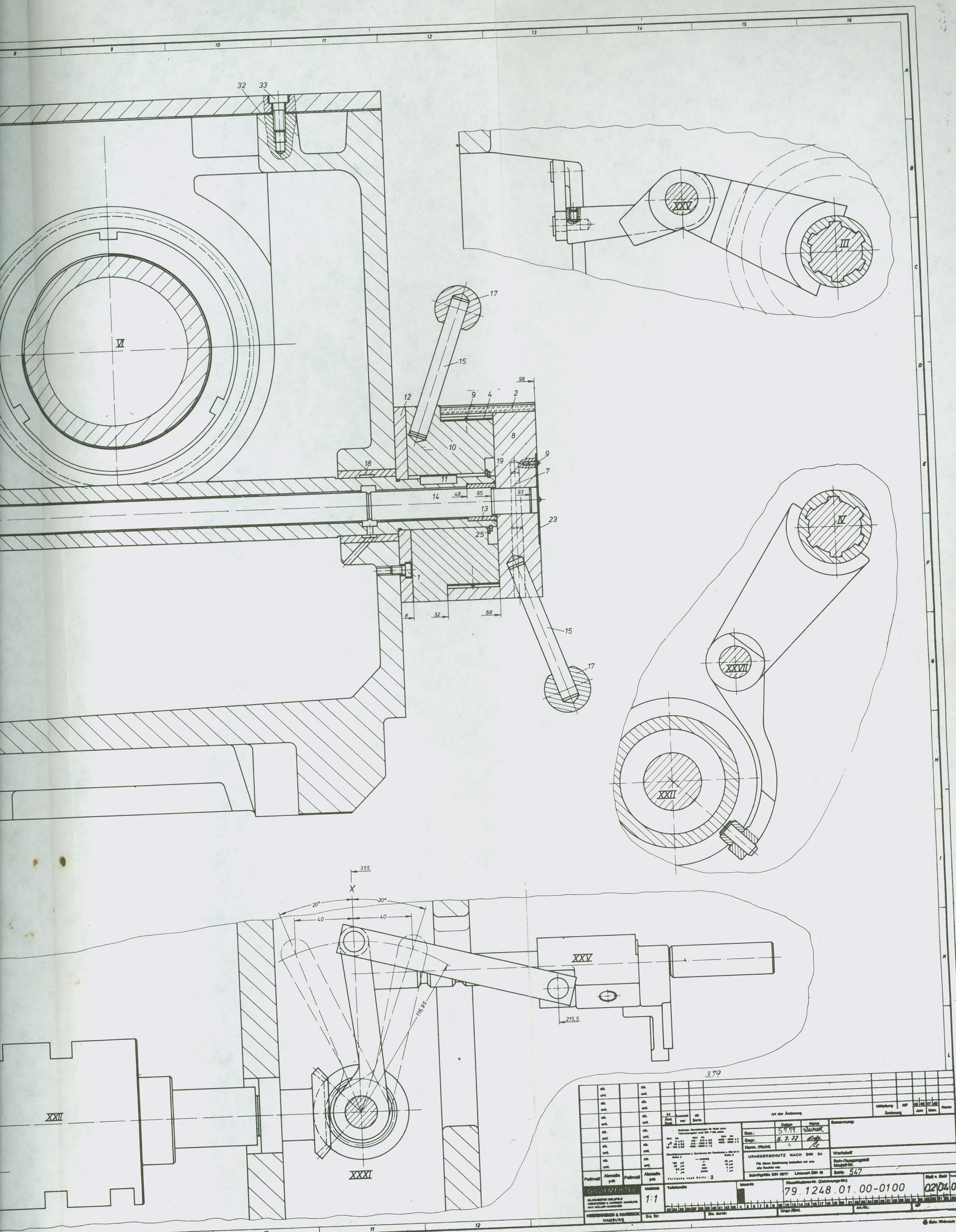
   Re item 5) and 6), see explanation in chapter "Control system".

6) Check parameter store


XXXI
XXII
I
IV
V
VI
11 ASA B 5.9
11 DIN 55022
3.79
Paßmaß
Abmaße µm
Art der Änderung
Datum
Name
Gez.: 23.1.79
Gepr.
Norm./Richtl.
Benennung:
URHEBERSCHUTZ NACH DIN 34
Für diese Zeichnung behalten wir uns alle Rechte vor.
Schriftgröße DIN 16/17 Linienart DIN 15
Werkstoff
Roh-/Ausgangsteil Modell-Nr.
Serie
Fertigung nach Reihe: 2
GILDEMEISTER
GILDEMEISTER BIELEFELD
HEIDENREICH & HARBECK HAMBURG
MAX MÜLLER HANNOVER
HEIDENREICH & HARBECK HAMBURG
Maßstab 1:1
Teilefamilie
Ident-Nr.
Klassifikations-Nr. (Zeichnungs-Nr.)
79. 1248. 01. 00-0101
Blatt v. Blatt
01 04 0
Ers. für:
Ers. durch:
Urspr./Ähnl.
Art.-Nr.:



Ident-Nr.					
2	70.1248.01.01-0100	(2)	1	M 8x20	DIN 912
4	70.1248.01.01-0500	(3)	3	M 5x10	DIN 913
6	70.1248.01.01-0600	(4)	5	M 5x20	DIN 913
8	70.1248.01.01-0700	(4)	7	M 5x10	DIN 915
10	70.1248.01.01-0800	(4)	9	5x12	DIN 1481
12	70.1248.01.01-0900	(2)	11	AS 16x 8x40	DIN 6885
14	70.1248.01.01-1000	(4)	13	3x 8	DIN 1481
16	78.1248.01.01-0100	(4)	15	35x 1,5	DIN 471
18	78.1248.01.01-0200	(4)	17	50x 2	DIN 471
20	78.1248.01.01-0300	(4)	19	90x 3	DIN 472
22	70.1248.01.01-1200	(4)	21	5	ESP 5225
			23	6307	DIN 625
			25	6210 Z	DIN 625
			27	K 40x45x17	INA
			29	WR 47	INA
			31	M 8x16	DIN 913
30	70.1036.01.02-0101	(4)	37	M 8x10	DIN 913
32	70.1036.01.02-0400	(4)	39	38x 1,75	DIN 471
34	70.1036.01.02-0500	(4)	41	30x 1,5	DIN 983
36	70.1036.01.02-0601	(4)	43	62x 2	DIN 472
38	70.1248.01.02-0100	(3)	45	3206	DIN 628
40	70.1248.01.02-0200	(4)	47	B 62x10	ESP 5220
42	70.1248.01.02-0300	(4)			
44	70.1248.01.02-0400	(4)			
54	70.1036.01.03-0101	(4)	57	M 8x10	DIN 913
56	70.1036.01.03-0201	(3)	59	42x 1,75	DIN 471
58	70.1036.01.03-0301	(4)	61	55x 2	DIN 471
60	70.1036.01.03-0401	(4)	63	35x 1,5	DIN 983
62	70.1036.01.03-0501	(4)	65	30x 1,5	DIN 983
64	70.1036.01.03-0100	(4)	67	62x 2	DIN 472
66	78.1036.01.03-0101	(4)	69	80x 2,5	DIN 472
			71	3205	DIN 628
			73	6211	DIN 625
			75	6307	DIN 625
			77	B 62x10	ESP 5220
76	70.1030.01.03-1900	(4)	87	M 8x50	DIN 912
78	70.1036.01.04-0103	(2)	89	M 6x30	DIN 7984
80	70.1036.01.04-0201	(3)	91	M 6x 8	DIN 913
82	70.1036.01.04-0301	(3)	93	10x80	DIN 7976
84	70.1036.01.04-0401	(4)	95	35x 1,5	DIN 471
86	70.1036.01.04-0501	(4)	97	42x 1,75	DIN 471
88	70.1036.01.04-0600	(4)	99	50x 2	DIN 471
90	70.1036.01.04-0701	(4)	101	30x 1,5	DIN 983
92	70.1036.01.04-0800	(4)	103	60x 2	DIN 983
94	70.1036.01.04-0901	(4)	105	80x 2,5	DIN 472
96	70.1036.01.04-1000	(4)	107	6210	DIN 625
98	40.1036.01.04-1502	(4)	109	6307	DIN 625
100	78.1036.01.04-0100	(4)	111	OR 7,3x2,4	HuH 313
102	78.1036.01.04-0201	(4)	113	EK 10 D 24V	
112	70.1036.01.05-0101	(4)	123	M 8x10	DIN 913
114	70.1036.01.05-0201	(3)	125	AM 8x10	DIN 914
116	70.1036.01.05-0501	(4)	127	52x 2	DIN 471
118	78.1036.01.05-0101	(4)	129	45x 1,75	DIN 983
			131	85x 3	DIN 472
			133	3209	DIN 628
			135	NI 308	DIN 5412
			137	B 85x16	VDF 5220
128	70.01.20.01.51-1600	(4)	147	M 5x20	DIN 912
130	70.1036.01.55-0102	(3)	149	M 12x25	DIN 912
132	70.1036.01.55-0202	(2)	151	M 8x30	DIN 7984
134	70.1036.01.55-0301	(3)	153	B 8,4	DIN 125
136	70.1036.01.55-0401	(4)	155	AS 6x 6x20	DIN 6885
138	70.1036.01.55-0500	(4)	157	AS 6x 6x25	DIN 6885
140	70.1248.01.55-0400	(2)	159	AS 12x 8x32	DIN 6885
142	70.1248.01.55-0500	(4)	161	AS 18x11x80	DIN 6885
144	70.1036.01.55-1004	(2)	163	AM 8x20	DIN 914
146	70.1248.01.55-0600	(2)	165	51226	DIN 711
148	40.1036.01.55-1600	(4)	167	M 12x25	DIN 915
150	70.1248.01.55-0700	(2)	169	NN 3028 K/SP	DIN 5412
152	40.1248.01.55-0200	(3)	171	180x4	DIN 472
154	70.1248.01.55-0300	(3)	173	6026 C3	DIN 625
156	70.1248.01.55-0800	(3)	175	51126 P5	DIN 711
158	70.1248.01.55-0900	(2)	177	NNU 4926 K/SP	DIN 5412
	11 DIN 55022				
164	70.0120.01.72-0200	(3)	179	M 10x40	DIN 912
166	70.0120.01.72-0300	(4)			
188	78.1248.01.71-0300	(2)			
178	70.1036.01.22-0202	(4)	189	M 8x10	DIN 913
180	70.1036.01.22-0302	(2)	191	6x60	DIN 1481
182	40.1036.01.22-0400	(4)	193	6x32	DIN 1481
184	70.1036.01.22-0600	(3)	195	20x28	DIN 988
186	70.1036.01.22-0700	(4)	197	1,6x 8x32	VDF 5400
			199	20x 1,2	DIN 983
			201	52x 2	DIN 472
			203	6304	DIN 625
			205	B 52x10	VDF 5220
	11 ASA B59				
196	78.1248.01.81-0200	(2)			
215	3/8 UNC x 26	VDF 6047			
217	11	VDF 6046			
219	1,25x8x25	VDF 5400			


32
33
VI
XXV
III
17
15
12
9
4
2
98
8
10
18
11
19
9
7
14
48
65
93
13
23
25
1
8
32
68
IV
XXVII
XXII
355
X
20°
40
XXV
116,95
215,5
XXII
XXXI
3.79
Art der Änderung
Änderung
Jahr
Mon.
Name
Änd. Zust.
kommt vor
ab Serie
Datum
Name
Gez.:
5.7.79
Gepr.
Norm./Richtl.
Benennung:
URHEBERSCHUTZ NACH DIN 34
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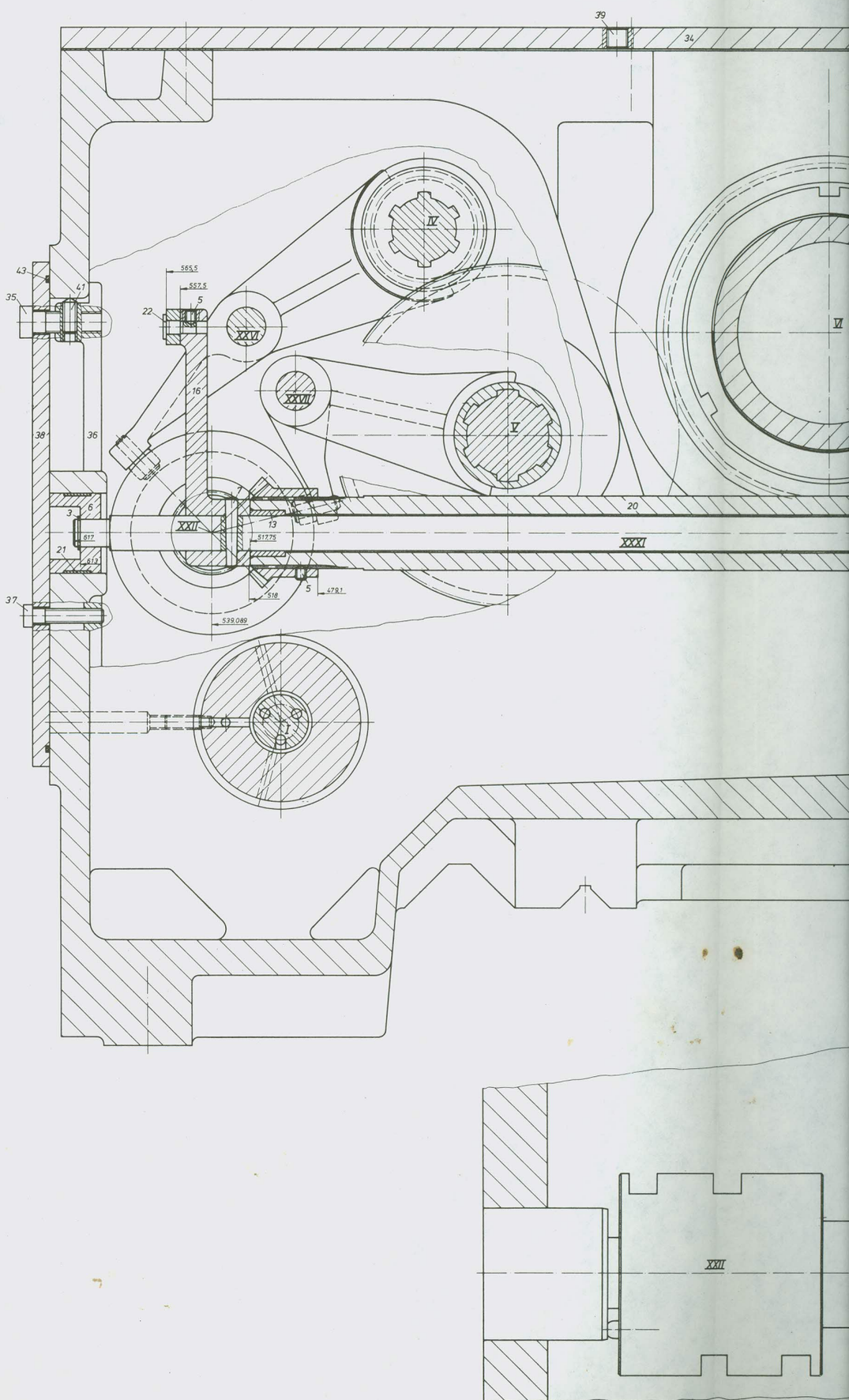
Schriftgröße DIN 16/17
Linienart DIN 15
Werkstoff
Roh-/Ausgangsteil
Modell-Nr.
Serie 547
Paßmaß
Abmaße μm
Fertigung nach Reihe : 3
GILDEMEISTER
HEIDENREICH & HARBECK
HAMBURG
Maßstab
1:1
Teilelendliste
Klassifikations-Nr. (Zeichnungs-Nr.)
79.1248.01.00-0100
Blatt v. Blatt
02 04 0
Ers. für:
Ers. durch:
Urspr./Abw.
Art.-Nr.:

2	40.1222.01.33-0500 (4)	1	M6x10 DIN7984
4	40.1248.01.31-0600 (2)	3	16x1 DIN471
6	70.1036.01.31-2100 (4)	5	M6x8 DIN914
8	70.1248.01.31-0100 (2)	7	6x40 DIN7978
10	70.1248.01.31-0200 (3)	9	2x6 DIN1476
12	70.1248.01.31-0300 (3)	11	AS 6x6x25 DIN6885
14	70.1248.01.31-0500 (3)	13	20x26x20 DIN1850
16	70.1248.01.31-0700 (4)	15	12x100 VDF 5323
18	70.1248.01.31-0800 (4)	17	KN 32 DIN 319 schw.
20	78.1248.01.31-0100 (3)	19	35x1.5 DIN 471
22	70.0110.04.08-0700 (4)	21	BN 45x15
		23	F 63 VDF 5438
		25	35x4.5 DIN 988

32	40.1248.01.20-0200 (2)	33	M8x20 DIN 7984
34	40.1248.01.20-0300 (2)	35	M12x25 DIN7984
36	70.1037.01.20-1400 (3)	37	M8x40 DIN7984
38	70.1238.01.98-0100 (3)	39	M12x12 DIN 913
		41	M8x20 DIN 914
		43	Ø31/16701g



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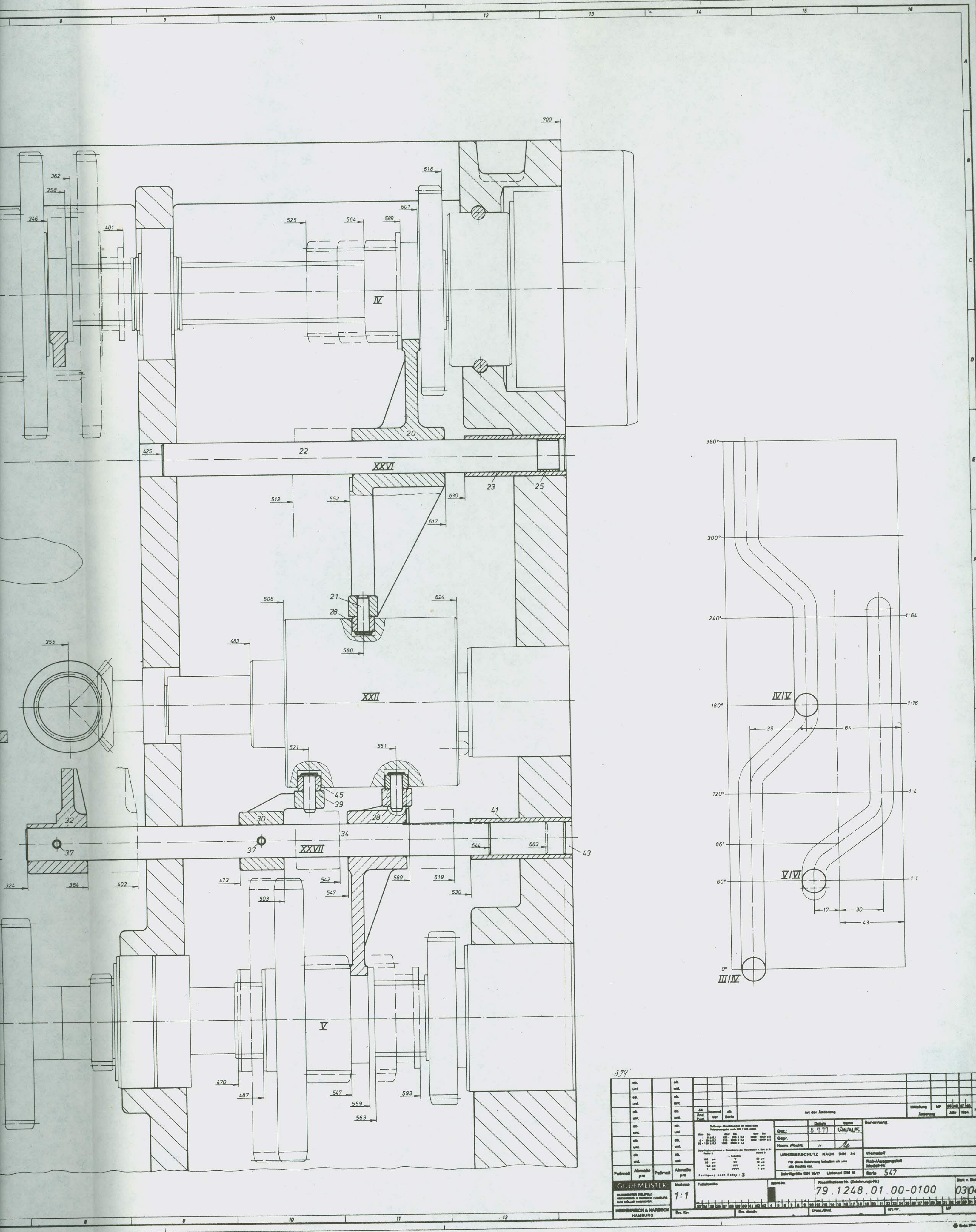

IV
XXVI
XXII
XXVII
V
IV/V
V/VI
III/IV
360°
300°
240°
180°
120°
85°
60°
0°
1:64
1:16
1:4
1:1
39
64
17
30
43
3.79
Art der Änderung
Datum
Name
Gez.: 5.7.77
Gepr.
Norm./Richtl.
Benennung:
URHEBERSCHUTZ NACH DIN 34
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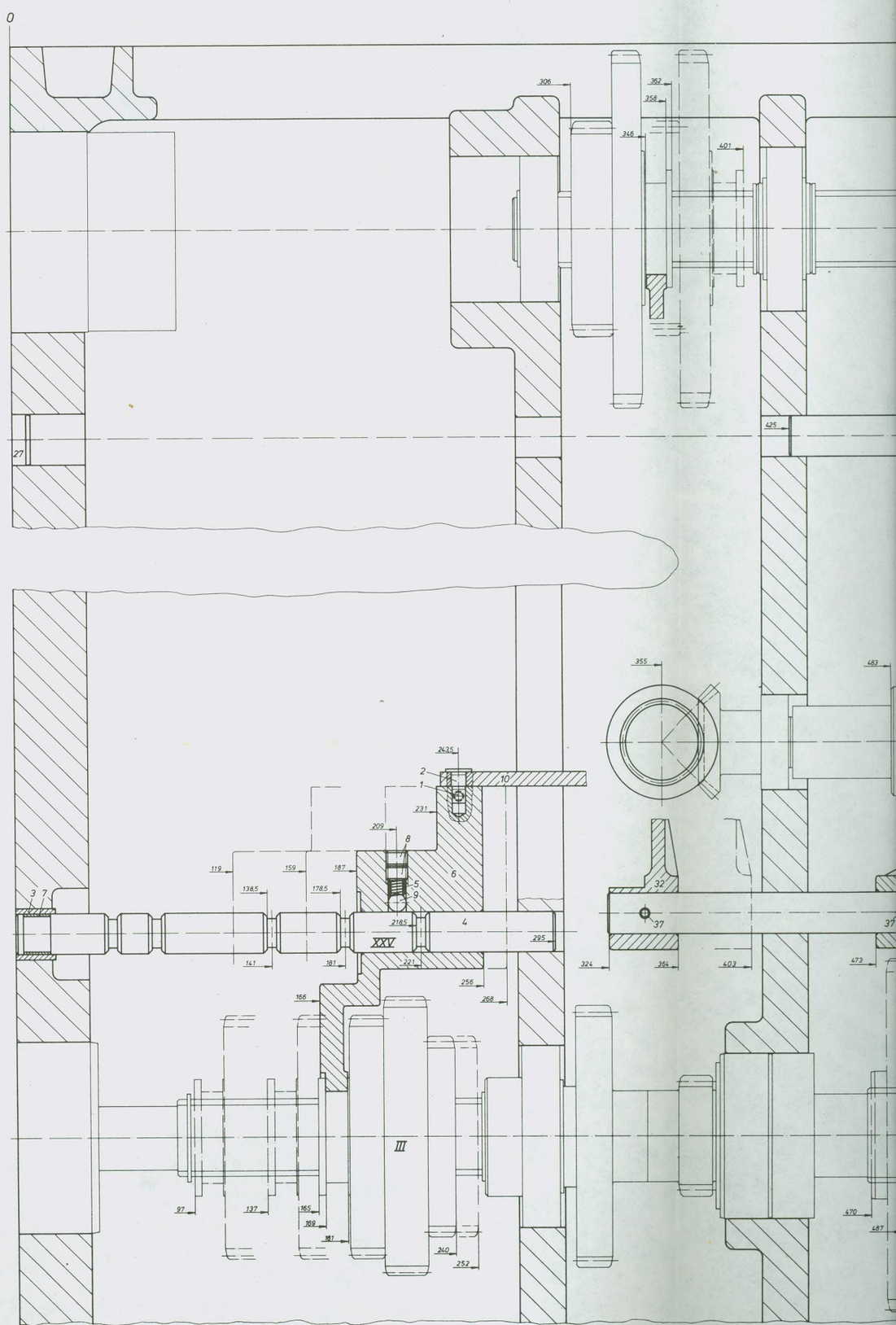
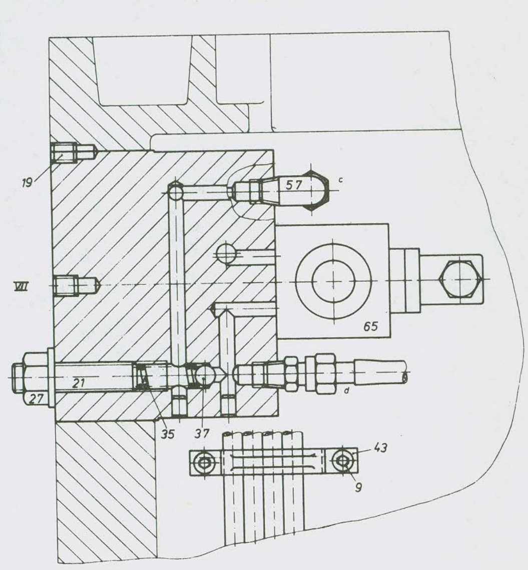
Schriftgröße DIN 16/17
Linienart DIN 15
Werkstoff
Roh-/Ausgangsteil Modell-Nr.
Serie 547
Paßmaß
Abmaße µm
Fertigung nach Reihe: 3
GILDEMEISTER
HEIDENREICH & HARBECK HAMBURG
Maßstab
1:1
Teilefamilie
Ident-Nr.
Klassifikations-Nr. (Zeichnungs-Nr.)
79.1248.01.00-0100
Ers. für:
Ers. durch:
Urspr./Ähnl.
Art.-Nr.:



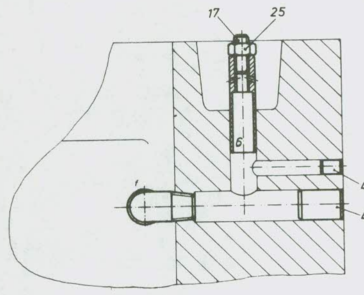
		XXV	
2	70.0110.04.08 - 0700 (4)	1	M6x8 DIN 914
4	70.1036.01.25 - 0100 (3)	3	22x28x2.00 DIN 1850
6	70.1036.01.25 - 0300 (3)	5	1.25x8x15 VDF 5400
8	70.1036.01.25 - 0800 (4)	7	BN 22x15
10	70.1248.01.25 - 0100 (4)	9	10 KL3 DIN 5401
		XXVI	
20	70.1036.01.26 - 0101 (3)	21	8h6x25 DIN 1434
22	70.1036.01.26 - 0200 (4)	23	22x28x7.00 GG DIN 1850
		25	BN 22x15
		27	A28x10 VDF 5220
		29	16 VDF 5810
		XXVII	
28	70.1036.01.27 - 0201 (3)	37	6x40 DIN 1481
30	70.1036.01.27 - 0302 (3)	39	8h6x25 DIN 1434
32	70.1036.01.27 - 0400 (4)	41	22x28x7.00 DIN 1850
34	70.1036.01.27 - 0500 (4)	43	B22x6 ESP 5220
		45	16 VDF 5810

743003 *

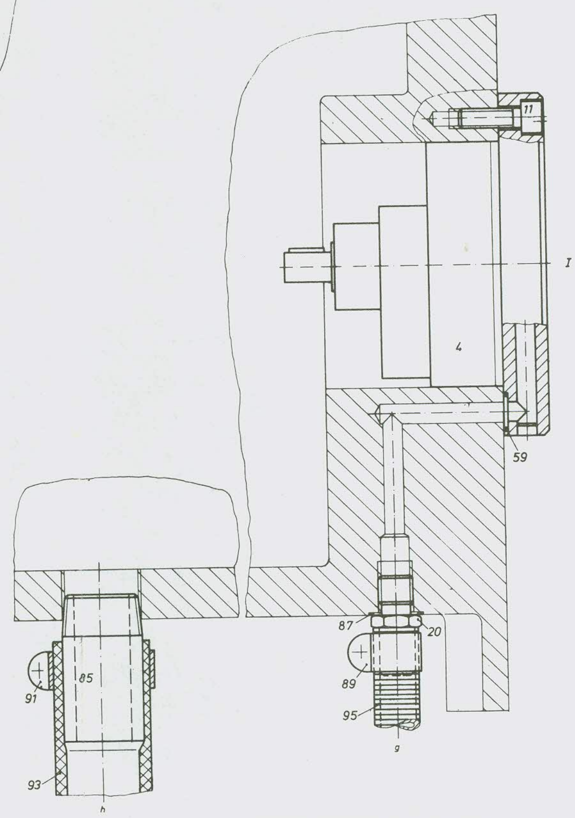
C - D



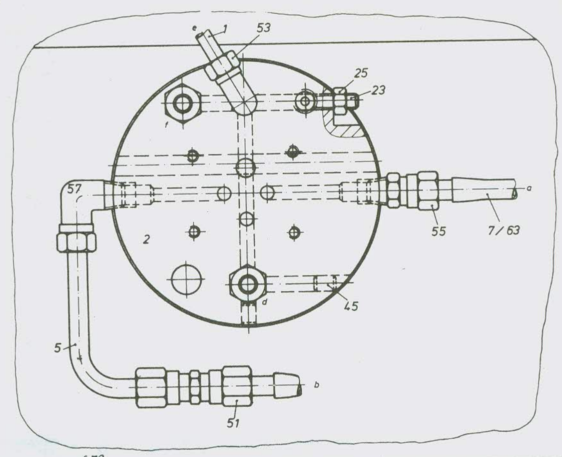
E - F



G - H



Z



2	70.1248.01.29-0100	(2)
4	40.1248.01.29-0200	(2)
6	70.1738.66.29-0200	(4)

1	5x1	VDF 5720
3	6x1	VDF 5720
5	8x1	VDF 5720
7	TR 9/6 B	
9	M 5x10	DIN 912
11	M 8x25	DIN 912
13	M 4x 6	DIN 7984
15	M 6x10	DIN 7984
17	M 6x16	DIN 913
19	M 8x10	DIN 913
21	M 12x50	DIN 913
23	M 6x20	DIN 914
25	M 6	DIN 934
27	M 12	
29	30	HuH 566
31	40	VDF 5741
33	4x150 LG	
35	1,25x8x32	VDF 5400
37	8 KL 3	DIN 5401
39	1x 5	DIN 72571
41	1x 8	DIN 72571
43	5x 8	DIN 72573
45	6	ESP 5225
47	12	ESP 5225
49	M 10x 1	DIN 908
51	ELL 8	DIN 2353
53	FLL 6	DIN 2353
55	ALL 8	DIN 2353
57	FLL 8	DIN 2353
59	OR 10x 3	HuH 313
61	A 10x13,5	DIN 7603
63	BE 8-L-6	
65	S6 VH 10G 4/2	

16	40.1248.01.99-0100	(3)
18	70.1036.01.99-0202	(4)
20	70.1222.02.01-0700	(4)

75	M 16x60	DIN 912
77		
79	M 16x110	DIN 912
81	M 5x 7	HuH 304
83	M 42x1,5	DIN 1804
85	Z 1x60	HuH 372
87	OR 16x 3	HuH 313
89	S 18x12	HuH 536
91	S 40x15	HuH 536
93	30x 5	
95	14,5x18,7	

3.79

Paßmaß | Abmaße µm | Paßmaß | Abmaße µm

Änd. Zust. 44 | kommt vor | ab Serie | Art der Änderung | Mitteilung Änderung | MF | Jahr | Mon.

Fertigung nach Reihe: 3

	Datum	Name
Gez.:	28.6.77	Gollub
Gepr.	5.7.77	Wirtz.
Norm./Richtl.	"	

URHEBERSCHUTZ NACH DIN 34
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Schriftgröße DIN 16/17 Linienart DIN 15

Benennung:

Werkstoff

Roh-/Ausgangsteil Modell-Nr.

Serie 547

GILDEMEISTER
GILDEMEISTER BIELEFELD
HEIDENREICH & HARBECK HAMBURG
MAX MÜLLER HANNOVER

HEIDENREICH & HARBECK HAMBURG

Maßstab 1:2,5 (1:1)

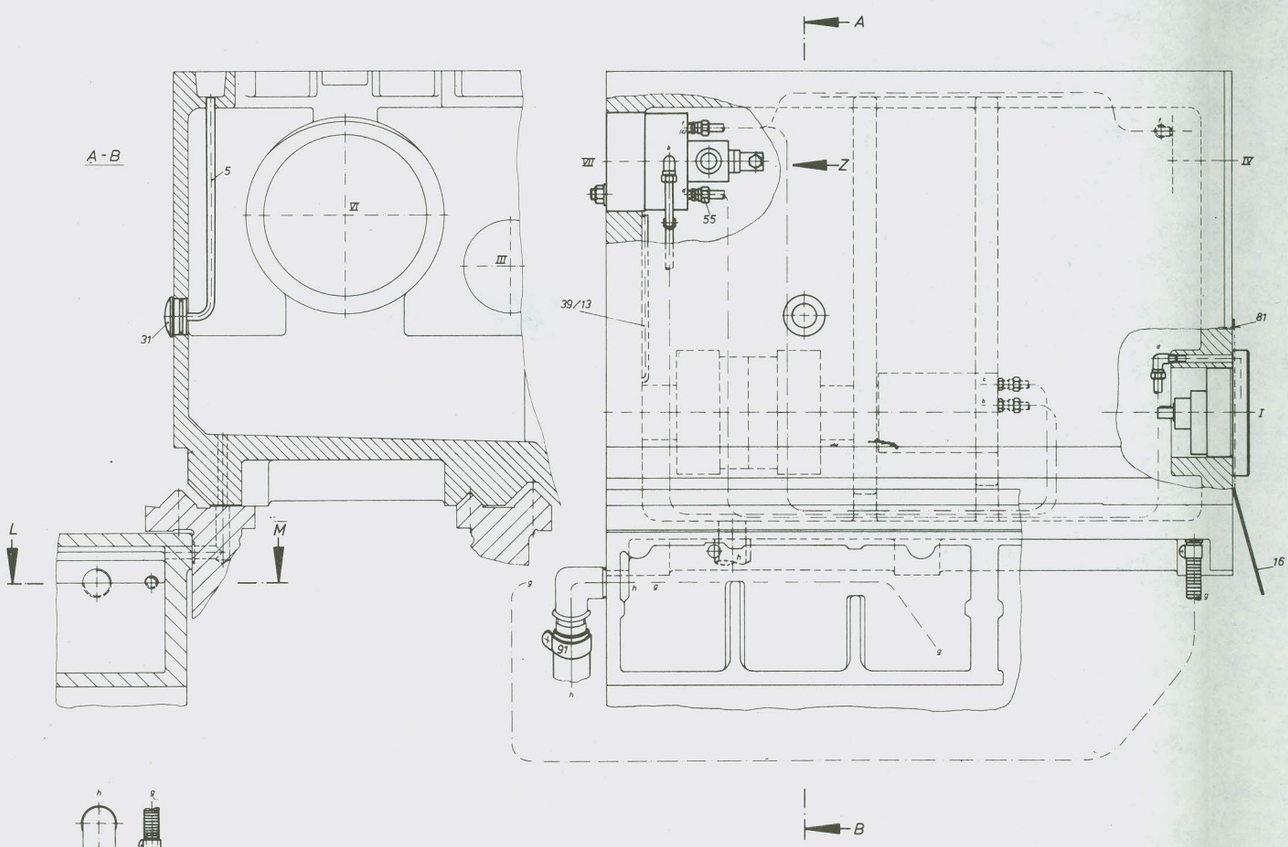
Teilefamilie

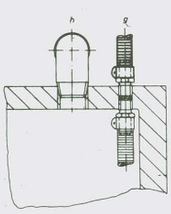
Ident-Nr.

Klassifikations-Nr. (Zeichnungs-Nr.) 79.1248.01.00-0100

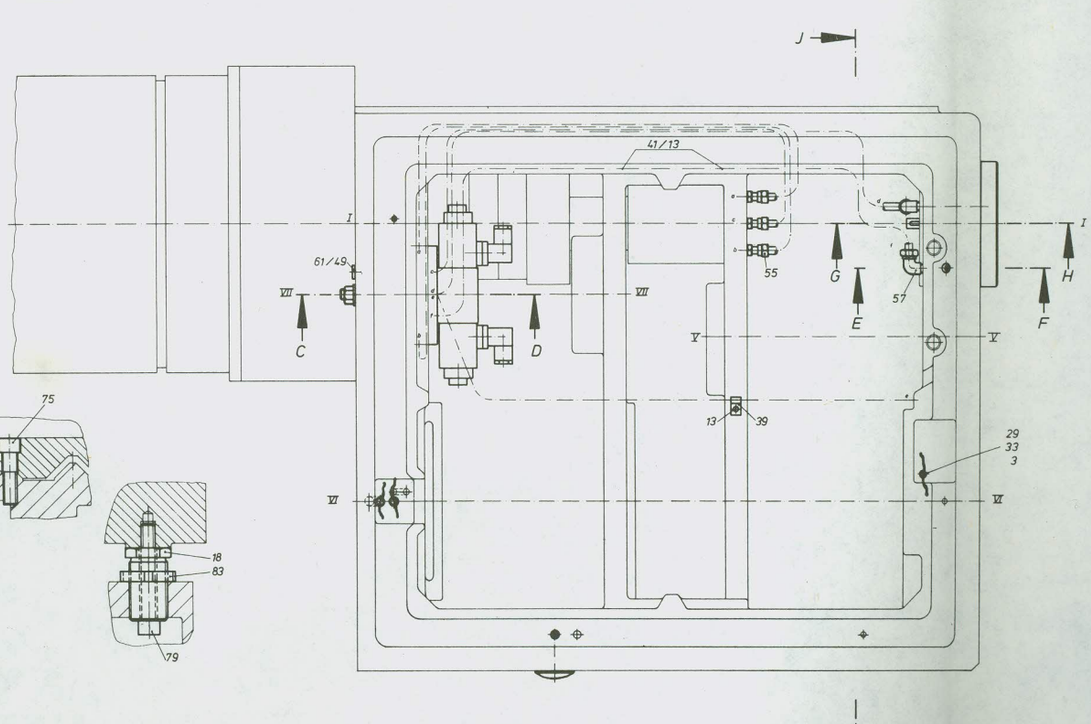
Blatt v. 04

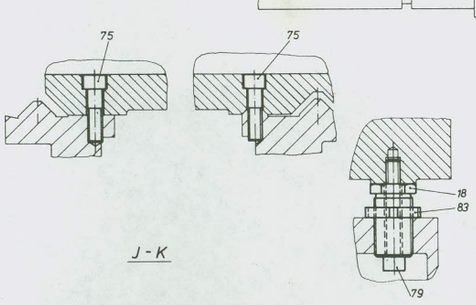
Ers. für: | Ers. durch: | Urspr./Abtl. | Art.-Nr.: | MF



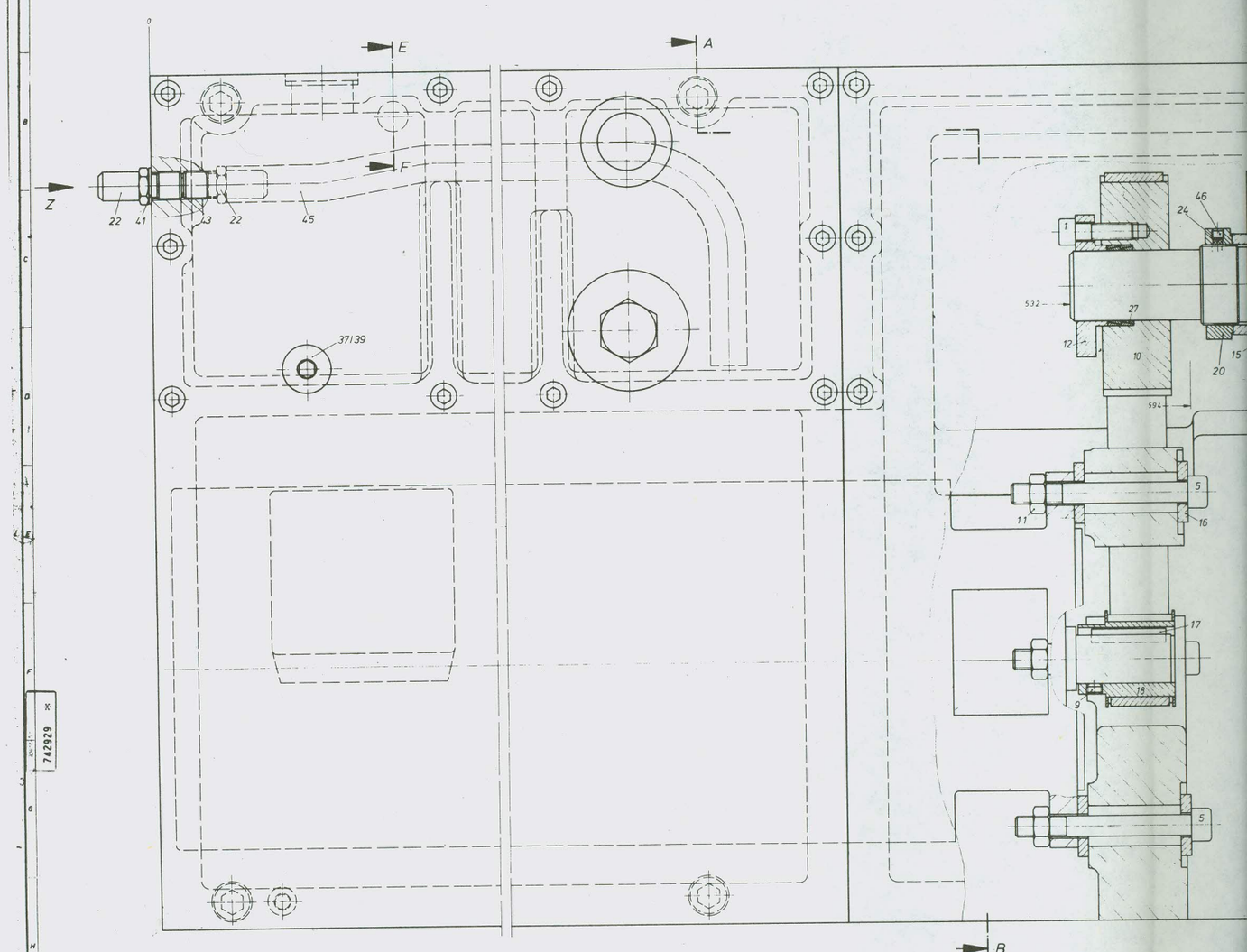


L - M





J - K



742929 *

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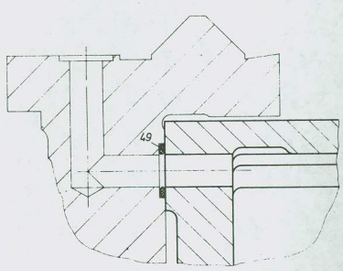
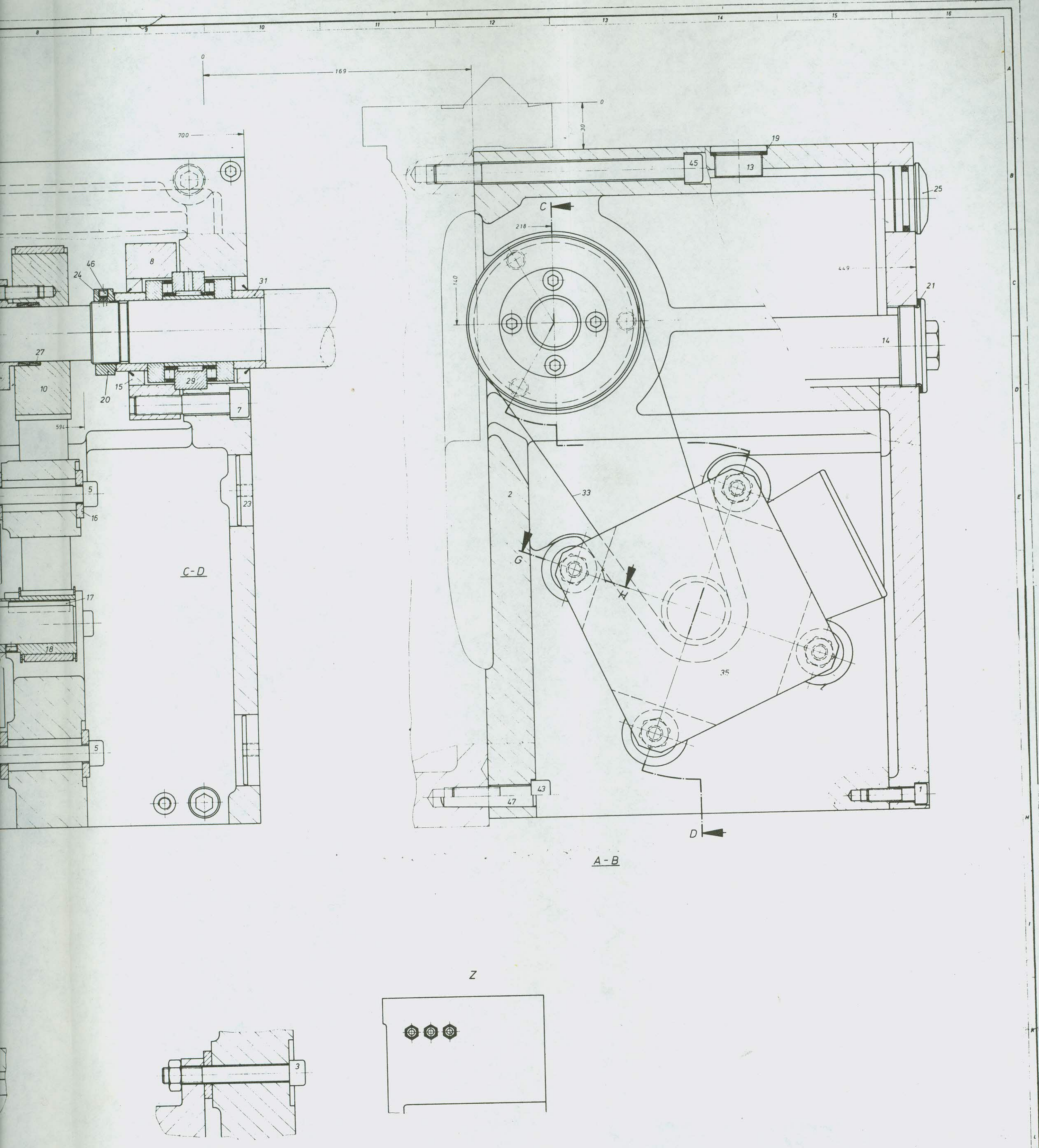
4	70 1248 02 01 - 0200 (3)
6	70 1248 02 01-0300 (3)
8	70 1248 02 01-0400 (3)
10	40 1248 02 01-0500 (3)
12	70 1248 02 01-0600 (4)
14	40 1248 02 01-0700 (4)
16	70 1248 04 01-0300 (4)
18	40 1248 04 01-0400 (4)
20	701243.02.01-0300(4)
22	70 1222 02 01-0700 (4)
24	701243.0201-0400(4)

43	M 12 × 50 DIN 912
45	M 12 ×160 DIN 912
47	12×60 DIN 7978
49	R 18 × 3 HuH 313

1	M 8 × 30 DIN 912
3	M 10 × 80 DIN 912
5	M 10 × 90 DIN 912
7	M 12 × 60 DIN 912
9	AM 8 × 8 DIN 913
11	M 10 DIN 934
13	M 30 × 1,5 DIN 908
15	A 50 × 68 × 8 DIN 3760
17	A 8×7×40 DIN 6885
19	A 30 × 36 CU DIN 7603
21	50×3
23	B 47 × 10 VDF 5220
25	40 VDF 5741
27	35 × 40 RFN 8006
29	ZARN 4075
31	IR 40×50×20
33	T 10 I 660 B 32
35	IHU 3075 SSW
37	M 18x1,5 DIN 908
39	A 18×22 DIN 7603
41	A 14×18 DIN 7603
43	A 8×11,5 DIN 7603
45	14,5×18,7 5501g
46	M6×6 DIN 913



E-F



3.79

Paßmaß	Abmaße µm	Paßmaß	Abmaße µm
	ob. / unt.		ob / unt.
	ob. / unt		ob / unt
	ob / unt		ob. / unt.
	ob / unt		ob / unt
	ob. / unt		ob. / unt.
	ob / unt		ob / unt.

44 Änd Zust. | kommt vor | ab Serie | Art der Änderung | Mitteilung Änderung | MF | 45 46 Jahr | 47 48 Mon | Name

Zulässige Abweichungen für Maße ohne Toleranzangabe nach DIN 7168 mittel

Oberflächenzeichen u. Zuordnung der Rauhtiefen n. DIN 3141

Fertigung nach Reihe 2

	Datum	Name
Gez.	24.8.76	[signature]
Gepr.		
Norm /Richtl.	4.10.76	[initials]

URHEBERSCHUTZ NACH DIN 34
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Schriftgröße DIN 16/17 Linienart DIN 15

Benennung:

Werkstoff

Roh-/Ausgangsteil
Modell-Nr.

Serie 547

GILDEMEISTER
GILDEMEISTER BIELEFELD
HEIDENREICH & HARBECK HAMBURG
MAX MÜLLER HANNOVER

HEIDENREICH & HARBECK
HAMBURG

Maßstab 1:1

Teilefamilie

Ident-Nr

Klassifikations-Nr. (Zeichnungs-Nr.)
9.1248.02.01-0100

Blatt v. Blatt

0

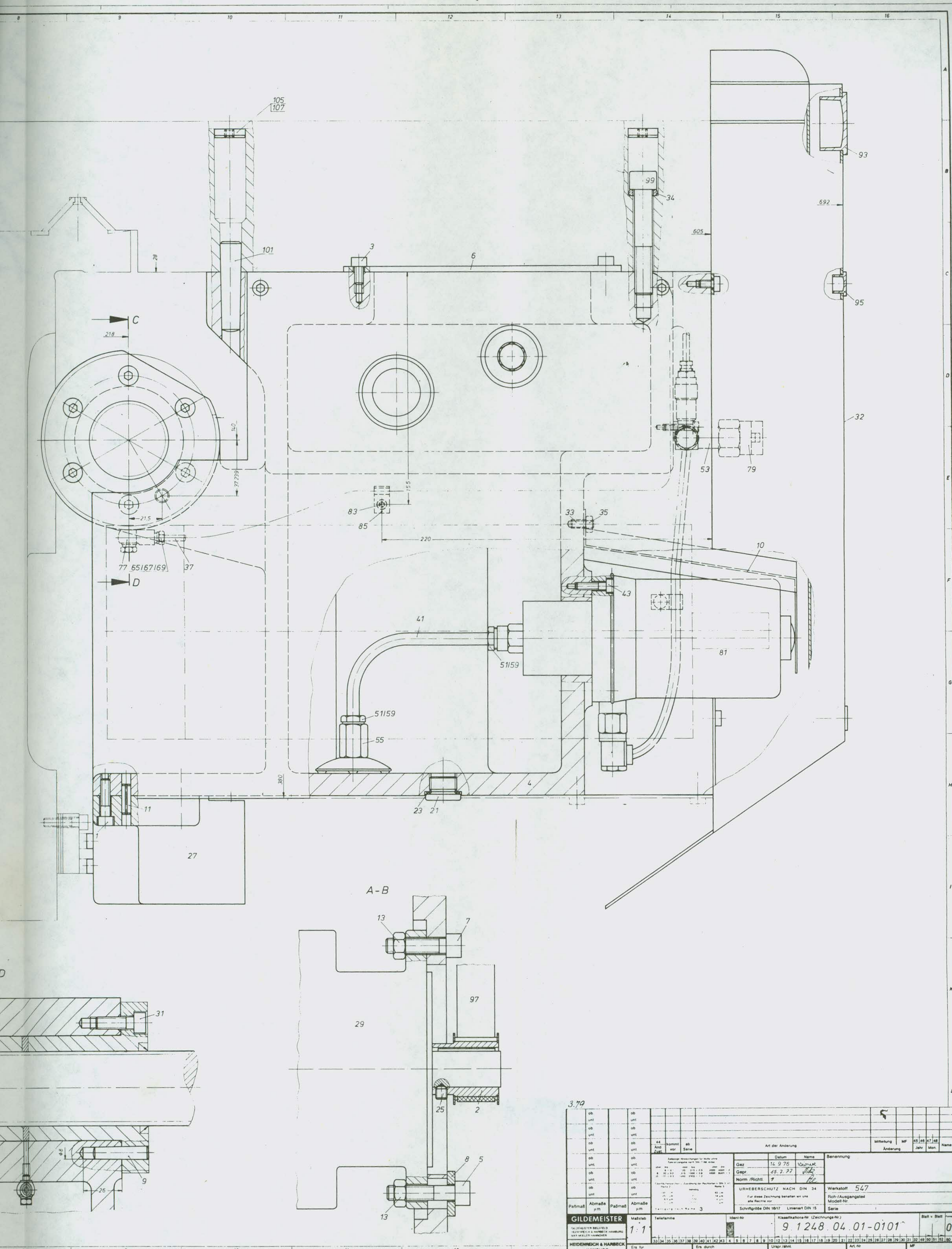
Ers. für

Ers. durch

Urspr./ähnl.

Art.-Nr.

MF



3.79

Paßmaß	Abmaße µm	Paßmaß	Abmaße µm
	ob / unt		ob / unt
	ob / unt		ob / unt
	ob / unt		ob / unt
	ob / unt		ob / unt
	ob / unt		ob / unt
	ob / unt		ob / unt

44 Änd. Zust.	kommt vor	ab Serie	Art der Änderung	Mitteilung Änderung	MF	45 46 Jahr	47 48 Mon.	Name

Fertigung nach Reihe 3

	Datum	Name
Gez	14.9.76	Weimert
Gepr.	15.7.77	Nidz
Norm./Richtl.	7	Be

URHEBERSCHUTZ NACH DIN 34
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Schriftgröße DIN 16/17 Linienart DIN 15

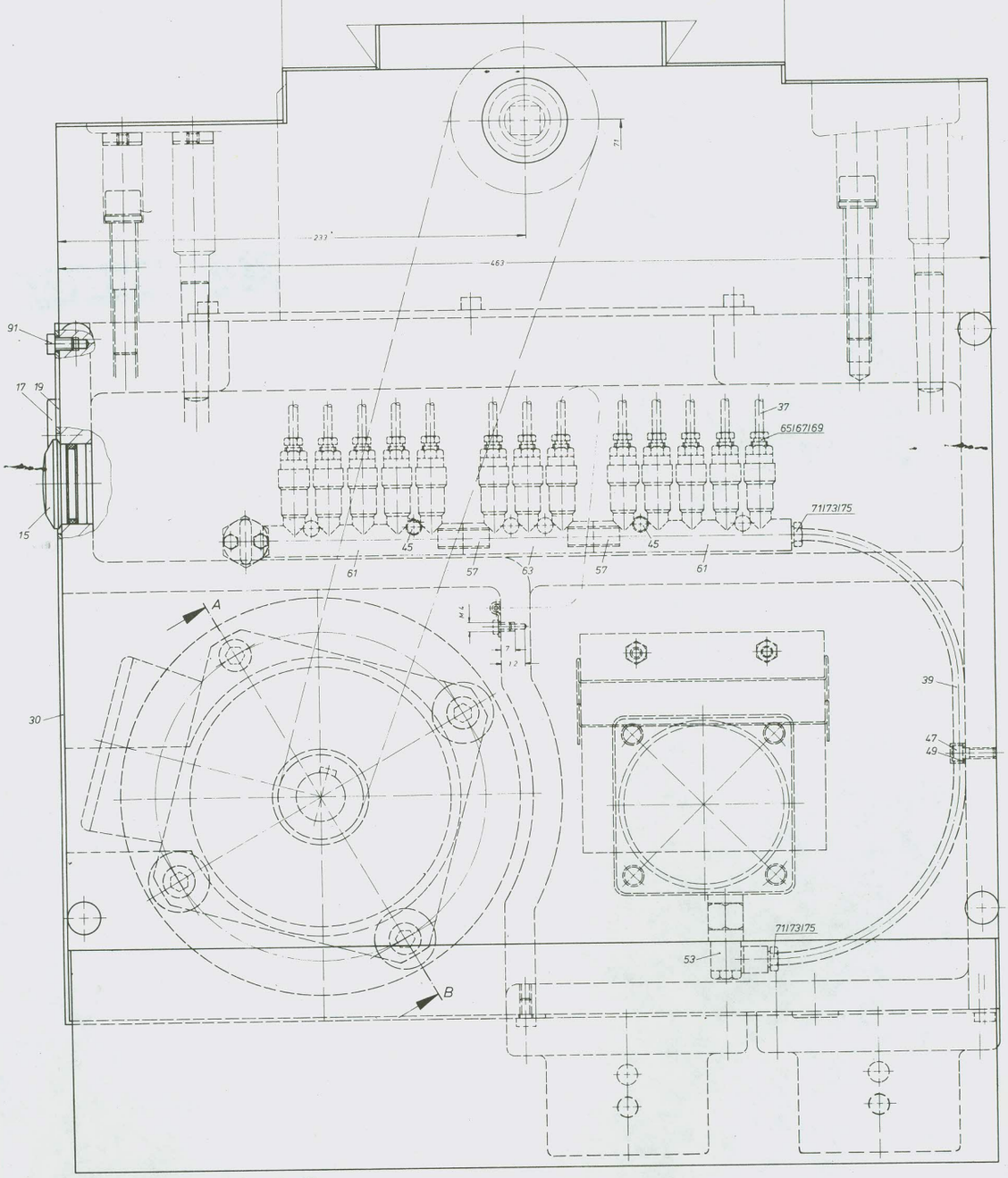
Benennung:
Werkstoff 547
Roh-/Ausgangsteil Modell-Nr.
Serie

GILDEMEISTER
GILDEMEISTER BIELEFELD
HEIDENREICH & HARBECK HAMBURG
MAX MÜLLER HANNOVER
HEIDENREICH & HARBECK HAMBURG

Maßstab 1:1
Teilefamilie
Ident-Nr
Klassifikations-Nr. (Zeichnungs-Nr.) 9.1248.04.01-0101
Blatt v. Blatt
0

Ers. für | Ers. durch | Urspr./ähnl. | Art.-Nr | MF

Gebr. Widmann 553



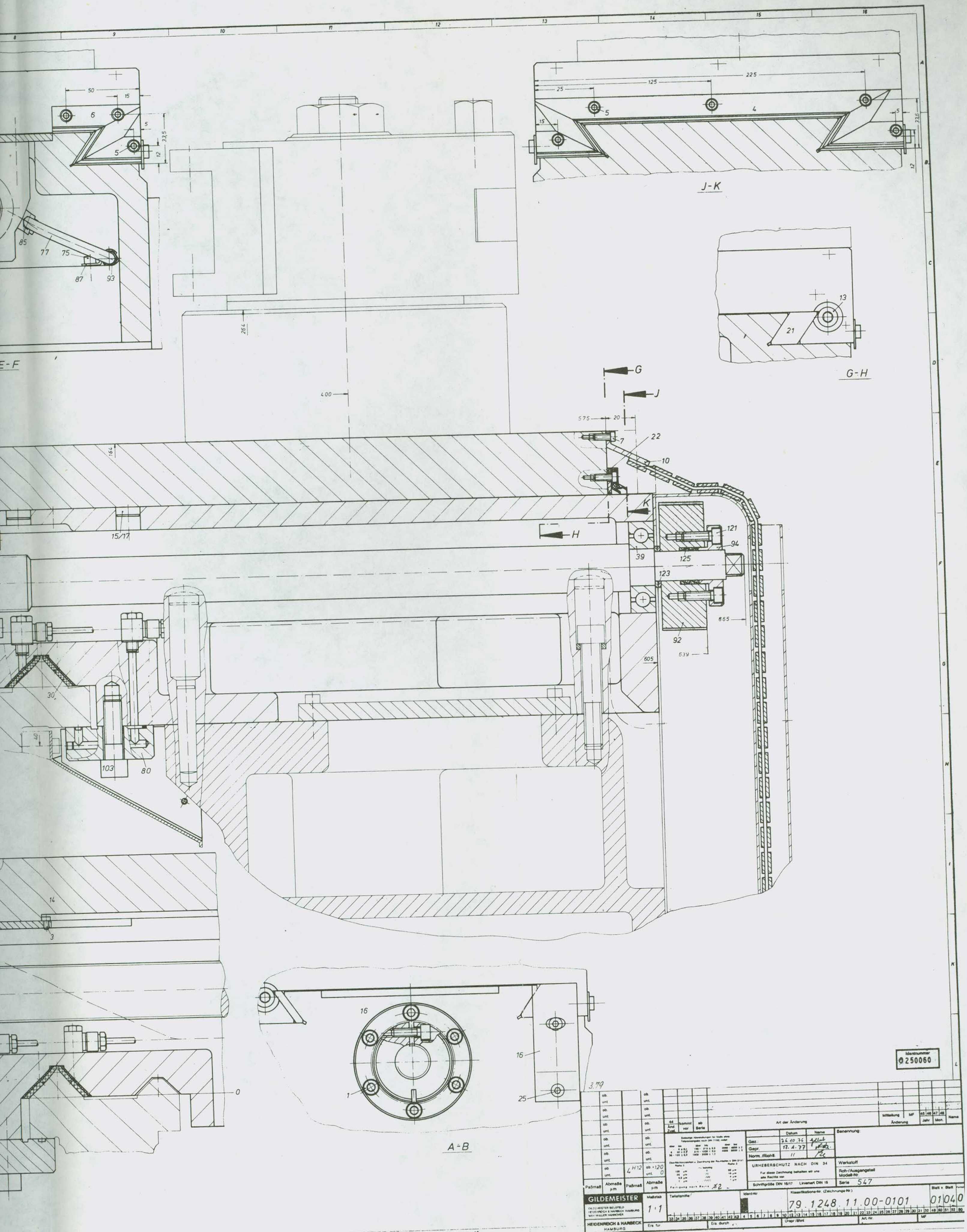
2	40.1248.04.01-0400(4)	1	M6x25 DIN912
4	70.1248.04.01-0101(1)	3	M6x12 DIN912
6	70.1248.04.01-0500(2)	5	M10x45 DIN912
8	70.1248.04.01-0300(4)	7	M10x40 DIN912
10	40.1222.04.01-0400(2)	9	8x36 DIN 7978
		11	6x20 DIN1481
		13	M10 DIN934
		15	40 VDF 5741
		17	M30x1.5 DIN 908
		19	A30x36 DIN 7603
		21	M18x1.5 DIN 908
		23	A18x22 DIN 7603
		25	M5x8 DIN 914
		27	R2 D16 DIN 43 697
		29	1 HU 3071
		31	M8x25 DIN912
		33	M6x16 DIN913
		35	M6 DIN934

30	40.1248.04.99-0100(2)	91	M6x10 DIN7984
32	40.1248.04.99-0200(10)	93	3/8 HuH 338
34	70.1910.11.01-0600(4)	95	1/2 HuH 338
		97	1.101.920 25 Bar
		99	M12x10 DIN912
		101	12x60 DIN7978

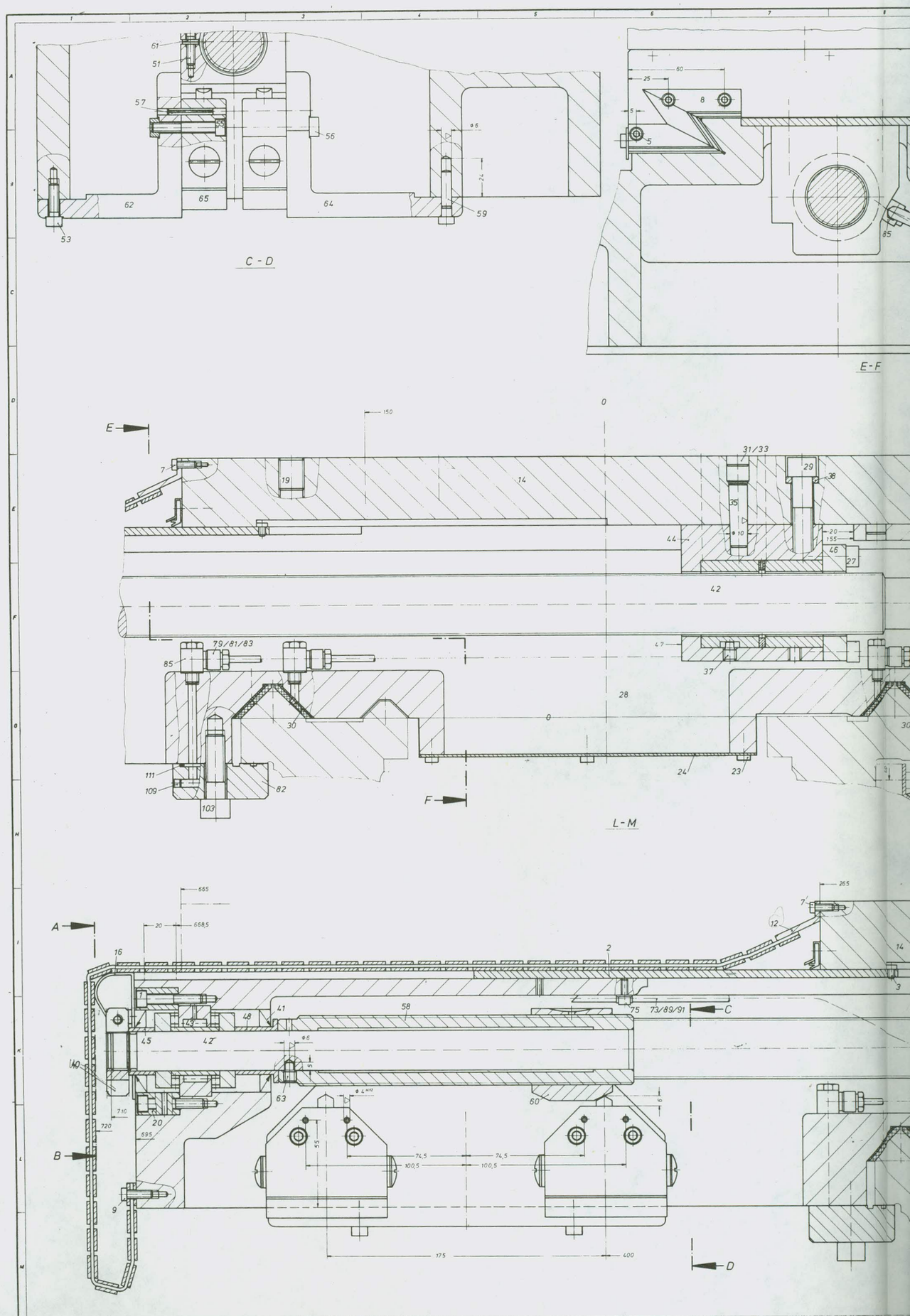
		103	
		105	B20x8 VDE 5220
		107	VESZ [illegible]-3

37	4x0.75	41	8x1
39	6x1	43	M5x20 DIN912
		45	M4x20 DIN912
		47	M5x12 DIN912
		49	606 010
		51	408 001
		53	506 140
		55	208 555
		57	406 233
		59	408 202
		61	345 400-4
		63	343 400-4
		65	404 611
		67	404 612
		69	404 603
		71	406 603
		73	406 611
		75	406 612
		77	504 162
		79	P-66 S12-2
		81	MFE 5
		83	M4x6 DIN 7984
		85	1x4 DIN 7257

C-D



E-F
J-K
G-H
A-B
Identnummer 0250060
URHEBERSCHUTZ NACH DIN 34
Für diese Zeichnung behalten wir uns alle Rechte vor
Schriftgröße DIN 16/17 Linienart DIN 15
Gez. 26.10.76
Gepr. 17.1.77
Serie 547
GILDEMEISTER
GILDEMEISTER BIELEFELD
HEIDENREICH & HARBECK HAMBURG
MAX MÜLLER HANNOVER
HEIDENREICH & HARBECK HAMBURG
Maßstab 1:1
Klassifikations-Nr. (Zeichnungs-Nr.)
79.1248.11.00-0101
Blatt v. Blatt 01 04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E - F
L - M
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B
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D
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53
60
25
8
5
85
150
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29
38
35
44
46
27
42
19
14
7
79/81/83
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47
37
28
30
111
109
82
103
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668,5
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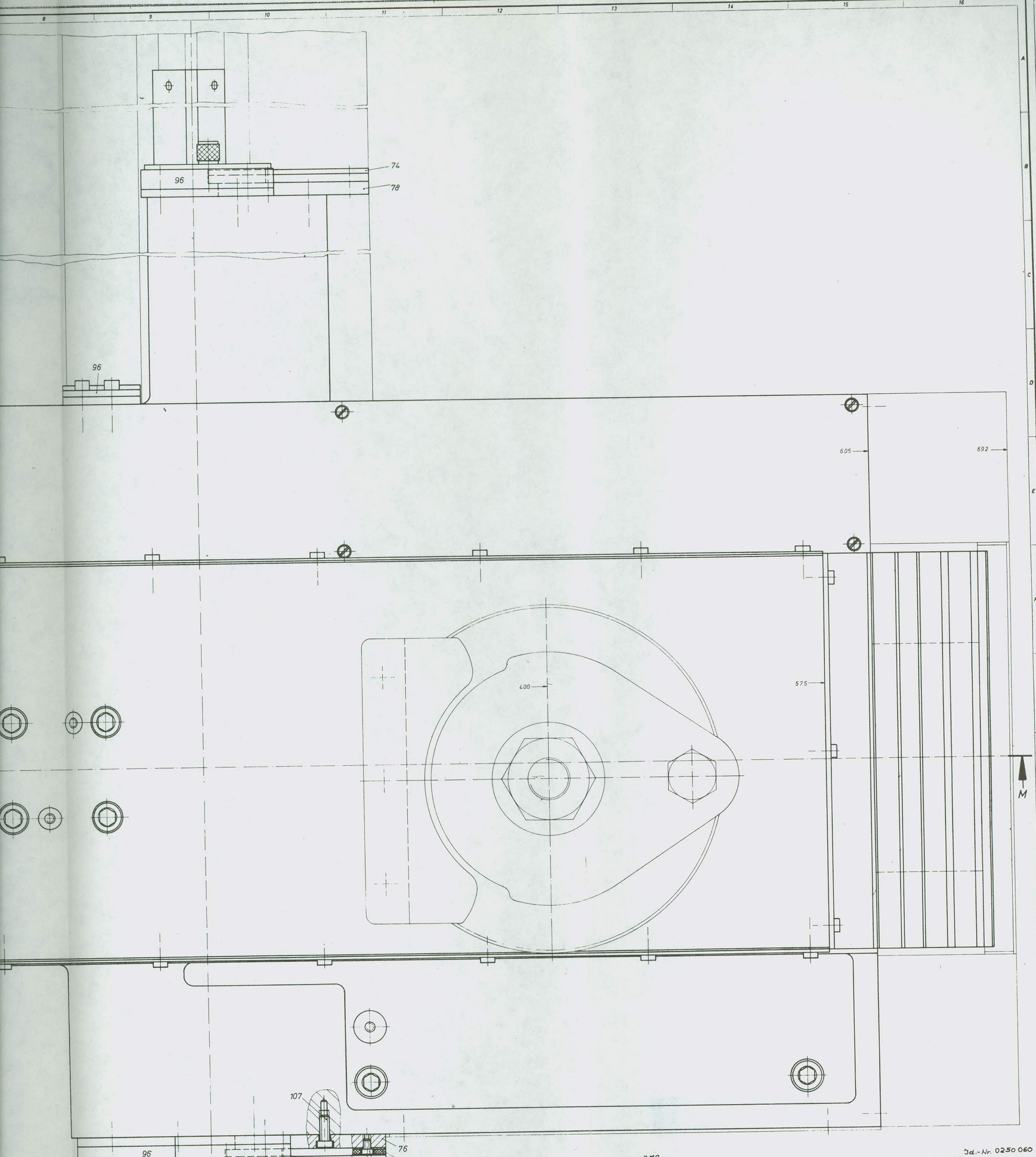
9



3.79

Id.-Nr. 0250 060

Paßmaß	Abmaße µm	Paßmaß	Abmaße µm
	ob. / unt.		ob. / unt.
	ob. / unt.		ob. / unt.
	ob. / unt.		ob. / unt.
	ob. / unt.		ob. / unt.
	ob. / unt.		ob. / unt.
	ob. / unt.		ob. / unt.

44 Änd. Zust.	kommt vor	ab Serie	Art der Änderung	Mitteilung Änderung	MF	45 46 Jahr	47 48 Mon.	Name

Zulässige Abweichungen für Maße ohne Toleranzangabe nach DIN 7168, mittel

Oberflächenzeichen u. Zuordnung der Rauhtiefen n. DIN 3141

Fertigung nach Reihe 2

	Datum	Name
Gez.:	26.10.76	Gollub
Gepr.	17.1.77	Nidz.
Norm./Richtl.	"	Re

URHEBERSCHUTZ NACH DIN 34

Für diese Zeichnung behalten wir uns alle Rechte vor.

Schriftgröße DIN 16/17 Linienart DIN 15

Benennung:

Werkstoff

Roh-/Ausgangsteil Modell-Nr.

Serie

GILDEMEISTER

GILDEMEISTER BIELEFELD
HEIDENREICH & HARBECK HAMBURG
MAX MÜLLER HANNOVER

HEIDENREICH & HARBECK HAMBURG

Maßstab 1:1

Teilefamilie

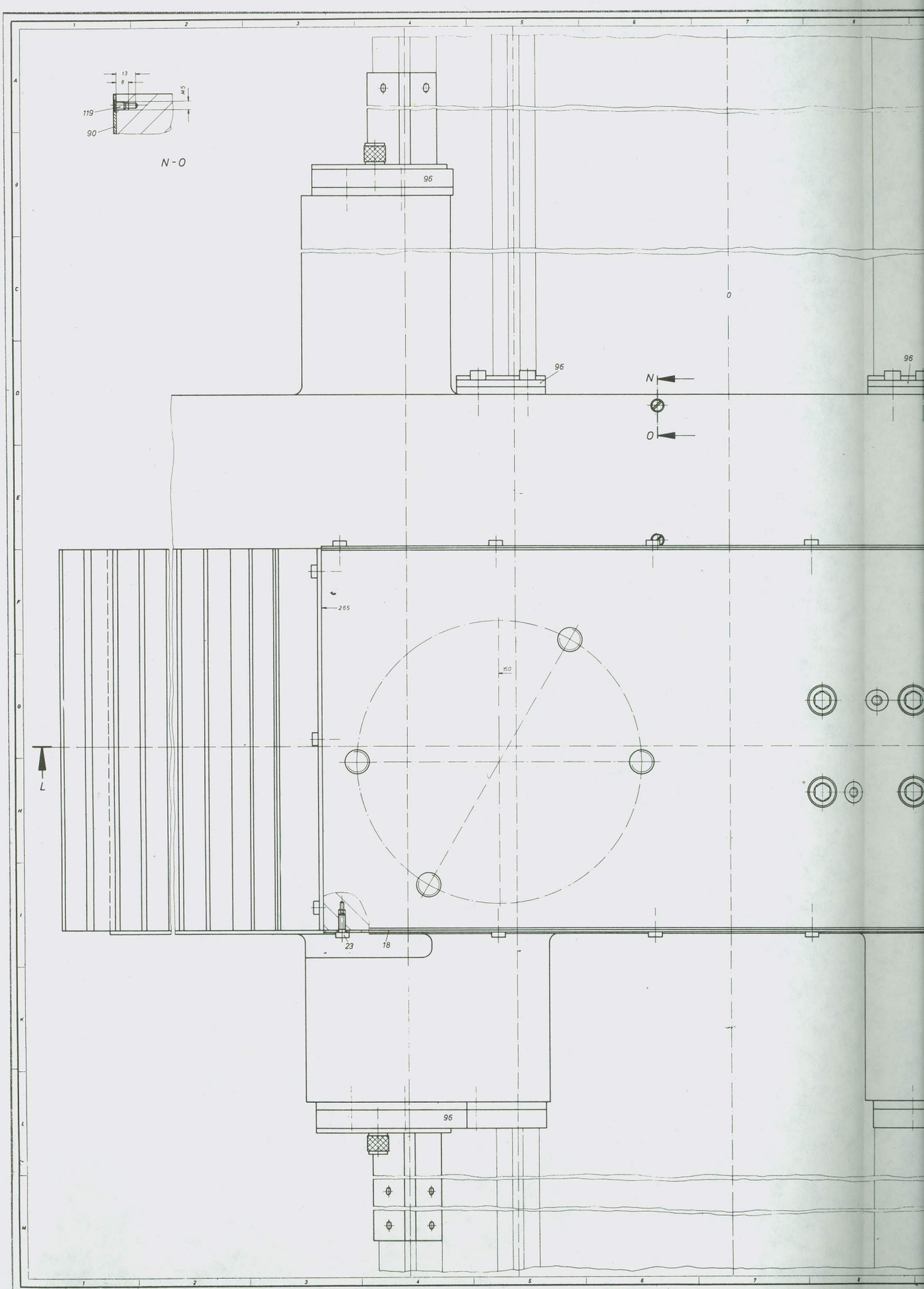
Ident-Nr.

Klassifikations-Nr. (Zeichnungs-Nr.) 79.1248.11.00-0101

Blatt v. Blatt 0204

Format 0

Ers. für: | Ers. durch: | Urspr./ähnl. | Art.-Nr. | MF


13
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M5
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96
96
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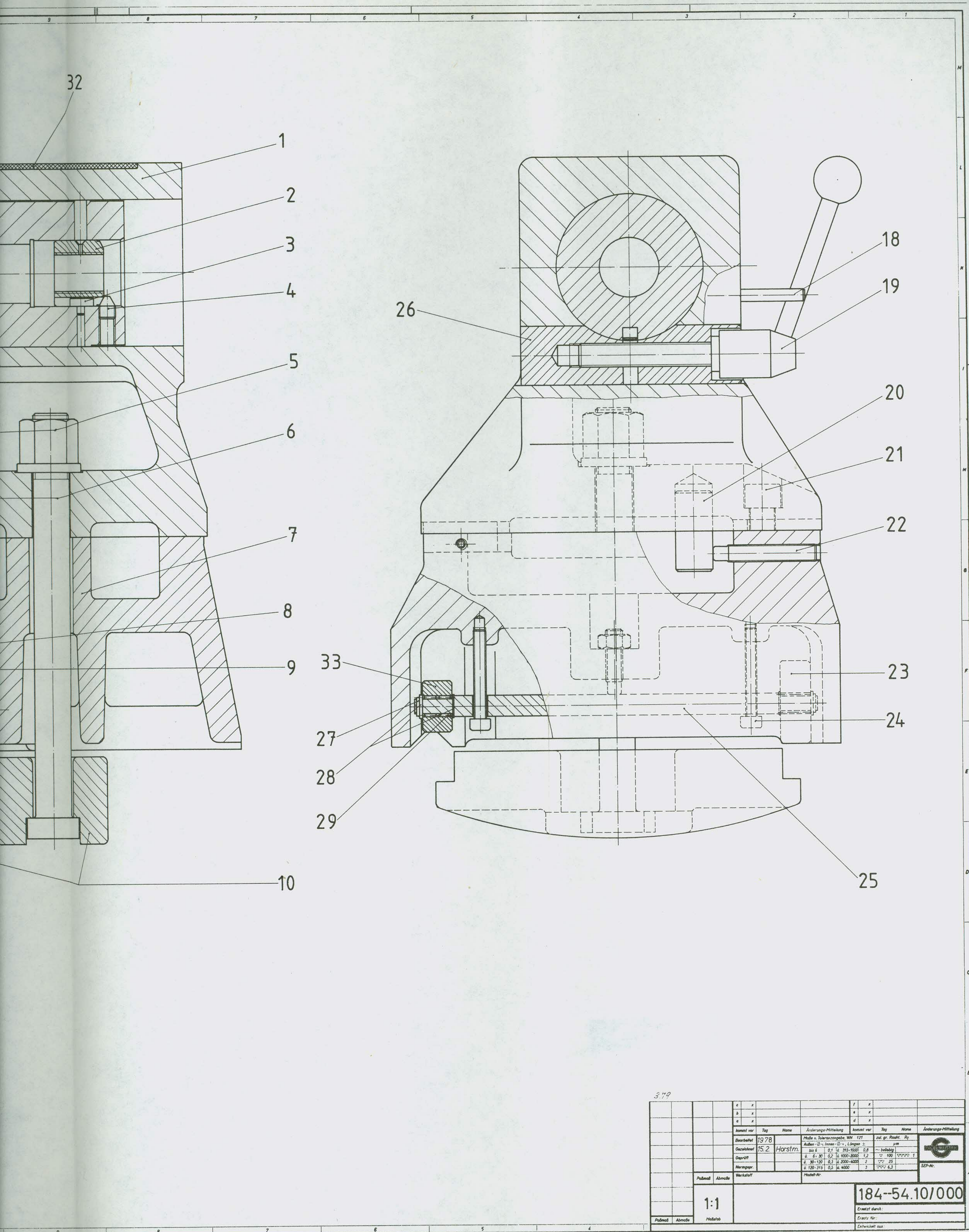
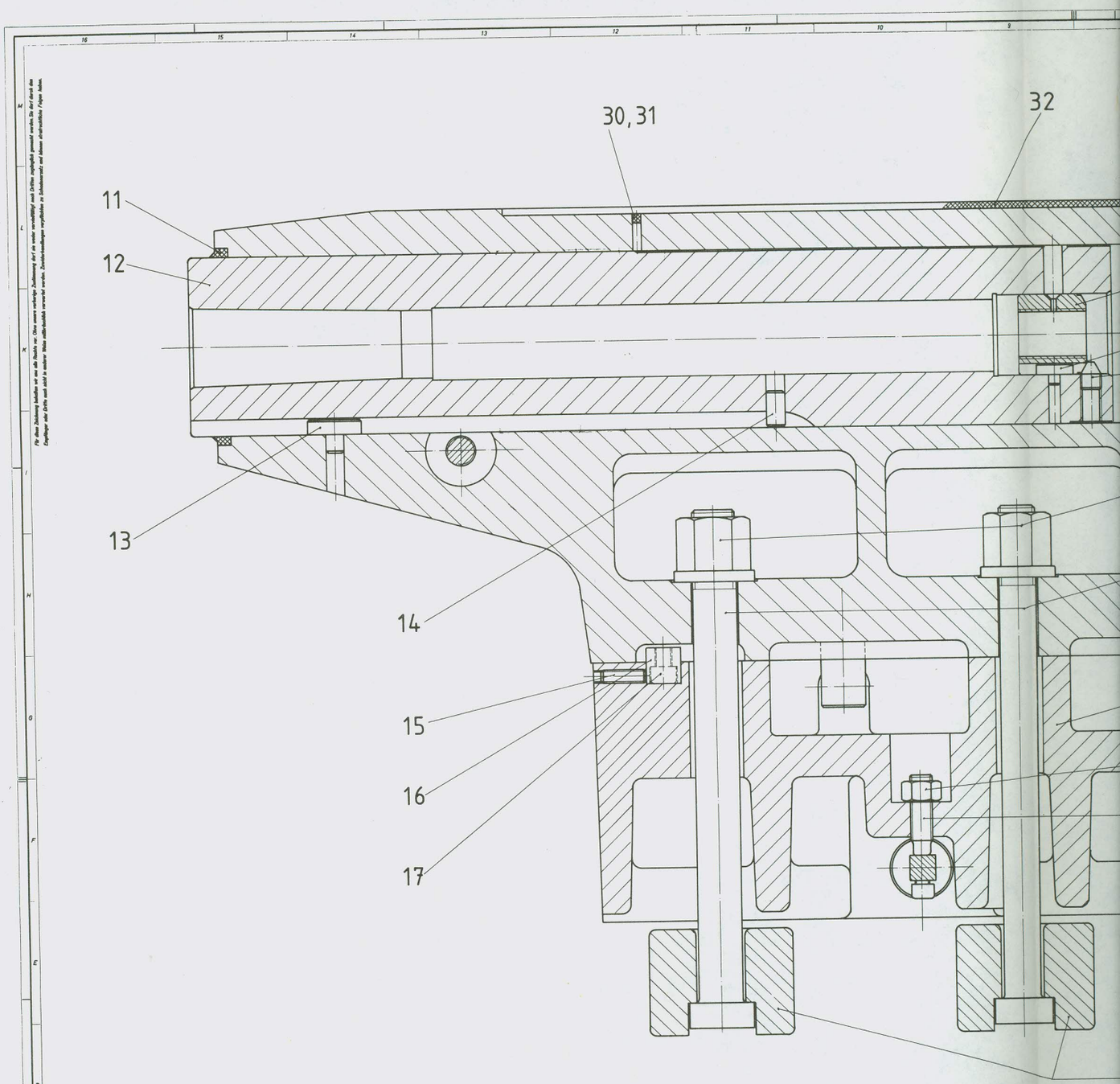
O
O
265
160
L
23
18
96

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16
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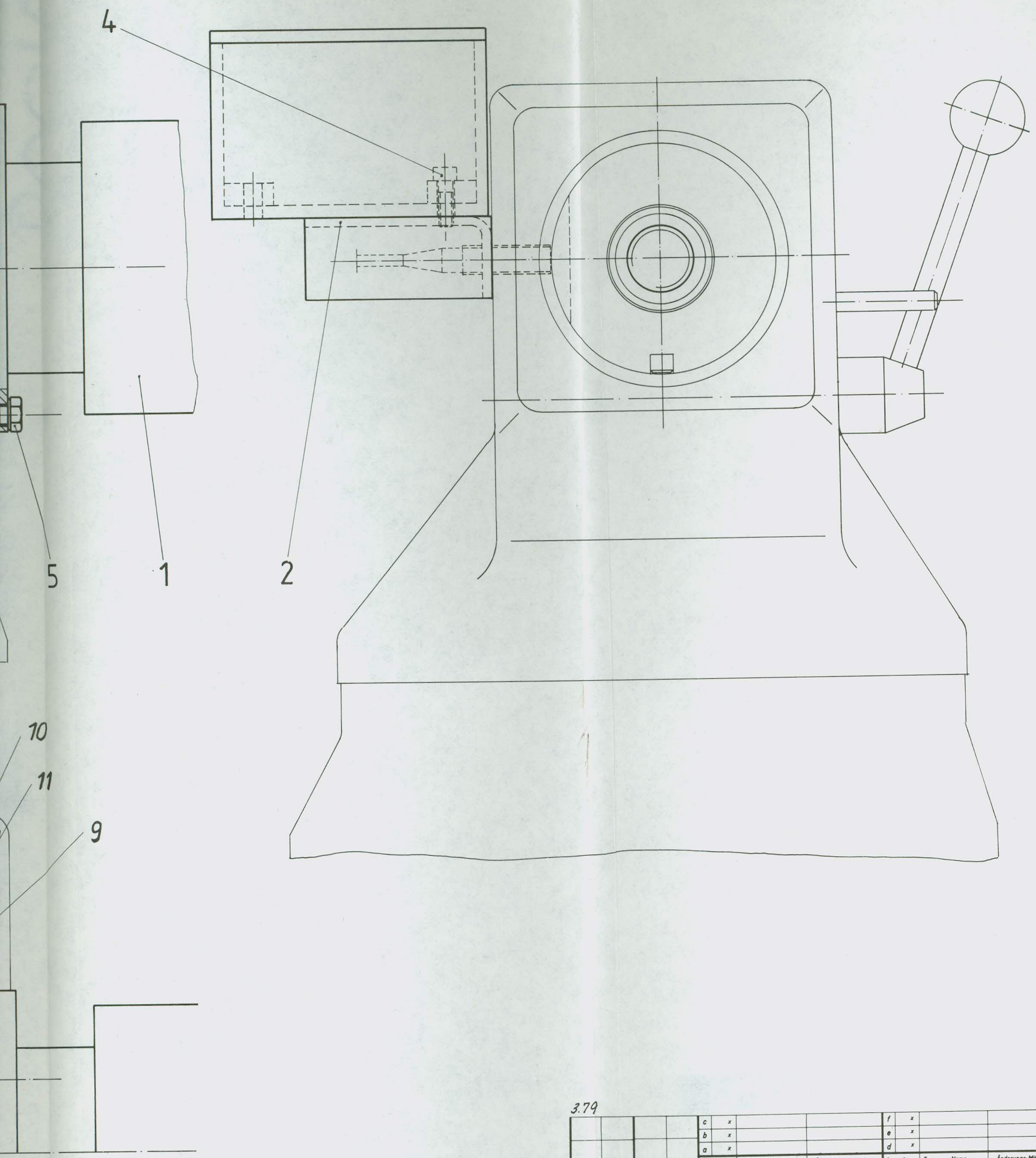


3.79

c	x				
b	x				
a	x				
kommt vor	Tag	Name	Änderungs-Mitteilug.		
f	x				
e	x				
d	x				
kommt vor	Tag	Name	Änderungs-Mitteilug.		

Bearbeitet	1978	
Gezeichnet	21.2.	Nordmann
Geprüft		
Normgepr.		

Maße o. Toleranzangabe, WN 121
Außen-∅ −, Innen-∅ +, Längen ±

bis 6	0,1	ü. 315 ÷ 1000	0,8
ü. 6 ÷ 30	0,2	ü. 1000 ÷ 2000	1,2
ü. 30 ÷ 120	0,3	ü. 2000 ÷ 4000	2
ü. 120 ÷ 315	0,5	ü. 4000	3

zul. gr. Rauht. R_t µm

~ beliebig	
▽ 100	▽▽▽▽ 1
▽▽ 25	
▽▽▽ 6,3	

GILDEMEISTER

SEP-Nr.

Paßmaß | Abmaße

Werkstoff

Modell-Nr.

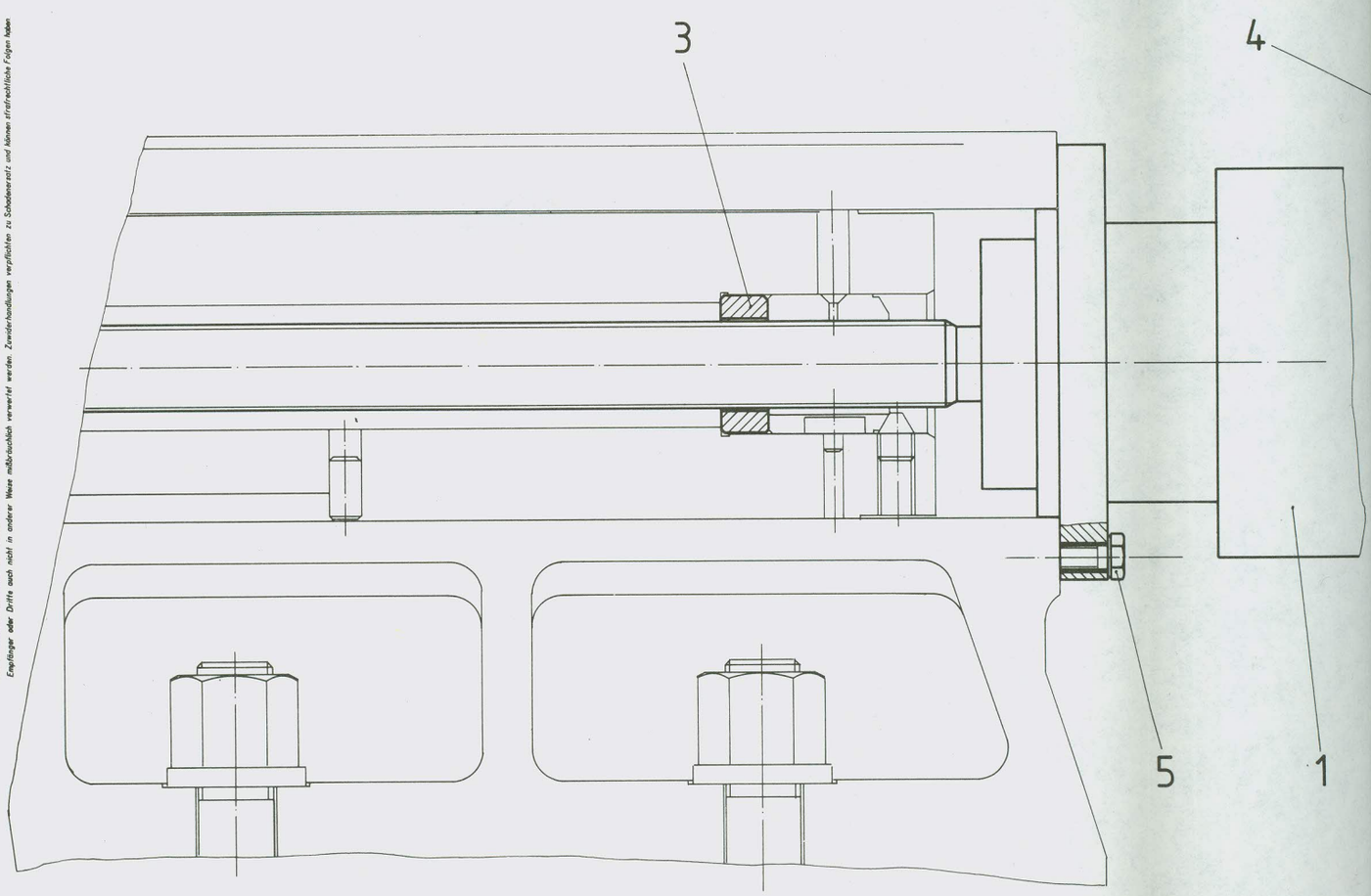
1:1
Maßstab

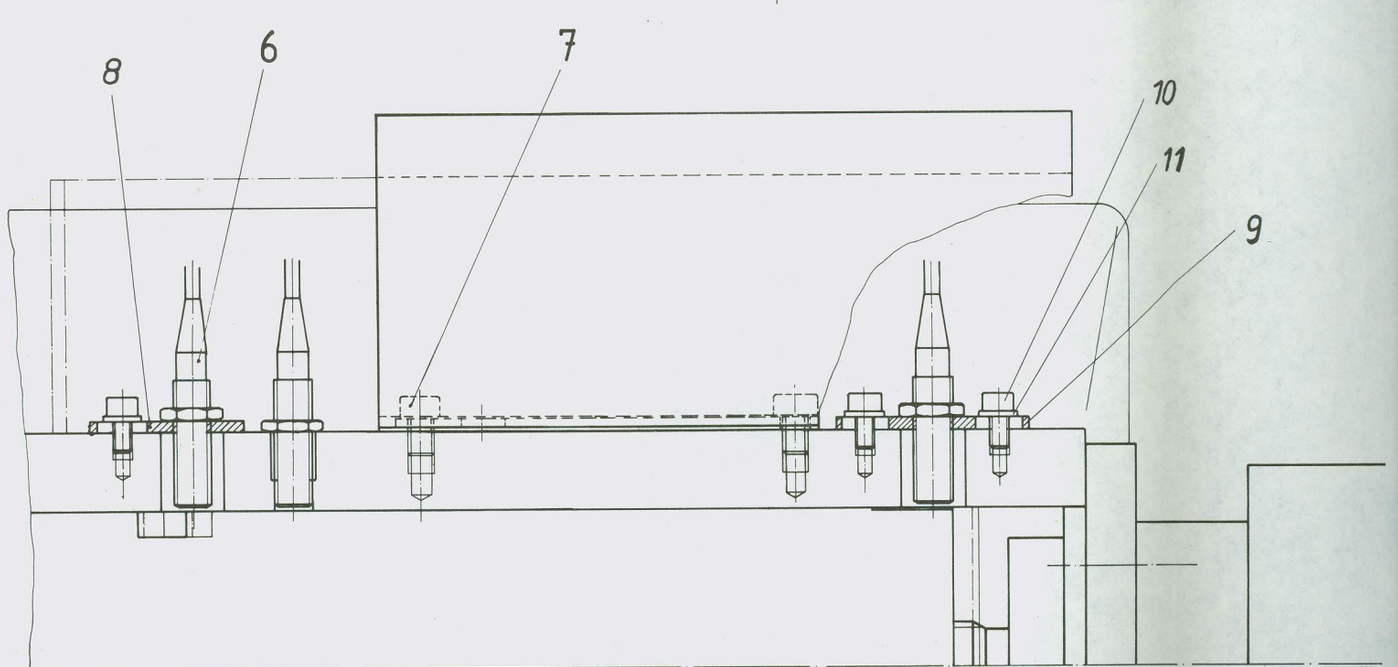
Paßmaß | Abmaße

184--54.201000

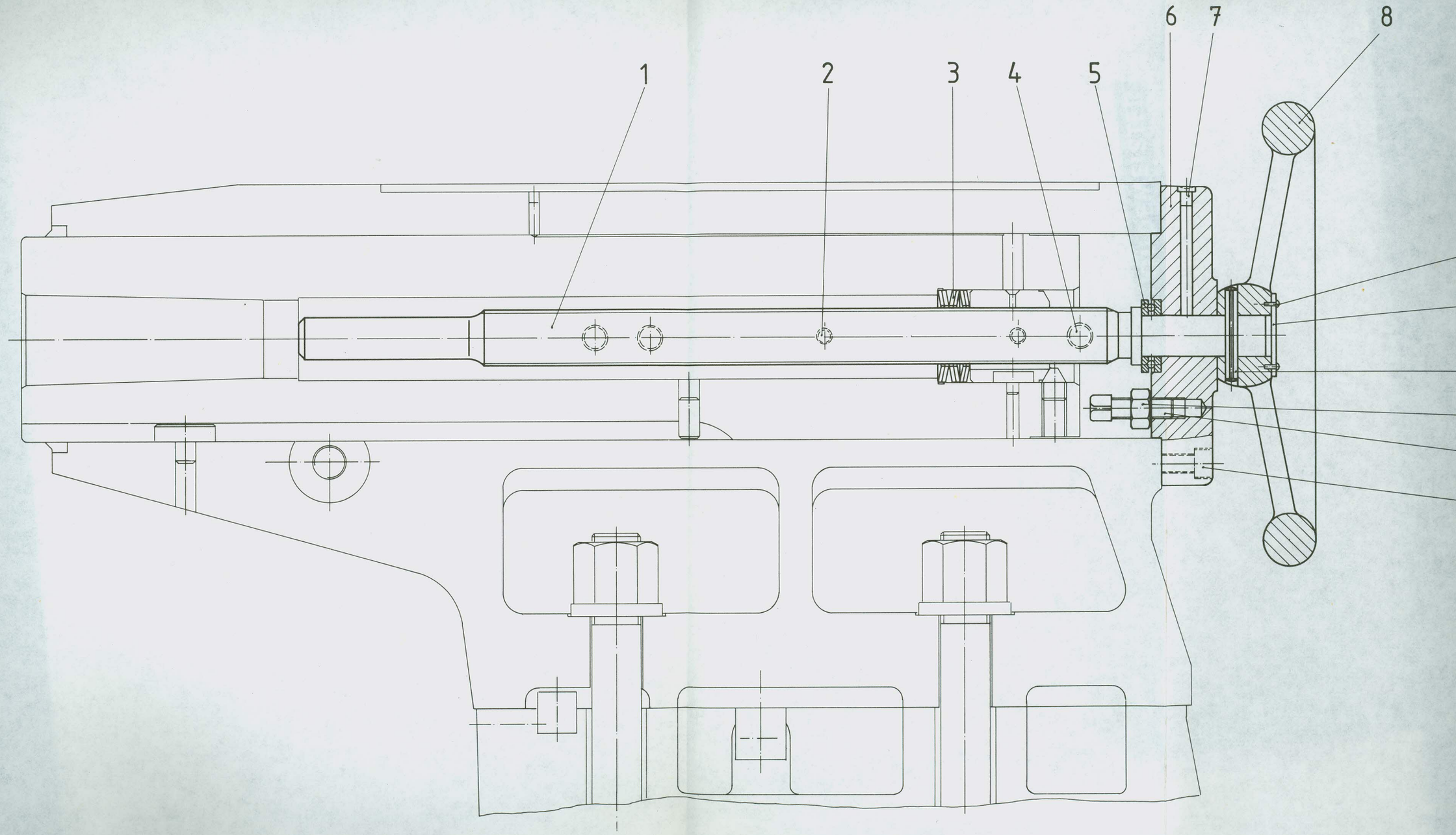
Ersetzt durch:
Ersatz für:
Entwickelt aus:

„Sefir-Normdruck" 01 6414





Friedrich Haag, Wurl



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The required spindle speed can be established from the speed and performance table duly taking into consideration the cutting speed (v) and the turning diameter.

The cutting speed is dictated by both material and tool.

The main drive motor transmits power to the main spindle via a 4-speed headstock transmission. Every transmission stage allows the selection of two speeds with ratio 1 : 1 or 1 : 1.6, alternatively on the N.E.F. 660 - 1 : 1 or 1 : 1.25. The overall range of 24 speeds is shown below.

The basic range is selected with the rear lever(s). The actual speed required is chosen with the front lever.

Selections may only be made when the main spindle is at a standstill.

The selector levers must engage fully in the desired position.

Do not leave selector levers in intermediate positions.

Make selections smoothly.

The main spindle can be rotated by hand when in neutral "0".

Starting the drive motor, determining the direction of rotation and selecting the transmission stage (1 : 1 or 1 : 1.6 or 1 : 1.25) is only possible through the address letter M and the control system.

The drive motor is stopped by the main switch on the control cabinet or by the EMERGENCY STOP button.

Starting and stopping of the main spindle is also obtained through address letter M or the appropriate selector switch.

M function in conjunction with drive motor and rotation:

M3 = Motor anti-clockwise — Main spindle runs clockwise

M4 = Motor clockwise — Main spindle runs anti-clockwise

M5 = Spindle stop

M6 = Speed selector stage 1 : 1.6 (1 : 1.25), in accordance with n1

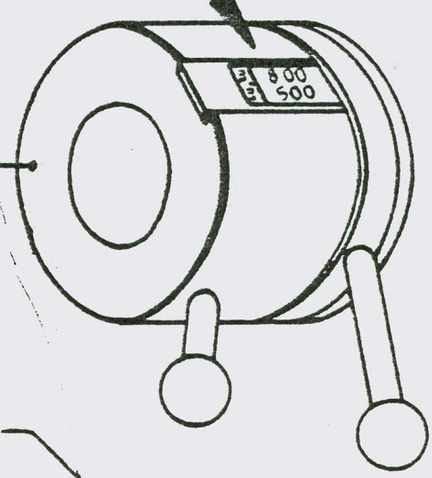
M7 = Speed selector stage 1 : 1, in accordance with n2.

2240
1400
800
500
1120
710
1600
1000
560
355
200
125
280
180
400
250
140
80
50
31,5
71
45
100
63

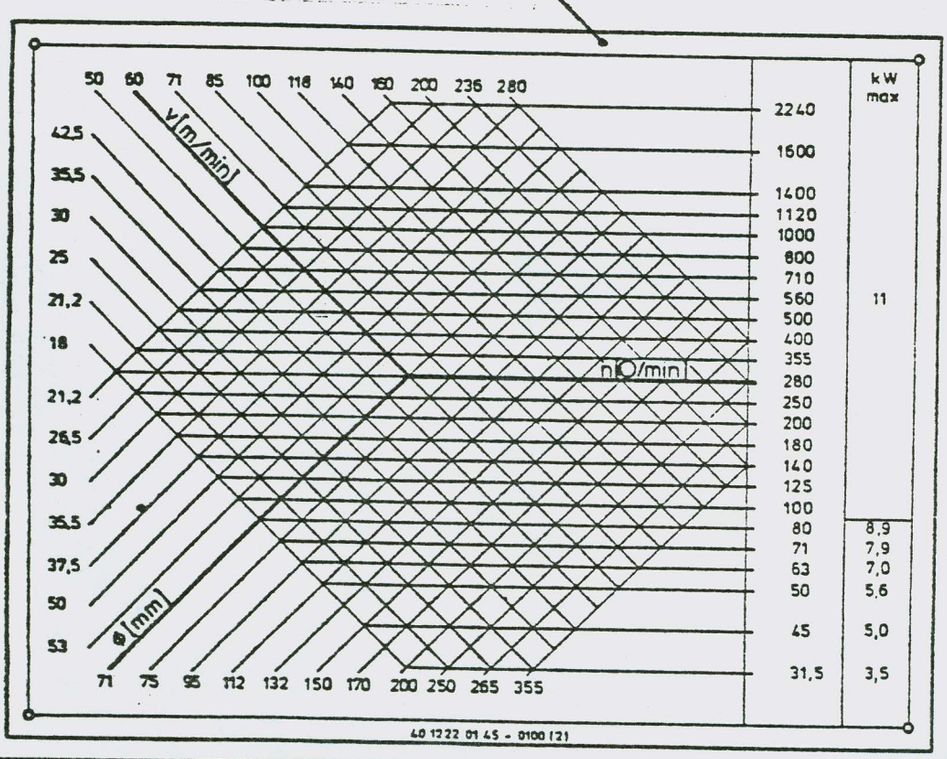
Speed range

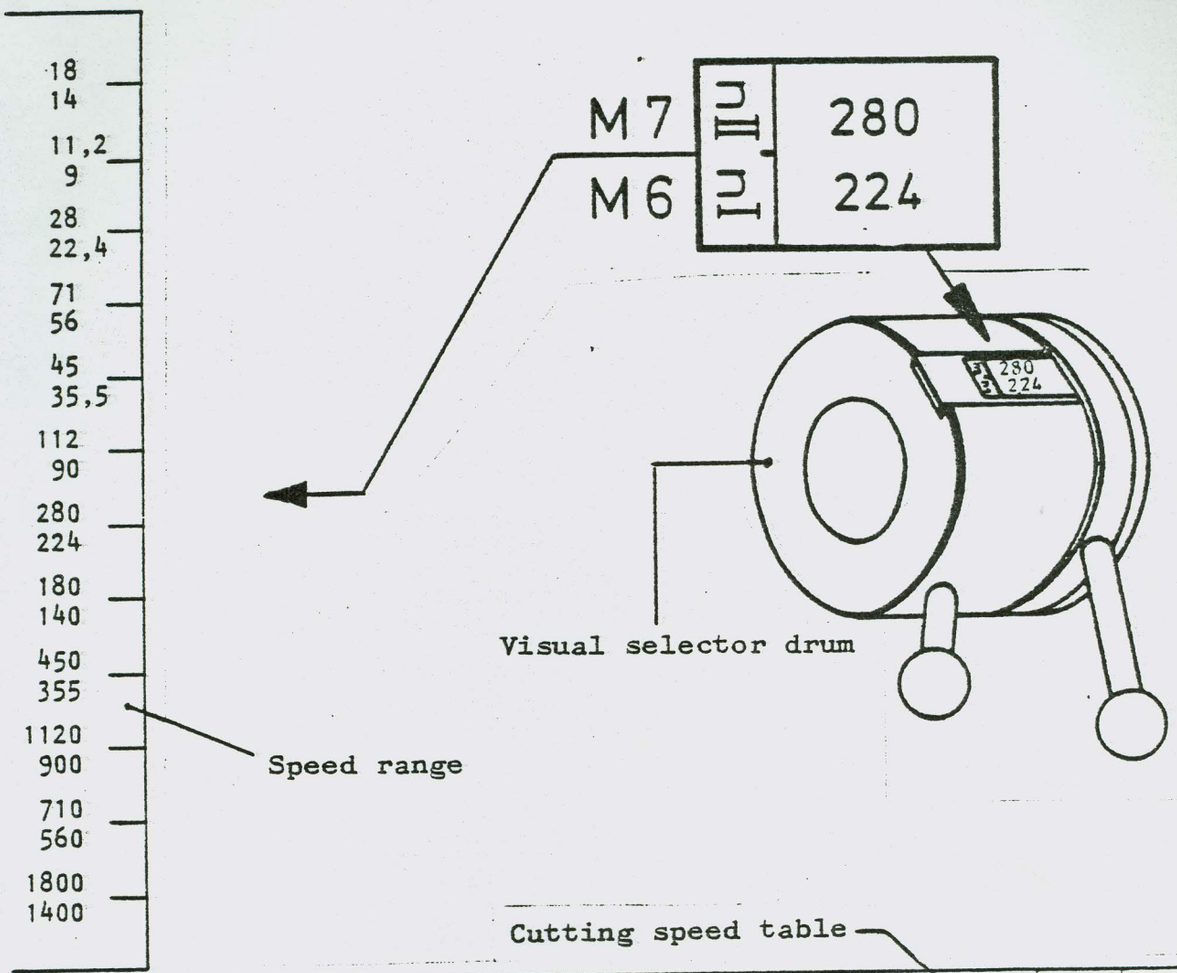
M7 III 800
M6 II 500

Visual selector drum

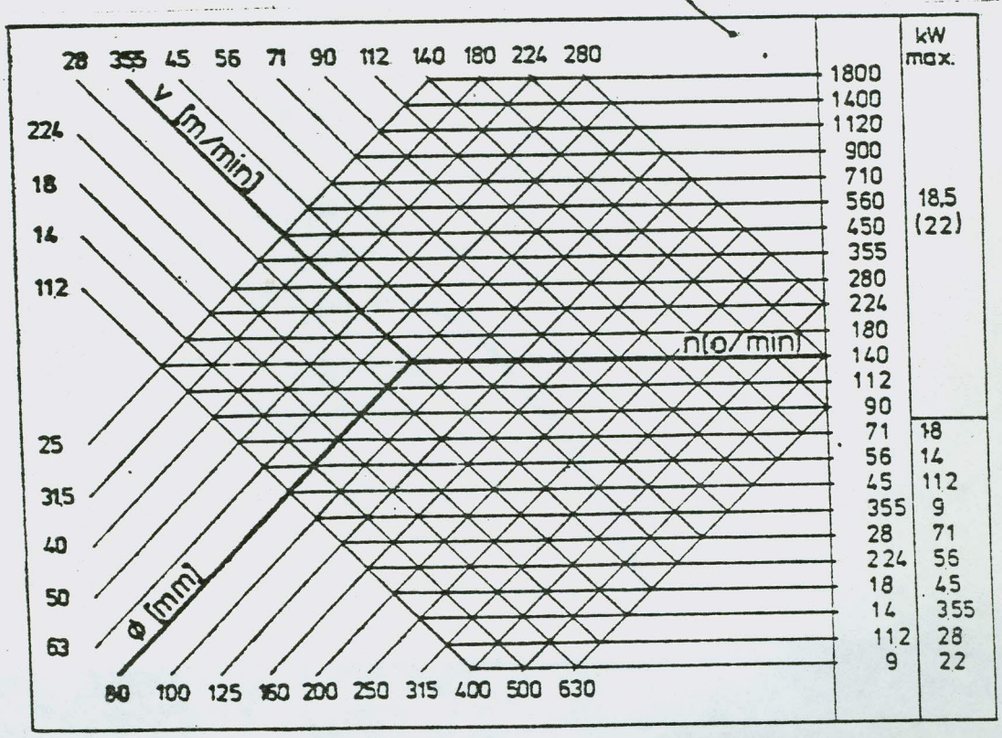


Cutting speed table





Cutting speed table



All the transmission units and bearing points in the headstock are supplied with lubricants by a circulating lubrication system. A lubrication gear pump in the headstock is driven directly from the main drive shaft. The lubrication system thus remains operative for as long as the drive motor is running. Correct function is indicated through a sight glass in the front face of the headstock where lubricant can be seen to drip slowly.

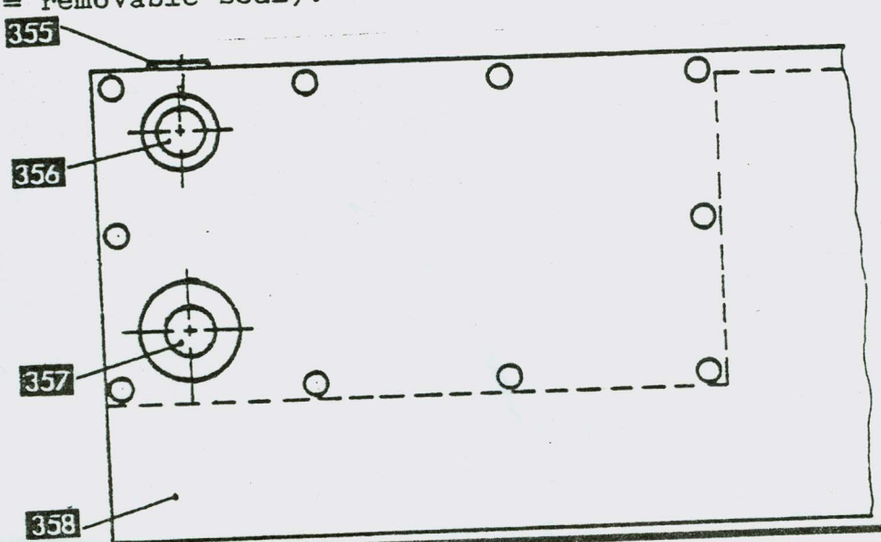
The lubricant level should be checked daily prior to starting work by observing sight glass 356 on the lube oil tank. When the motor is at rest, the sight glass should be filled with lubricant to half its height.

If lubricant requires topping up, unscrew the filler plug 355 in the lube oil tank.

The first oil change should be carried out after 500 working hours. For subsequent oil changes, see lubrication schedule. Oil changes should be carried out immediately after stopping the machine when the latter has attained its normal working temperature. Suspended particles are then still in movement and will thus be drained off with the used oil (drain aperture 357). The threaded drain plug in the draining aperture is connected to a magnetic rod-type filter. This is pulled out when the oil is changed and any contaminants should then be completely removed.

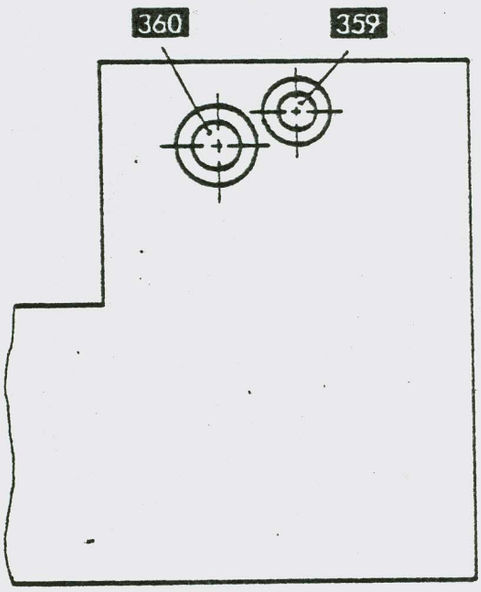
CAUTION. Cover 358 must be unscrewed to allow cleaning of the oil tank.

After unscrewing the cover, remove any sealant residues from it. When refitting, do not forget to apply new sealant. (e.g.: Atomsit = removable seal).



All saddle lube points are supplied with lubricant from a pressure system. A motor-driven gear pump delivers a predetermined amount of lubricant in intervals of 5 minutes. The system becomes operative as soon as the main drive motor is witched on. Lubricant thus delivered is taken to the individual lube points via plunger-type distributors.

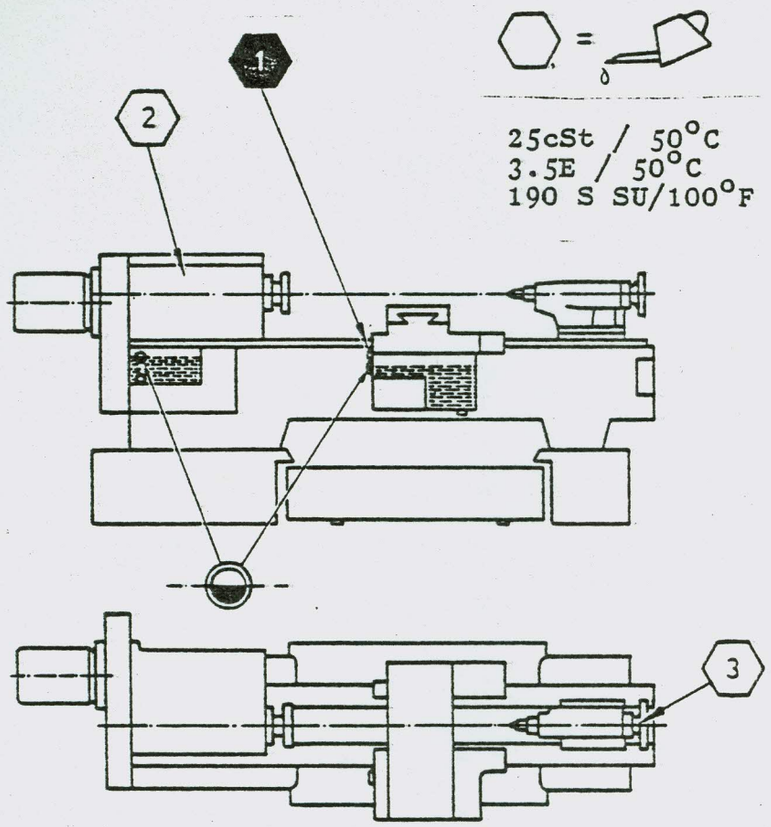
A pressure switch is incorporated to provide continuous monitoring of pump function. Should saddle lubrication fail, the working sequences automatically cut out in the sequence: feed ..... main drive. The fault indicator lamp lights up on the control cabinet in this case.



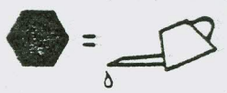
TOPPING UP LUBRICANT. Consumption in single-shift operation is approximately 0.2 litres per week. However, this information can only be taken as a guideline because actual consumption depends on the type of work done. The tank should always be filled to the centre of sight glass 360.

- To allow filling in oil, unscrew the plug 359.

The lube points on the machine appear in the lube schedule together with information regarding time and volumes. The sight glasses shown must be filled to half their height when the machine is at a standstill. All time data concerning lubrication and oil changes refer to single-shift production.



25cSt / 50°C
3.5E / 50°C
190 S SU/100°F



37cSt / 50°C
5 E / 50°C
290 S SU/100°F

N.E.F.480

No.	1	2	3
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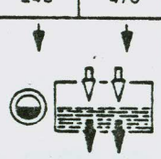
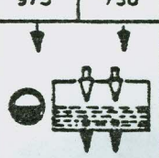
cm^3	4000	7500	1
in^3	245	470	0.06
			 3-4x

N.E.F.660

No	1	2	3
h	50	1200	8
cm^3	16000	12000	1
in^3	975	730	0,06
			 3-4x

Alloyed, refined machine oil, corrosion-preventing, non-foaming, water-repellent, age-resisting, pressure-proof.