

*Betriebsanleitung*  
*Operating instructions*  
*Instructions de service*



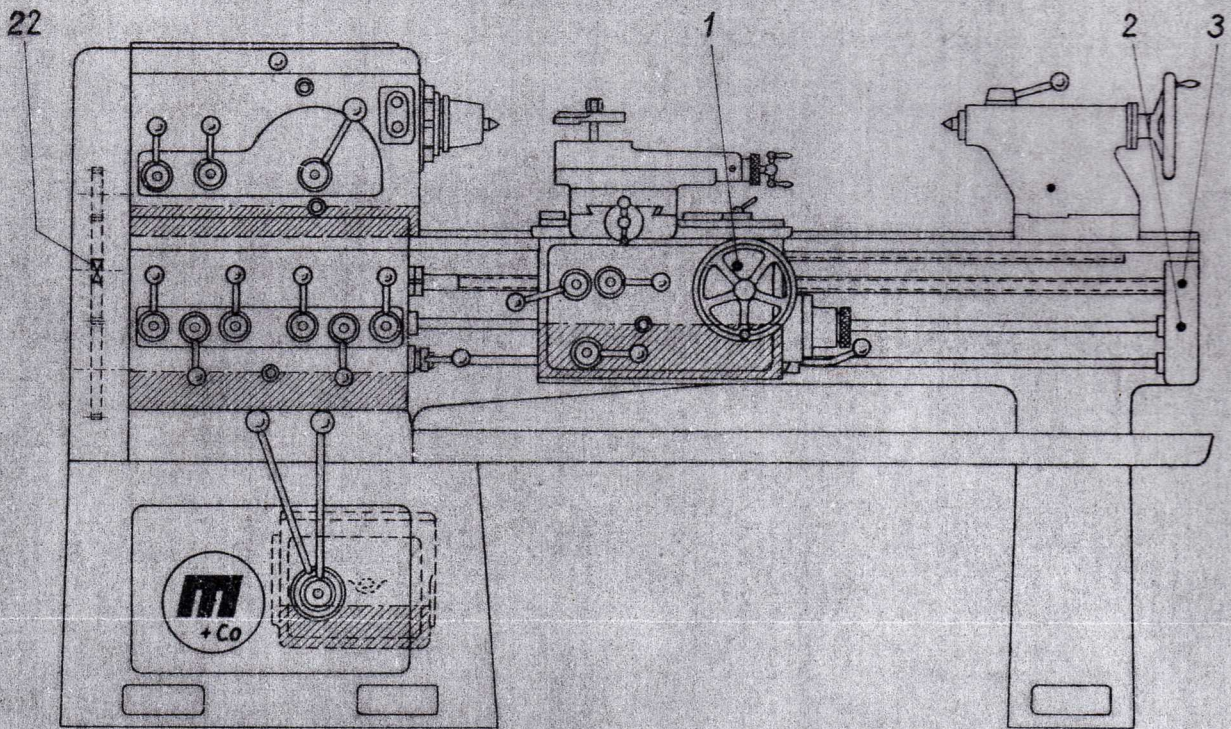
Maschinen-Nr.:  
19.918




Type:  
MO

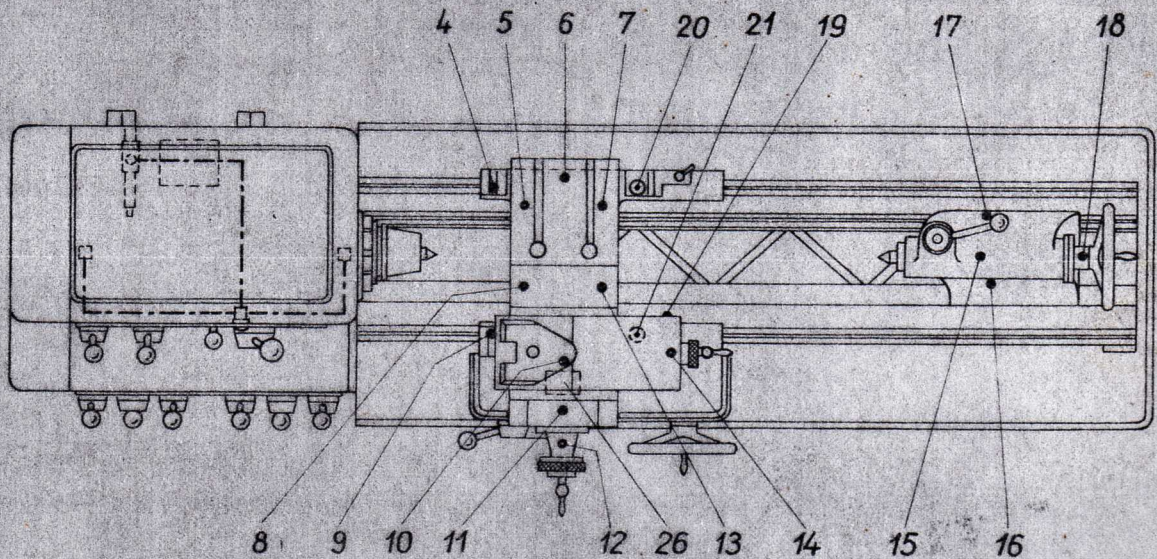
*Meuser & Co. G.m.b.H.*  
*Werkzeugmaschinenfabrik*  
*Frankfurt/Main-Mainkur*

Sketch 5

Lubrication Diagram

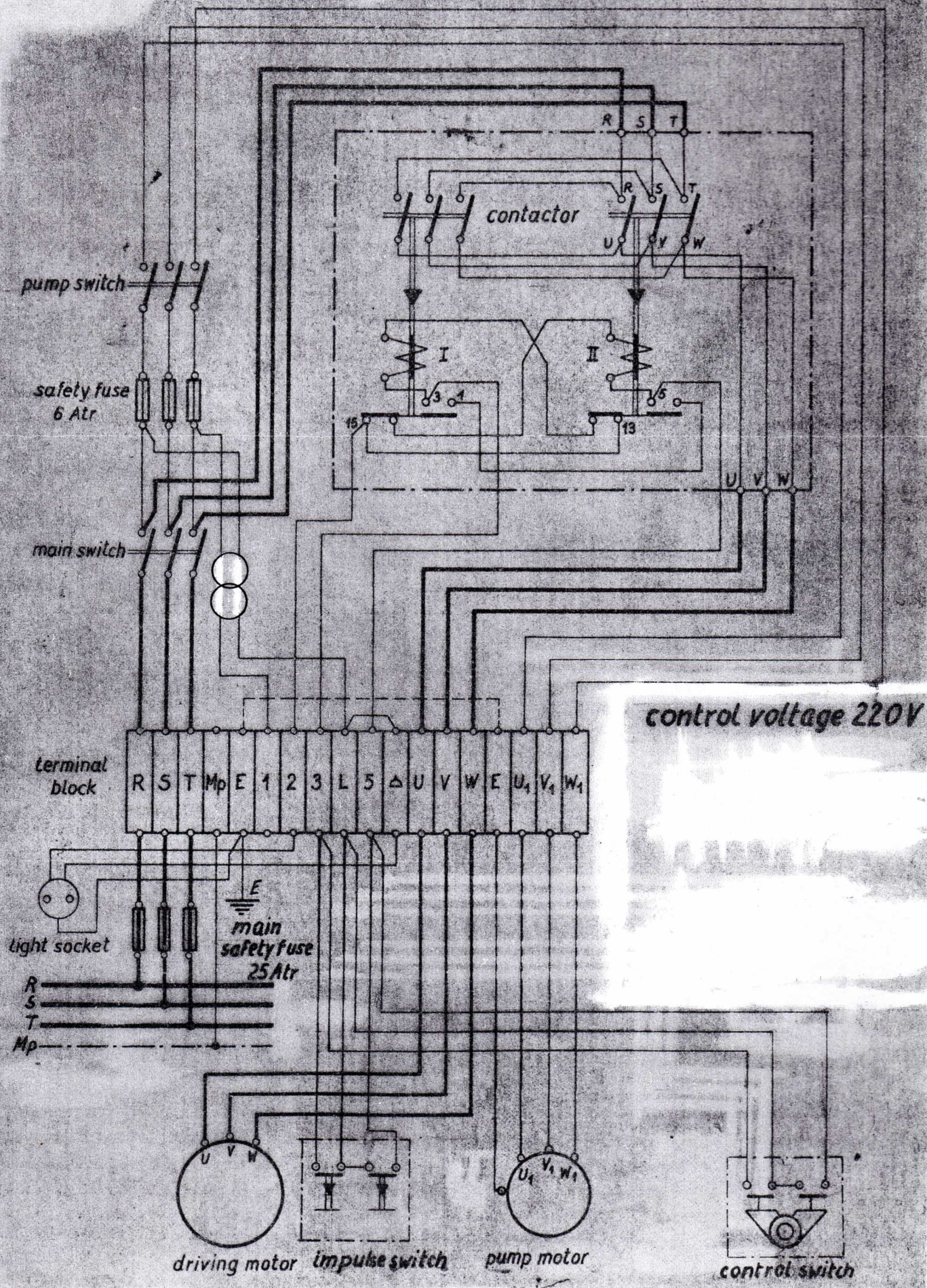


-  Oil Bath
-  Oil Level Gauge
-  Oil Pump for Lubrication of Spindle Bearings



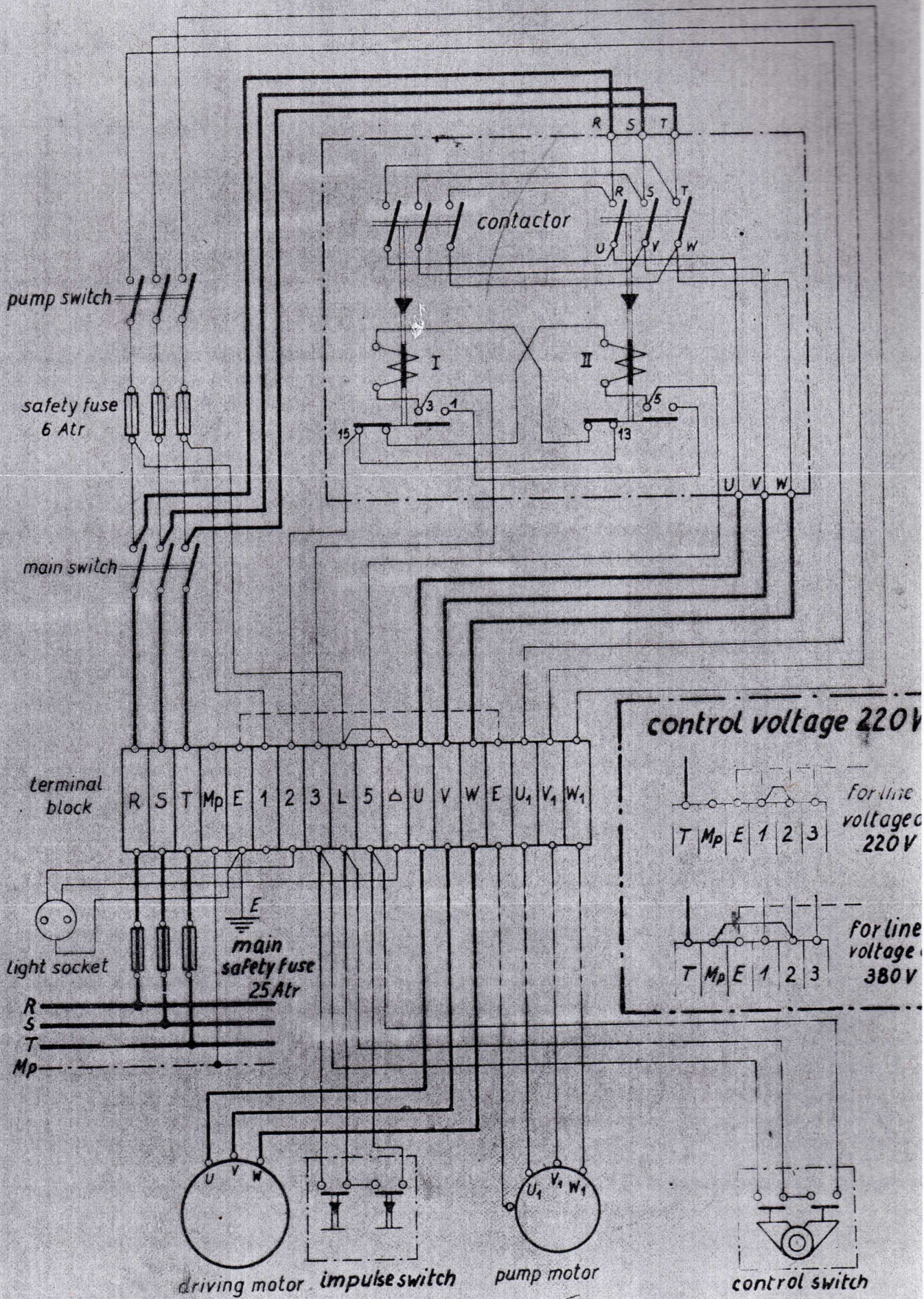
- 1 - 19 Points for manual lubrication : daily
- ◉ 20 - 21 Lubrication by wick : weekly
- ⊠ 22 Ball bearings :

# Sketch 6 Wiring diagram



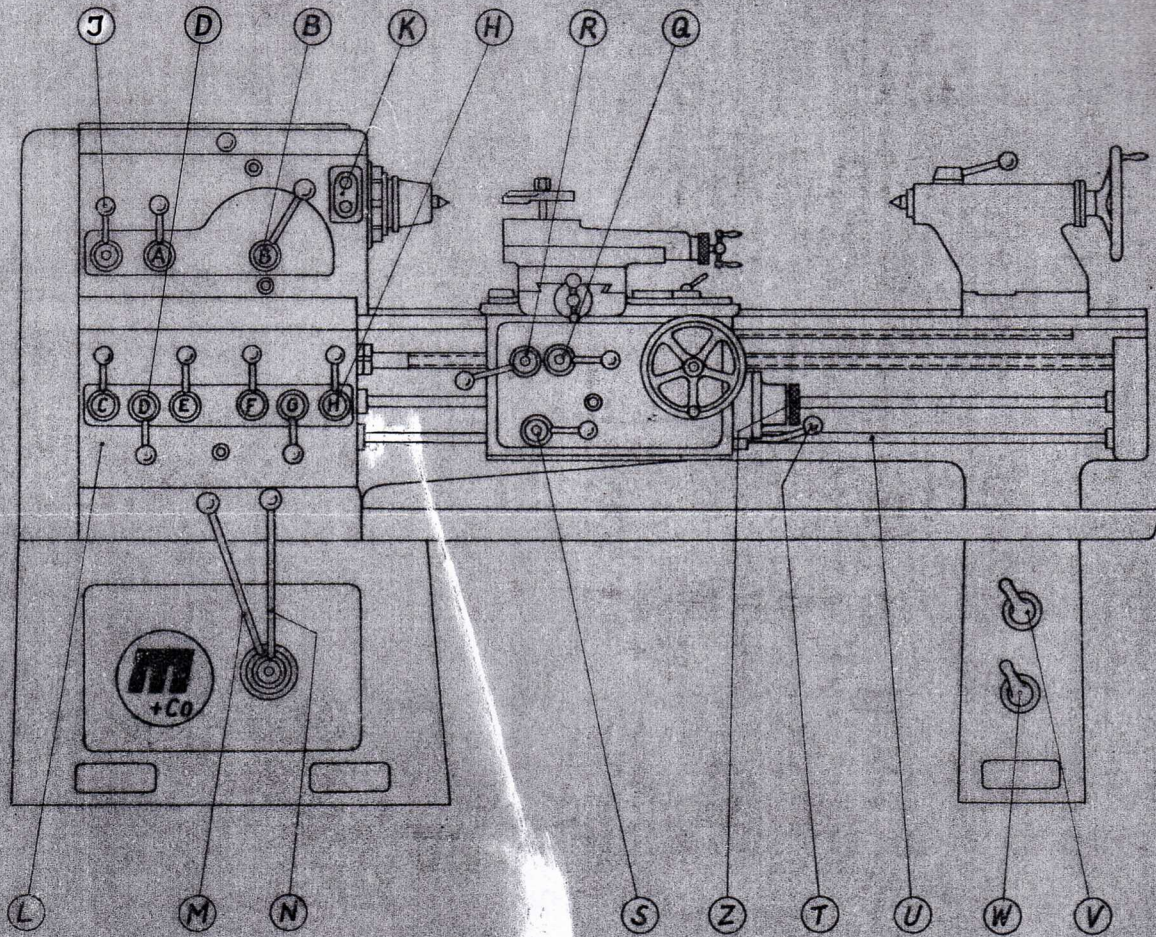
# Sketch 6

## Wiring diagram



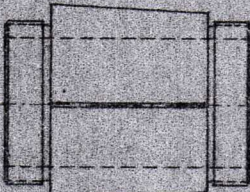
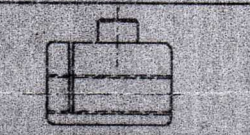





Sketch 7

Important Control Elements



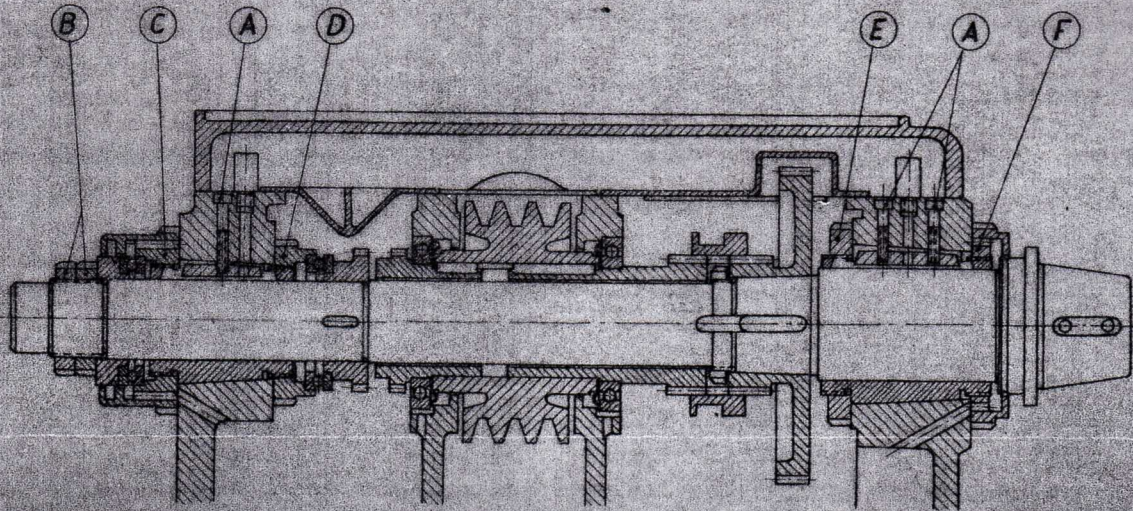
- (A) Lever for standard and coarse pitch threads
- (B) Intermediate gear lever at the headstock
- (D) Lever for metric and inch thread
- (C) Lever for changing the speeds
- (E-G) of guide and feed spindle
- (H) Lever for guide and feed spindle
- (J) Reserve switch lever for clockwise and anti-clockwise motion of the guide and feed spindle
- (K) Impulse switch
- (L) Gear box
- (M) Back gear switch lever
- (N) Front gear switch lever
- (Q) Lever for longitudinal or cross feed
- (R) Lever for split nut
- (S) Trip worm for switching on and off the longitudinal or transverse motion of the slide
- (T) Lever for clockwise and anti-clockwise motion of the machine
- (U) Switch Rod
- (V) Pump switch for cooling agent pump (special arrangement)
- (W) Main switch
- (Z) Fixing of the automatic self-release

## S p a r e p a r t s

List No.	Designation	scetch
13015a	front bronze bearing	
13022a	back bronze bearing	
14052a	nut for cross-slide screw	
14055	nut for top slide screw	
17043a	worm wheel	
17058a	split-nut	
17x1900	3 Vee-belts 180 H.-centr. (50~) 180-200H.-centr. (60~)	
17x2000	3 Vee-belts 200 H.-centr. (50~)	

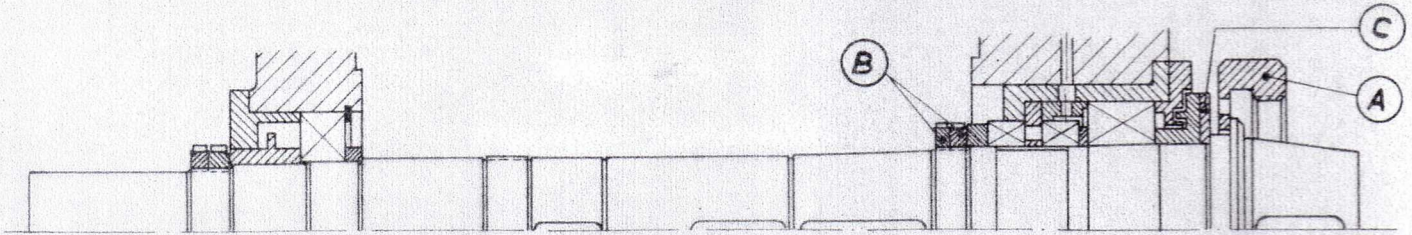
Sketch 8

Adjusting of the Main Bearings



Radial play of the front and rear anti-friction bearing will be adjusted as follows:

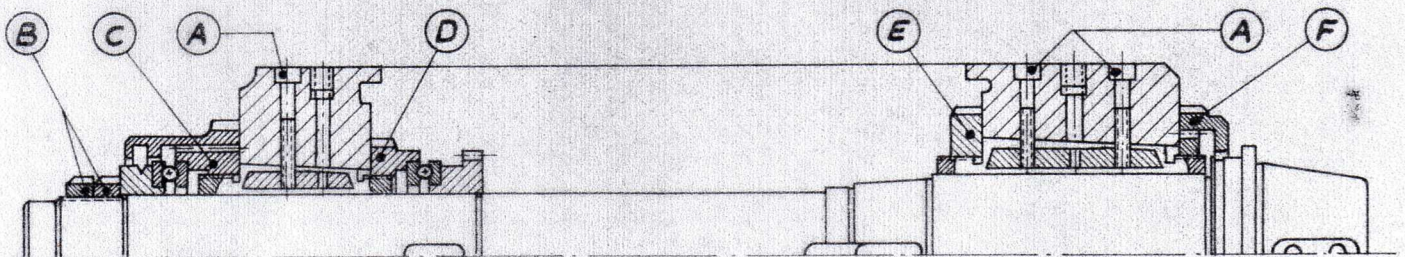
- 1) Loosen screws "A"
- 2) Loosen nuts "B", "C", and "E".
- 3) Fasten nut "F" until the sliding of the main spindle can be felt by turning the driving plate, transmission disengaged.
- 4) Fasten and secure nut "E", fasten screws "A"
- 5) Fasten nut "D" until the sliding of the main spindle can be felt by turning the driving plate, transmission disengaged
- 6) Secure nut "C", fasten screw "A"
- 7) Axial play of the main spindle to be eliminated by fastening and securing of nut "B"



Main spindle with roller bearing

Adjustment of the front main bearing:

- 1.) Remove chuck or face plate, etc.
- 2.) Loosen the fastening screws of the divided ring "C" and withdraw them out through the bored holes in the cap nut "A". Take off divided ring.
- 3.) Loosen counter-nuts "B". Screw the other nut until the bearing runs again free from play and the spindle will allow to be turned easily by hand.
- 4.) Face-grind the divided ring "C" and place it again.
- 5.) Check nut "B" by securing it.



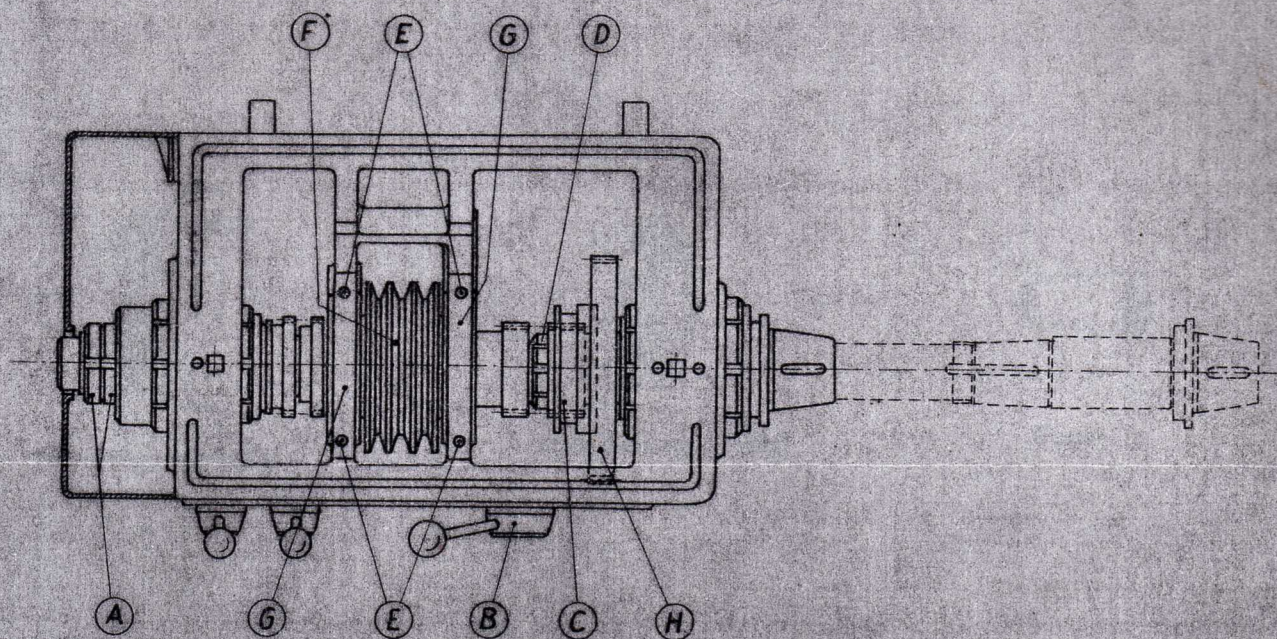
Radial play of the front and rear anti-friction bearing will be adjusted as follows:

- 1.) Loosen screws "A".
- 2.) Loosen nuts "B", "C" and "E".
- 3.) Fasten nut "F" until the sliding of the main spindle can be felt by turning the driving plate on disengaged transmission.
- 4.) Fasten and secure nut "E", fasten screws "A".
- 5.) Fasten nut "D" until the sliding of the main spindle can be felt by turning the driving plate on disengaged transmission.
- 6.) Secure nut "C", fasten screw "A".
- 7.) Axial play of the main spindle to be eliminated by fastening and securing of nut "B".



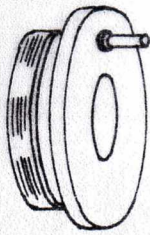
Sketch 11

Changing of the V-Belts



- 1) Remove nut "A"
- 2) Clutch "C" to be shifted to the right with back-gear lever "B"
- 3) Loosen nut "D" and main spindle gear
- 4) Remove main spindle from the right
- 5) Lift transmission in the left cabinet foot and remove the belts from the driving gear
- 6) Remove the 4 hexagonal (inside) screws
- 7) Remove and exchange V-belt pulley "F" with bearing covers "G" and belts
- 8) V-belt pulley with belts, "F" to be mounted
- 9) Apply sealing agent to bearing lid "G", mount and fasten with screws "E"
- 10) Apply belts to the driving gear and fasten transmission
- 11) Insert main spindle, mount main spindle gear "H" and fasten nut "D"
- 12) Fasten nut "A" and secure with counter-nut

Sketch No. 1  
Standard Accessories



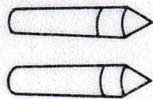
Driving plate



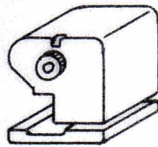
Fastening ring



Cone



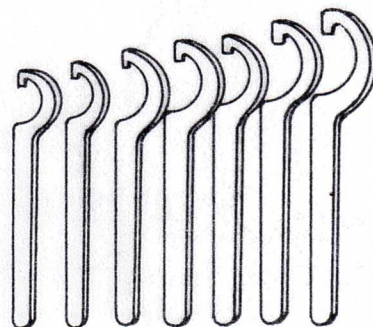
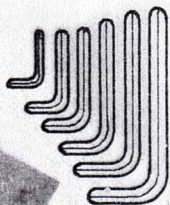
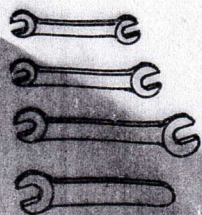
2 dead centres



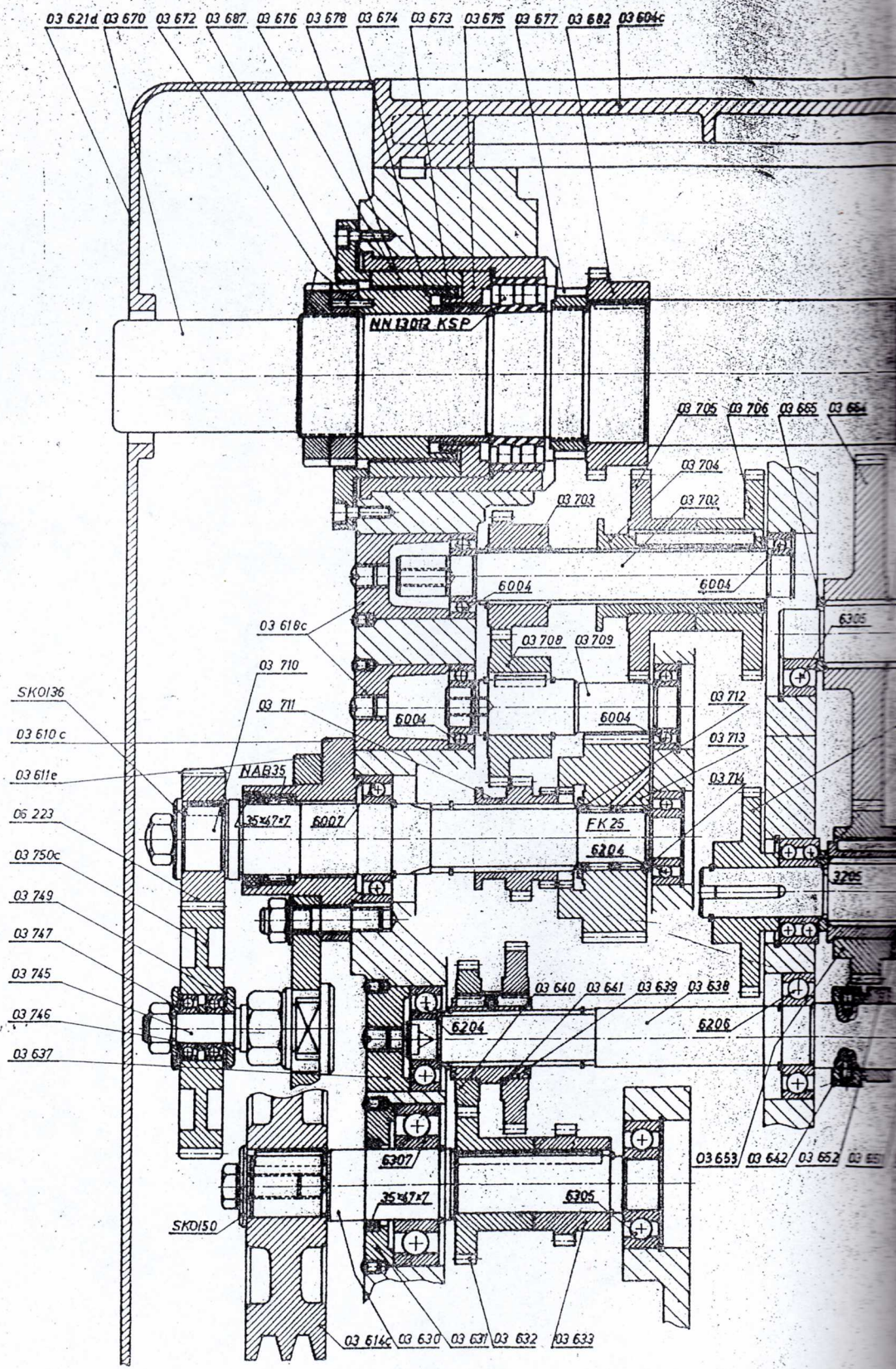
Releasing dog for 2 directions

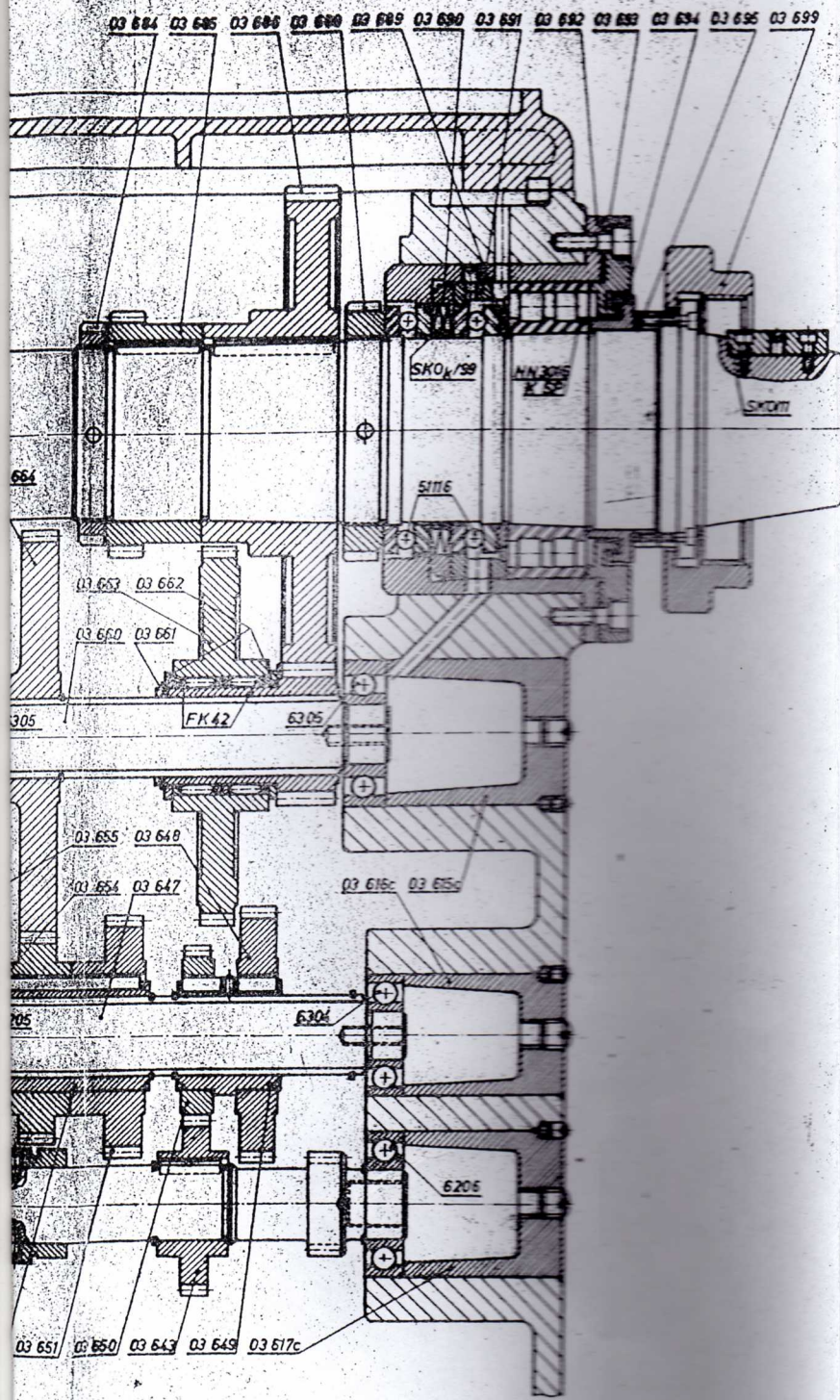


oil gun



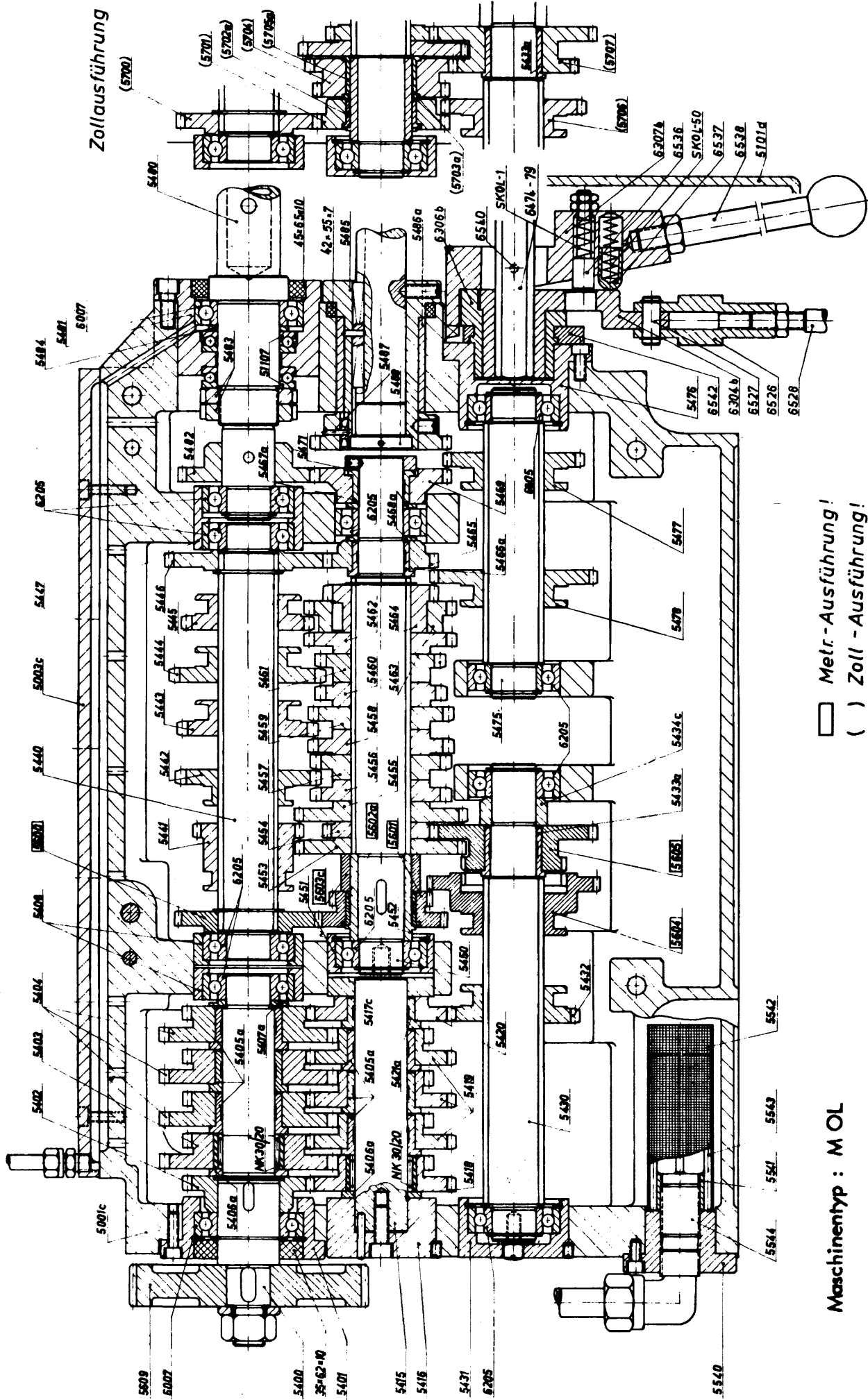
Wrenches





Ausführung mit  
Kegelrollenlagerung

Zeichnung	03 699	Messer & Co. G.m.b.H.
Teil	Spindelstock	Frankfurt a. M. - Höchst
Hersteller	MOK	



Maschinentyp : M OL

□ Metr.-Ausführung!  
 ( ) Zoll - Ausführung!

SCHALTKASTEN

GEARBOX

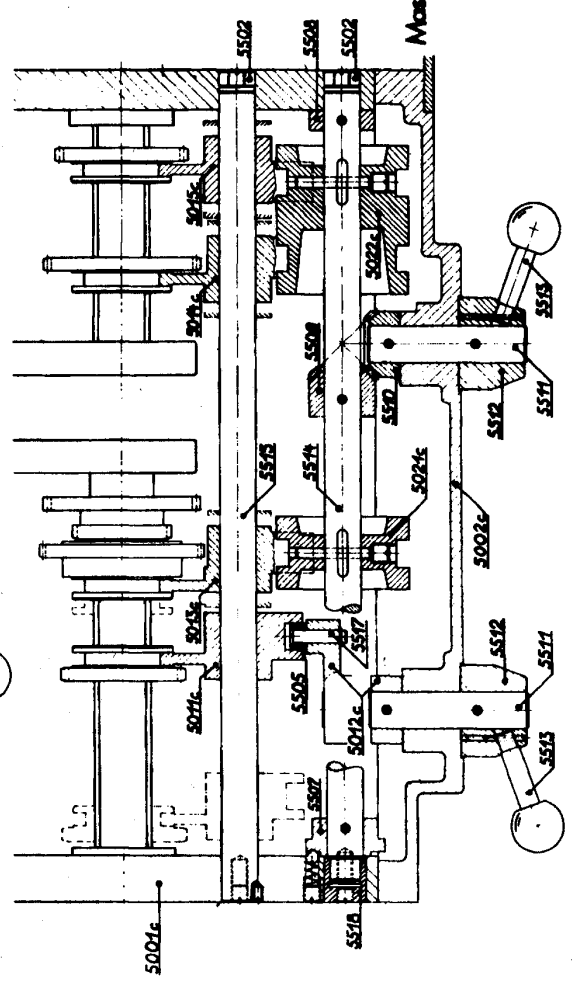
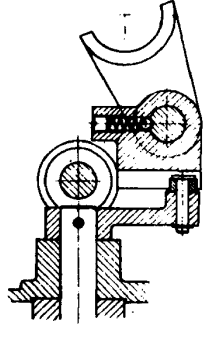
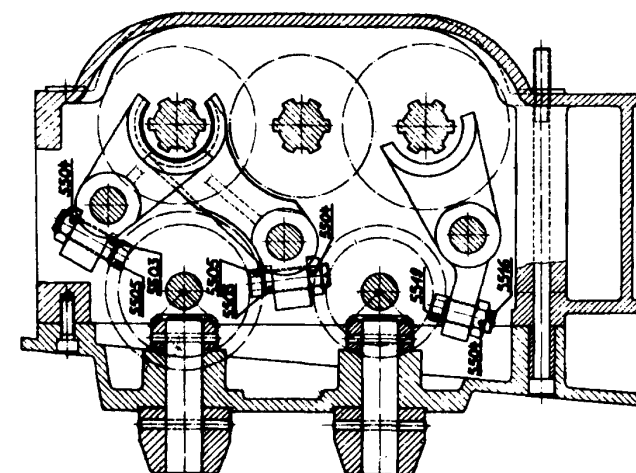
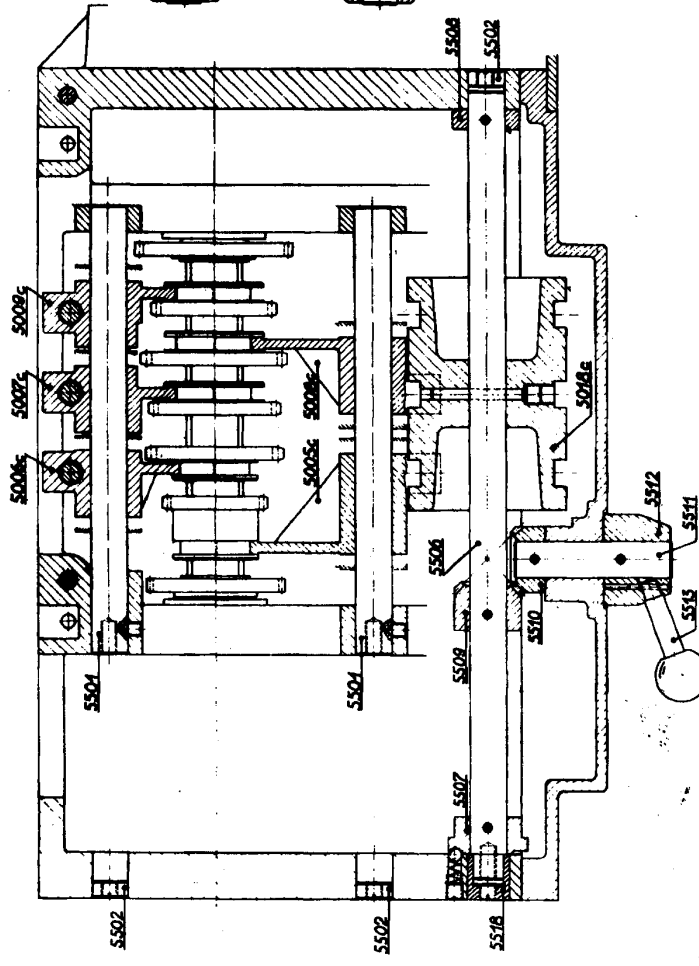
INTERRUPTEUR

CAJA NORTON

Modell  
 MOL

Schaltkasten  
 Gearbox S1

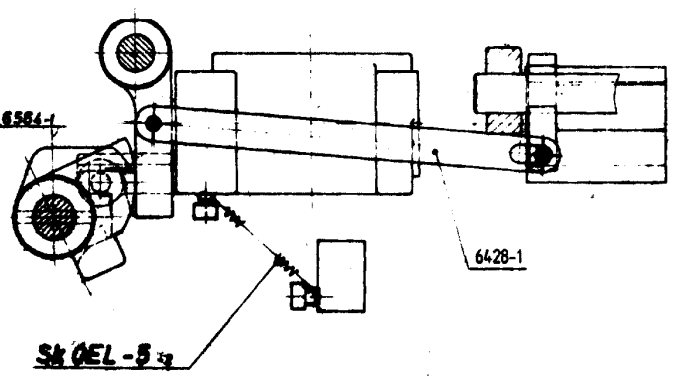
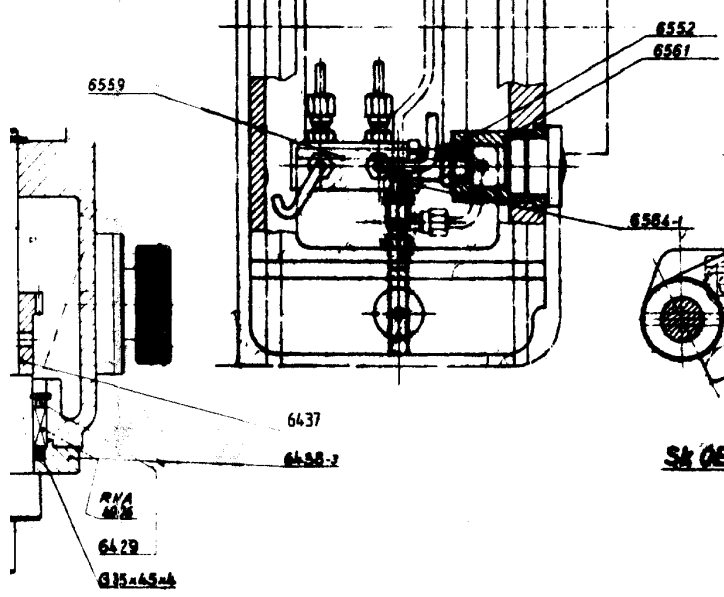
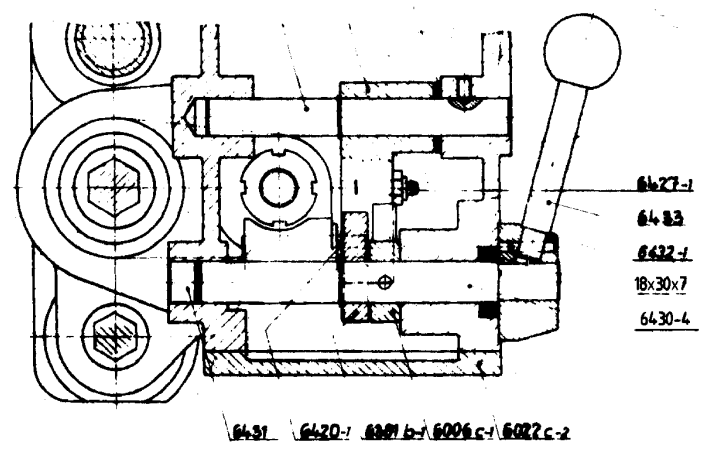
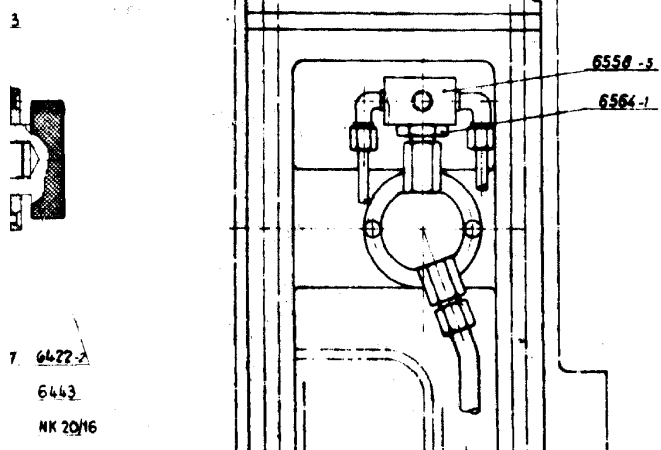
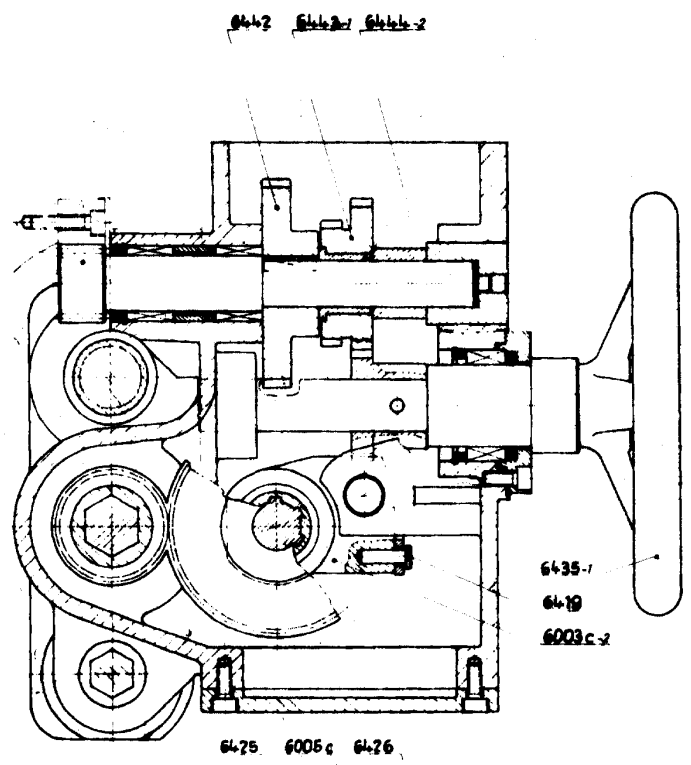
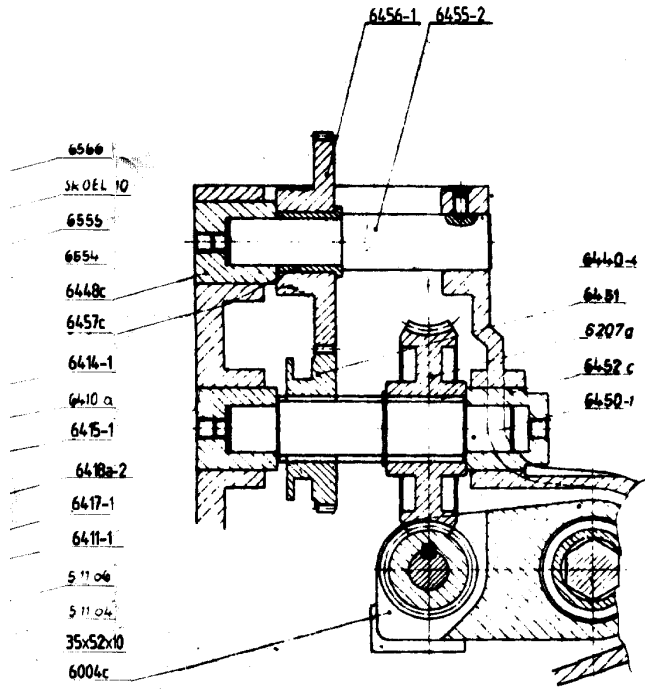
Maßstab  
 1:1



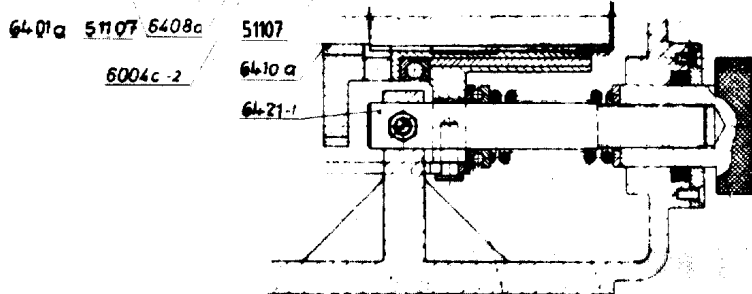
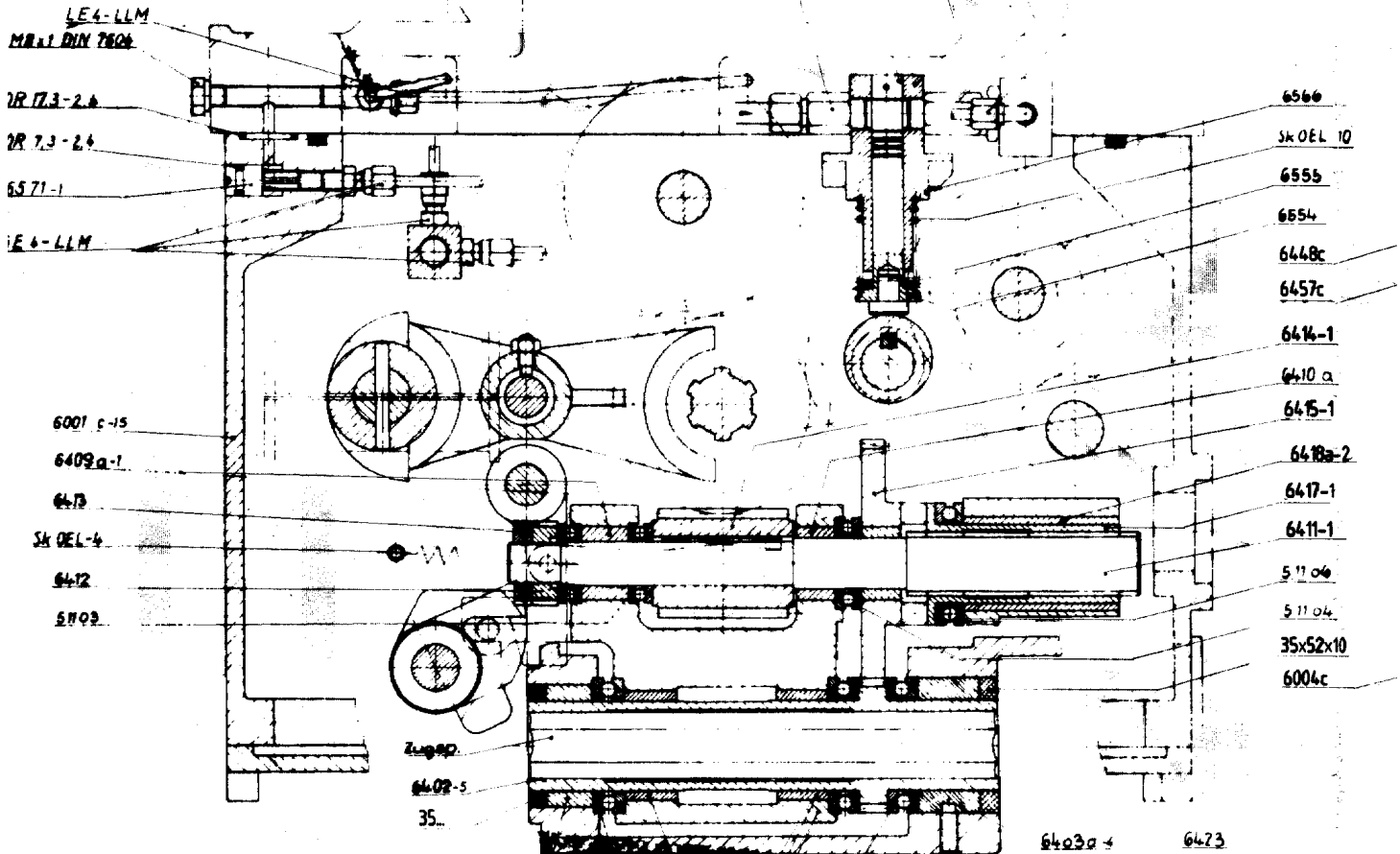
Maschinentyp : M O L

SCHALTKASTEN  
 GEARBOX  
 INTERRUPTEUR  
 CAJA NORTON

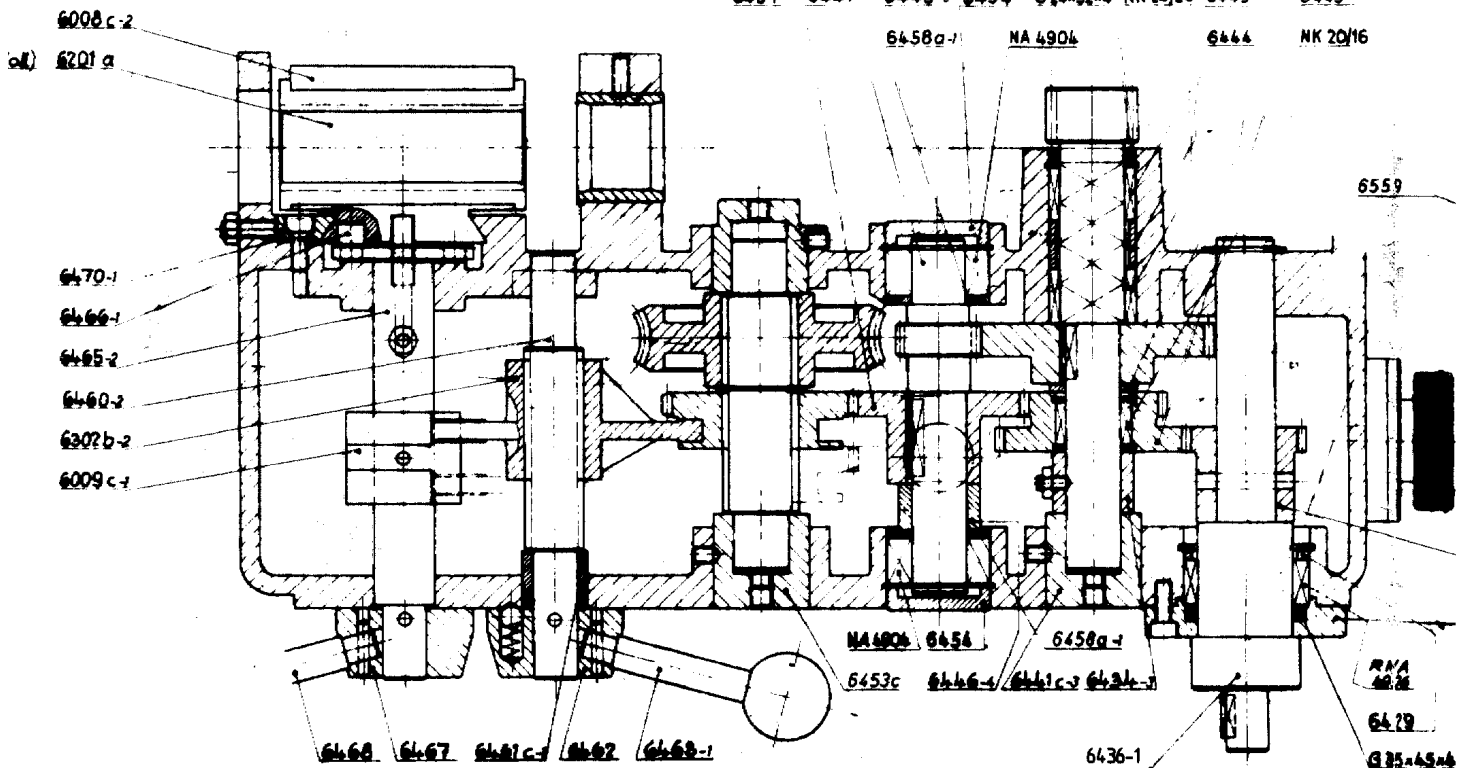
Modell MOL	SchalTKasten Gearbox S2	Maßstab 1:1
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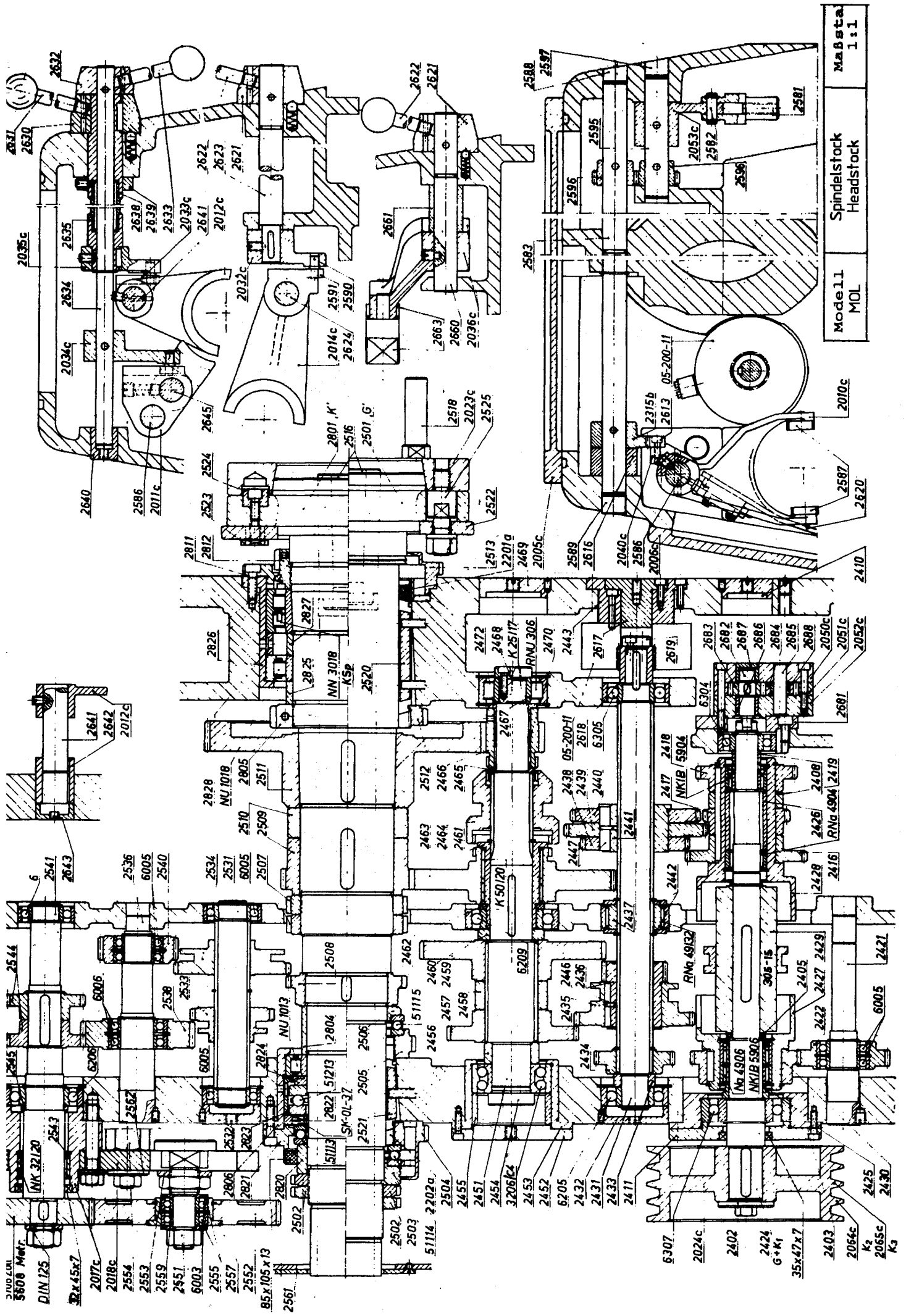
Modell MOL	Schloßkasten Apronbox	Maßst. 1:1
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51103 SK OEL-6 30x407 6422-1  
 6497 6447 6445-5 6454 G26x32x6 NK 26/20 6449 6443  
 6458 a-1 NA 4904 6444 NK 20/16







Ma.Bista 1:1	Spindelstock Headstock
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Modell  
MOL

2010c

2587

2581

2040c

2040c

2040c

2040c

2040c

2040c

2040c

2040c

2040c