

The

myford

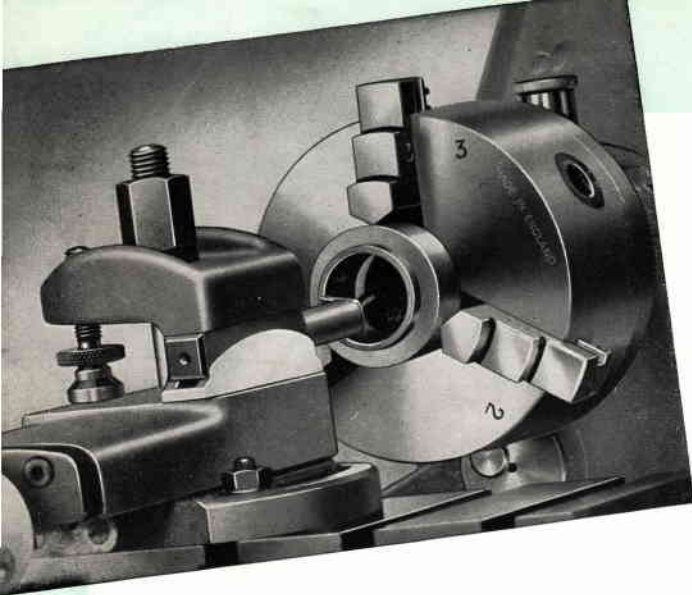
QUICK SETTING
LATHE TOOLS



My

QUICK-SETTING

Tool shapes are of standard



DESIGN

One of the most important factors in obtaining good turning results is to ensure adequate support to the lathe tool, the best tools being those of solid form clamped directly down to the base support.

Quick adjustment for centre height has been the problem on those machines designed to afford this type of tool clamp, and several methods both simple and ingenious have been tried out to overcome the inconvenience of finding correct packing thicknesses to obtain the tool's true centre height. Most devices have inherent weaknesses inasmuch as the tool base can become unsupported for a large portion of its area; overhang of the tool not only causes chatter but also restricts the full supported movement of cross slide; close facing on deep shoulder work becomes difficult, and so on.

Myford ML7, Super 7 and ML4 Lathes, also ML8 compound slides have a height from top slide to centre of $\frac{3}{8}$ " and the $\frac{1}{2}$ " square Quick Setting Lathe Tools also the $\frac{3}{8}$ " square, when the latter are used with the MA108ZA tool boat, will suit any machine having not less than this capacity. For ML10 Lathes and other lathes with $\frac{1}{2}$ " height from top slide to centre use MA108, $\frac{3}{8}$ " square tools with MA108ZB tool boat.

Cat. No.		$\frac{1}{2}$ " Square Section
MA 109 Tungsten Carbide Tipped	MA 107 18% Tungsten Butt Welded	
Type	Type	Description
CC	C	Straight Turning R.H.
DC	D	Straight Turning L.H.
KC	K	Slight Cranked R.H.
LC	L	Slight Cranked L.H.
MC	M	Off Set, R.H.
NC	N	Off Set, L.H.
IC	I	Round Nose R.H.
JC	J	Round Nose L.H.
EC	E	Parting Tool
ESC	ES	External Screwing Tool
BTC	BT	Boring Tool
ISC	IS	Internal Screwing Tool
MA107Z	Z	Tool Boat for above

Prices for these tools are given on



Myford

LATHE TOOL

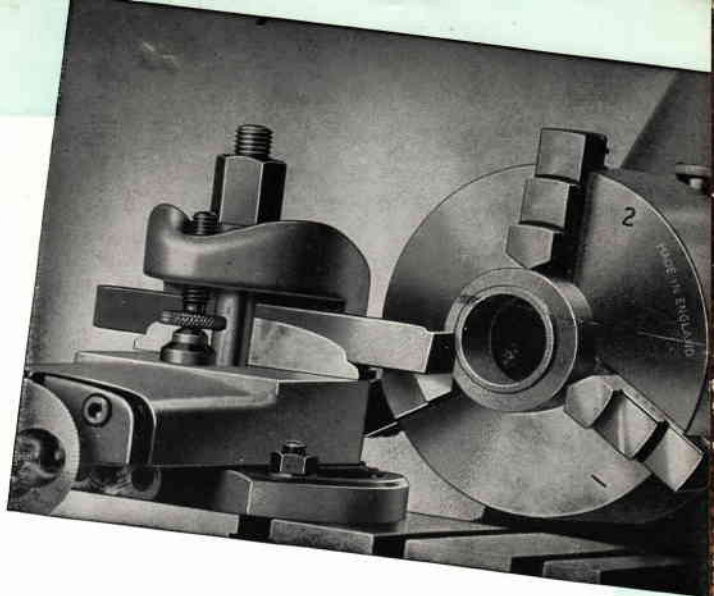
design, ground ready for use.

Cat. No.
MA 108
18%
Tungsten
Butt
Welded

$\frac{3}{8}$ " Square Section

Type	Description
CA	Straight Turning R.H.
DA	Straight Turning L.H.
KA	Slight Cranked R.H.
LA	Slight Cranked L.H.
OA	Cranked Turning (Heavy Cutting) R.H.
PA	Cranked Turning (Heavy Cutting) L.H.
IA	Round Nose R.H.
JA	Round Nose L.H.
EA	Parting Tool
ESA	External Screwing Tool
BTA	Boring Tool
ISA	Internal Screwing Tool
ZA	Tool Boat for above
ZB	Tool Boat for ML10 and other lathes with $\frac{1}{2}$ " height from top slide to centre.

Price Lists Nos. S.519 and S.1033

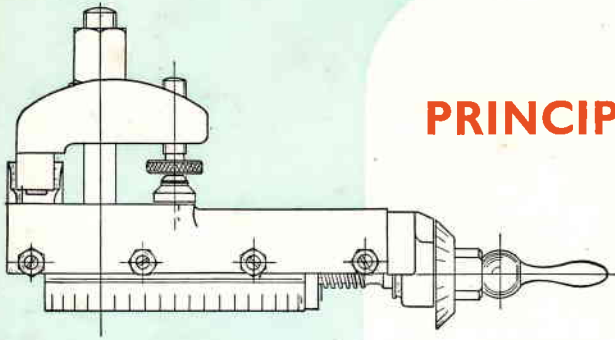


ADVANTAGES

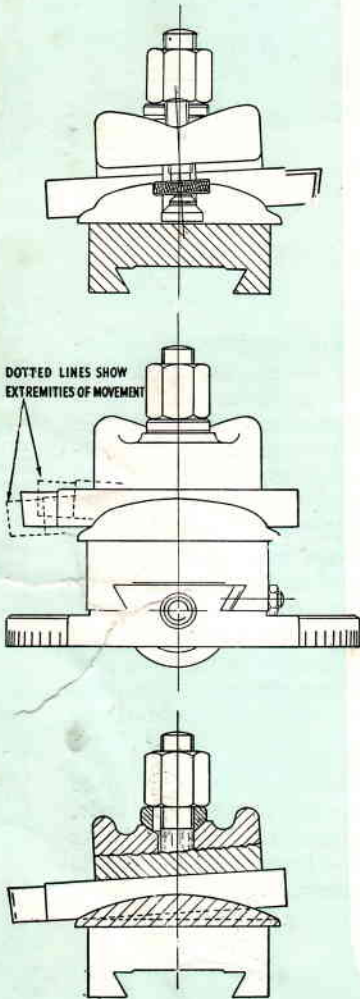
With the Myford tool, such weaknesses as overhang, insufficient support, poor and ineffective packing, are obviated. The quick-setting tool is clamped directly in the boat shaped holder to the base support and therefore none of these complications are in evidence. The annular grooves machined in tool and boat, form the radial movement to obtain exact tool centre height. The Myford tool clamp with its spherical washer forms an ideal medium for tool locking, the spherical washer enabling the clamp plate to position itself to any angle when the tool is raised or lowered. The loose heel adjusting screw now fitted to the clamp plate adds to the efficiency of the clamping, and prevents damage to the top slide surface.

Owing to the non-slip nature of the tool boat and the large area of base contact, the position of the tool remains constant when the clamping is made. The tools are quality products, their shapes being carefully selected to give the user the best possible choice of turning tools at the minimum of expense.

PRINCIPLE & OPERATION



1. Tool clamped in set position, note the large area of base contact.
2. Tool set at high limit illustrating angular movement of tool clamp with square position of adjusting screw loose heel.
3. Range of tool adjustment. The tool boat always remains in firm contact with its base support, clamping being evenly distributed over the whole area of clamping surfaces.
4. Tool shown in extreme low limit setting. This setting can be obtained by a single piece of packing placed under the tool boat for hard brass turning where tool top rake is not required. Note the actions of spherical washer and large radial clamping surface of tool.



For the efficient working of the Myford Quick-Setting Lathe Tool, the top clamp support spring should be removed. On earlier models the spherical washer will require opening out to $\frac{9}{16}$ in. bore to give full scope to the radial movement of the clamp.

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