

LEVER

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OPERATED

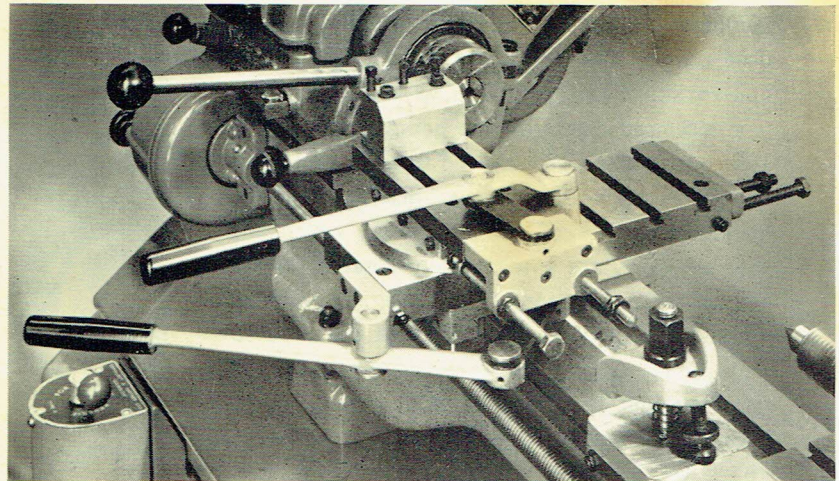
TURNING AND FACING SLIDE

No. 20/058 LEVER OPERATED TURNING AND FACING SLIDE for mounting to the bed of any standard or long bed ML7 or SUPER 7 Lathe. Adjustable stops are provided for both the cross-slide and the top-slide. These limit the movement of each slide in each direction. The top-slide can be swivelled through 360° and the base is graduated to facilitate setting. The cross-slide is provided with tee slots, so that the No. 1468 rear tool post can be mounted on it to permit tools to be used for under-cutting and so on. The tee slotted cross-slide also enables users readily to attach any special rear toolholders which they may find it desirable to make up for specific operations.

The toolholder mounted on the top-slide in the illustrations is No. 30/004 and is supplied separately, as some users may not want this item, since they may need to make up special toolholders for particular requirements. Again, the mounting of such toolholders is facilitated by the tee slots.

SPECIFICATION

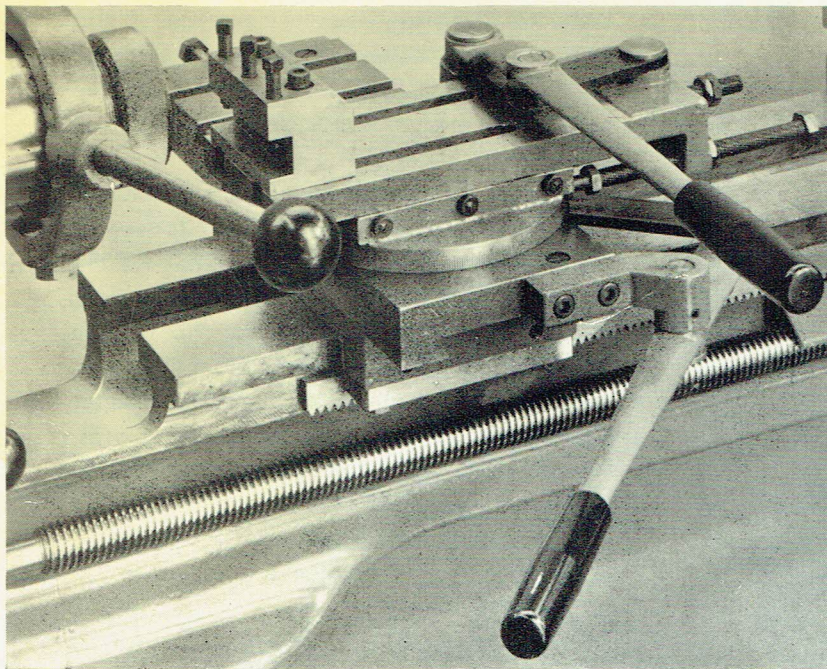
Cross-slide travel ...	4" (100 mm.)
Top-slide travel ...	3" (75 mm.)
Top-slide swivels...	360°
Top-slide base graduated either side ...	45°
Height from top-slide to Lathe centre ...	$\frac{9}{16}$ " (16 mm.)
No. 30/004 open sided toolholder for tools ...	$\frac{3}{8}$ " square (10 mm.)



**PRODUCTION
EQUIPMENT
ML7
SUPER 7**

The illustrations show a No. 20/058 slide mounted on a standard bed SUPER 7 (19" between centres) Lathe ready for use in conjunction with the No. 20/066 lever operated collet chuck. There is no necessity to remove either the saddle or tailstock and these can be seen in the bottom right hand corner of the illustration above.

This attachment has been made specially for second operation work. When using it in conjunction with the lever operated collet chuck the ML7 and SUPER 7 Lathes can be converted into high production second operation Lathes. The collet chucks are our standard, No. 20/065 for ML7 and No. 20/066 for SUPER 7. Both use the style No. 1027 collet, and have a capacity of $\frac{5}{8}$ " (16 mm.). There is sufficient length of bed even on the standard machine for the use of this attachment when the tailstock and carriage are moved as far to the right as possible. For grooving or forming, the stop screws may be used to lock the top-slide in the required position. Similarly for simple parallel or conical turning operations the stop screws may be used to lock the cross-slide.



Illustrations not binding in detail.

Designs and Specifications subject to change without notice.

5M/6/73

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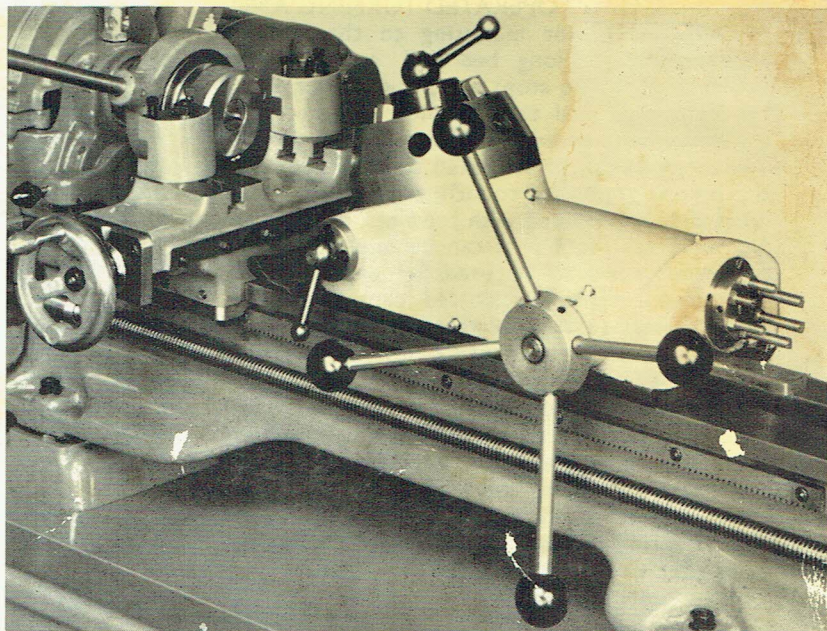
SELF-INDEXING TURRET SLIDE

20/068 SELF INDEXING TURRET SLIDE can be used on any ML7 or SUPER 7 standard or long bed Lathe. Being complete with its own base it is mounted direct on the bed and its lengthwise position can be adjusted to suit the length of the components being machined. The inclined turret head and the stops, which are coupled to it, are automatically rotated during the return movement of the slide. In addition a lever is provided at the front of the slide so that, when setting up or when only two or three stations are in use, time may be saved by rotating the turret head by hand.

When the turret is supplied from the factory with a new machine, the tool station holes are bored, though when it is supplied as an accessory for an existing machine they are left unbored, so that the machining of them can be carried out on the Lathe on which the slide is to be used, thus ensuring correct alignment with the headstock spindle.

SPECIFICATION

Useful (working) stroke ...	$2\frac{5}{8}$ " (66 mm.)
Indexing stroke	$1\frac{11}{16}$ " (42 mm.)
Total stroke	$4\frac{5}{16}$ " (109 mm.)
Angle of inclination of turret head	20°
Tool station holes	$\frac{5}{8}$ " dia.



The illustrations show the turret slide, with and without tooling, mounted on an ML7BT Lathe. Also clearly visible are the 20/065 lever operated collet chuck and 1458 cut-off slide.

PRODUCTION EQUIPMENT ML7 SUPER 7

The self indexing turret will convert either the ML7 or the SUPER 7, standard or long bed, Lathe to a capstan when the machine is also equipped with the lever operated collet chuck (20/065 for ML7, 20/066 for Super 7) and the 1458 cut-off slide, or the lever operated cut-off slide, 20/088.

For non-ferrous work the ideal combination may be in conjunction with the SUPER 7 in view of the maximum spindle speed of 2,150 R.P.M., though for work on ferrous materials, particularly where threading is required, the ML7T Lathe may be more suitable. The latter, if fitted also with a two speed motor, provides instant selection of up to 6 different spindle speeds. For example, after box-turning at say 1,280 R.P.M., depression of the appropriate lever on the Tri-Leva in conjunction with the switching of the motor will immediately give either 357 or 200 R.P.M.

All the tooling available for use with the 1408 turret attachment can be used on the new self indexing turret.

