

NeBEL

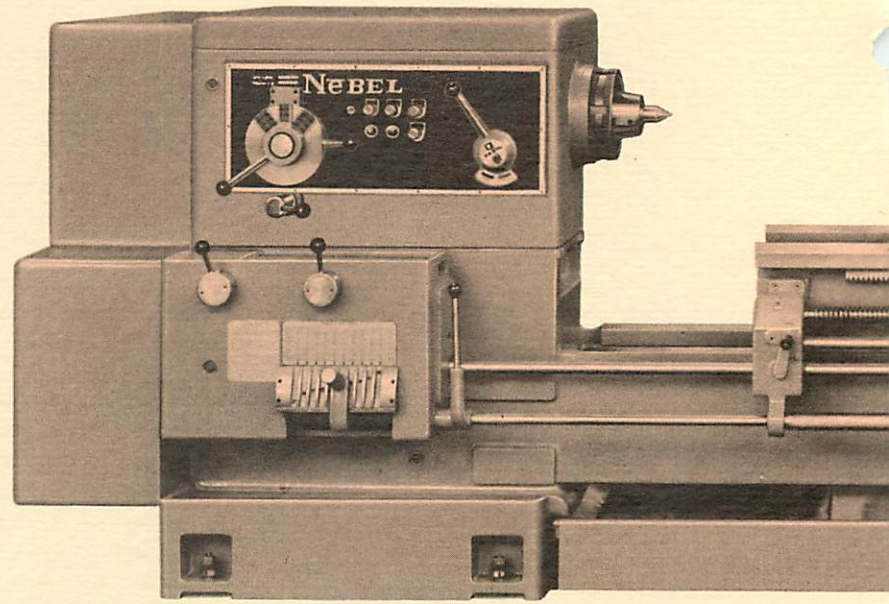
HXB 2516/49

HEAVY DUTY
EXTENSION BED
GAP LATHE

NeBEL LATHE DIVISION • NEBEL MACHINE TOOL CORP. • CINCINNATI 15, OHIO

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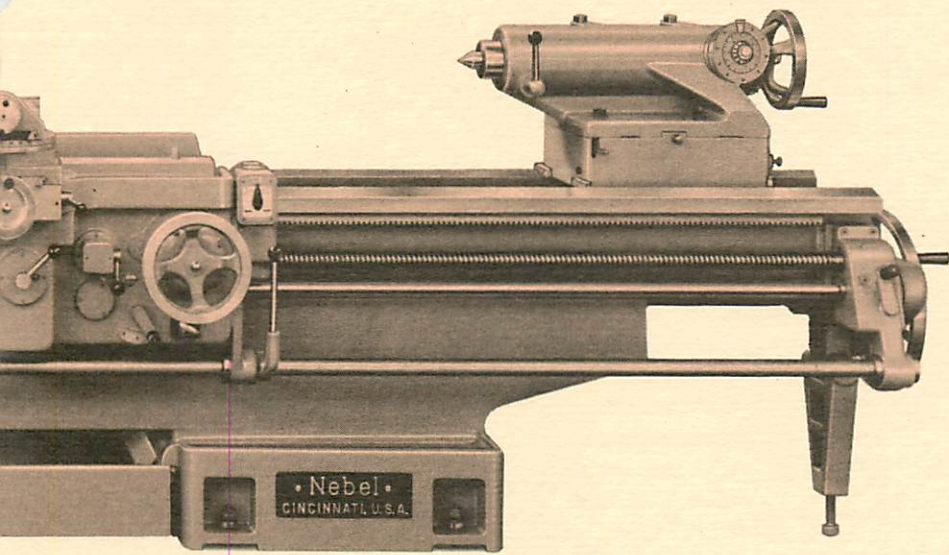


model HXB 2516/49 **NEBEL** heavy

now for the first time



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uty extension bed gap lathe

EXTENSION BED DESIGN

- Perfect alignment between the upper and lower beds is assured by means of a "V" and a flat way guide. The upper bed is moved along these guides by means of a heavy screw located in the center of the bedway guides.
- The lower bed is equipped with wipers to prevent the possibility of chips entering between the two bedway surfaces.
- The gap is opened and closed effortlessly by power traverse to the upper bed from the longitudinal feed mechanism, operated from either end of the bed, or manually through a handwheel.
- Hardened and ground steel inserted bedways, consisting of one "V" and one Flat Way, are provided on the upper bed.
- Extra wide self-aligning clamps secure the upper bed to the lower bed in position.
- Built-in single leveling support jack provides a three-point bearing suspension when the upper bed is extended.

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MODEL HXB 2516/49 EXTENSION BED GAP LATHE

also available in Model HXB 2013/46 and HXB 2516-20/54



Standard Equipment . . .

Hardened and ground cross feed screw
Bronze compensating cross feed nut
Two way power rapid traverse
Hardened and ground replaceable steel bedways,
front and rear on upper bed
40" diameter face plate
12" diameter driver plate
Single screw tool post or four stud tool post

Compound rest with hardened and ground feed screw
and hinged dirt guard
Chasing dial
Single point leveling support for upper bed
Hardened and ground tailstock spindle with hardened
insert tang slot
Direct reading tailstock spindle traverse indicator
Shear wipers on carriage, tailstock and lower bedways
Centers and necessary wrenches

For each 24" increase in center distance with upper bed closed, the center distance with upper bed open and the overall length increase 36" and the length of the gap increases 12".

Extra Equipment . . .

Hydraulic duplicating attachment (fixed 45 degree, front
swivel mounted or universal longitudinal type)
Telescopic taper attachment
Coolant pan
Coolant pump and equipment
Steady rest
Follow rest
24" diameter face plate
Four way tool block
Connected rests
Plain block rests
Metric translating gears
Micrometer carriage stop

Ball bearing center
Multiple carriage stop, six position, with adjustment
screws for use on either side of carriage
Single or multiple position cross feed stop for inside
and outside location when turning or boring
Two speed tailstock with direct reading spindle
traverse indicator
Anti-friction tailstock spindle
Collet chuck attachment and collets
Revolving ball bearing pipe centers
Electric clutch and brake
Hardened and ground cross slide ways
Hardened and ground lead screw
Additional special accessories available on request

Capacity

Swing over bedways and carriage wings	26 $\frac{3}{8}$ "
Swing over compound rest or cross slide	16"
Swing in gap	49 $\frac{1}{2}$ "
Distance face plate to end of gap	28 $\frac{3}{4}$ "
Distance between centers, base length	48"
Distance between centers, base length, gap closed	48"
Distance between centers, base length, gap opened	84"
Center distance increases in increments of	24"
Size of tool	$\frac{3}{4}$ " x 1 $\frac{1}{8}$ "
Steady rest capacity	$\frac{1}{2}$ " - 7"
Follow rest capacity	$\frac{1}{2}$ " - 5 $\frac{1}{2}$ "
Face plate, large, diameter	40"
Driver plate, diameter	12"

Headstock

Spindle speeds, number, single speed motor	18
two-speed motor	36
Spindle speed range, 1200 RPM motor	11 - 666
1800 RPM motor	16 - 1000
1800 RPM motor	24 - 1500
1200/600 RPM motor	5 $\frac{1}{2}$ - 666
1800/900 RPM motor	8 - 1000
1800/900 RPM motor	12 - 1500
Spindle bearings, number	3
Journal diameters:	
Front	4"
Center	3 $\frac{3}{4}$ "
Rear	2 $\frac{3}{4}$ "
Front spindle bearing, precision, tapered roller:	
Outside diameter	7 $\frac{1}{2}$ "
Radial load, 100 RPM, pounds	26,400
Thrust load, 100 RPM, pounds	17,500
Center spindle bearing, precision, tapered roller:	
Outside diameter	6 $\frac{3}{8}$ "
Radial load, 100 RPM, pounds	18,600
Thrust load, 100 RPM, pounds	12,500
Rear spindle bearing:	
Outside diameter	5"
Radial load, 100 RPM, pounds	13,000
Spindle size of hole, straight	2 $\frac{1}{32}$ "
Spindle size of tapered hole, (American Standard)	#250
Spindle size of center, Morse No.	5
Spindle nose, long taper key, size No.	L-2
Camlock	8" - D-1
Headstock length on bed	37"

Bed

Length, base length	8'8 $\frac{1}{2}$ "
Length, top bed, base length	7'2"
Length, bottom bed, base length	10'0 $\frac{1}{2}$ "
Length increases in increments of	24"
Width across ways	22 $\frac{3}{8}$ "
Depth, top bed	12 $\frac{13}{16}$ "
Depth, bottom bed	13 $\frac{1}{16}$ "

Carriage

Length on ways	29"
Bearing surface square inches	146"
Cross slide, travel with or without taper attachment	27"
Compound rest travel	7"
Bridge width	11 $\frac{1}{2}$ "
Lubrication type	one shot
Rapid traverse travel—in./min.	240"

Feeds & Threads

Feed changes, number	60
Range in gear drive0027" - .195"
Thread changes, number	60
Threads per inch, range	1 - 72
Leadscrew diameter	1 $\frac{3}{4}$ "
Leadscrew threads per inch	2

Taper Attachment (telescopic)

Maximum taper per foot	4 $\frac{1}{2}$ "
Turns at one setting	24"

Tailstock

Spindle diameter	4"
Center, Morse No. (American Standard)	5
Spindle travel	10 $\frac{1}{2}$ "
Spindle set over, right or left	1"
Length on ways	18 $\frac{1}{2}$ "

Main Drive Motor

Motor capacity, 1200 rpm	20 HP
1800 rpm	25 HP

Weight and Dimensions

Domestic shipping weight, pounds	13,595
Net weight, each additional 24" length, pounds	850
Floor space required, base length	79 $\frac{1}{2}$ " x 184"
Distance, spindle center to floor	46 $\frac{7}{8}$ "