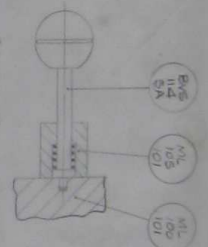
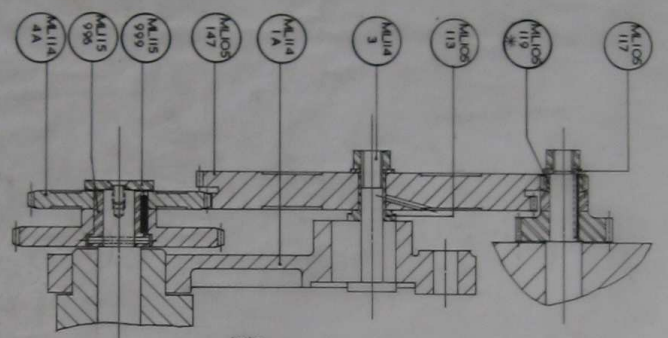
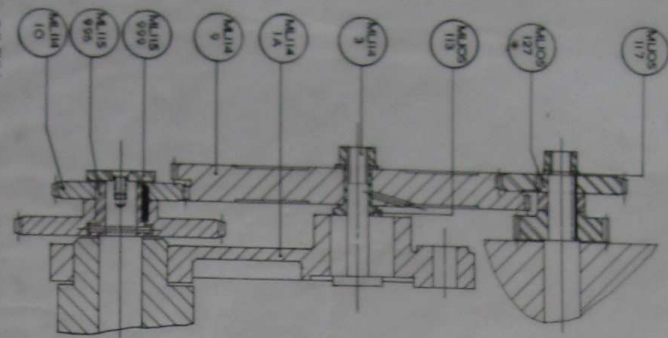
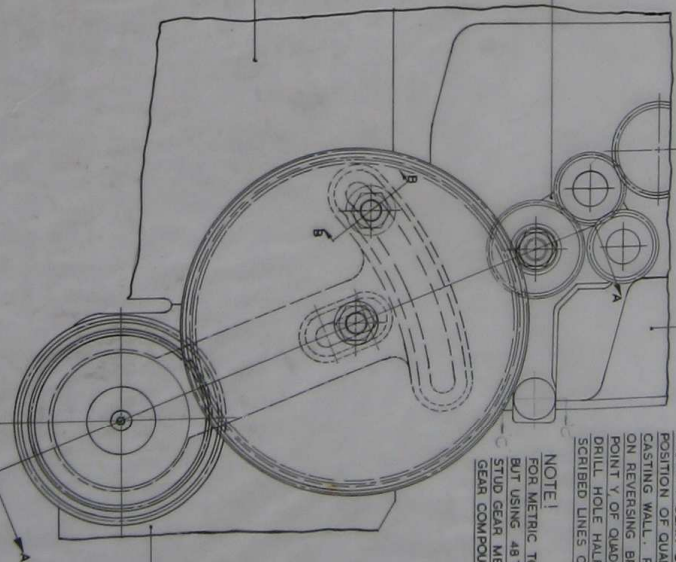


METRIC TO ENGLISH CONVERSION  
 3 M LEAD SCREW  
 \* STD. STUD GEARS SUPPLIED: 48T-ML105/127,  
 48T-ML114/13, 52T-ML105/128, 54T-ML105/29

ENGLISH TO METRIC CONVERSION  
 8 TRI. LEAD SCREW  
 \* STD. STUD GEARS SUPPLIED: 16T-ML105/119,  
 24T-ML105/131, 26T-ML105/139, 48T-ML105/127,  
 56T-ML105/100, 60T-ML105/131, 64T-ML114/5,  
 66T-ML114/7



OUTLINE OF HEADSTOCK ML105/101A  
 FOR ARR'T SEE ML105/100B



NOTE  
 FOR METRIC TO ENGLISH: AS ABOVE  
 BUT USING 48T STUD GEAR & 54T  
 STUD GEAR MESHING WITH 132/135 T  
 GEAR COMPOUND

CHART CHIALI 2 X FULL

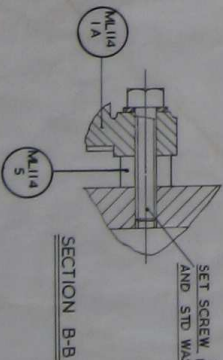
TOP LAYER	54	48	54	49	54	52	54	STUD GEAR	DIAL READING
1	1	2	2	3	4	5			
4	4	5	5	6	6	7		10000	
8	9	10	11	12	13	14		10000	
16	18	20	22	24	26	28		10000	

METRIC TO ENGLISH TRANSPOSING GEAR AND GEAR BOX POSITIONS

DENFORD MACHINE TOOLS LTD.  
 BRIGHOUSE YORKSHIRE

LEFT LAYER	64	66	60	48	48	56	56	DIAL READING
6.0	5.0	4.5	4.0	3.5	3.0			
6.0	5.0	4.5	4.0	3.5	3.0			
3.0	2.75	2.5	2.25	2.0	1.75			
3.0	3.00	3.00	2.66	2.40	2.10			
4.50	4.20	3.82	3.43	3.04	2.67			
1.80	1.65	1.50	1.35	1.20	1.05			

W.P. = SLIDING  
 W.R. = ISURFACING,  
 AND DISBURCUTTING  
 PITCHES SHOWN IN  
 M.M. OPER. REV. OF  
 HD STOCK SPINDLE



5" VICEROY GB

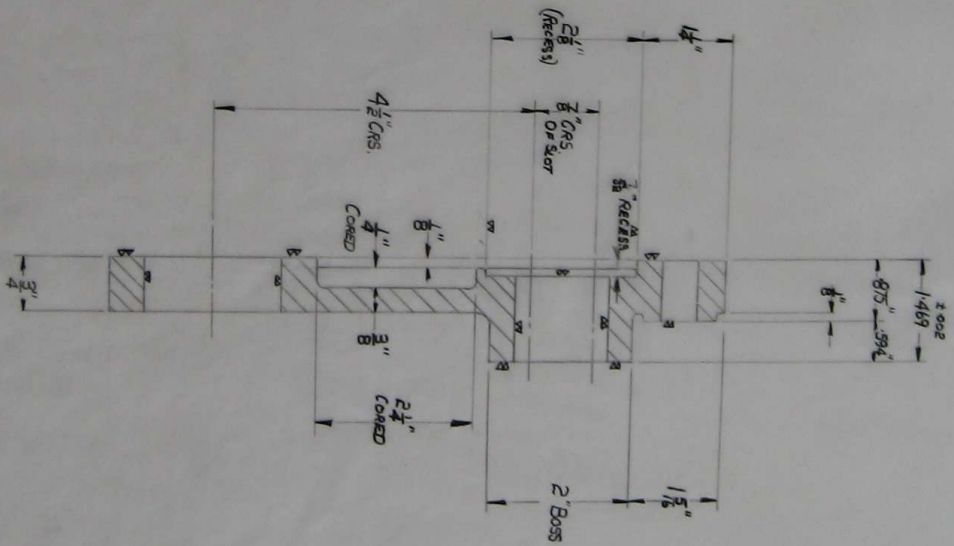
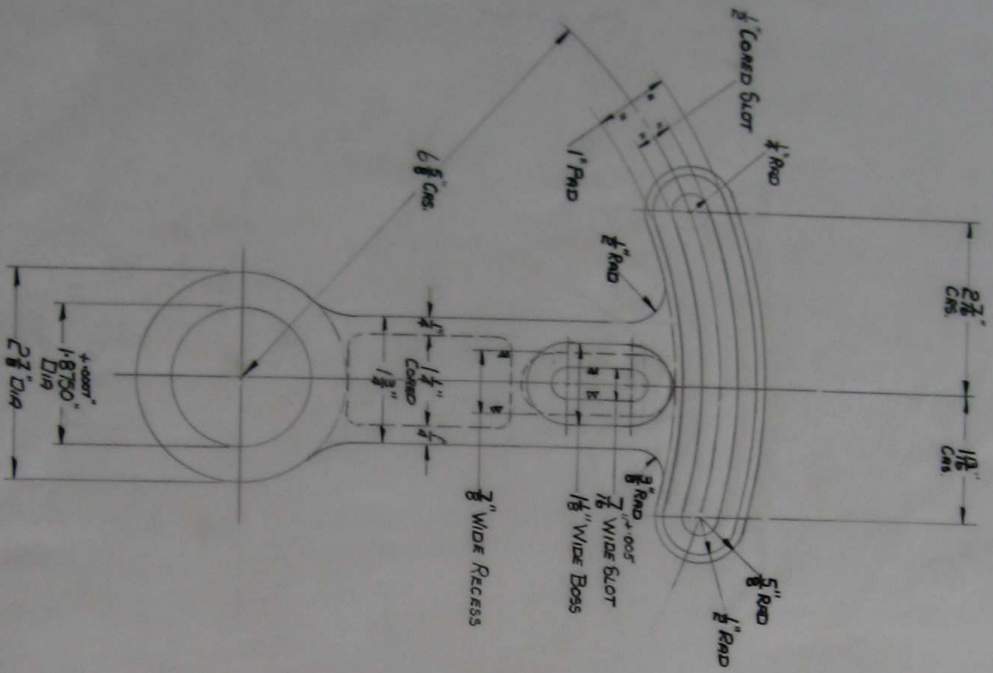
LATHE - METRIC AND ENGLISH TRANSPOSING SET UP

DRAWING No. ML 114

DATE: 14-4-72

SCALE: FULL

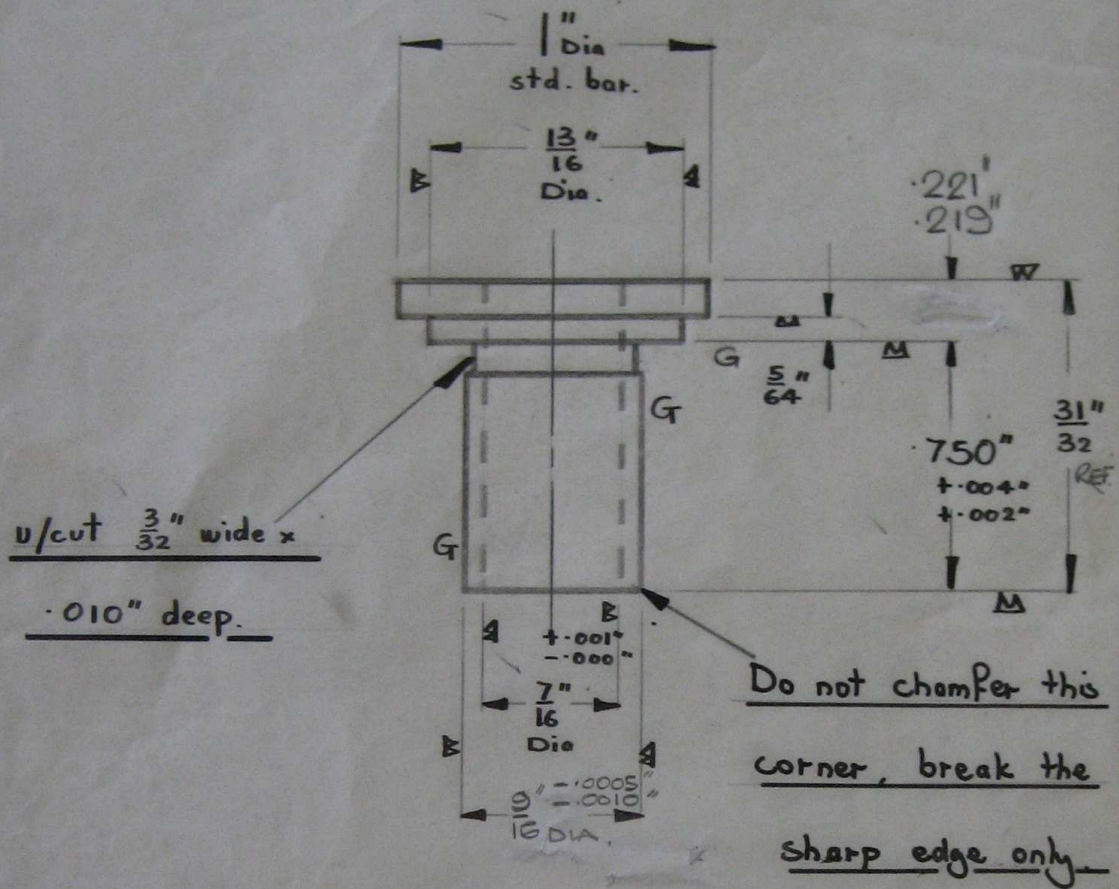
IF IN DOUBT ASK



DRG. No.

DESCRIPTION	ALTERATIONS	LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED: ANGULAR ± 1/2° 3 PLACE DECIMAL ± .005° RATIONAL ± .001" 4 PLACE DECIMAL ± .0005"	DATE: <b>C.T.</b>	MATERIAL: <b>CASTING</b>	DRAWN: <b>J.P.</b>	TRACED:	CHECKED:	APPROVED:	DATE: <b>31-3-72</b>	SCALE: <b>FULL</b>
DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.			5" VIDEROL G.B. LATHE : METRIC TRANSPOSING GEARS QUADRANT			DRAWING No. M.L. 114/1A				

IF IN DOUBT ASK.



Cyanide Harden

Grind at 'G'

Machine at w

5" Viceroy Metal Lathe : Spacing Bush.

DENFORD MACHINE TOOLS LTD.  
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.  
BRIGHOUSE,  
YORKSHIRE.

DRAWN M. M. Souden  
CHECKED AS  
PASSED  
DATE 27.1.65

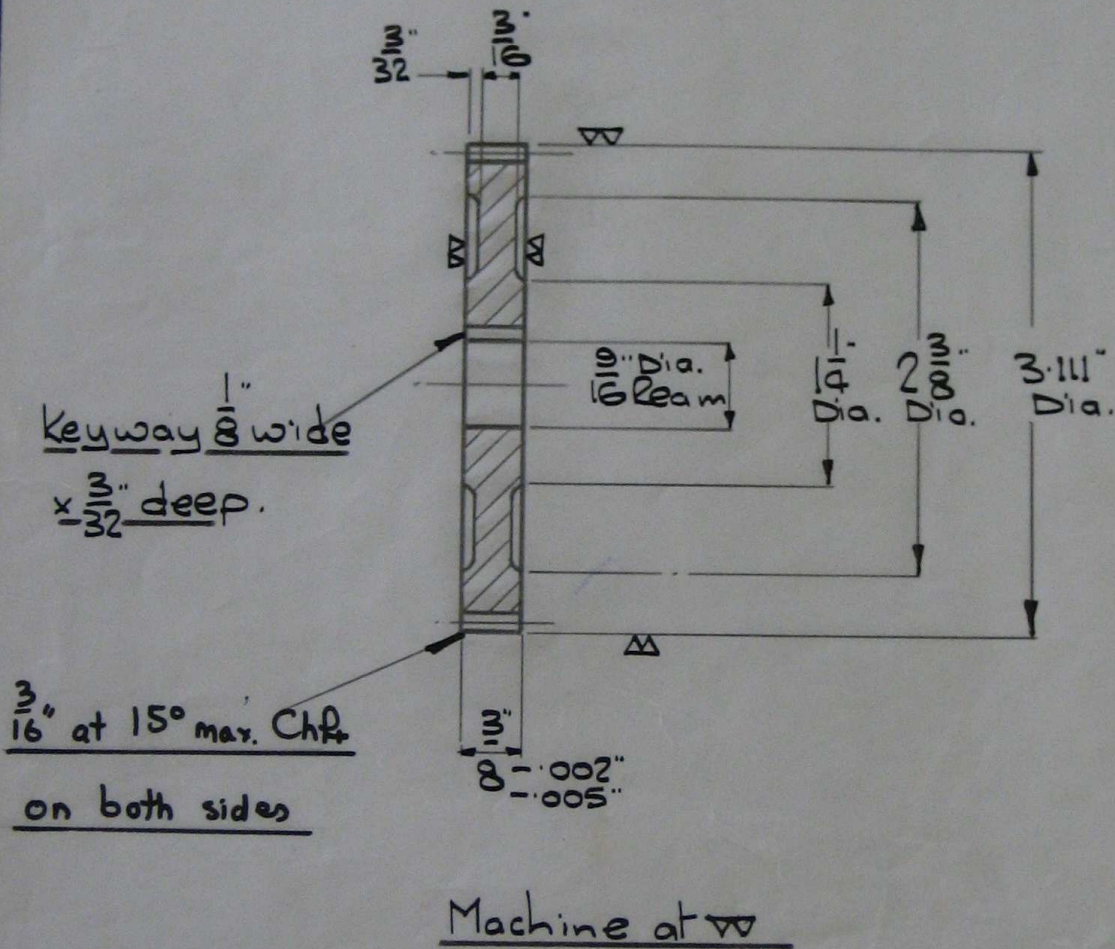
MAT. Mild Steel Cyanide Hd.  
MAT SIZE 1" Dia x 1 1/4" long  
No. REQD. 2 SCALE 2 x Full  
DRAWING No. ML105/113

IF IN DOUBT ASK.

1303/66 8-3-66 S

CALIPER SETTINGS	
ADD.	.056"
WIDTH	.086"
	.084"

No. TEETH	54
PITCH	18 D.P.
PRESS. $\angle$	20°
P.C.D.	3.000"



5" Metal Turning Lathe - 54T. CHANGE WHEEL.

DENFORD MACHINE TOOLS LTD.  
 (Inc.) DENFORD SMALL TOOLS (BRIG) LTD.  
 BRIGHOUSE,  
 YORKSHIRE.

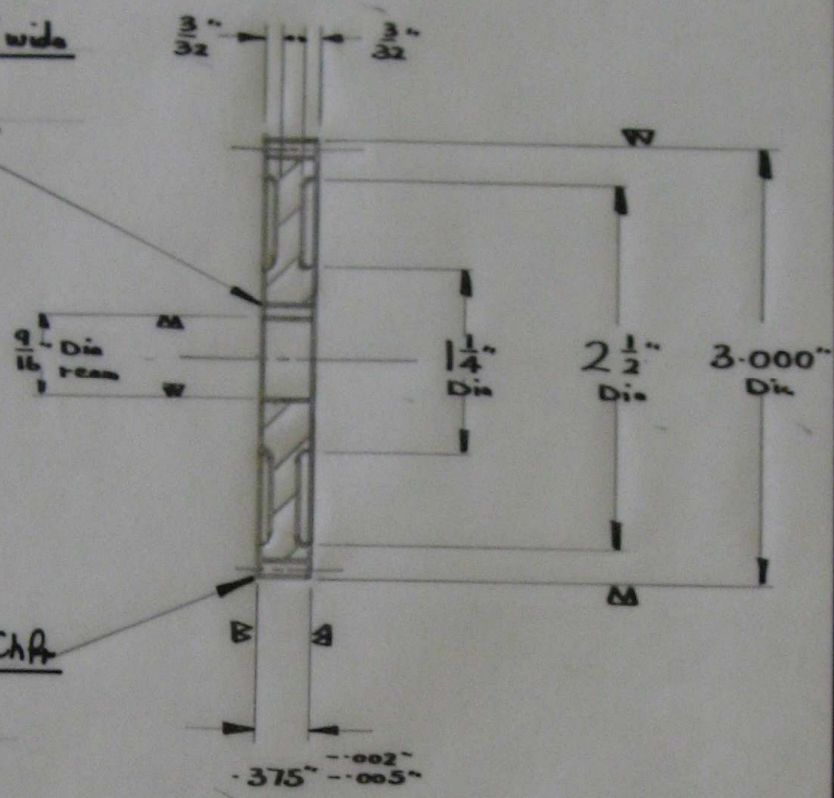
DRAWN *A. C. S. G. G. G.*  
 CHECKED *[Signature]*  
 PASSED  
 DATE 1.4.64.

MAT. CAST IRON.  
 MAT SIZE CASTING.  
 No. REQD. 1 | SCALE FULL.  
 DRAWING No. M.L. 105/129

IF IN DOUBT ASK.

Rev. 11-6-65  
1303/66 B-366

Keyway:  $\frac{1}{8}$ " wide  
x  $\frac{3}{32}$ " deep



$\frac{3}{16}$ " at 15° max. Chf.  
on both sides

Machine at W

Caliper Settings.	
Add.	.056"
Width	.086"
	.084"

N° of Teeth	52
Pitch	18 D.P.
Press. Angle	20°
P.C.D.	2.888"

5" Viceroy P.C.S. Lathe : 52 r Change Wheel.

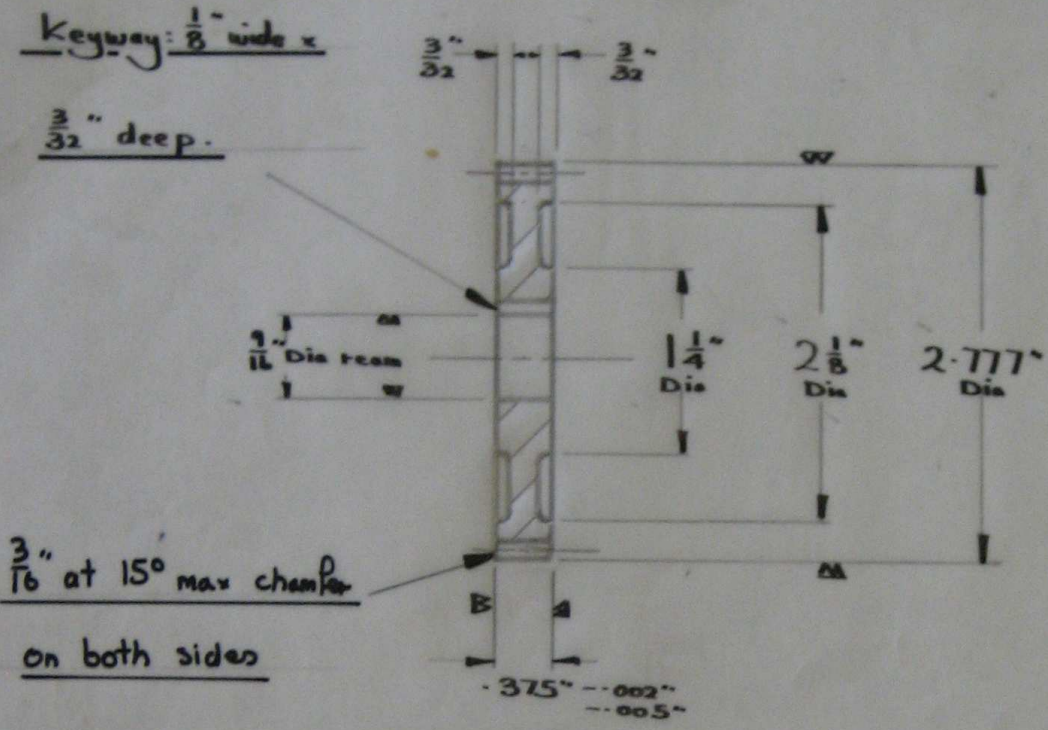
DENFORD MACHINE TOOLS LTD.  
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.  
BRIGHOUSE,  
YORKSHIRE.

DRAWN M.M.Soudan  
CHECKED  
PASSED  
DATE 11-6-65

MAT. C.I.  
MAT SIZE Casting  
No. REQD. 1 SCALE Full  
DRAWING No. ML105/128

IF IN DOUBT ASK.

Revised 11-6-65  
1303/66 8-3668



Machine at W

Caliper Settings	
Add.	.056"
Width	.086"
	.084"

N° of Teeth	48
Pitch	18 D.P.
Press Angle	20°
P.C.D.	2.666"

5" Viceroy P.C.S. Lathe : 48T Change Wheel.

DENFORD MACHINE TOOLS LTD.  
(INC.) DENFORD SMALL TOOLS (BRIG) LTD.  
BRIGHOUSE,  
YORKSHIRE.

DRAWN M.M.Souden  
CHECKED  
PASSED  
DATE 11-6-65

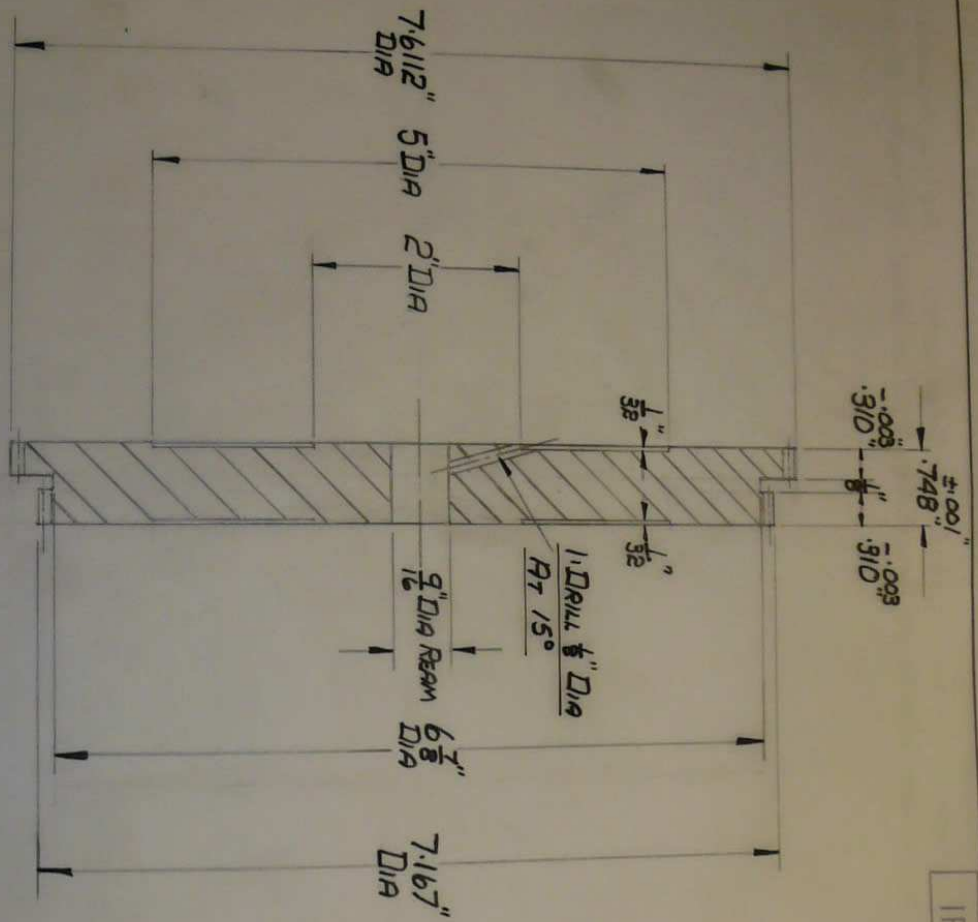
MAT. C.I.  
MAT SIZE Casting  
No. REQD. 1 SCALE Full  
DRAWING No. ML 105/127

IF IN DOUBT ASK.

DRG. No.

N° OF TEETH	135
PRESS. $\angle$	20°
PITCH	18 D.P.
P.C.D.	7.5000"

CALIPER SETTINGS	
RDD	.0558
WIDTH	.086



N° OF TEETH	127
PRESS. $\angle$	20°
PITCH	18 D.P.
P.C.D.	7.0556

CALIPER SETTINGS	
RDD	.0558
WIDTH	.086

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

5" VICEROY G.B. LATHE - 1357/1277 GEAR.

No.	1357/1277 - 6922 JB
DESCRIPTION	
CHKD/APPD.	
DATE	
ALTERATIONS	


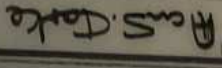
LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.  
 ANGULAR  $\pm \frac{1}{2}^\circ$  3 PLACE DECIMAL  $\pm .005^\circ$   
 RATIONAL  $\pm .010$  4 PLACE DECIMAL  $\pm .0005$

MATL. C.I.  
 MATL. SIZE CASTING  
 No. RECD. 1  
 MACHINE ALL OVER  
 GRIND AT G

DRAWN	J.P.	TRACED	CHECKED	APPROVED	DATE	SCALE
					31-3-72	FULL

DRAWING NO. M.L. 114/9

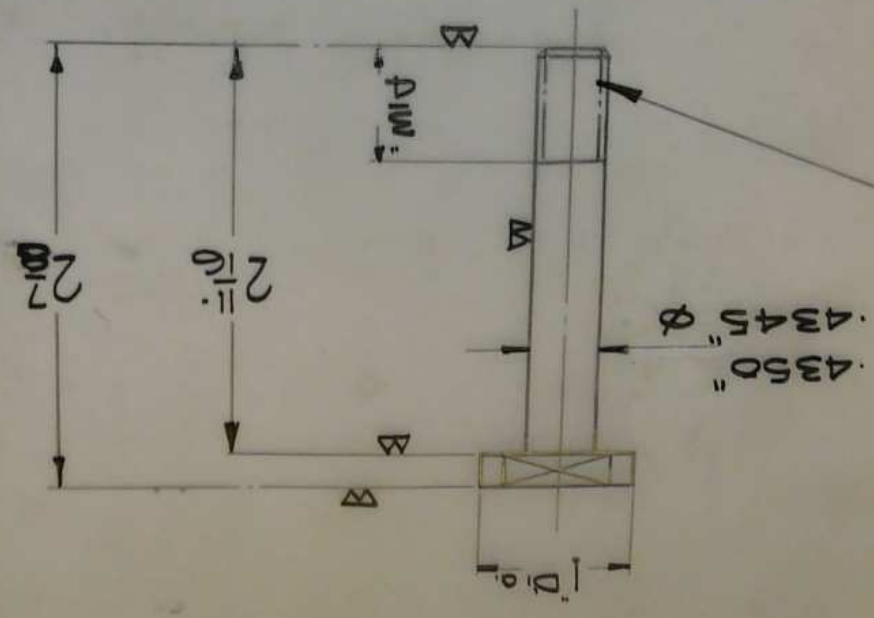
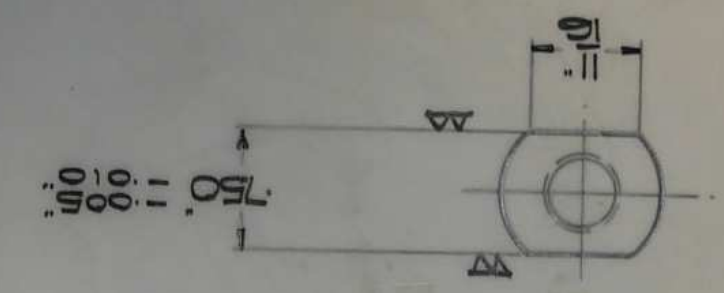
DENFORD MACHINE TOOLS LTD.  
 (The) DENFORD SMALL TOOLS (BRIG) LTD.  
 BRIGHOUSE,  
 YORKSHIRE

DATE 25.8.63.  
 PASSED  
 CHECKED   
 DRAWN 

MAT. M.S.  
 MAT SIZE 1" dia. x 3 1/8"  
 No. RECD 2 SCALE Full.  
 DRAWING No. M.L.114/3

5" Viceroy Metal Lathe - INTERMEDIATE STUD (TRANS. CEAS.)

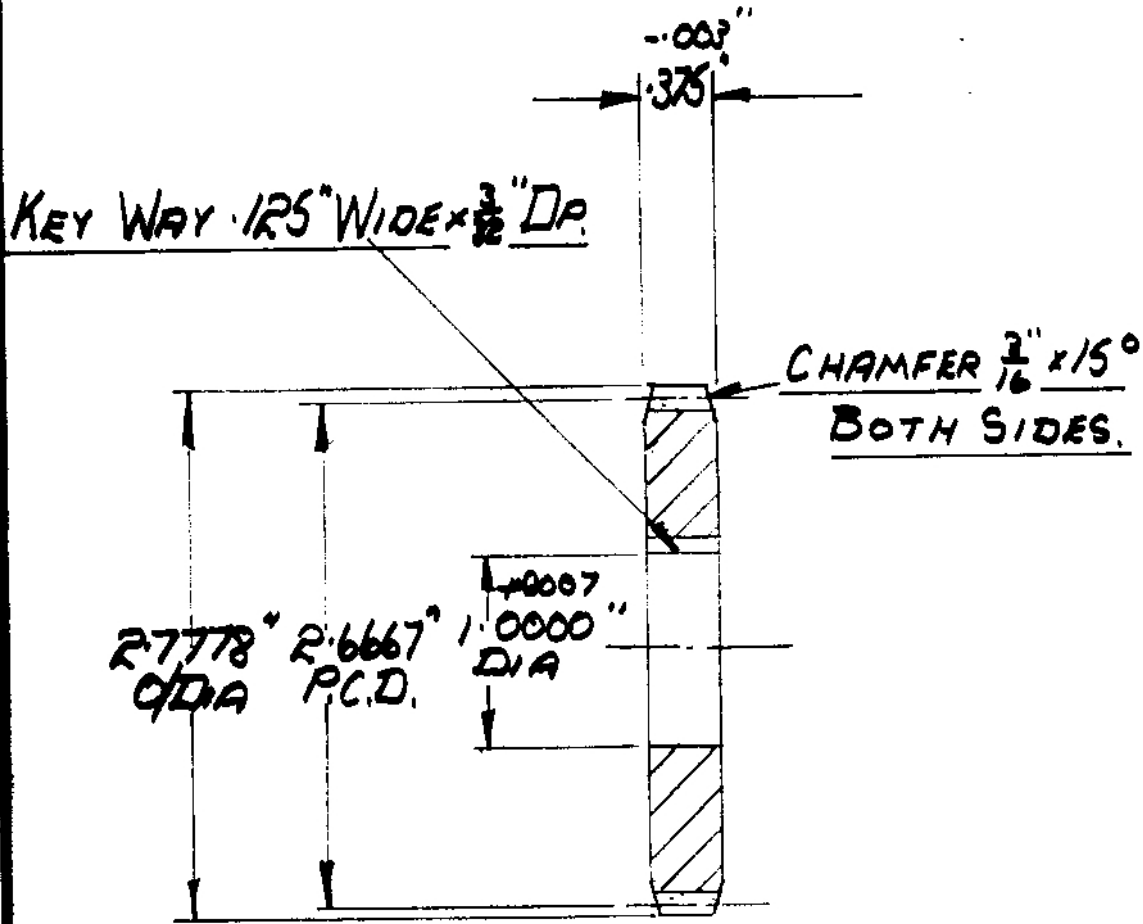
~~Chowdhury~~  
 Machine of V.



IF IN DOUBT ASK.

1807/71.25.2.71





48 TEETH 18 D.P.  
20° PRESSURE ANGLE.  
WHOLE TOOTH DEPTH .1198"


MACHINE ALL OVER

CALIPER SETTINGS.	
ADD.	.056
WIDTH	.086
	.084

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

5" VICEROY G.B. LATHE - 48 T. GEAR (TRANSPOSING SET UP)

DENFORD MACHINE TOOLS LTD.  
 (INC.) DENFORD SMALL TOOLS (BRIG) LTD.  
 BRIGHOUSE,  
 YORKSHIRE.

DRAWN J.P.  
 CHECKED   
 PASSED  
 DATE 5-4-72

MAT. C.I.  
 MAT. SIZE CASTING  
 No. REQD. 1 SCALE F  
 DRAWING No. ML 114/10