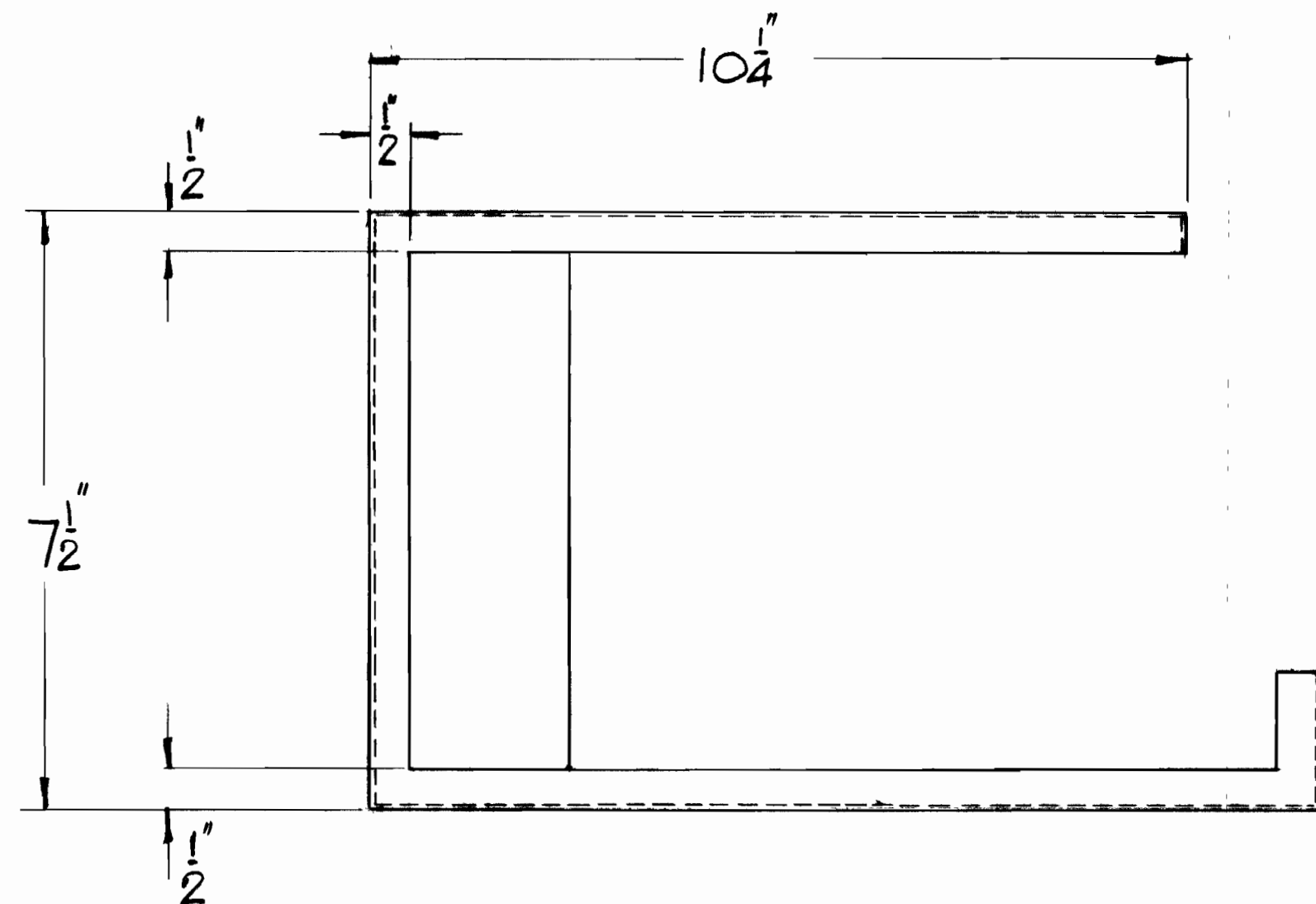


DRG. No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROY DRILLING MACHINE - MOTOR COVER

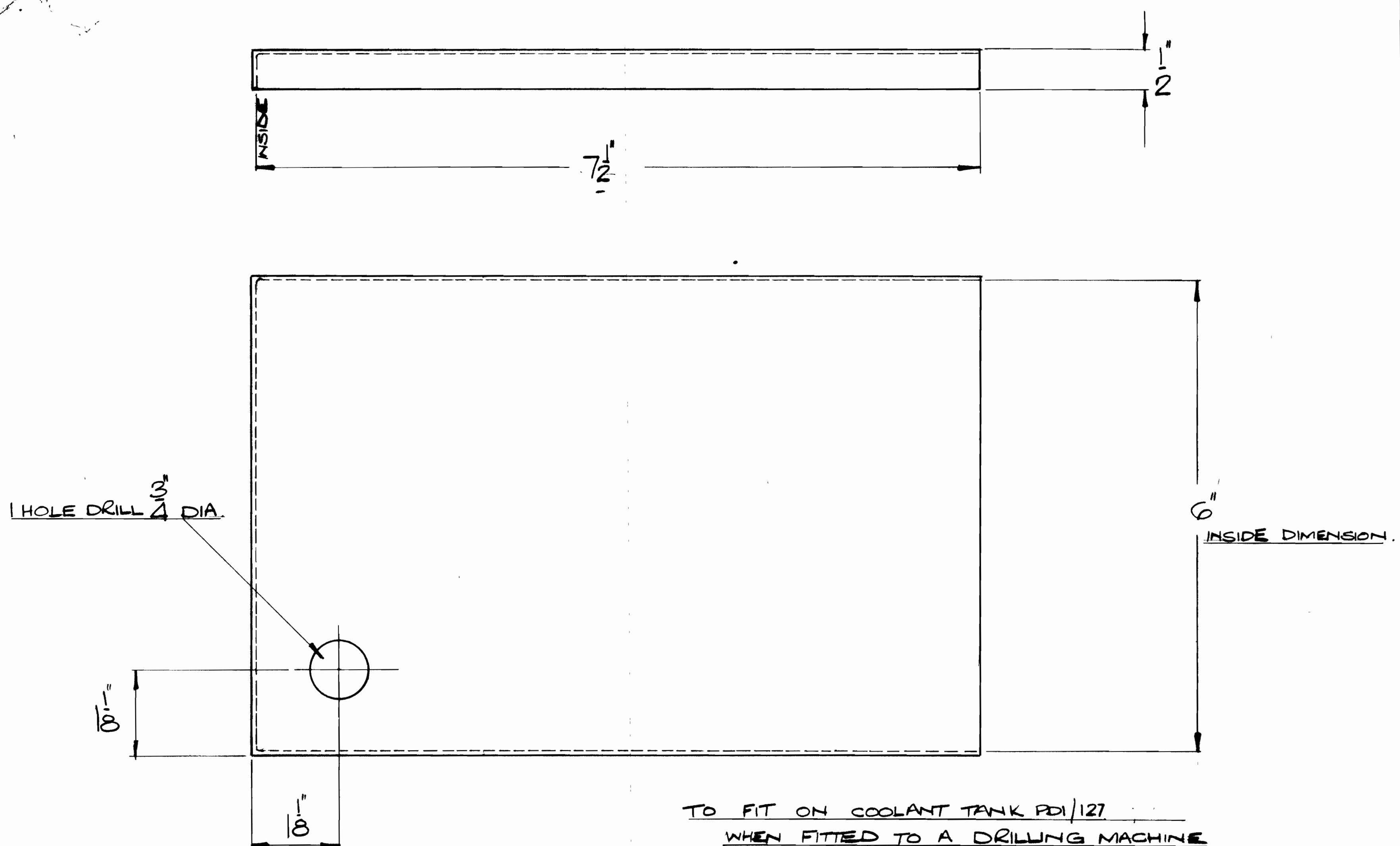
No.	258578 .30.878 W	DESCRIPTION	DATE
		ALTERATIONS	

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
 ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005$
 RATIONAL $\pm .016$ 4 PLACE DECIMAL $\pm .0005$

MATL.	SHEET STEEL
MATL. SIZE	16 SWG
No. REQD.	1
MACHINE AT	W
GRIND AT	G

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				30.878	1/2 Full

DRAWING No. PDI/123.A.



DRG. No.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROY DRILLING MACHINE - COOLANT TANK LID.

2844/82.16 6 82.14			
No.	DESCRIPTION	DATE	DATE
	ALTERATIONS		

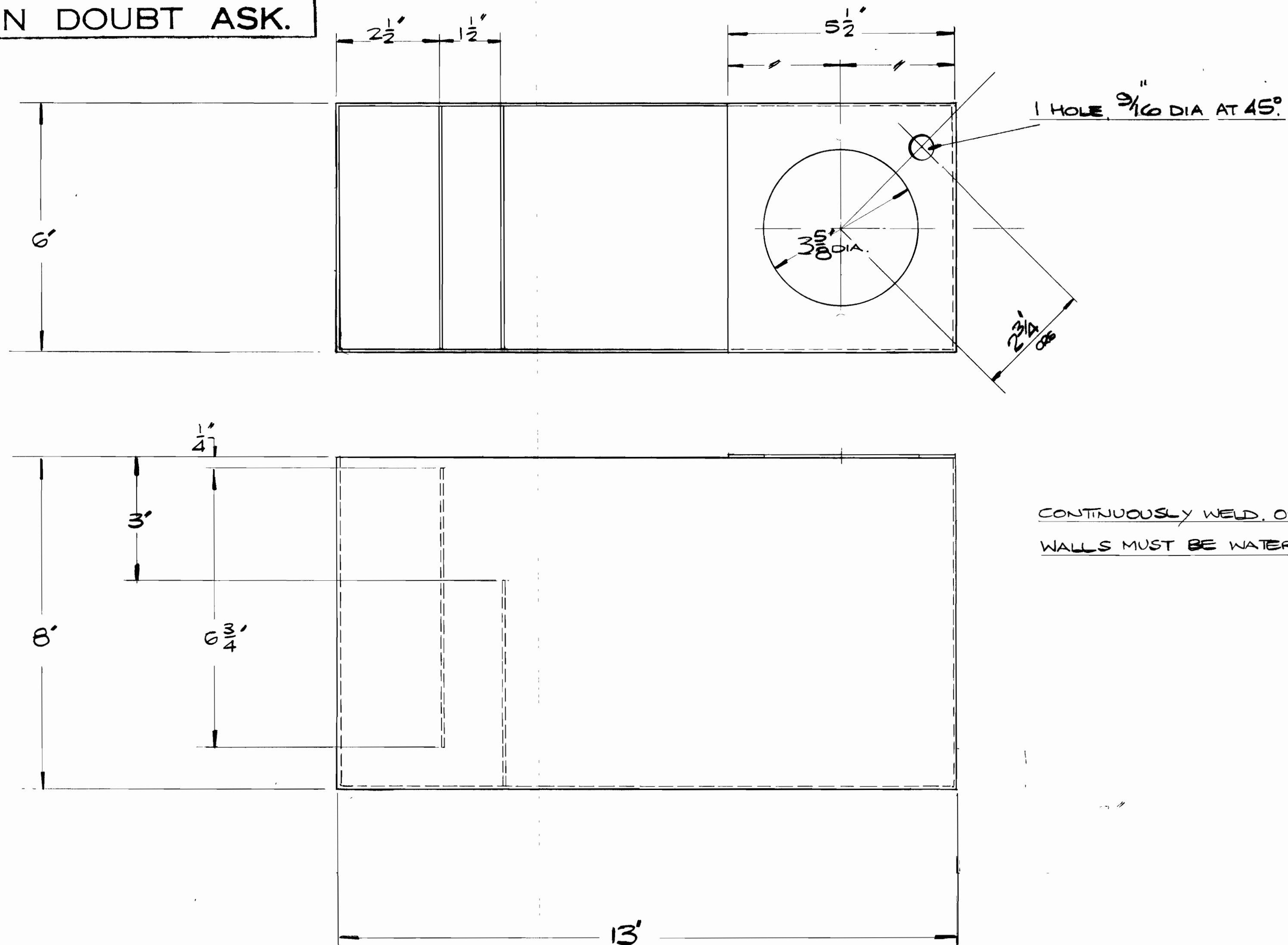
LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
RACTIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$

MATL SHEET STEEL.
MATL. SIZE 16 SW.G.
No. REQD. 1
MACHINE AT W
GRIND AT 'G'.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				8/17	FULL

DRAWING No. PDI-125

IF IN DOUBT ASK.



DRG. No.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROY DRILLING MACHINE - COOLANT TANK.

REDRAWN 2.8.78					
2844/82					
No.	DESCRIPTION	CHKD	APPD	DATE	
ALTERATIONS					

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

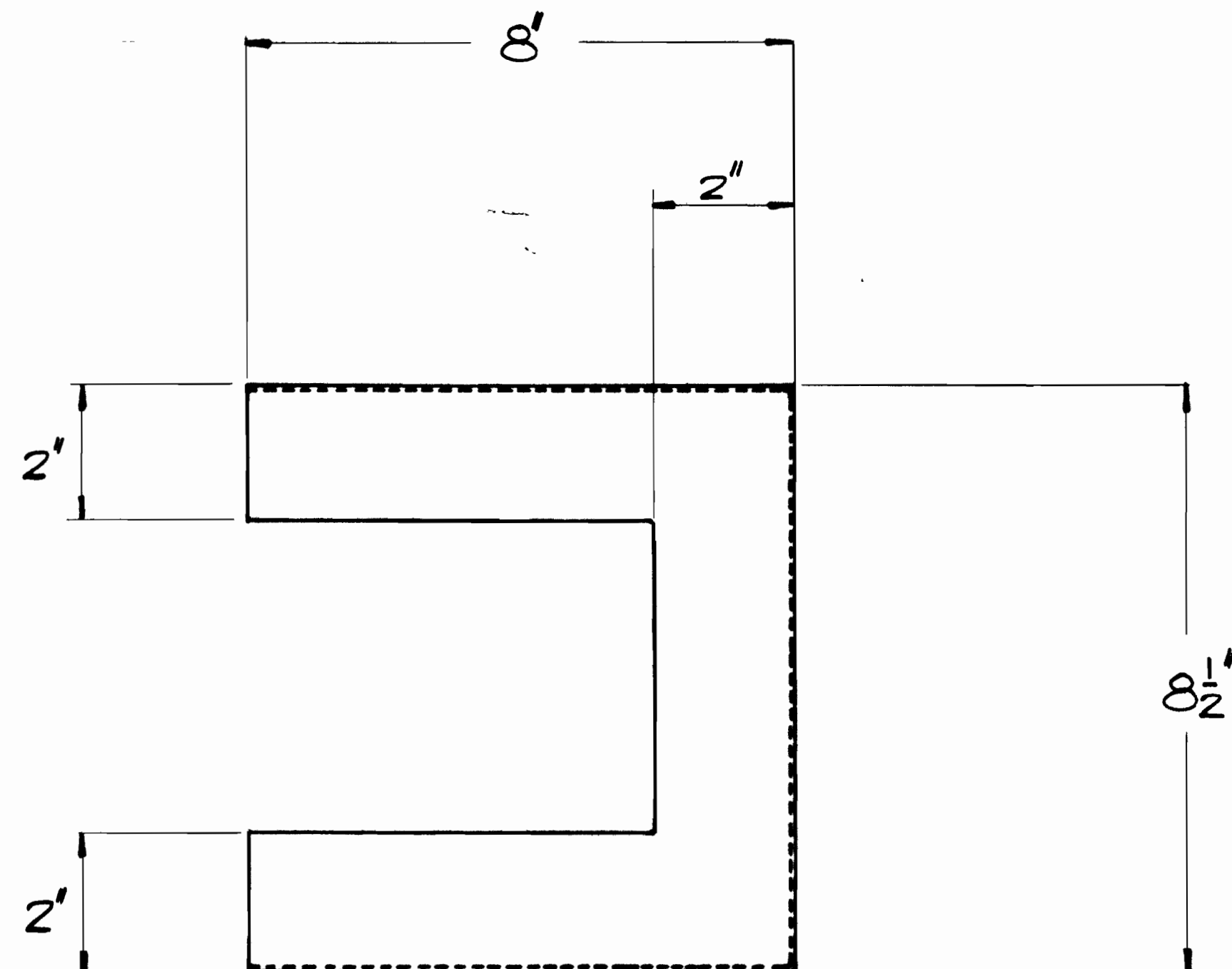
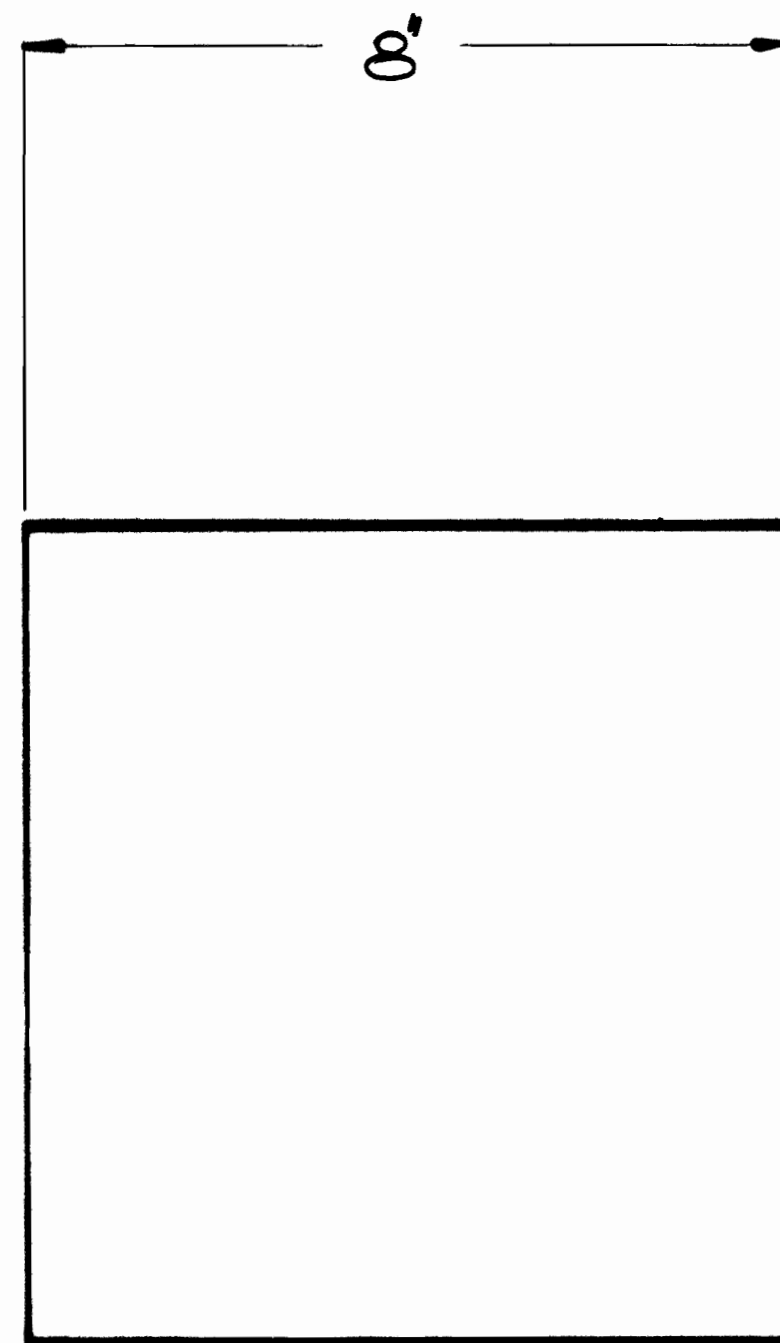
MATL SHEET STEEL.
MATL SIZE 16 SWG
No REQD. 1.
MACHINE AT W
GRIND AT 16

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
RD				2.8.78	$\frac{1}{2} = \text{FULL}$

DRAWING No. PDI/127.

3RD ANGLE PROJECTION.

DRG. No.



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

'VICEROY' 4 SPEED DRILL - MOTOR COVER (ASEA)

No.	DESCRIPTION	CHKD APP'D	DATE
ALTERATIONS			

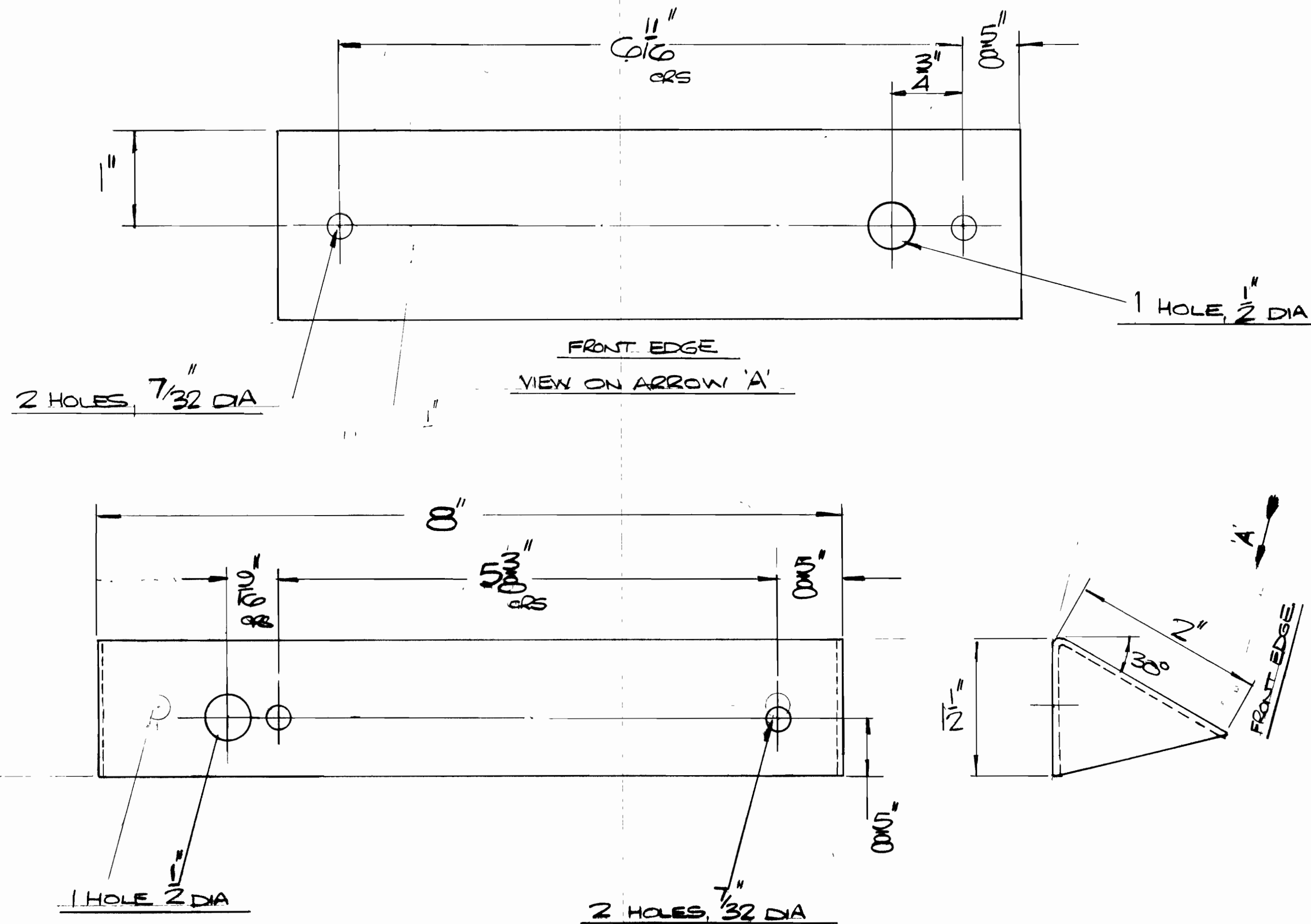
LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
FRACTIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$

MATL. MILD STEEL SHEET.
MATL. SIZE 16 S.W.G.
No. REQD. ONE per m/c
MACHINE AT 99
GRIND AT 'G'.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				12.3.80	$\frac{1}{2}$ x FULL

DRAWING No. PD1-132

DRG. No.



DEN-CRD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE

DRILLS & GRINDERS - FOOT "KNOCK OFF" PLATFORM

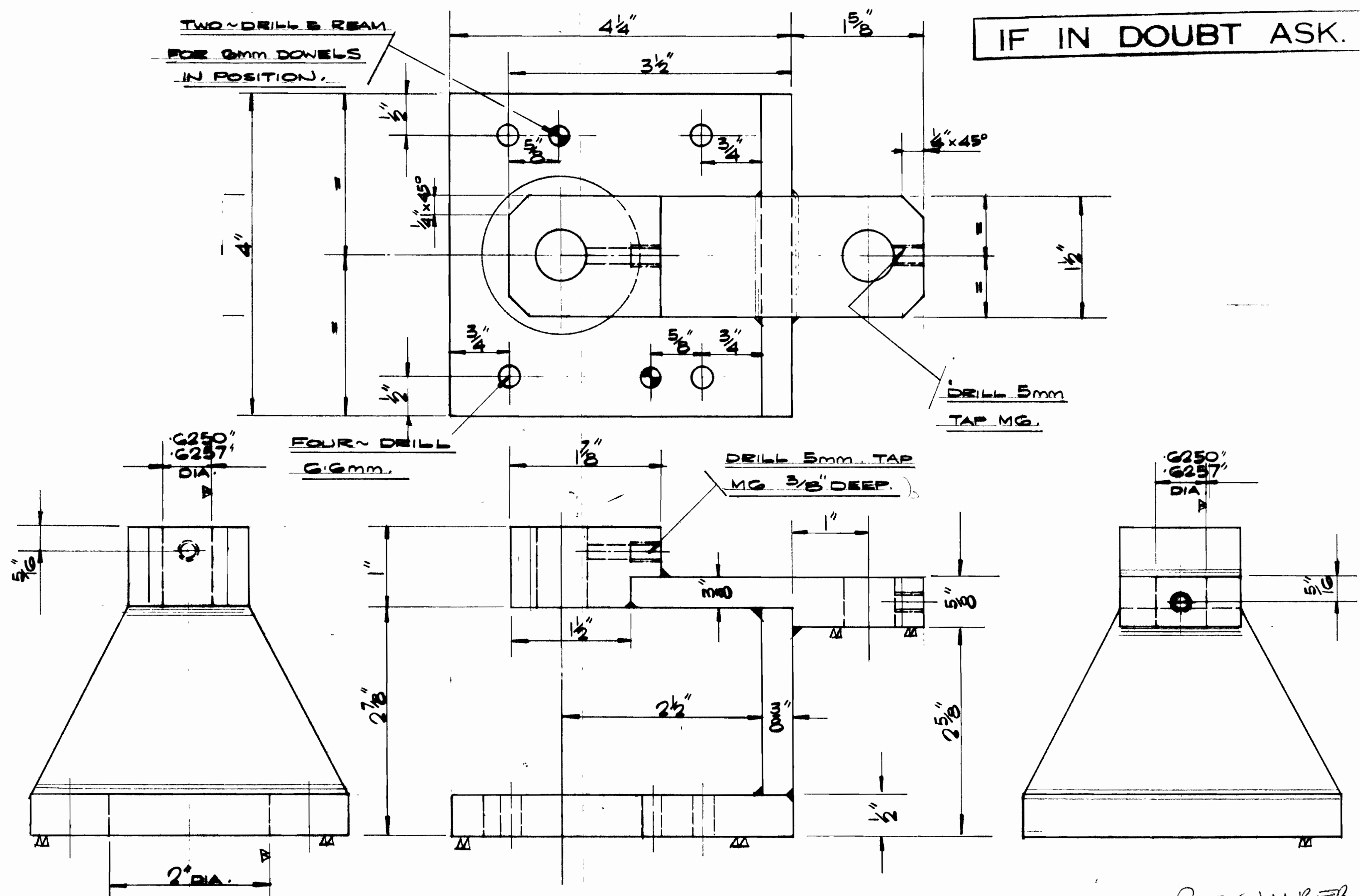
No	DESCRIPTION	CHK'D	APP'D	DATE
	ALTERATIONS			

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

MATL. ZINTEL
 MATL SIZE 12 SWG
 No KCD ONE
 MACHINE AT W
 GRIND AT 'G'

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
W.				5384	FULL

DRAWING No. PDI-120

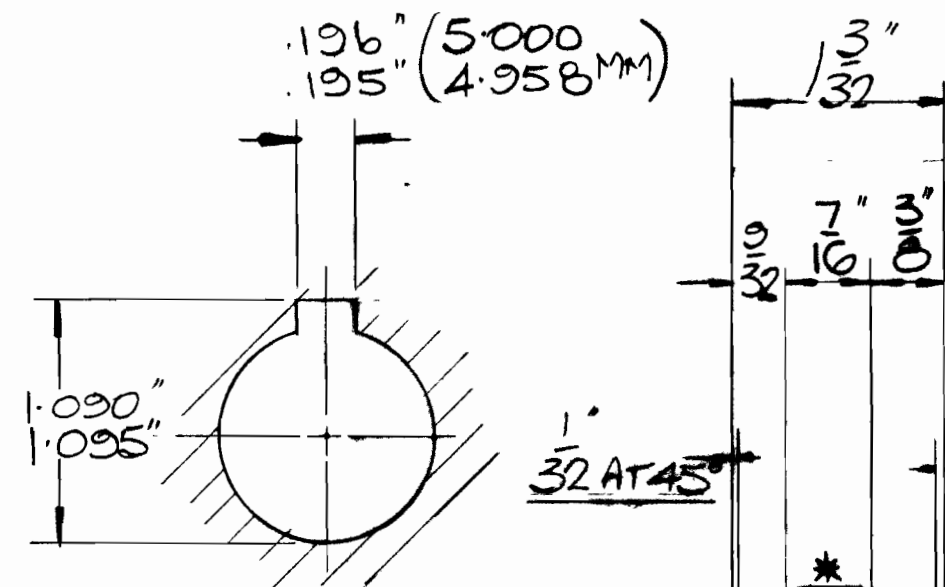


DRG.No.PD3/19

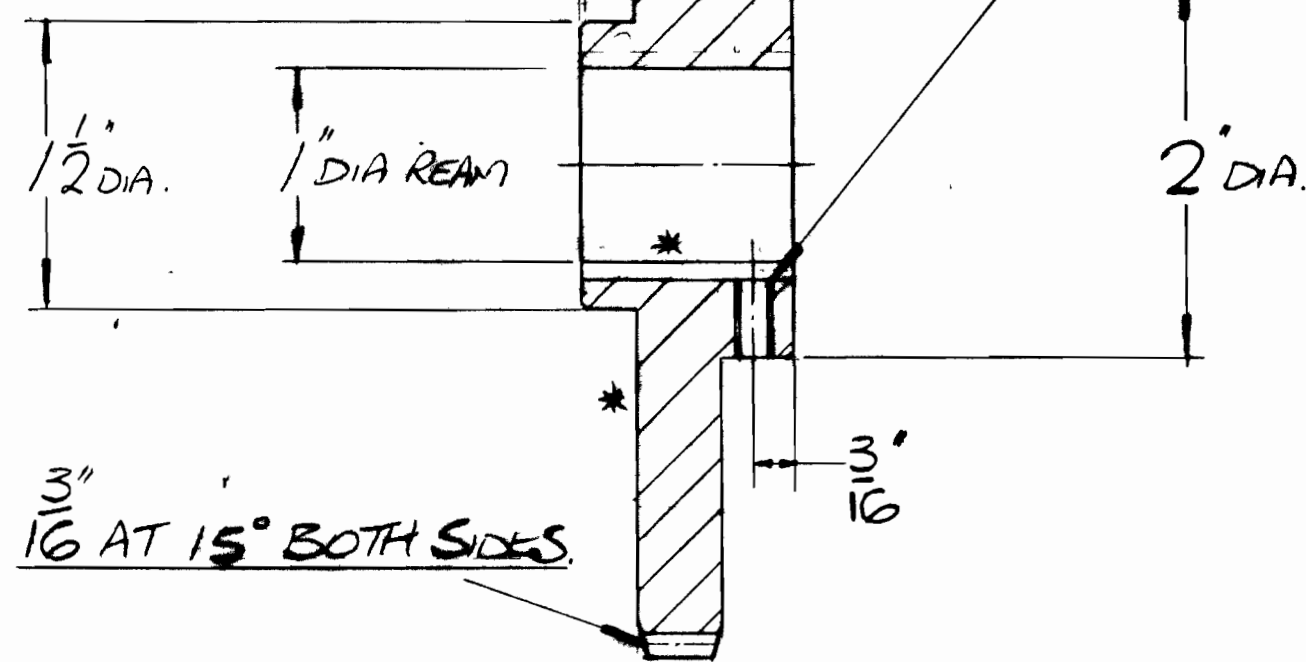
RENUMBER

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.				TDS 23 BG. PEDESTAL DRILLING M/C. BACKGEAR BRACKET			
No.		DESCRIPTION		ON DIMENSIONS UNLESS OTHERWISE STATED.		MATERIAL WELDED FABRICATION	
				ANGULAR ± 1/2° 3 PLACE DECIMAL ± .005"		MATERIAL SIZE	
				FRACTIONAL ± .010" 4 PLACE DECIMAL ± .0005"		No. REQD.	
						MACHINE AT	
						DRAWN	
						TRACED	
						CHECKED	
						APPROVED	
						DATE	
						22.2.77	
						SCALE	
						FULL	
						DRAWING No. PD3/19	

IF IN DOUBT ASK.



SCRAP SECTION
THRO' KEYWAY.



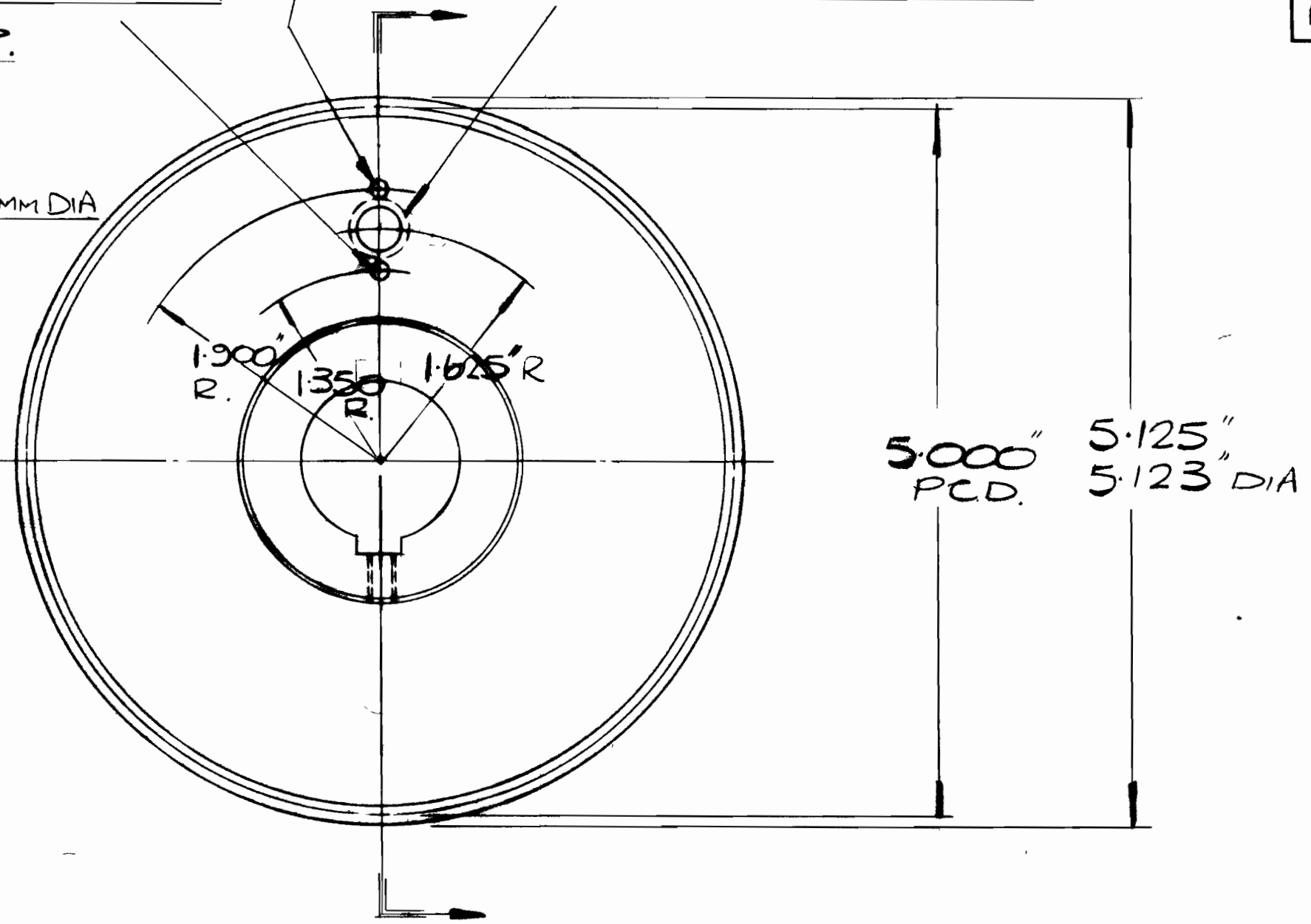
SECTION THRO' IN
DIRECTION OF ARROWS.

1 HOLE DRILL .125" DIA.
x 1/16" DEEP.

1 HOLE DRILL THRO 4.2mm DIA
TAP M5 x 0.8mm.

1 HOLE DRILL THRO .125" DIA.

1 HOLE DRILL & REAM 1/16" DIA
5/16" DRILL 7/16" DIA. x 7/32" DEEP.



GEAR DATA.	
No. OF TEETH	80T.
D.P.	16
ADDENDUM	.062"
DEDENDUM	.078"
TOOTH THICKNESS	.098"

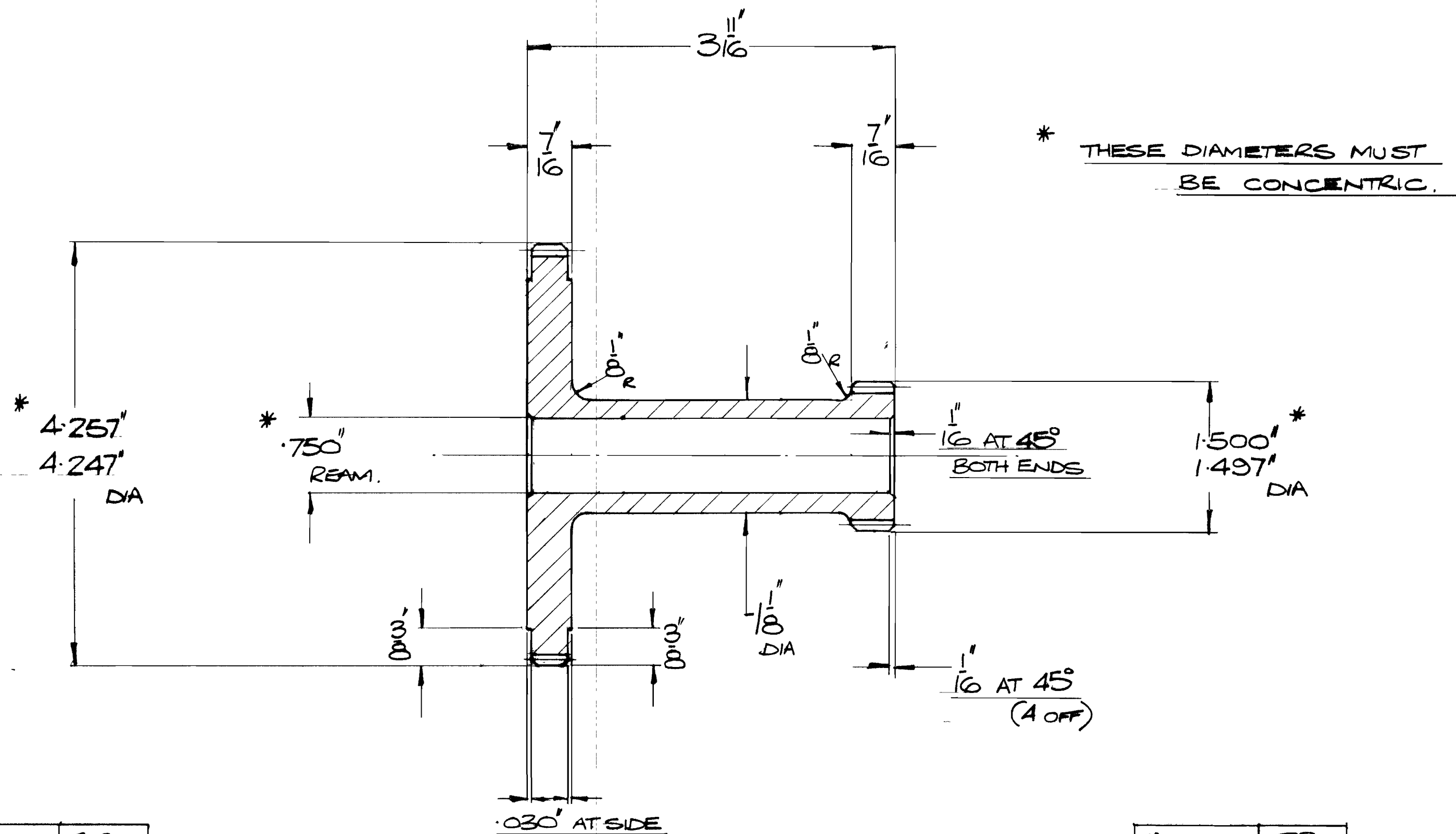
* DIA'S & FACES MARKED THUS *

MUST BE CONCENTRIC WITHIN .0002" T.I.R.

DENFORD MACHINE TOOLS LTD. WILKINS HOUSE, YORKSHIRE.				TDS 23 B.G. VICEROY BACKGEAR DRILL - BULL GEAR.			
LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED. ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005"$ FINISH $\pm .0005"$				MATL. C.I. MATL. SIZE CASTING. No. REQD. 1. MACHINE ALL OVER. GRIND AT 'G'			
2310/16.3.9.16.9 2330/17.4.1.77.13				DRAWN RD TRACED CHECKED APPROVED DATE 4.3.76 SCALE FULL			
No. DESCRIPTION DATE DATE		ALTERATIONS		DRAWING No. PD3/3.			

DRG. No.

DRG. No.



N ^o OF TEETH	66
D.P.	16
P.C.D.	4.125"
PRESS 4	20°
ADDEN	.062"
DEDEN	.078"
TOOTH THICKNESS	.098"

N ^o OF TEETH	22
D.P.	16
P.C.D.	1.375"
PRESS 4	20°
ADDEN	.062"
DEDEN	.078"
TOOTH THICKNESS	.098"

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

'VICEROY' 8 SPEED DRILL - BACK GEAR.

No.	DESCRIPTION	CHKD	APPD	DATE
	ALTERATIONS			

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

RACTIONAL $\pm .010"$ 4 PLACE DECIMAL $\pm .0005"$

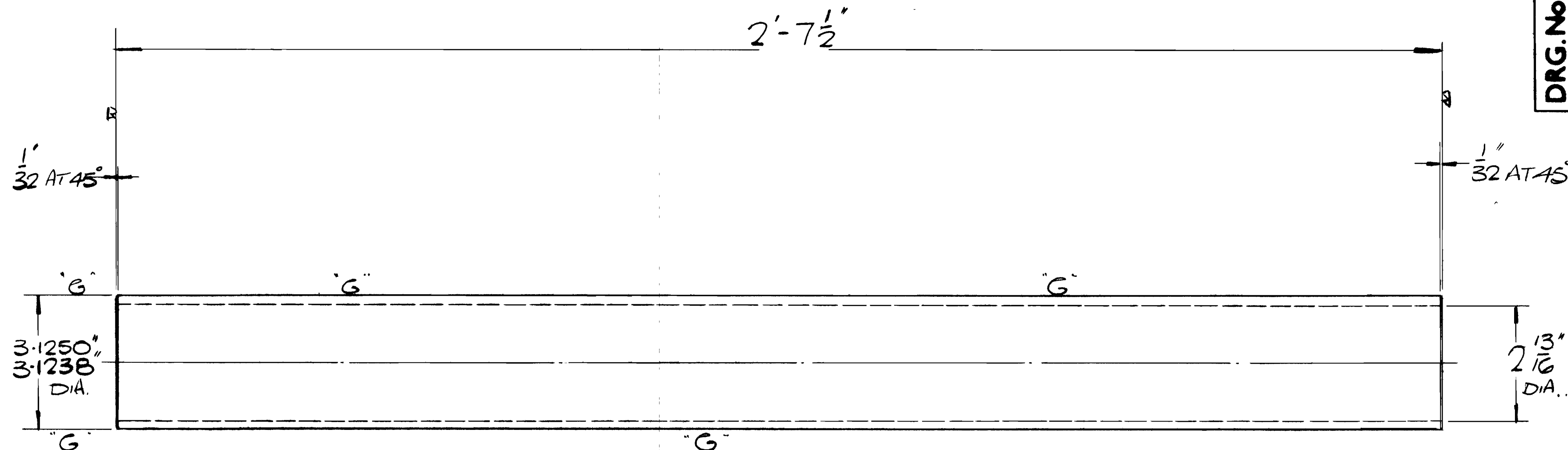
MATL	CAST IRON
MATL SIZE	CASTING
No. REQD.	1 per m/c
MACHINE AT	W
GRIND AT	G.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV.				16.10.79	FULL

DRAWING No. PD.3/9.

IF IN DOUBT ASK.

DRG.No.



N.B. TUBE TO BE NORMALISED
BEFORE GRINDING.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

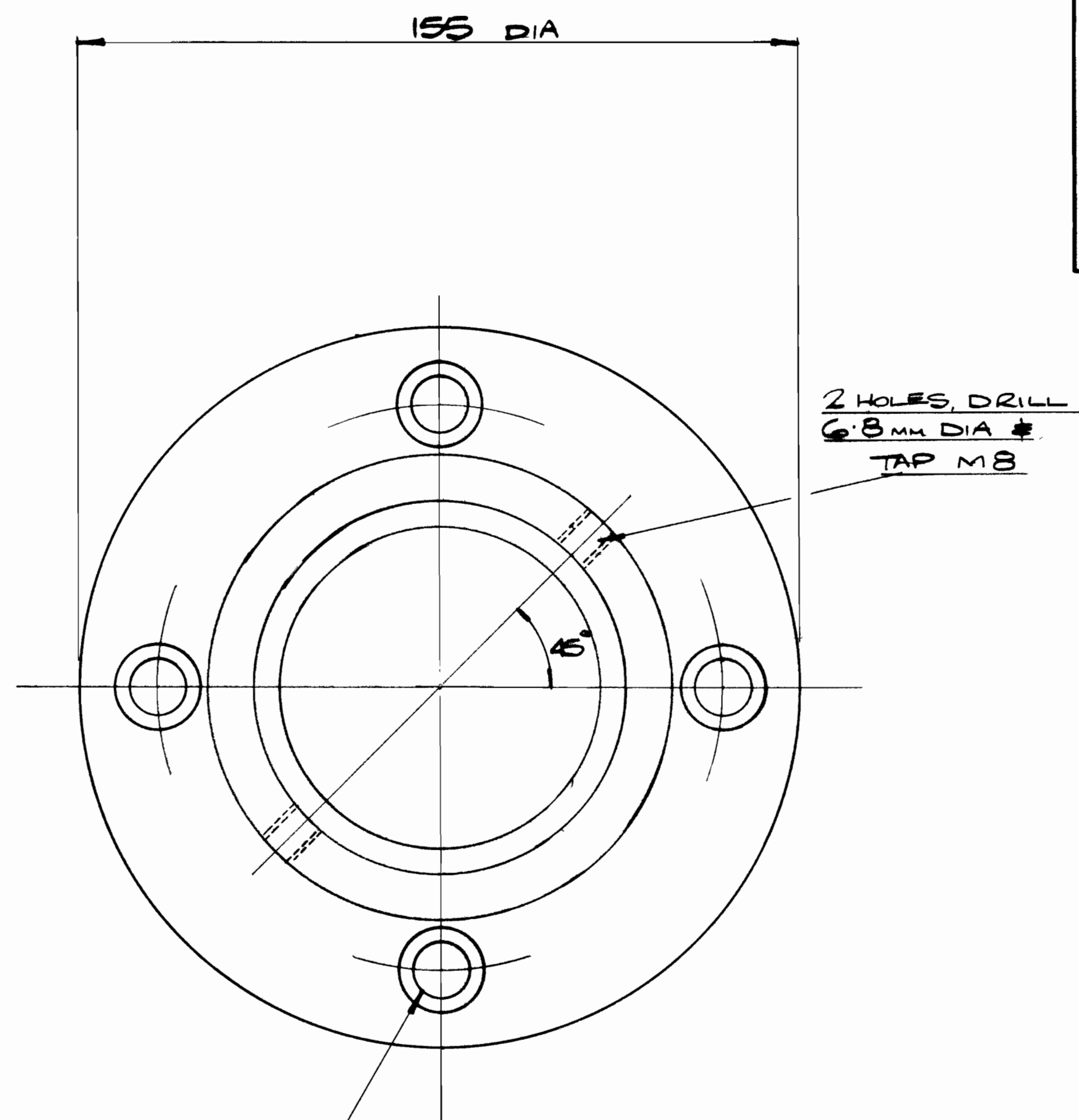
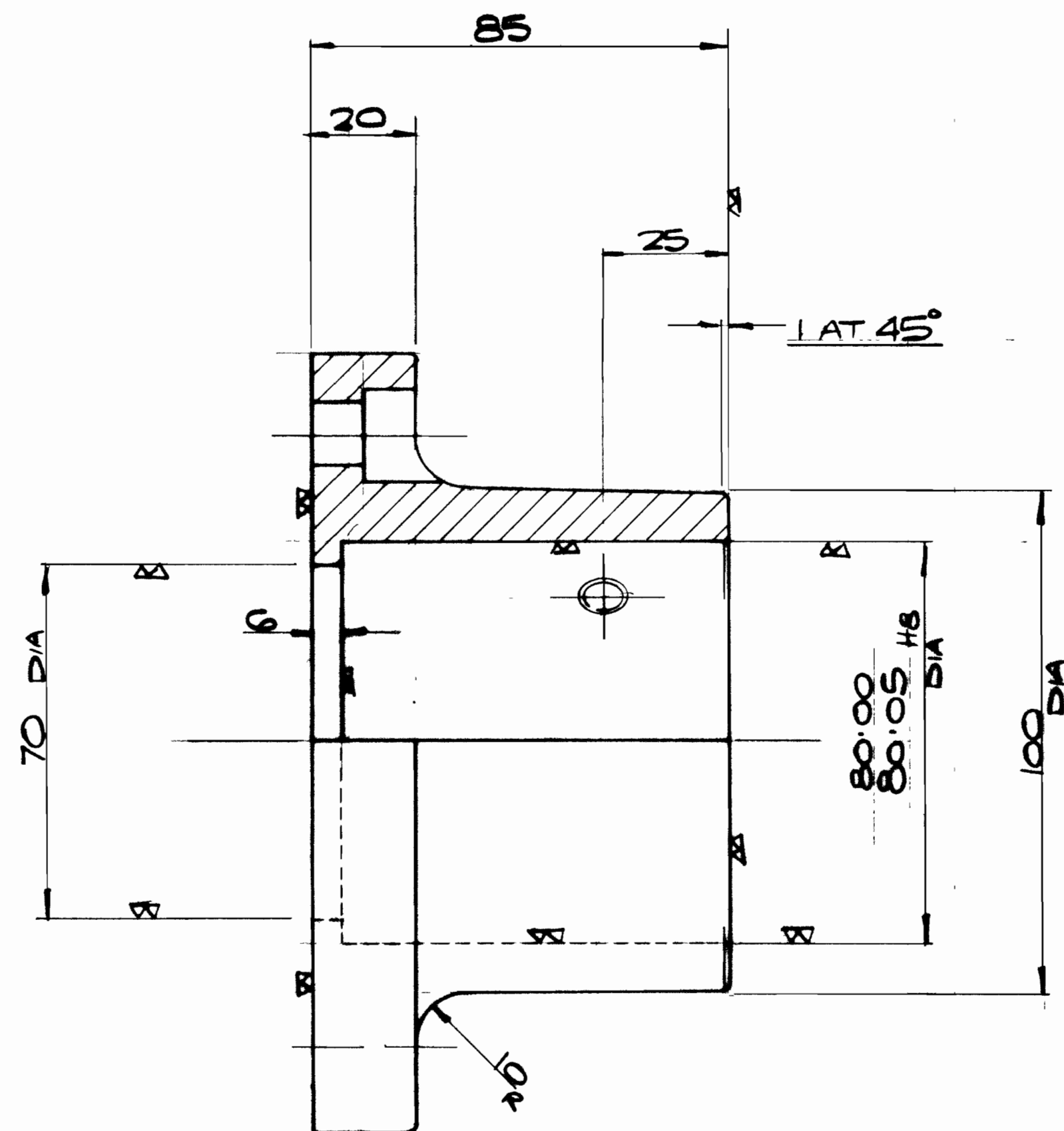
TDS. 22. VICEROY BENCH DRILLING MACHINE - PILLAR.

No.	DESCRIPTION	DATE	APPROVED

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .001$
FRACTIONAL $\pm \frac{1}{16}"$ 4 PLACE DECIMAL $\pm .0001$

MATL. MECH. TUBING
MATL. SIZE $3\frac{1}{8}"$ DIA. $\times 2'-7\frac{3}{4}"$
No. REQD 1
MACHINE AT W

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
RD.				30.3.76	$\frac{1}{2}$ SIZE
DRAWING No. PD4-2.					



4 HOLES, DRILL 11 DIA &
 9/BORE 17 DIA x 10 DEEP
 EQUISPACED ON A 120 P.C.D.

2 HOLES, DRILL
 6.8 MM DIA &
 TAP M8

DRG. No.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

TDS.22 BENCH DRILL - PILLAR SUPPORT

No.	DESCRIPTION	CHE'D	APP'D	DATE
	ALTERATIONS			

LIMITS ON DIMENSIONS UNLESS
 OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005$ "

FRACTIONAL $\pm .010$ " 4 PLACE DECIMAL $\pm .0005$ "

MATL. CAST IRON

MATL. SIZE CASTING

No. REQD. ONE

MACHINE AT W

GRIND AT 'G'.

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
IV				3.9.84	FULL

DRAWING No. PD. 4/4

FOUR ~ DRILL 6.6mm.
SPOTFACE $\frac{7}{16}$ " DIA.

2 HOLES DRILL 4.2MM DIA. x
9/16" DP. & TAP M5 x 0.8MM

MARK OFF

TWO ~ DRILL & REAM FOR
6MM PIN. IN POSITION.

DRILL 6.8 MM DIA #
TAP M8 x 1.25 MM

DRG. No.

TDS 23 BG. PEDESTAL DRILL, BACKGEAR BKT.

No.	DESCRIPTION	CHEMICAL	DATE
ALTERATIONS			

5. ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005''$

ACTIONAL $\pm .010'$ 4 PLACE DECIMAL $\pm .0005''$

MATL	CAST IRON
MATL SIZE	CASTING
No. REQD.	ONE
MACHINE AT	W
GRIND AT	G

DRAWN mm	TRACED	CHECKED	APPROVED	DATE 27.6.77	SCALE FULL
-------------	--------	---------	----------	-----------------	---------------

DRAWING No. PDG/12.

DRUGS

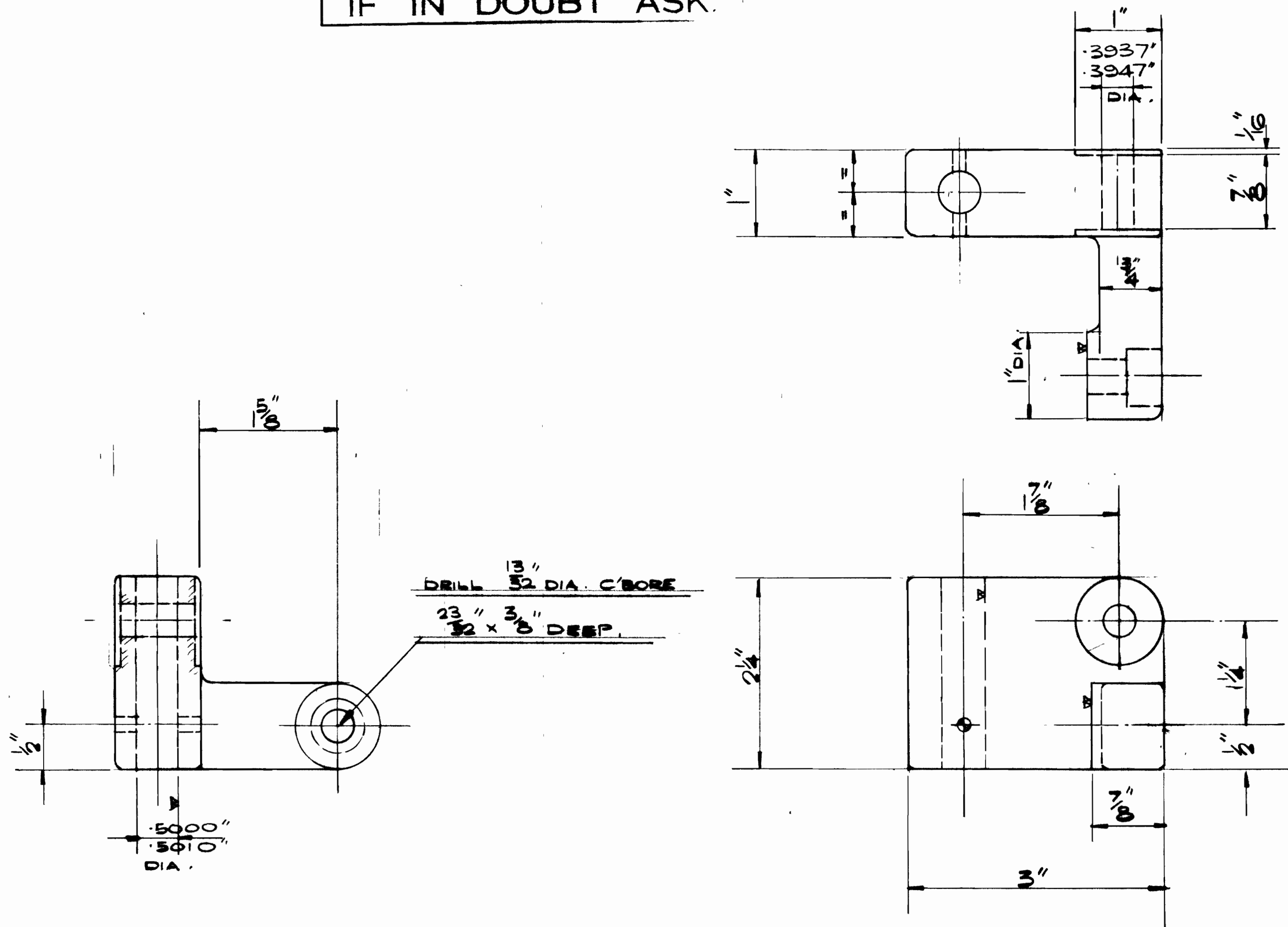


TDS 23BG PEDESTAL DRILL SPINDLE DRIVE SHAFT

						DIMENSIONS ON DIMENSIONS UNLESS OTHERWISE STATED.		SHEET NO. 1		DRAWN		TRACED		CHECKED		APPROVED		DATE		SCALE	
								SHEET NO. 1		mm								5-5-77		FULL	
No.	DESCRIPTION			CHKD	APPD	DATE	ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACES DECIMALS - 0.001		MACHINE AT W		DRAWING No. PD 6/2										
ALTERATIONS						FRACTIONAL \pm 0.01 4 PLACES DECIMALS - 0.0001															

IF IN DOUBT ASK.

DRG.No. PD3/40



DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

TDS. 23BG. PEDESTAL DRILLING MACHINE. ACTUATOR BKT.

No.	DESCRIPTION	CHKD BY	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 $\pm .0001$

MATL. CAST IRON
MATL. SIZE CASTING
IN. REQ.
MACHINE AT 77
GRIND AT 10

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
mm				21.3.77	FULL
DRAWING No. PD 6/22					

DRG. No.



VICEROY DRILLING MACHINE - COVER FOR CONTACTOR BLOCKS.

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

FRACTIONAL $\pm .010'$ 4 PLACE DECIMAL $\pm .0005''$

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
RD				20.10.77	FULL

DRAWING No. PD. 6/46.

IF IN DOUBT ASK.

2 HOLES DRILL
5.5 MM DIA.

2 HOLES DRILL
13/16" DIA.

14 HOLES DRILL 4.2 MM DIA.
#TAP M5 x 0.8 MM.

DRG. No.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROY DRILLING MACHINE - COVER BOX SUPPORT PLATE.

No.	DESCRIPTION	DATE

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.
DECIMAL $\pm \frac{1}{1000}$ 3 PLACE DECIMAL $\pm .008$ "
FRACTIONAL $\pm \frac{1}{16}$ " 4 PLACE DECIMAL $\pm .0001$ "

MATL SHEET STEEL
MATL SIZE 13 S.W.G.
No RECD 1.
DATE AT 00

DRAWN	TRACED	CHECKED	APPROVED	DATE	SCALE
RD.				20.10.77	FULL

DRAWING No. RD. 6/47

IF IN DOUBT ASK.

ANDERTON CIRCLIP REF:-

1400/2 - 1 OFF.

PDG
44

PDG
1

PDG
6

M4 x 6MM LONG SKT. HD.

SET SCR. KND. CUP PT.

2 OFF.

3MM DIA. x 16MM LONG

TENSION PIN - 3 OFF.

MICRO-SWITCH

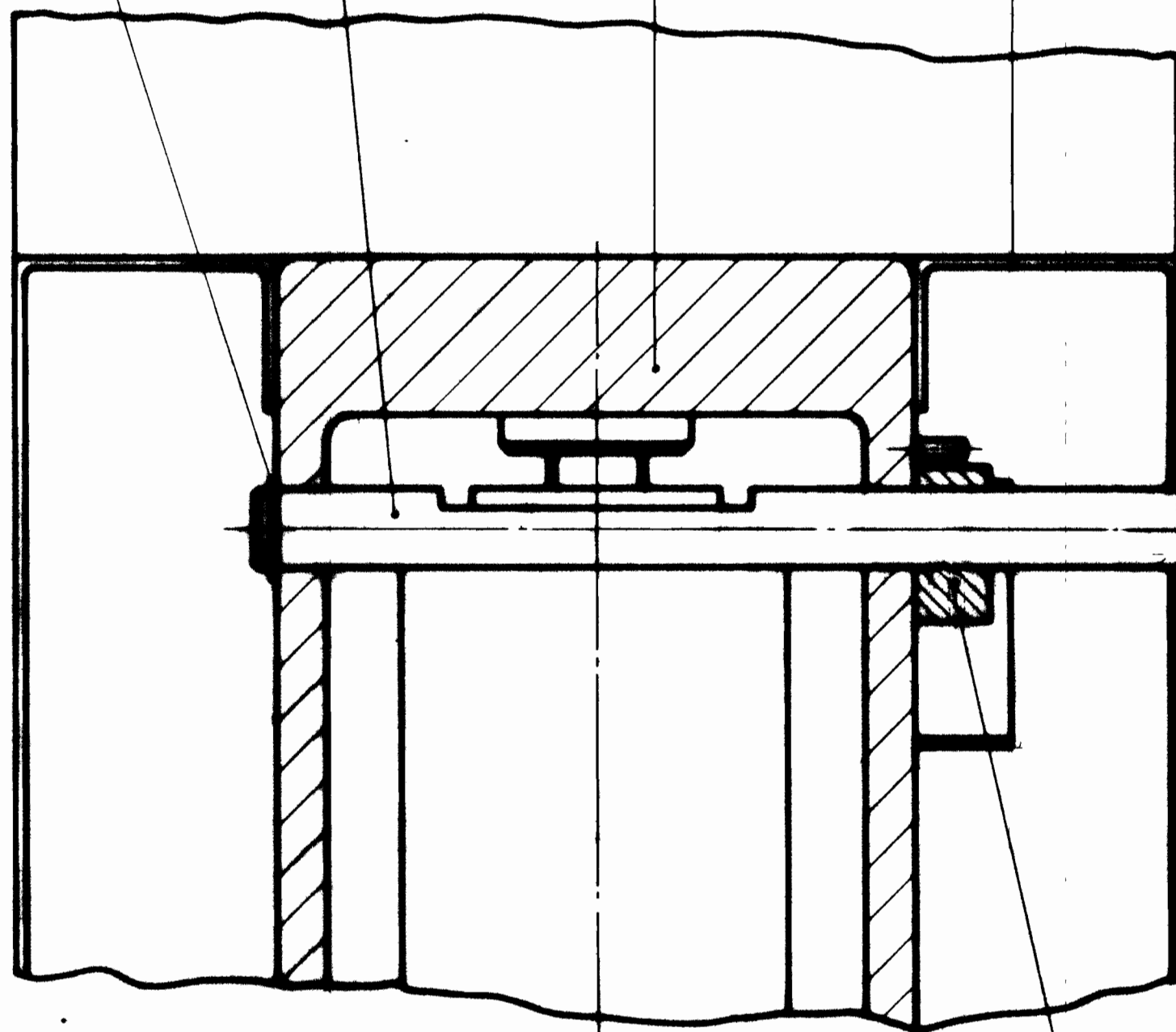
REF:- GV.9 - 1 OFF.

PDG
31

PDG
55

PDG
43

DWG. No.



SECTION THRO' IN DIRECTION
OF ARROWS.

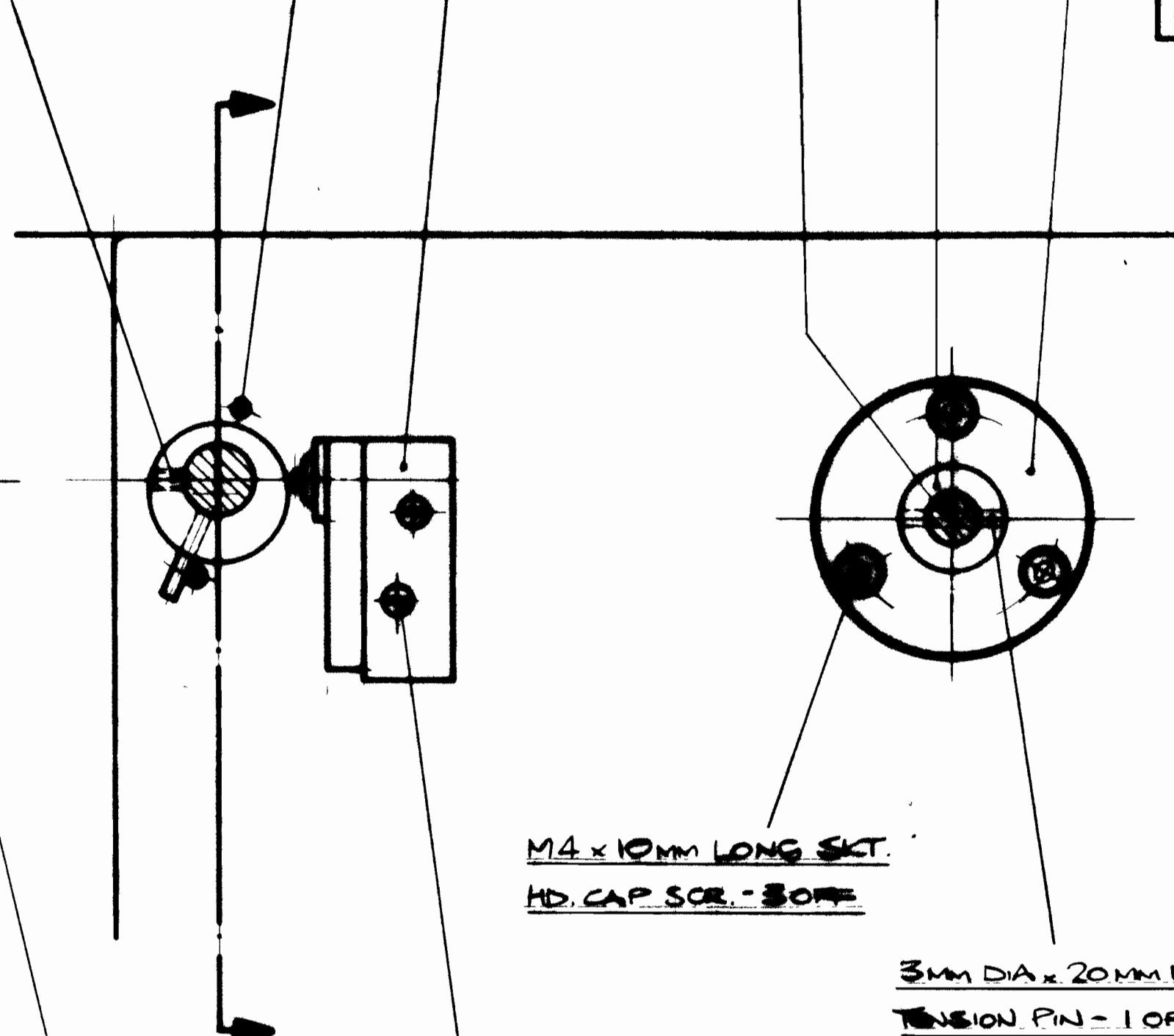
PDG
51

RENOL HANDWHEEL REF:-

5"
1127 16 WHIT. BORE: 1 OFF.

6 BA x 1' LONG CK.

MACHINE SCREWS - 2 OFF.



M4 x 10MM LONG SKT.

HD. CAP SCR. - 3 OFF.

3MM DIA x 20MM LG

TENSION PIN - 1 OFF.

DENFORD MACHINE TOOLS LTD. BRIGHOUSE, YORKSHIRE.

VICEROY DRILLING MACHINE - DRILL EJECTION ARRANGEMENT.

No.	DESCRIPTION	DATE	BY

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.	
SINGULAR $\pm \frac{1}{2}$ 3 PLACE DECIMAL $\pm .005$ "	
FRACTIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$ "	

MATL	
MATL SIZE	
No REQ	
MACHINE AT	

DRAWN	TRACED	CHECKED	DATE	SCALE
PD			21.12.71	FULL
DRAWING No. PDG/E.				