

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. D.S.M.100.

1.

DATE

TITLE: T.D.S.29. 'Viceroy' Drill Sharpening M/c.

4.10.72

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
DSM100		Arrangement.			
"	1	Baseplate.	C.I.	1	Casting.
"	2	Motor Platform. OBSOLETE 16-5-73		1	"
"	3	Bearing Housing.	"	1	"
"	4	Main Spindle.	EN33	1	$\phi 1" \times 6\frac{1}{8}"$
"	5	Rear End cap	M.S. plate	1	2"sq. x 1/4"
"	6	Front " "	"	1	2"sq. x 1/8"
"	7	Bearing Spacer.	M.S.	1	$\phi 7/8 \times 15/8"$
"	8	Grinding Wheel Hub.	Mall. Iron	1	$\phi 2\frac{1}{4} \times 1\frac{1}{4}"$
"	9	Locking Ring.	" "	1	$\phi 2\frac{1}{4} \times 1/2"$
"	10	Swivel Slide.	C.I.	1	Casting.
"	11	Compound Slide.	"	1	"
"	12	Top Compound Slide. REDRAWN 4-4-73	"	1	"
"	13	" Slide Gib Strip	M.S.	1	$5\frac{1}{4} \times 3\frac{1}{4} \times 1/8"$
"	14	Compound Slide Gib Strip.	"	1	$6\frac{1}{8} \times 3\frac{1}{4} \times 1/8"$
"	15A	T/Slide & C/Slide Feednut (English)	Phos. Bro.	2	$\phi 7/8 \times 1\frac{1}{8}"$
"	15B	" " " " (Metric)	"	2	" x "
"	16	Compound Slide End Plate.	C.I.	1	Casting.
"	17	Top Slide " "	"	1	"
"	18	Corner Block.	M.S.	1	$13\frac{1}{4} \text{sq.} \times 5/8"$
"	19	Collet Block Location Pin.	EN8	1	$\phi 3/8 \times 13/4"$
"	20	" " REDRAWN 9-2-73	C.I.	1	Casting.
"	21	" Mandrel. REDRAWN 10-2-73	EN8	1	$3\frac{1}{2} \phi \times 4"$
"	22	End cap. OBSOLETE 4-4-73.		1	$\phi 3" \times 13/8"$
"	23	Locknut.	M.S.	1	$\phi 2\frac{1}{4} \times 3/4"$
"	24	Location Pin. REDRAWN 12-2-73	Silver St.	1	$\phi 1/4 \times 2\frac{3}{4}"$
"	25	Lever	B.D.H.S.	1	$\phi 3/16 \times 13/16"$
"	26	Drill Location Bar.	"	1	$\phi 7/16 \times 5"$
"	27	" " Plate REDRAWN 4-4-73	M.S. plate	1	$2\frac{1}{4} \times 1\frac{1}{2} \times 1/8"$
"	28	Collet Block Swivel Pin REDRAWN 9-2-73	Silver St.	1	$\phi 5/8 \times 13/4"$
"	29	Drill Location Bar Housing. REDRAWN 4-4-73	M.S. & pbt	1	See Drg.
"	30	Location Pin Handle.	M.S.	1	$\phi 7/16 \times 3/4"$
"	31	Brg. Housing Swivel Pin	"	1	$\phi 3/4 \times 2\frac{1}{4}"$
"	32	Wheel Guard.	St. Steel	1	20 S.W.G.
"	33	Pulley "	" "	1	" "
"	34	Friction Plates.	M.S.	2	$\phi 13/8 \times 1/4"$

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SHEET No.

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ASSY. DRG. No. DSM100

DATE

TITLE: T.D.S 29 'Viceroy' Drill Sharpening M/C.

4.10.72

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
DSM100 35	Handle Bar.	M.S.	1	$\phi 3\frac{1}{8} \times 43$
" 36	" " Support Brkt.	"	1	$2\frac{1}{2} \times 1\frac{3}{4} \times 1\frac{1}{2}$
" 37	Swivel Slide Location Pin	"	1	$\phi 1\frac{1}{2} \times 2\frac{1}{2}$
" 38	Adjusting Screw Brkt.	C.I.	1	CASTING
" 39	Platform Adjusting Screw.	M.S.	1	$\phi 5\frac{1}{8} \times 4\frac{1}{4}$
" 40A	Adjusting Screw (R.H. Thrd.)	"	1	$\phi 7\frac{1}{8} \times 1\frac{1}{4}$
" 40B	" " (LH ")	"	1	" x "
" 41	Location Screw	"	2	$\phi 3\frac{1}{4} \times 1\frac{1}{4}$
" 42	LOCK PAD	SILVER STEEL	1	$1\frac{1}{4} \phi \times 1$
" 43	PLATE	ANODISED ALUMINIUM	1	"
" 44	LOCATION BUSH	EN8	1	$3\frac{1}{4} \phi \times 3\frac{1}{4}$
	<u>Other Parts Required.</u>			
ML100 505B	Knob.	Hs & C.P.	2	$\phi 5\frac{1}{8} \times 2\frac{1}{2}$
" 509A	Leadscrew (English)	M.S.	2	" x $9\frac{1}{2}$
" 509B	" (Metric)	"	2	" x "
" 510A	" Bush.	"	2	$\phi 1\frac{5}{16} \times 1\frac{1}{4}$
" 515	Top & Cross Slide Brg' Collar	"	2	$\phi 3\frac{1}{4} \times 5\frac{1}{8}$
" 516	3 Ball Handle.	M.S. & C.P.	2	$\phi 1 \times 2\frac{7}{8}$
" 520A	Top & Cross Slide Dial (Eng)	M.S.	2	$\phi 1\frac{3}{4} \times 7\frac{1}{8}$
" 520B	" " " " (Metric)	"	2	" x "
DSM100 45	NAME PLATE	ANODISED ALUMINIUM	1	
" 46	GENTRE CARRIER	M.S.	1	$1 \times \frac{1}{2} \times 4$
" 47	SPIGOT FOR GENTRE CARRIER	M.S.	2	$1 \phi \times 2\frac{1}{4}$
" 48	GENTRE	SILVER STEEL	1	$\frac{1}{2} \phi \times 1\frac{3}{4}$
" 49	GENTRE GUIDE RODS	"	2	$3\frac{1}{8} \phi \times 12$
" 50				
" 51	MOTOR COVER	SHEET STEEL	1	16 S.W.G.
" 52	MOTOR SPACER	M.S.	4	$1 \phi \times 1$
" 53	COVER FOR BASE	SHEET STEEL	1	16 S.W.G.
" 54	MOTOR PLATFORM	C.I.	1	CASTING
" 55	BEARING HEAD CARRIER	C.I.	1	CASTING
" 56	SWIVEL SLIDE LOCK NUT.			
" 57	" " " " LEVER			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. D S M 100

DATE

6.10.72

TITLE: T.D.S.29. D.S.M/C. B.O. Parts.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>SK'T. HD. Cap Screws.</u>			
		1/4" Whit. x 1 1/2" long.	—	2	—
		" " x 3/4" "	—	1	—
		" " x 5/8" "	—	4	—
		" B.S.F. x 5/8" "	—	4	—
		2 B.A. x 3/4" "	—	2	—
		" x 1/2" "	—	3	—
		" x 3/8" "	—	1	—
		4 B.A. x 1/4" "	—	4	—
		5/16" WHIT x 5/8" "	—	6	—
		<u>Grubs : KN'D Cup Point.</u>			
		1/4" Whit. x 1" Long.	—	3	—
		" " x 3/4" "	—	3	—
		2 B.A. x 3/4" "	—	3	—
		" x 1/2" "	—	1	—
		" x 3/16" "	—	3	—
		<u>C'SK. SK'T. HD. Cap Screws.</u>			
		2 B.A. x 3/4" long.	—	4	—
		" x 1/2" "	—	4	—
		<u>Timing Belt Drive</u>			
		Pulley ref : 16X L037F.	—	1	Kenyon
		" " : 32X L037.	—	1	"
		Belt ref : 90XL : 3/8" wide.	—	1	"
		<u>Plastic Knobs</u>			
		1/4" dia x 5/16 Whit.	—	1	McMillans
		3/4" " x 2 B.A. ref : BP075.	—	1	Bluemels

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. DSM100

18

DATE

TITLE: T.D.S.29. 'Viceroy' D.S.M/c. B.O. Parts.

6.10.72

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Grinding Wheel.</u>			
		4" dia. 6207 r.p.m. : C60, C80, C100	—	1	Universal.
		<u>Pins.</u>			
		Mills Pin 1/8 dia x 1 3/4" long	—	2	—
		" " " " x 3/4" "	—	2	—
		" " " " x 1/4" "	—	2	—
		<u>Springs.</u>			
		1/4" O.D. 10 C.P.I. 1" FL. 25 S.W.G.	—	1	—
		9/32" " 12 C.P.I. 5/8" FL. 20 S.W.G.	—	1	—
		<u>Bearings.</u>			
		ref: 6202/2RS.	—	2	Koyo
		" : SN475 x 1/2" wide.	—	2	Lubbrook
		<u>Locknut & Washer.</u>			
		L/nut ref: TNO2	—	1	Timken
		Washer " : TW102	—	1	"
		<u>C/clips.</u>			
		Ref: 1300/35mm.	—	2	Anderton
		<u>Locknuts.</u>			
		Std. 1/4" Whit.	—	6	—
		" Z.B.A.	—	3	—

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. D. S. M. 100

10.

DATE

TITLE: T.D.S. 20. 'Viceroy' D.S.M/C. B.O. Parts.

6.10.72

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Washers.</u>			
		Std. 1/2"	—	1	—
		" 3/8"	—	1	—
		" Spring 3/8"	—	2	—
		<u>Thrust Bearings.</u>			
		Ref : NTA 613.	—	2	Torrington
		Thrust races ref : T.R.A 613.	—	4	"
		<u>Nuts.</u>			
		Std. 1/2" whit.	—	1	—
		<u>Set screws.</u>			
		Std. 3/8" whit. x 1 1/2" long.	—	1	—
		<u>Collets.</u>			
		ORSOLETE 44-73			
		Multibore range: 3mm (1/8") to 25mm (1")	—	8	Crawford
		<u>Handwheel.</u>			
		Ref : 1040 1 3/8" dia. x 3/8" whit.	—	1	Rencol.
		<u>Motor</u>			
		1/4 H.P. 1ph. 2850 r.p.m. type 2207-HBF	—	1	Hoover.
		<u>Motor Switch.</u>			
		Ref : 2SPSO 1ph.	—	1	MEM.
		CHUCK.			
		6 JAW SELF CENTRING 85mm		1	FRATT BURN
		DIA CHUCK CAPACITY 1.5mm-25mm			