

# IF IN DOUBT ASK

## ALTERATIONS

266878 15.12.78  
277079 12.11.79

CHAMFERS

1/8" AT 45°

4.16" DIA.

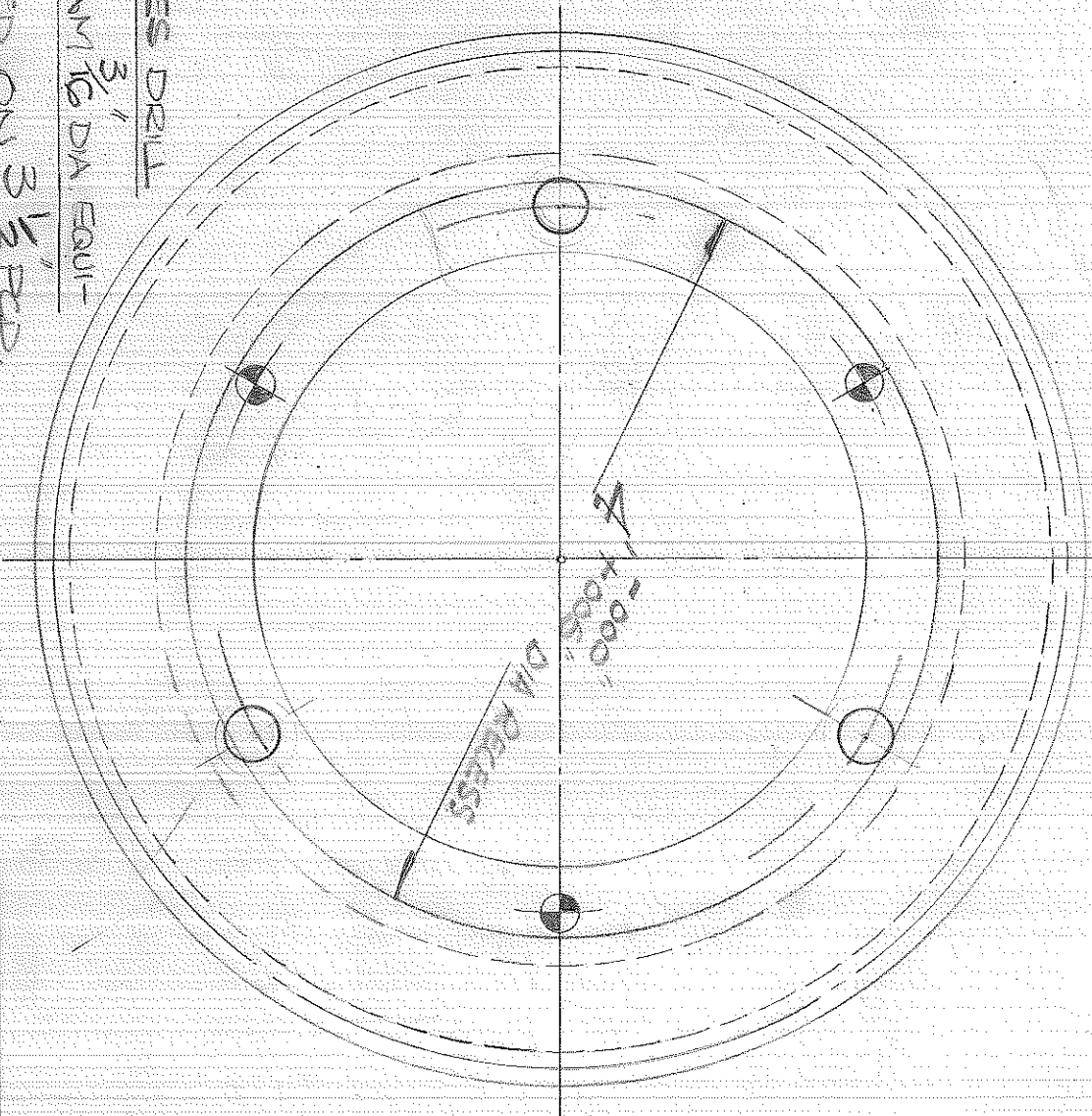
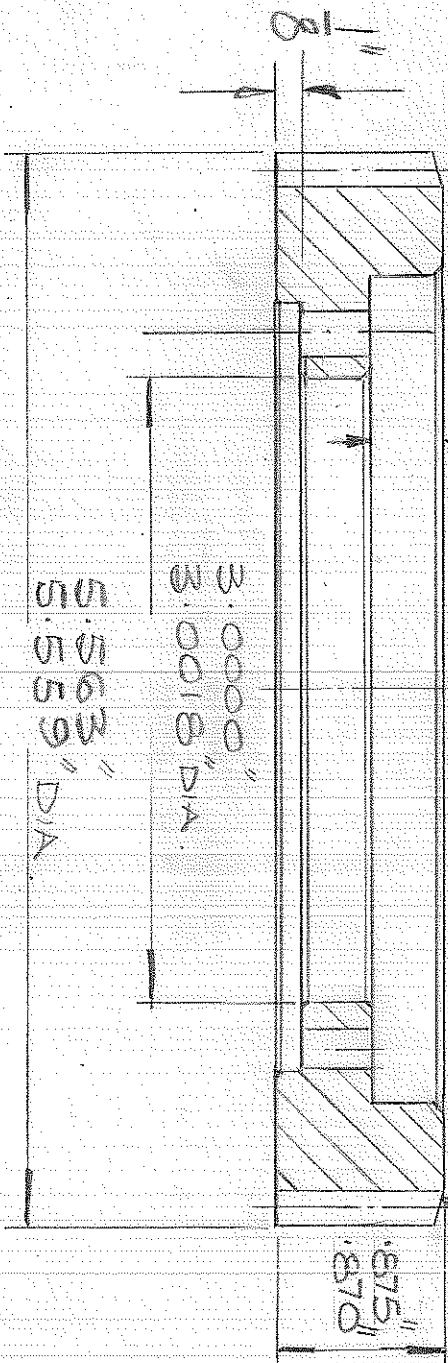
3/16" AT 15° CHAMFER

# TOOTH

ROUND

MID

.675"  
.670"



NO. TEETH	65	ST. CAMBER SETTING
ITCH	12 DP	ADD .084"
PCD	5.397"	.131"
FEED	20°	WIDTH .130"

VICEROY BENCH LATHE - GEAR ON LAYSHAFT.

DENFORD MACHINE TOOLS LTD.  
(INC.) DENFORD SMALL TOOLS (BRIG) LTD.

BRIGHOUSE,

YORKSHIRE.

DRAWN	ED	MAT.	TECHNICAL A 90
CHECKED		MAT. SIZE	170 x 80 BLANK x 1/8" THICK
PASSED		No. RECD.	1
DATE	13.4.78	DRAWING No.	BVS100/105.

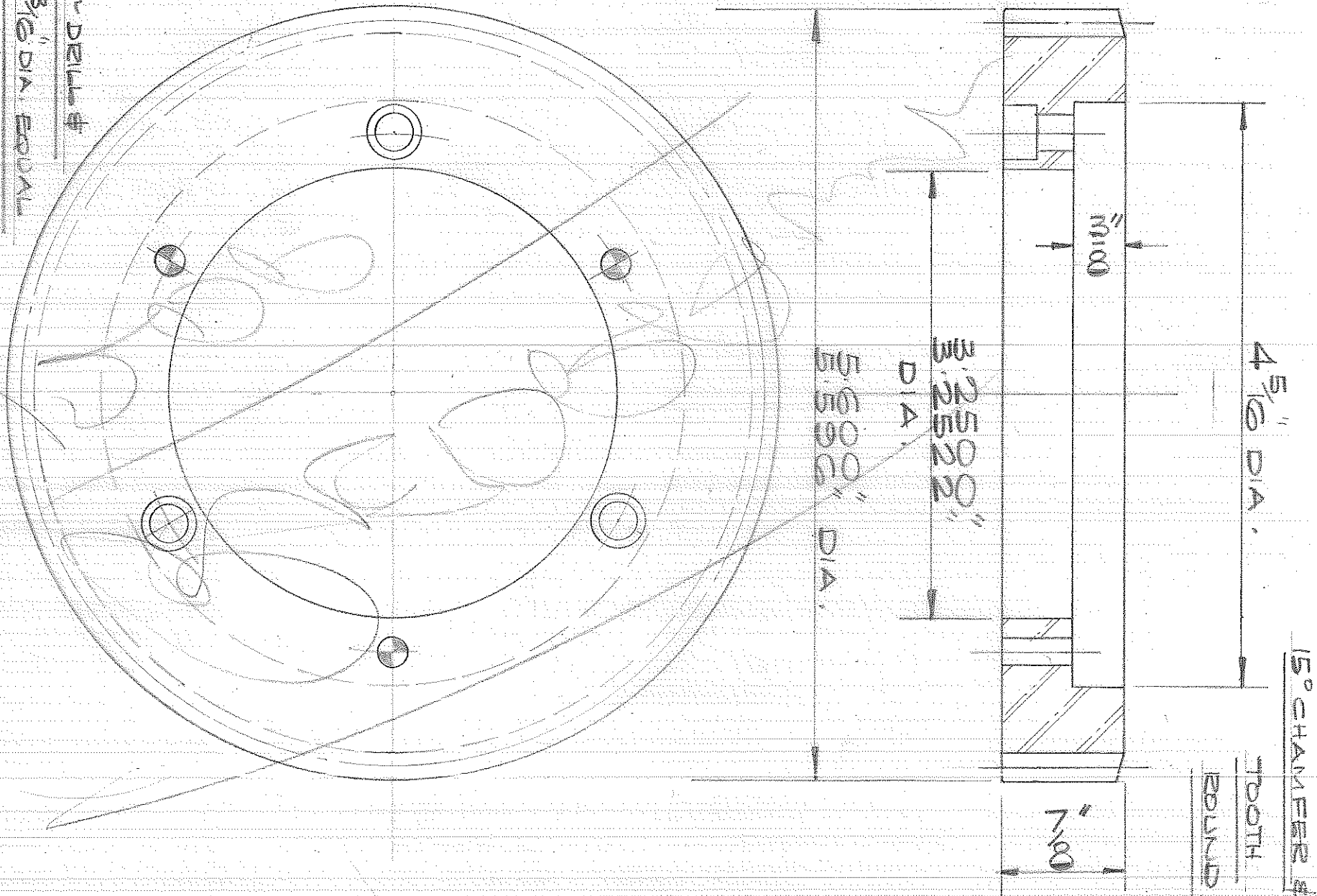
LIMITS ON DIMENSIONS UNLESS  
OTHERWISE STATED.

ANGULAR ± 1/2° 3 PLACE DECIMAL ± .005"

FRACTIONAL ± .010" 4 PLACE DECIMAL ± .0005"

IF IN DOUBT ASK

ALTERATIONS



THREE DEEL #  
BEAM 3/16\" DIA. EQUAL  
SPACED ON 3 3/4\" PCD.  
THREE DEEL 6.6 CORE  
11 X 6 DEEP EQU-SPACED ON  
3 3/4\" PCD.

NO. TEETH	54	CALIPER SETS.
PITCH	10DP	ADD
PCD	5.400	
PRESSURE	20°	WIDTH

VICEROY 280VS LATHE. GEAR ON LAYSHAFT

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

DRAWN	MM	MAT	TECHNYL A 90
CHECKED		MAT. SIZE	175 X 80 BLANK 1 1/8\" THICK
PASSED		NO. RECD.	ONE
DATE	14.10.77	DRAWING No.	MVS 100/138

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

845 100 / 105

## DENFORD MACHINE TOOLS.

## NOTICE OF MODIFICATION TO MANUFACTURED PART.

BVS. 100/105 &amp; 108

Request for mod. by	Name.	Date.	Sign.	Pattern Mod.	Parts List.
	D.O.	15-12-78	I. Vickery	YES/NO	Asst.

## Nature of request:

REDUCE P.C.D. OF GEARS BECAUSE OF  
THE COEFFICIENT OF LINEAR EXPANSION IN TECHNYL 'A' 90.

D.O. Job issued.	Date. 15-12-78	Sign. W.	Job completed.	Date. 15-12-78	Sign. W.
Mod. No. 2668/78	Copies issued to:	D.O., W.O., Insp., Fitting. Stores. <del>Mill. Fitting.</del> M/c. Shop.			No. of copies 4

## Drg. No. Details of Modification.

BVS.100/105 280 US LATHE - GEAR ON LAYSHAFT (G5T) 1/2 DP

THE 5.417" P.C.D IS NOW 5.397" &  
THE O/D WAS 5.583" / 5.579" IT IS NOW 5.563" / 5.559" DIA.

BVS.100/108 280 US LATHE - GEAR ON SPINDLE (G8T) 1/2 DP

THE 5.667" P.C.D IS NOW 5.647" &  
THE O/D WAS 5.823" / 5.829" IT IS NOW 5.813" / 5.809" DIA.

## Remarks.

As advised by GREEN'S of SUTTON.

## Checked.

I. Vickery

## DENFORD MACHINE TOOLS.

## NOTICE OF MODIFICATION TO MANUFACTURED PART.

BVS. 100/105

Request for mod. by	Name.	Date.	Sign.	Pattern Mod.	Parts List.
	D.O.	12-11-79	I. Vickery	YES/NO	Asst.

## Nature of request:

TO REDUCE THE LIMIT ON THE WIDTH  
OF THE GEAR

D.O. Job issued.	Date. 12-11-79	Sign. W.	Job completed.	Date. 12-11-79	Sign. W.
Mod. No. 2770/79	Copies issued to :-		D.O., W.O., Insp., Fitting. Stores. <del>Mill. Fitting.</del> M/c. Shop.		No. of copies 4

## Drg. No. Details of Modification.

BVS.100/105 VICEROY BENCH LATHE - GEAR ON LAYSHAFT

THE WIDTH WAS  $\frac{7}{8}$ "

IT IS NOW .875" / .870"

GIVING A CLEARANCE :-

MAX = .020"

MIN = .010"

## Remarks.

## Checked.

I. Vickery