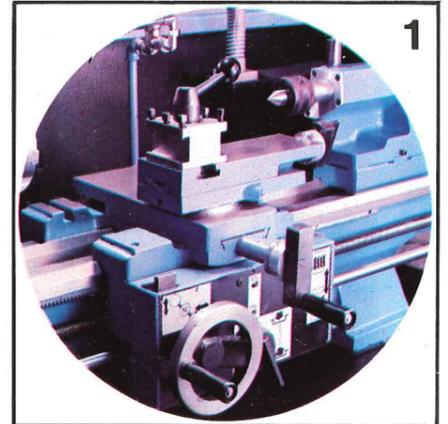


VICEROY 280^{VS}

METAL TURNING LATHE

CARRIAGE AND TAILSTOCK

Robust, compact saddle Crossslide swivel slide and top slide with 2-way tool post in position.
Separate leadscrew and feed-shaft with end drive bracket incorporating needle thrust washers is illustrated.
Sculptured Tailstock designed for maximum capacity and performance.



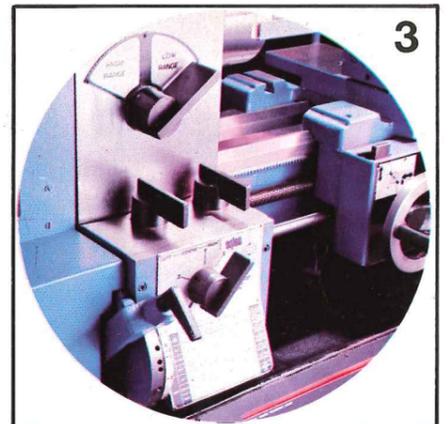
OPERATING CONSOLE

Key lock for Variable Speed is clearly shown alongside the Handwheel. Module design of assembly enables electrical components to be serviced or replaced easily.
Reversing switch interlocked with isolator is clearly shown as is Electronic Digital Tachometer (R.H. side).
Push Button controls for easy operation are supplemented by coolant pump switch (extra) as illustrated.



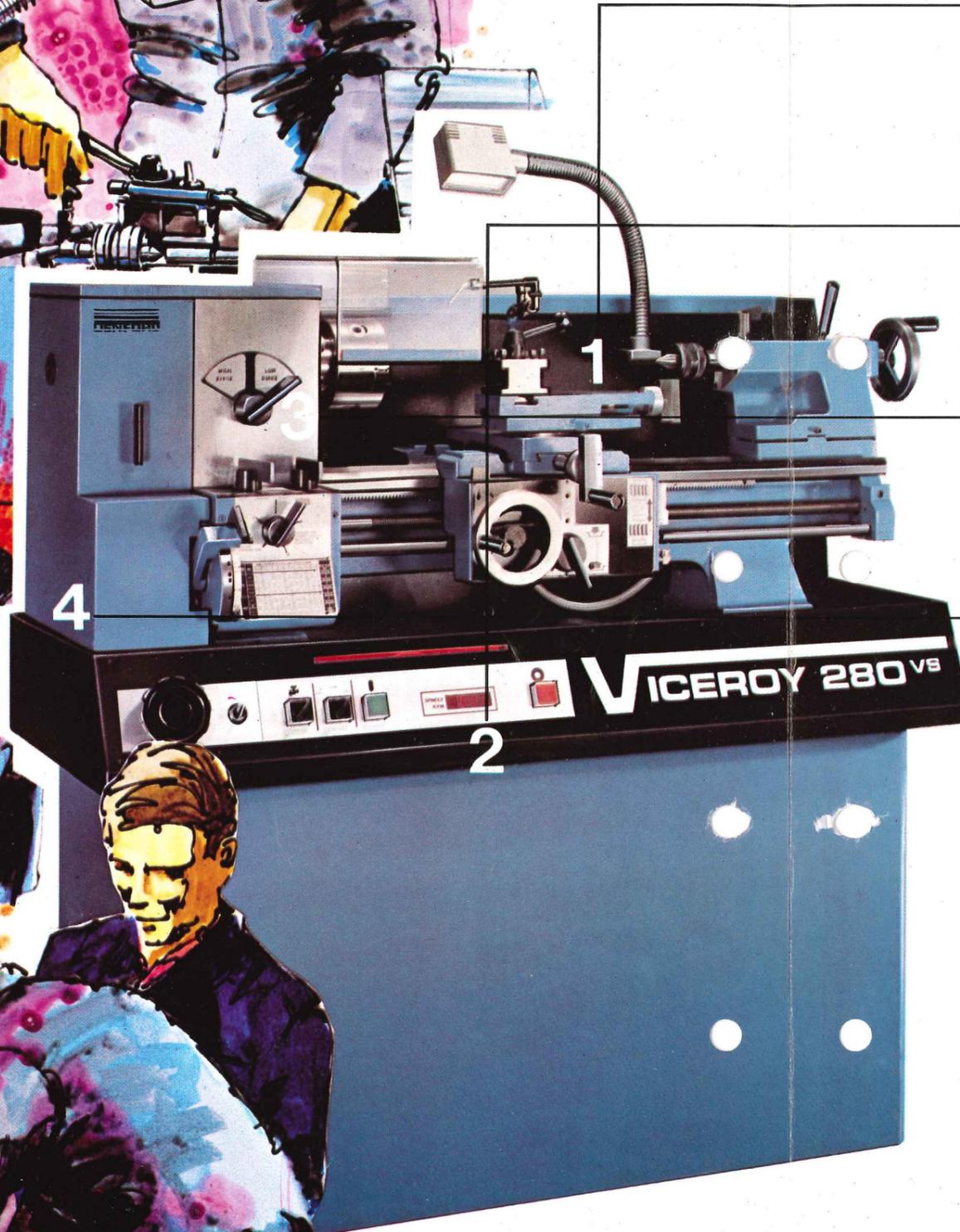
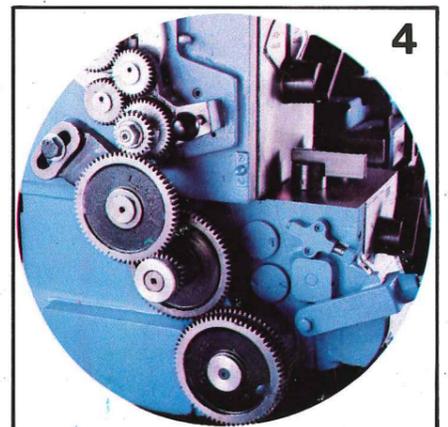
HEADSTOCK AND GEARBOX

Ergonomically Designed Controls for Headstock and Gearbox ensure simplicity and ease of operation.
High and Low Range Lever for Headstock engages Backgear.
Dial Selector Gearbox has graphically designed chart to ease operator training.



END DRIVE

Spindle/Gearbox End Drive incorporates Forward/Reverse Selector for Leadscrew and Feedshaft.
'A' and 'B' (High/Low) Gearbox position is easily reached along with Gearbox Driving Gear which includes a SAFETY Shear Pin.
END DRIVE GUARD Micro switch completes the safety circuit which is 24 v. Low Voltage.



TECHNICAL SPECIFICATION

	Metric	Imperial
CAPACITIES		
Swing Over Bed	280 mm.	11"
Swing Over Saddle Wings	240 mm.	9½"
Swing Over Cross Slide	170 mm.	6¾"
Spindle Bar Capacity	26 mm.	1"
Distance Between Centres	600 mm.	24" or
	1000 mm	40"
HEADSTOCK		
Spindle Nose	D1/3 Camlock	
Spindle Bore	27 mm.	1⅜"
Spindle Nose Internal Taper	4 M.T.	
Spindle Bearings	Timken Tapered Roller	
Spindle Speeds	60 to 2000 r.p.m.	
Low Range	60 to 400 r.p.m.	
High Range	400 to 2000 r.p.m.	
THREADS AND FEEDS		
Number of Threads and Feeds	72	48
Number of I.S.O. Threads	25 (.2 to 7.0)	224 t.p.i. to 4 t.p.i.
Longitudinal Feed Range	.03 to .80 mm.	.0012" to .0311"
Cross Feed Range	.012 to .40 mm.	.0005" to .0157"
Leadscrew	3 mm.	8 t.p.i.
CARRIAGE		
Movement along Bed	530 to 935 mm.	20" or 36"
Cross Slide Movement	130 mm.	5⅛"
Top Slide Movement	105 mm.	4⅛"
Swivel Slide Graduated Left and Right	0.90°	
Top Slide to Spindle C/L	27 mm.	1⅛"
BED		
Length	915 mm.	36"
Width	150 mm.	6"
Ground Ways	2 Vees — 2 Flats	
TAILSTOCK		
Barrel Taper	3 M.T.	
Barrel Movement	70 mm.	2¾"
Barrel Graduation	1.0 mm.	⅜"
MOTOR		
1,500 r.p.m. at 50 Hz.	1200 w	1½ h.p.
MACHINE		
Length	1270 mm.	50"
Height	1270 mm.	50"
Width	610 mm.	24"
Weight	300 kg.	660 lbs. or
	350 kg.	770 lbs.