

IF IN DOUBT ASK

ALTERATIONS

1185/65 P

28.5.65

1506/67 P

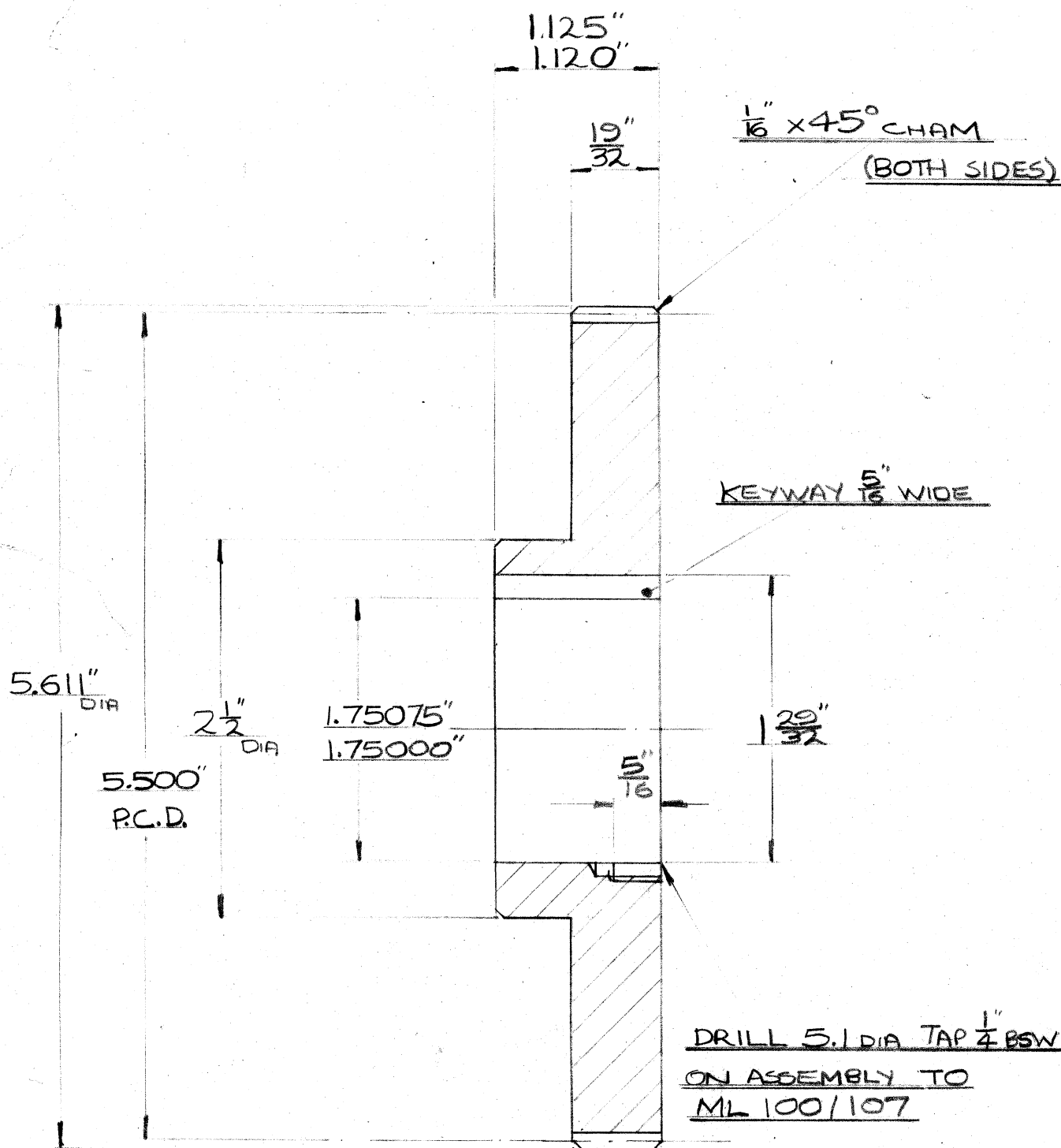
21.9.67

1517/67 P

29.11.67

REDRAWN

2.12.86 A.M.



TEETH	99
D.P.	18
PRESS ANGLE	20°
ADD	0.056"
WIDTH	0.086" - 0.084"
	3.8055"

FINISH MACHINE & GEAR CUT
AFTER ASSEMBLY WITH
ML 100/107

REMOVE SHARP CORNERS
MACHINE ALL OVER

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

FRACTIONAL ± .015" DECIMAL ± .0005"

99 SLIDING GEAR

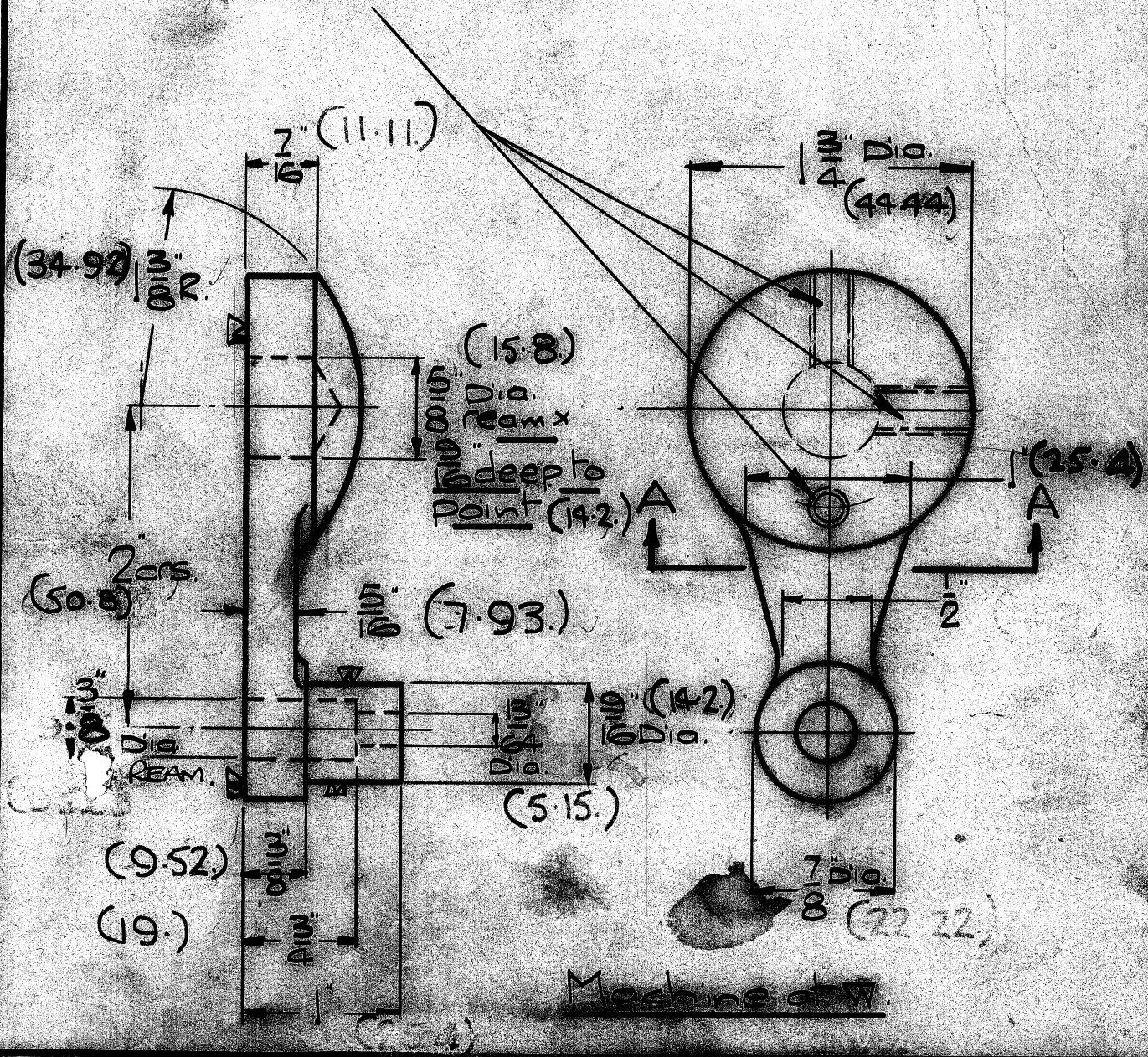
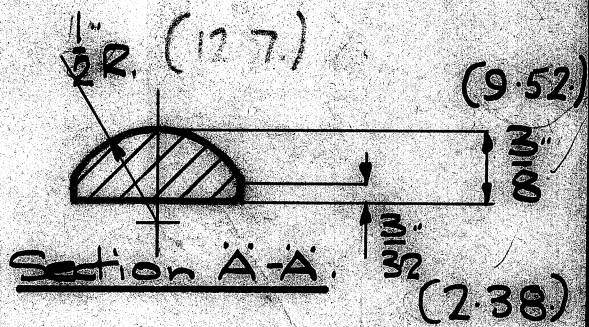
DRAWN	A.M.	MAT	CAST IRON
CHECKED		MAT SIZE	CASTING
PASSED		No. REQD.	ONE
DATE	2.12.86	SCALE	1:1
		ML 100/103	

IF IN DOUBT ASK.

JM

Metric dim's in brackets.

3 Holes drill $\frac{3}{8}$ " (5.15)
tap & whit (6.35)



5" Viceroy Metal Lathe HANDLE.

CAST IRON
CASTING

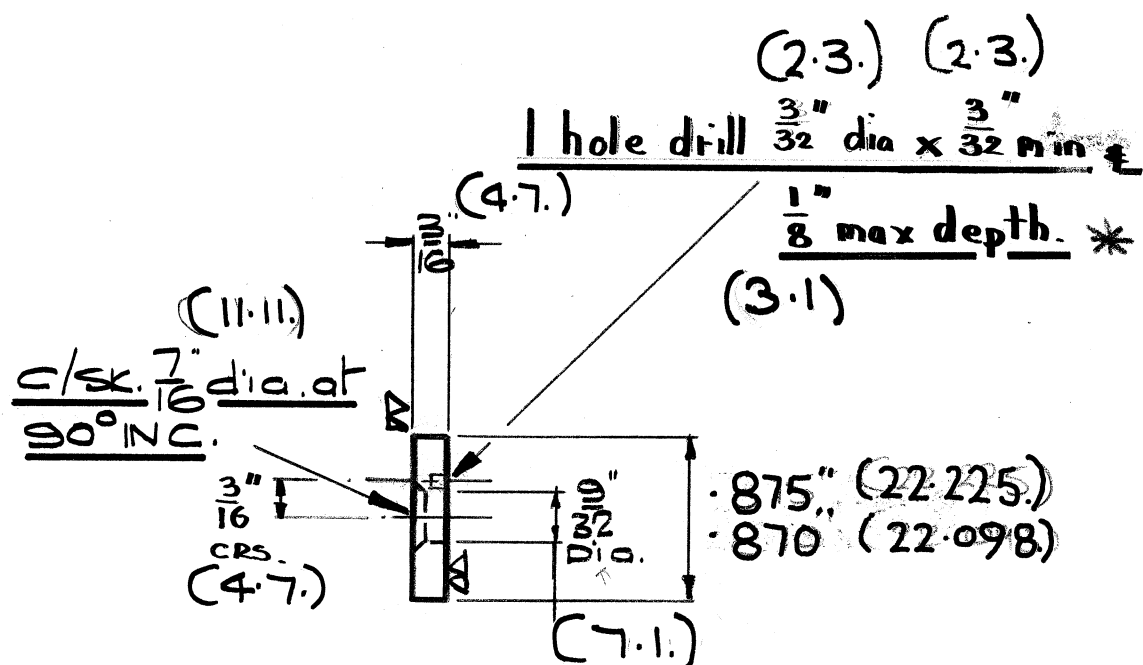
SCALE Full.

ML 100/10

1061/64 28.4.64 AD

1068/64 6.10.64 AD

1601/68 19.8.68 Jm



* This hole only to be used when plate is fitted to ML115/919 G.B. lathe.

metric dim's in brackets.

Machine at W.

IF IN DOUBT ASK.

5" Viceroy Metal Lathe - RETAINING PLATE.

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

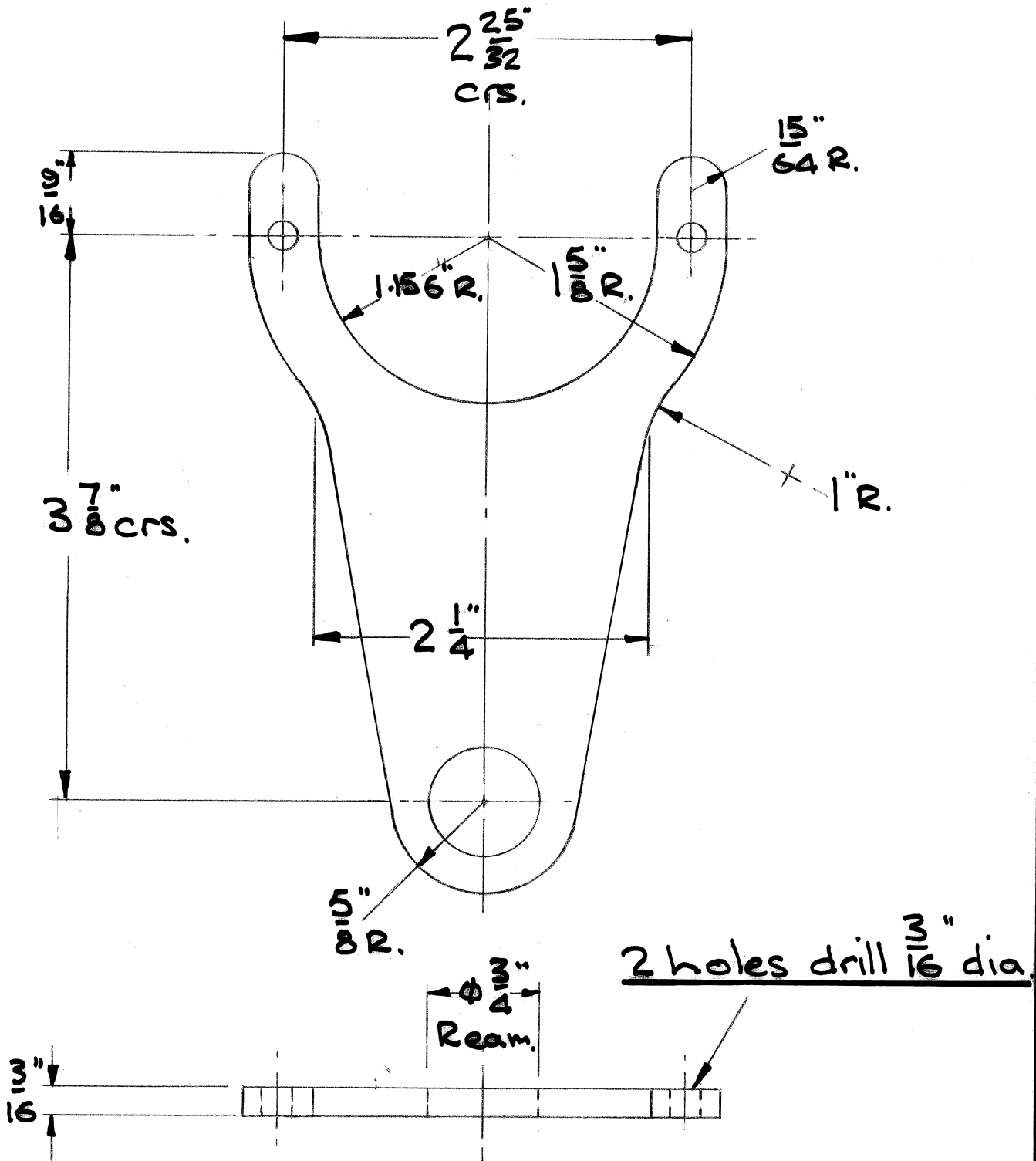
DRAWN Aans Clarke
CHECKED AS
PASSED
DATE 1.8.64.

MAT. $\frac{7}{8}$ " Dia. x $\frac{7}{16}$ " - M.S.
MAT SIZE (22.2) Dia x (11.11) - M.S.
No. REQD. 2 SCALE Full.
DRAWING No. M.L.100/117

IF IN DOUBT ASK.

ALTERATIONS

1896/71.20.10.71.90



Remove all sharp corners.

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm 1^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

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

5 Viceroy Metal Lathe :- Gear Shifter Fork.

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

DRAWN R.D.
CHECKED R.D.
PASSED
DATE 20.10.71.

MAT. M.S. Plate.
MAT. SIZE $5\frac{1}{16} \times 3\frac{1}{4} \times \frac{3}{16}$
No. REQD. 1. SCALE Full.
DRAWING No. ML100/109A.

2318/76.20.1276R

M/C at W.

$\phi 1 \frac{1}{4}$ "

$.745$ "
 $.740$ "

$\frac{1}{4}$ "

$\frac{1}{8}$ at 45°

$\frac{1}{32}$ at 45°

$3 \frac{15}{16}$ "

$3 \frac{11}{16}$ "

Mill slot: $.880$ "
 $.877$ " WIDE

$\frac{5}{16}$ "

$\frac{1}{32}$ at 45°

$\frac{1}{2}$ dia. drill.

Remove all sharp corners.

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

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

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

5" Viceroy Metal Lathe:- Gear Shifter Sliding Body.

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

DRAWN **R.A.**
CHECKED **R.D.**
PASSED
DATE **23. 10. 71.**

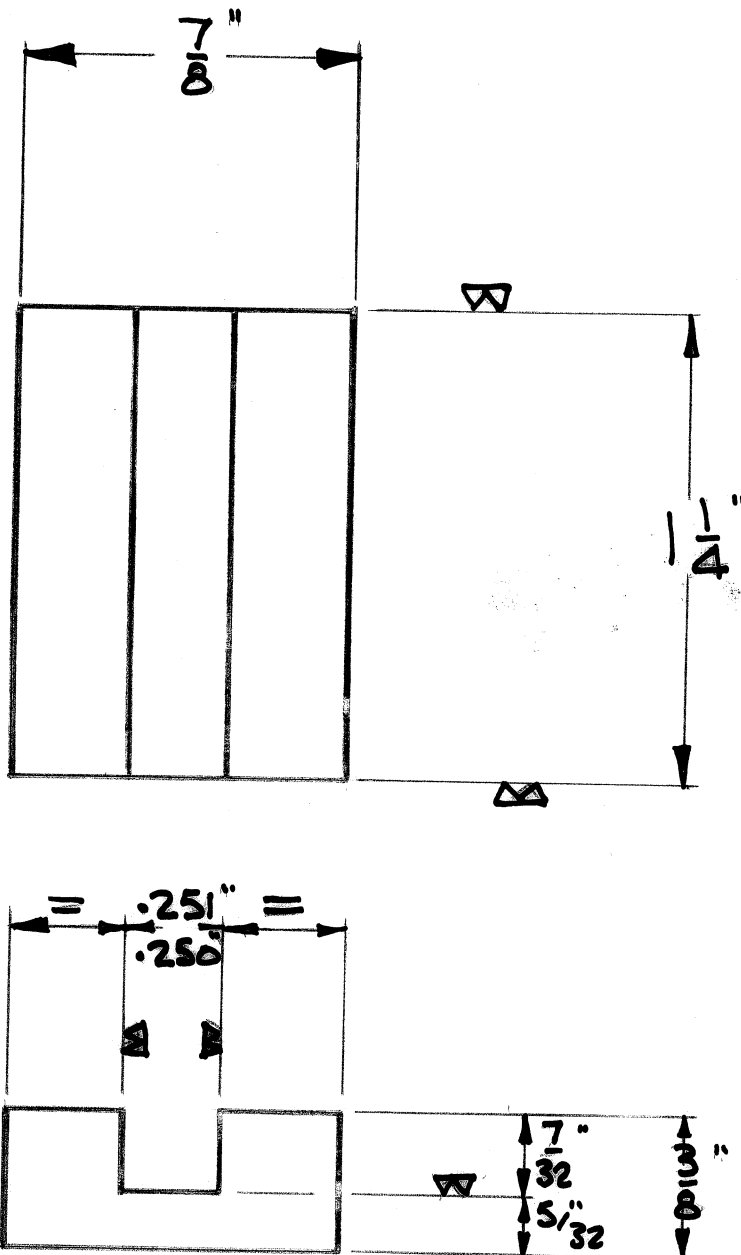
MAT.		M.S.
MAT. SIZE 1 1/4" dia x 4 3/16" long.		
No. REQD.	1	SCALE Full.
DRAWING No.		
ML100/109B.		

IF IN DOUBT ASK.

ALTERATIONS

1896/71. 20.10.71.

M/C at w.



Remove all sharp corners.

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

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

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

5" Viceroy Metal Lathe :- Gear Shifter Dog Insert.

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

DRAWN R.D.
CHECKED R.D.
PASSED
DATE 25.10.71.

MAT. M.S.
MAT. SIZE $1 \frac{1}{4} \times \frac{7}{8} \times \frac{3}{8}$
No. REQD. 1 SCALE Full x 2.
DRAWING No. ML100/109C.

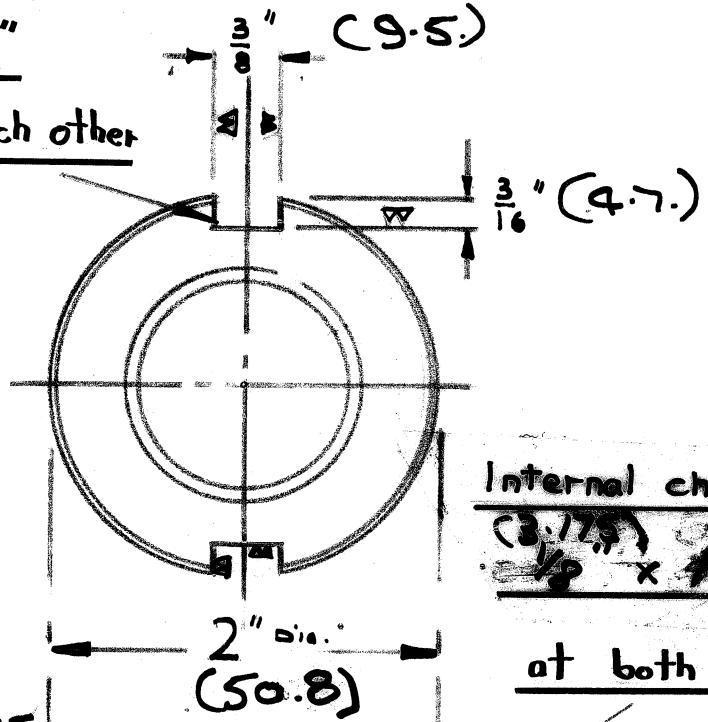
1018/64
 17.7.64 M.H.S.
 1029/64 1.12.64
 1205/65 17.7.65
 1503/67 20.9.67
 1720/69 12.12.69
 1989/72 12.9.72

3M
 RD.

(9.5) (4.7)

2 slots $\frac{3}{8}$ " wide x $\frac{3}{16}$ "

deep mill 180° to each other



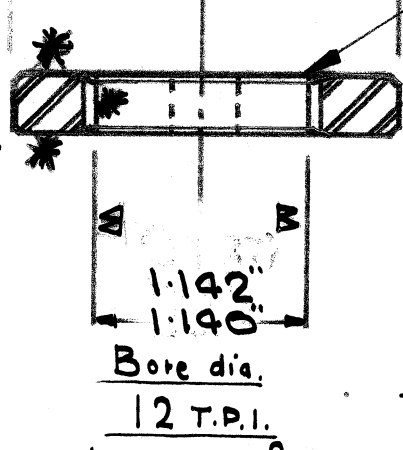
Machine at W

Internal chamfer
 (3.175)
 x 45°

at both sides

* BORE & FACES MUST
 BE SQUARE AND
 PARALLEL TO EACH
 OTHER

(.79)
 $\frac{1}{32}$ " at 45° chamfer both
 sides.



Metric dims in brackets.

Thread $\frac{1}{4}$ " nom. dia. (31.75)

Depth .053" (1.355).

IF IN DOUBT ASK.

5" VICEROY METAL TURNING LATHE - LOCKNUT

DENFORD MACHINE TOOLS LTD. (Inc.) DENFORD SMALL TOOLS (BRIG) LTD. BRIGHOUSE, YORKSHIRE.	DRAWN	M.M. Sowden	MAT.	B.D.M.S.
	CHECKED	AR.	MAT SIZE	(50.8) 2" dia x $\frac{9}{16}$ " LONG (14.288)
	PASSED		No. REQD.	2
	DATE	17.7.64	SCALE	FULL
			DRAWING No.	M.L 100/111

Redrawn 15.12.64

1494/67 22.8.67

2172/75.14.8.75

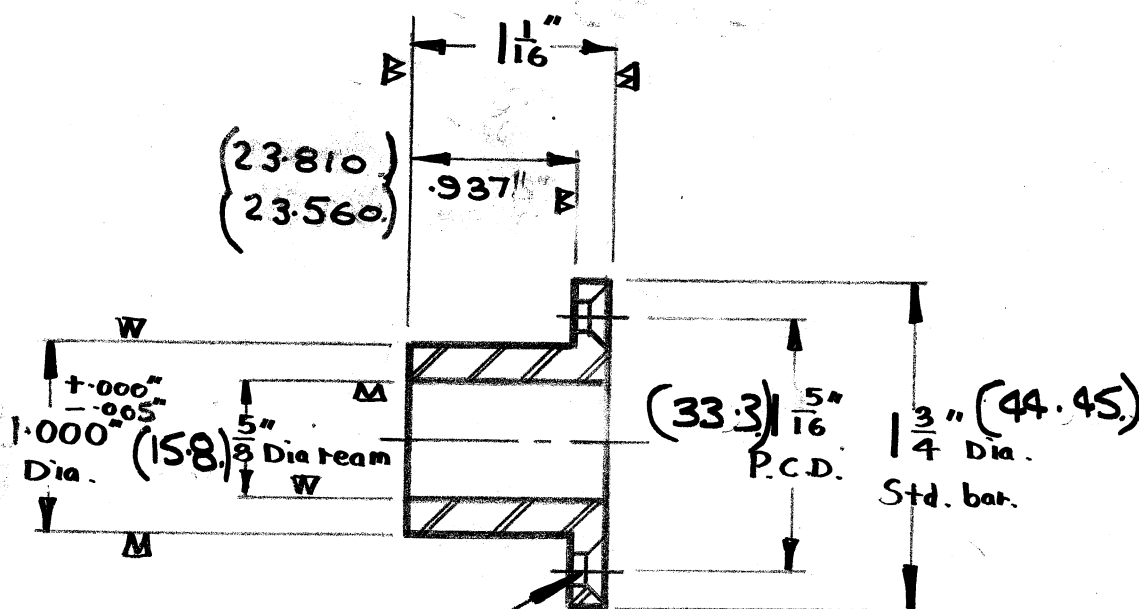
2394/77.8.77 RD.

2672/78.19.12.78 RD.

2743/79.25.5.79 N.

IF IN DOUBT ASK.

Metric dims in brackets.



2 holes drill 5.5mm dia &

c' sink 8mm dia x 90° incl. (FOR 2 BA)

Machine at W

5" Viceroy Metal Lathe - Gear Shifter Bush.

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

DRAWN *M.M. Sowden*
CHECKED *AS*
PASSED
DATE 15.12.64

MAT. Mild Steel (33.3)
MAT SIZE (44.5) 1 3/4" std. bar x 1 5/16" long
No. REQD. 1 SCALE Full
DRAWING No. ML100/112

IF IN DOUBT ASK.

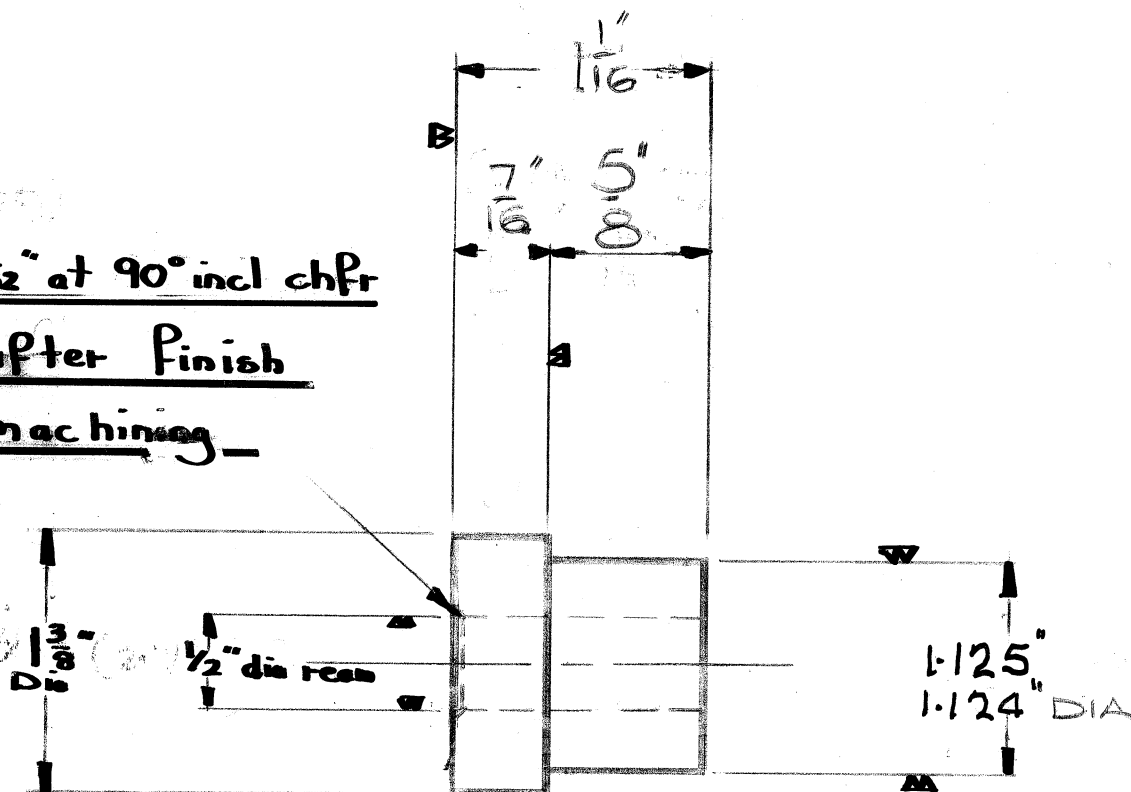
1190/651-665 D

1250/6513-11458

2463/77. 29.11.77 IV.

2616/78, 18.10.78 RD.

$\frac{1}{32}$ " at 90° incl chfr
after Finish
machining



Machine at w

5" Viceroy Metal Lathes : Back gear shaft bush.

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

DRAWN
M.M. Sowden
CHECKED
PASSED
DATE
1-6-65.

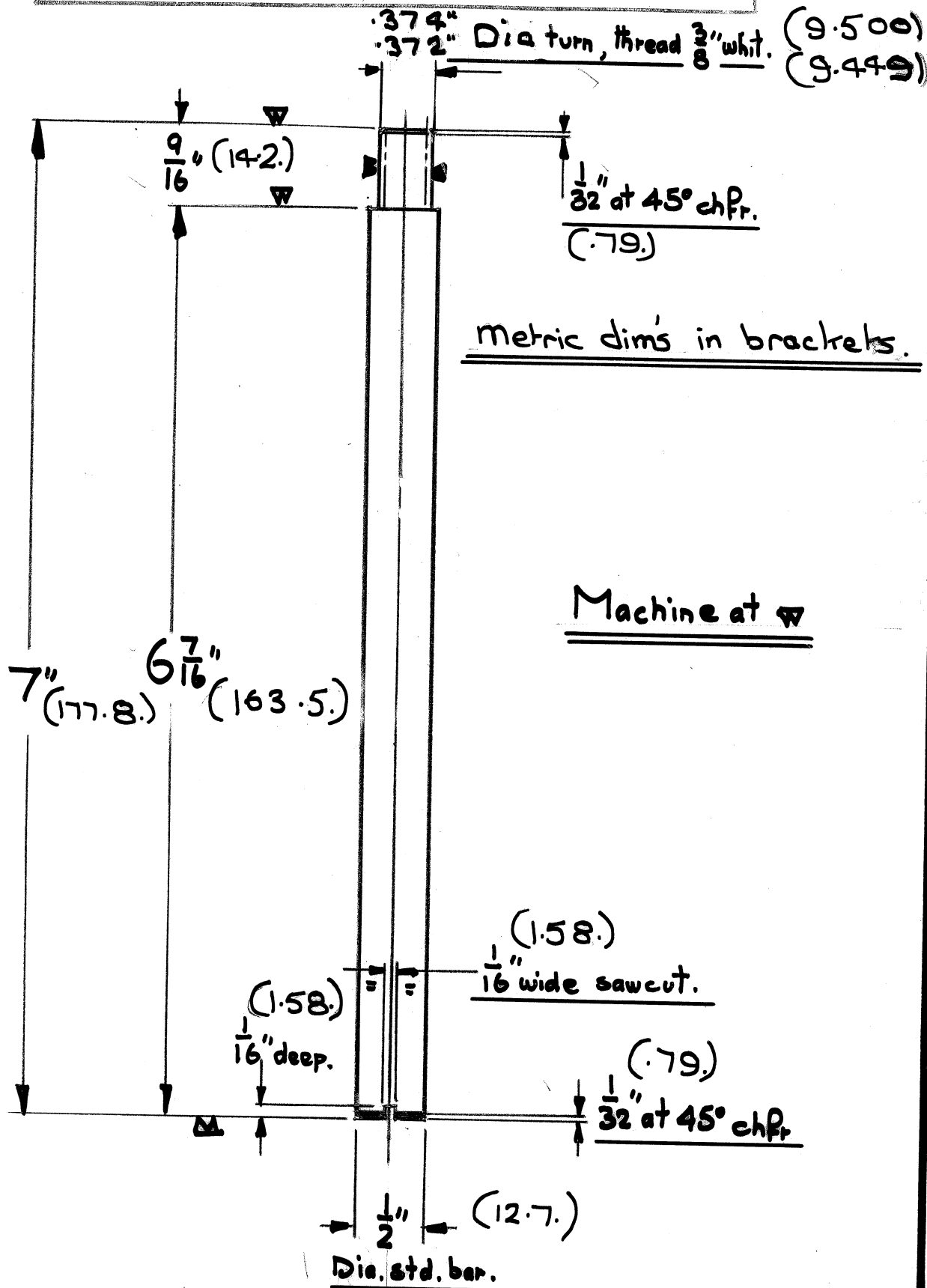
MAT. M.S. (34.92) x (36.5)
MAT SIZE 1 3/8" x 1 1/4"
No. REQD. 1 SCALE Full
DRAWING No.
ML100/115

MAT.	Mild Steel (25.4) x (31.75)		
MAT SIZE	1" Dia x 1 $\frac{1}{4}$ " long		
No. REQD.	1	SCALE	Full
DRAWING No.			
ML 100 / 116.			

IF IN DOUBT ASK.

am B

1284/66 18.1.66 S.
Redrawn 18.1.66 S.
1060/64 28.9.64 S.
1069/64 6.10.64 S.
1284/66 18.1.66 S.



5" Viceroy Metal Lathes - Gear Shifter Shaft

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

DESIGN
M. M. Sowden



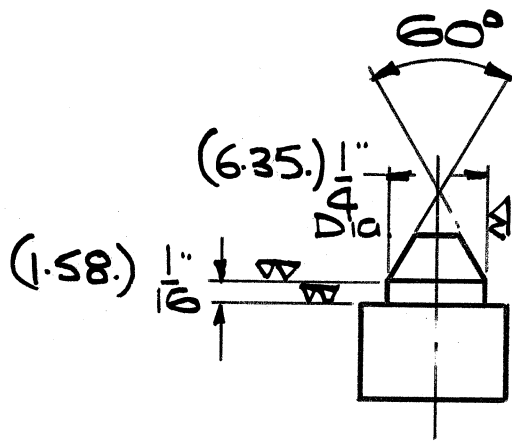
DATE
18.1.66

MAT. M.S. (12.7) x (184.2)

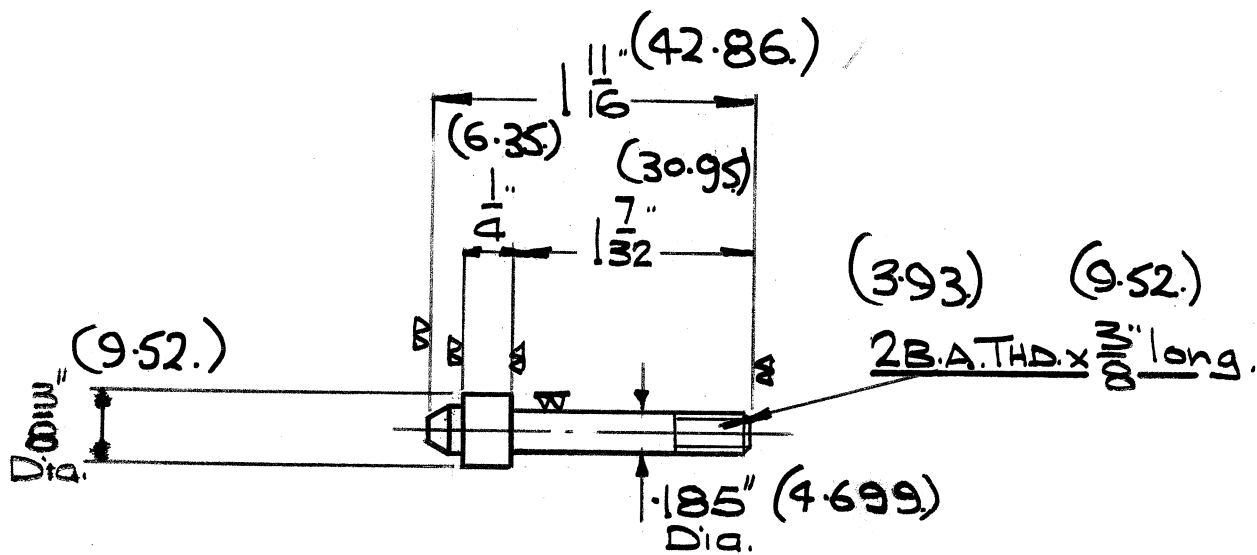
QTY 1/2" dia. x 7 1/4" long

SCALE Full.

ML100/118



2 x Full Size.



Metric dim's in brackets.

Machine at W.

Cyanide harden.

IF IN DOUBT ASK.

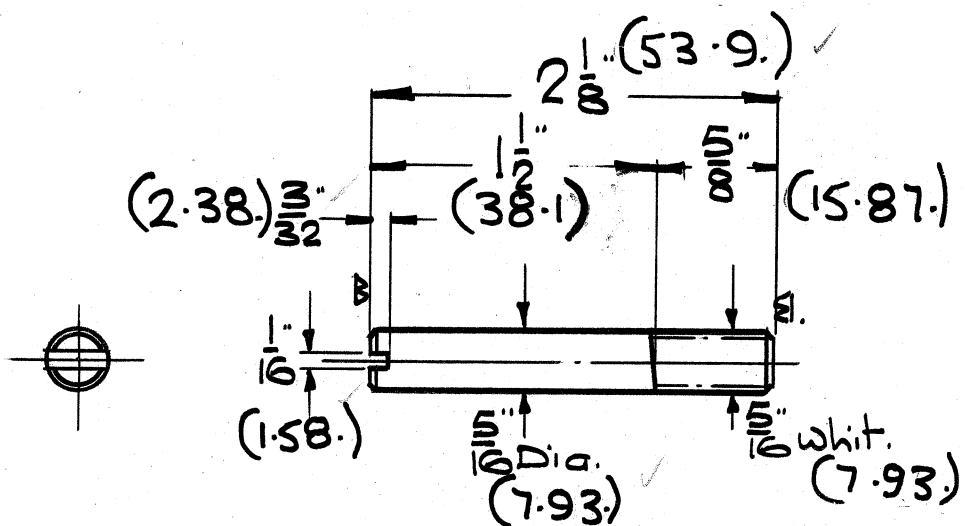
5" Viceroy Metal Lathe - LOCATING PIN.

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

DRAWN Aas. Clarke.
CHECKED
PASSED
DATE 1.5.64.

MAT. M.S. (9.52) Dia x (49.2)
MAT SIZE 3/8" Dia. x 1 15/16"
No. REQD. 1 SCALE Full.
DRAWING No. M.L.100/119

Metric dim's in brackets.



Machine at W.

IF IN DOUBT ASK.

5" Viceroy Metal Lathe - CATCH PLATE DRIVING PIN.

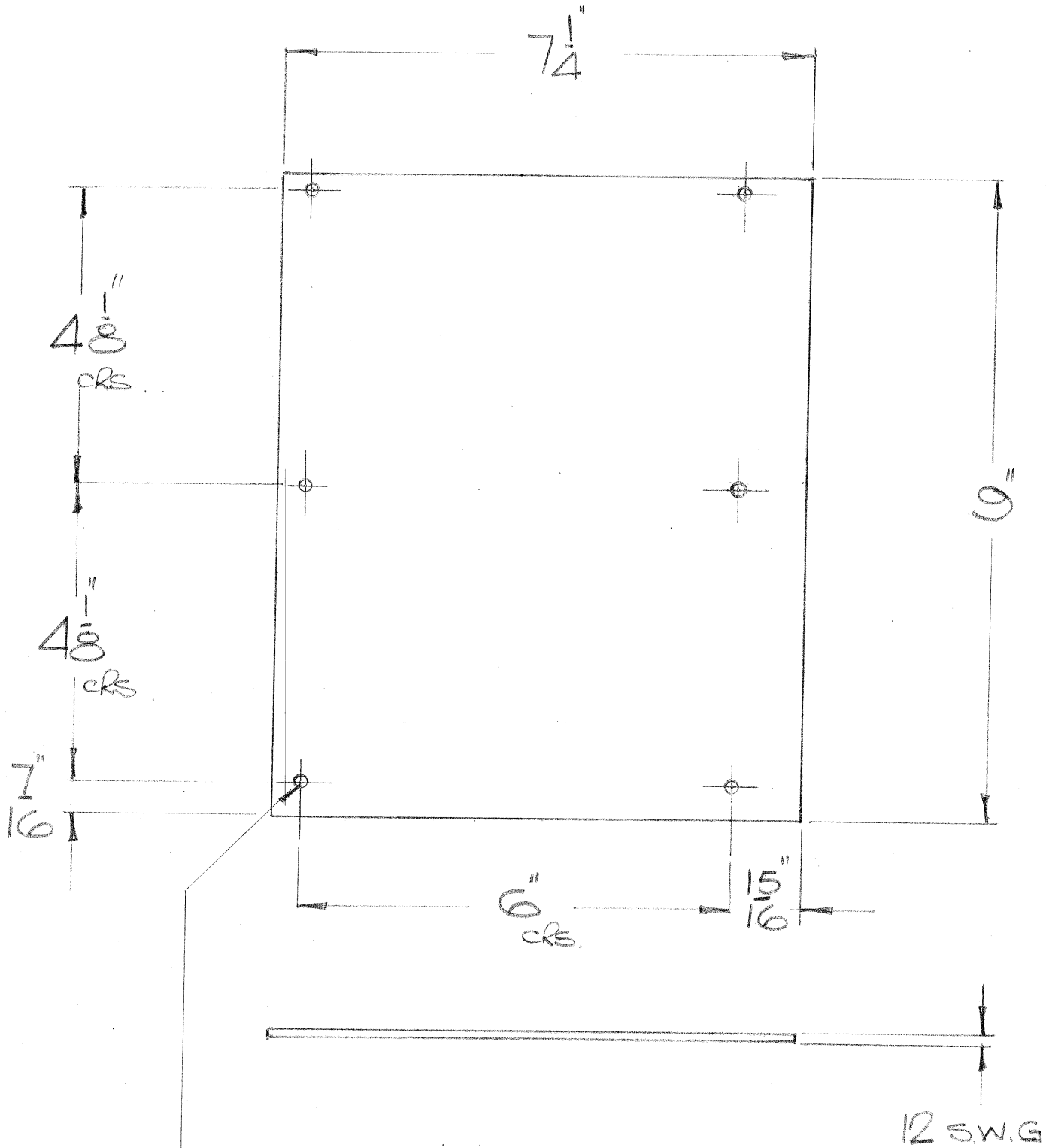
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN *A. S. Clarke*
CHECKED *[Signature]*
PASSED
DATE 1. 5. 64.

MAT. M.S. (7.93) dia x (60.3).
MAT SIZE $5 \frac{1}{16}$ " Dia. x $2 \frac{3}{8}$ "
No. REQD. 1 SCALE Full.
DRAWING No. M.L. 100/120

IF IN DOUBT ASK

ALTERATIONS



6 HOLES, DRILL
7"
32 DIA.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

ANGULAR $\pm 1^\circ$ 3 PLACE DECIMAL $\pm .005$ "

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

5" METAL LATHE - HEADSTOCK COVER

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

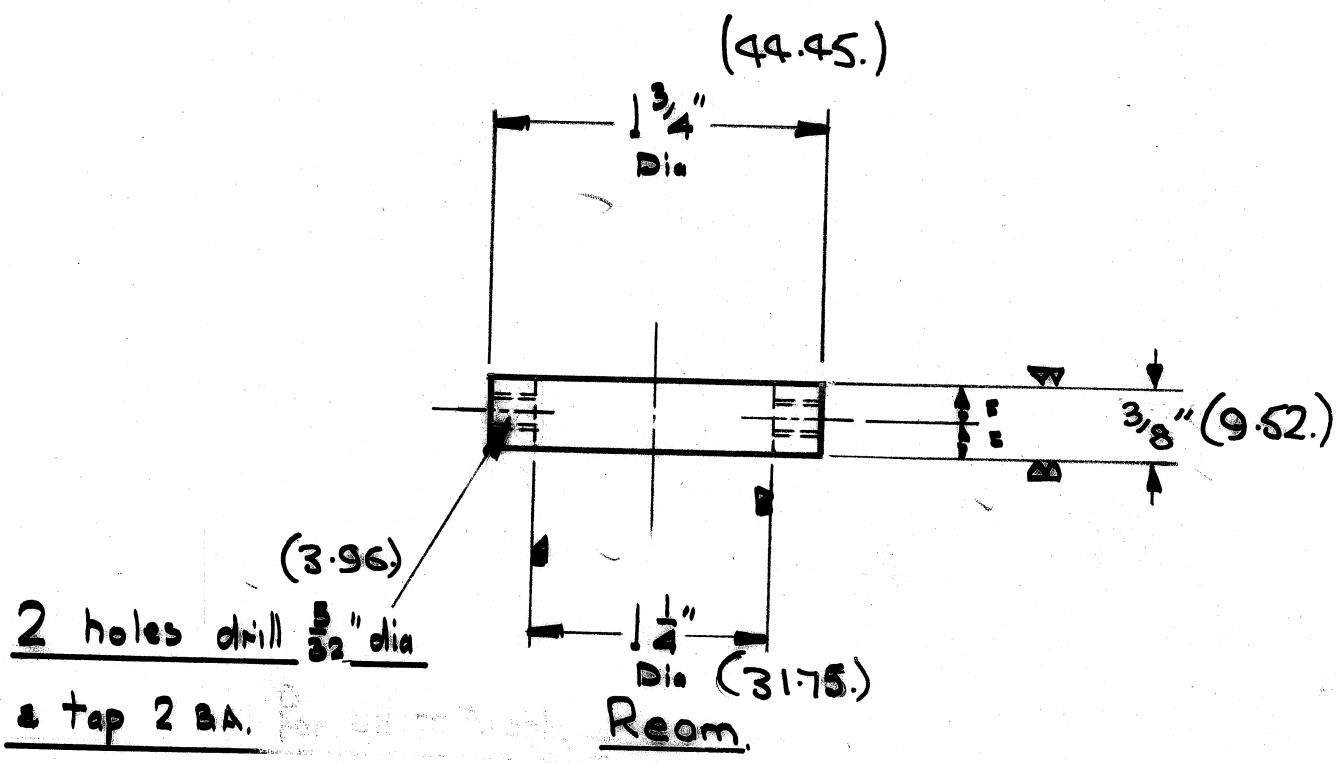
DRAWN IV.
CHECKED
PASSED
DATE 8.12.77

MAT. SHEET STEEL
MAT. SIZE AS ABOVE
No. REQD. 1 SCALE 1/2 x FULL
DRAWING No. ML.100/125

IF IN DOUBT ASK.

MT R

1154/65 20.3.65
Redrawn 26.10.65
1237/65 26.10.65
1379/66-12.8.66
1746/70.04.70



5" Viceroy Metal Lathes. - Thrust Washer

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

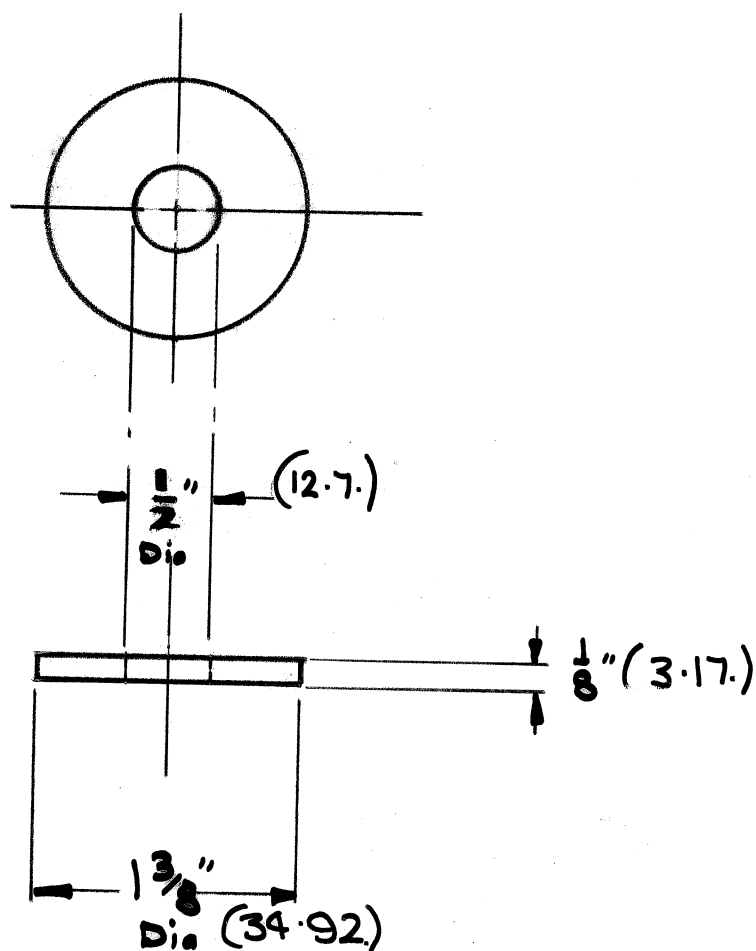
DRAWN *M. M. Souden*
CHECKED *[Signature]*
PASSED
DATE 26.10.65

MAT. M.S.
MAT SIZE (44.45) 1 3/4" dia x (15.87) 5/8"
No. REQD. 1 SCALE Full
DRAWING No. ML 100/129

IF IN DOUBT ASK.

M
D

Metric dim's in brackets.



Machine all Over

5" Viceroy Metal Lathes - Back Gear Washer

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

DRAWN *A. H. Sord-*
CHECKED *[Signature]*
PASSED
DATE 15. 11. 65

MAT. M.S.
MAT. SIZE (34.92) 1 3/8" Dia x 3/8" (9.52)
No. REQD. 1 SCALE Full
DRAWING No. ML 100 / 132

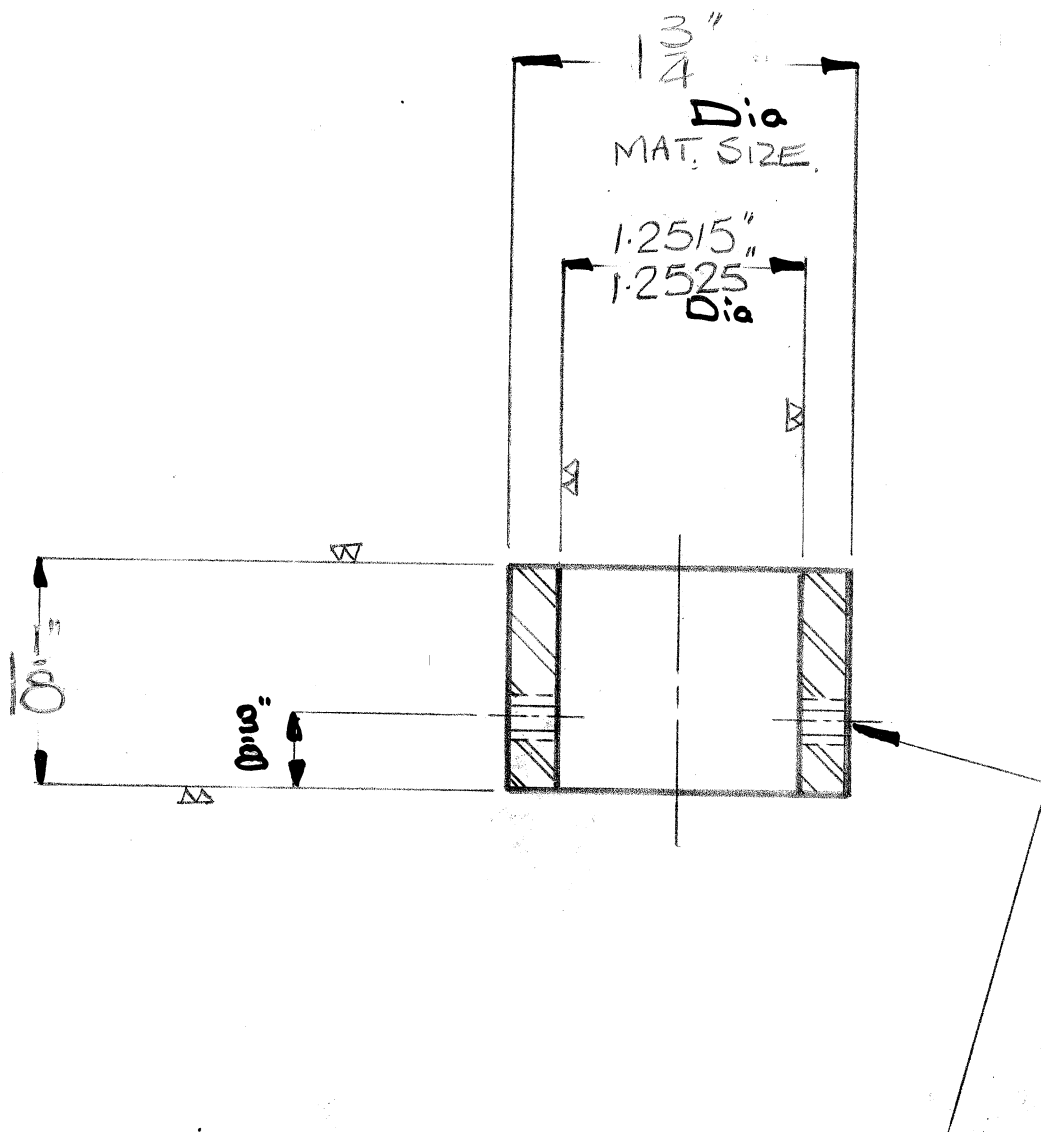
IF IN DOUBT ASK.

ALTERATIONS

2030/73.8.5.73P

2304/76.4.8.76.RD

2462/77.29.11.77.V.



2 holes drill $\frac{3}{32}$ dia
at top 2 B.A.

Remove all sharp corners.

MACHINE AT W.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" Viceroy Metal lathe - SPINDLE BUSH.

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

DRAWN ~~IT~~
CHECKED ~~IT~~
PASSED
DATE 6.1.70

MAT. M.S.
MAT. SIZE $1\frac{3}{4}$ Dia X $1\frac{5}{8}$ long.
No. REQD. 1 SCALE FULL.
DRAWING No. ML.100/136.

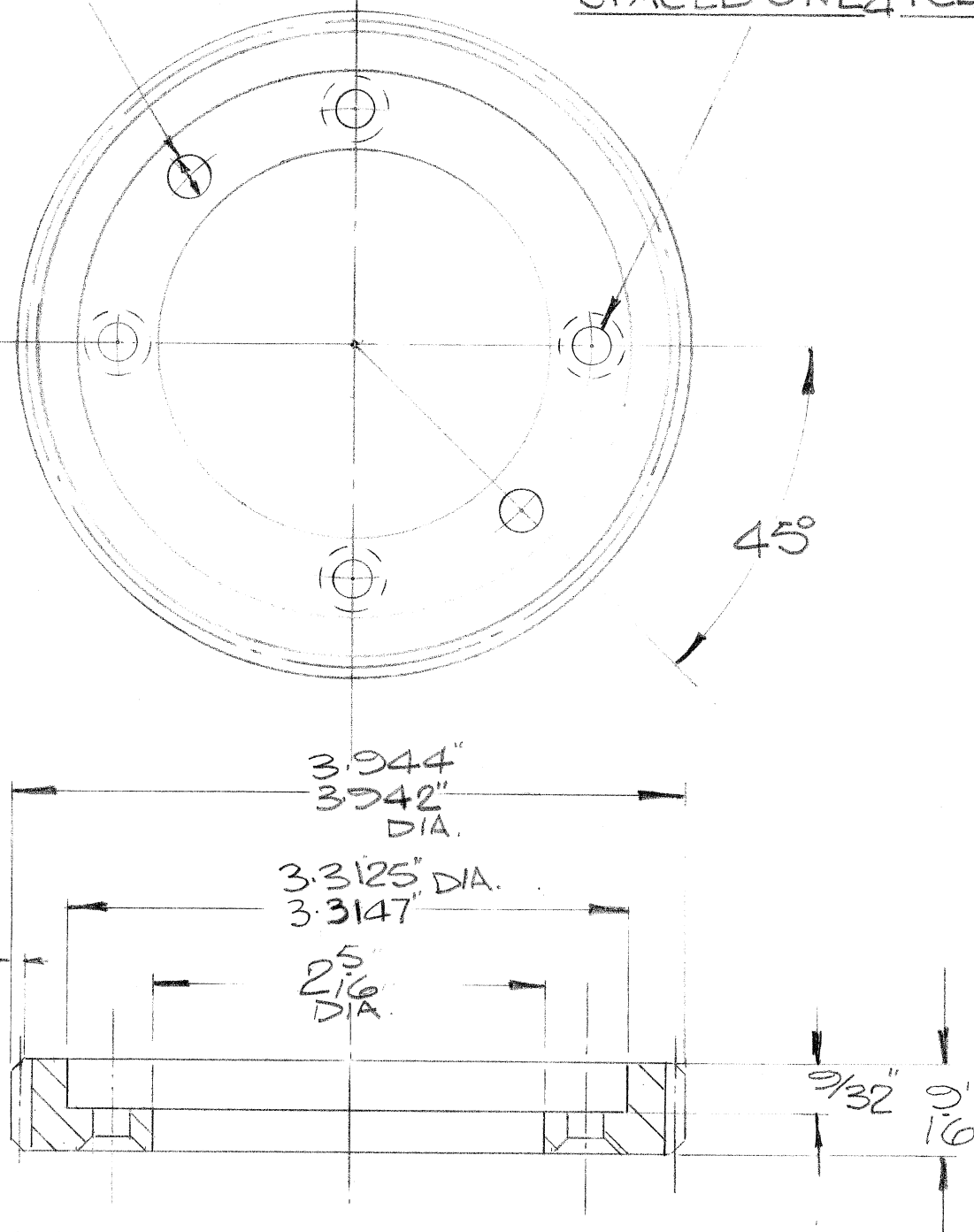
IF IN DOUBT ASK

ALTERATIONS

2 HOLES - DRILL
+ REAM $\frac{1}{4}$ " DIA.
EQUI-SPACED
ON $2\frac{3}{4}$ " PCD

4 HOLES - DRILL $\frac{7}{32}$ "
DIA., C/SINK $\frac{3}{8}$ " DIA.
x 90° INC. EQUI-
SPACED ON $2\frac{3}{4}$ " PCD

$\frac{1}{16}$ " x 45°
CHAMFER
BOTH SIDES



GEAR PARTICULARS	
No. of Teeth	69
DP	18
WIDTH	.086/.084"
ADD.	.056"
PCD	3.8333"
PRESS. ANG.	20°

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

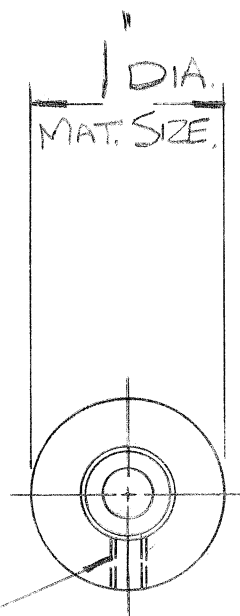
DRIVEN CLUTCH GEAR INSERT

DENFORD MACHINE TOOLS LTD. (Inc.) DENFORD SMALL TOOLS (BRIG) LTD. BRIGHOUSE, YORKSHIRE.	DRAWN DR	MAT. NYLON	
	CHECKED	MAT. SIZE	
	PASSED	No. REQD. 1	SCALE FULL
	DATE 29/5/74	DRAWING No. ML 100/137A	

IF IN DOUBT ASK

ALTERATIONS

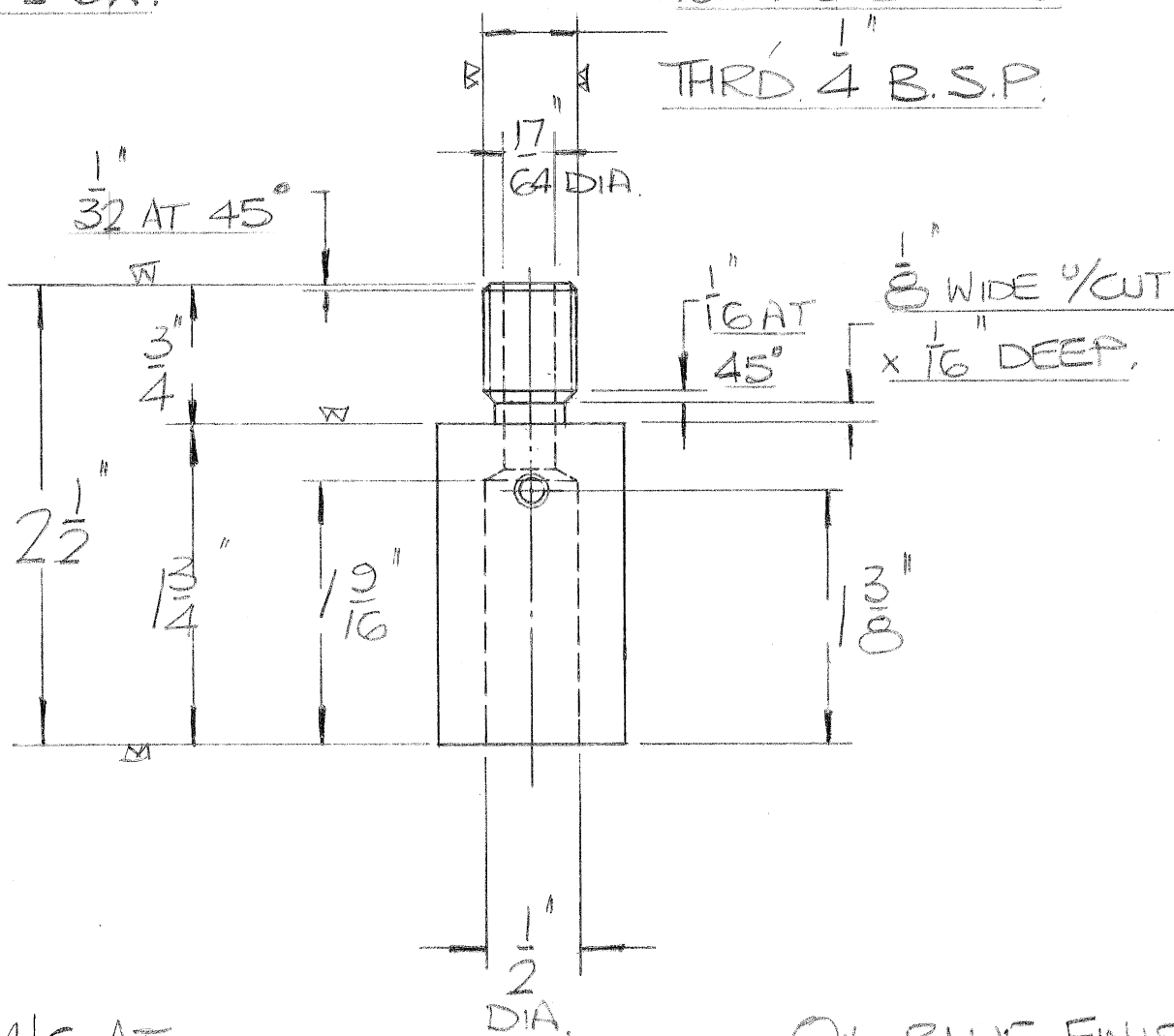
REDRAWN
9.1.75. RD.



1 HOLE DRILL 5/32" DIA.

2 BA.

TURN .518" DIA &
THRD 1/4 B.S.P.



M/C AT W

OIL BLUE FINISH

REMOVE ALL SHARP
CORNERS.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" VICEROY METAL LATHE - LO-V6 LIGHT FITTING.

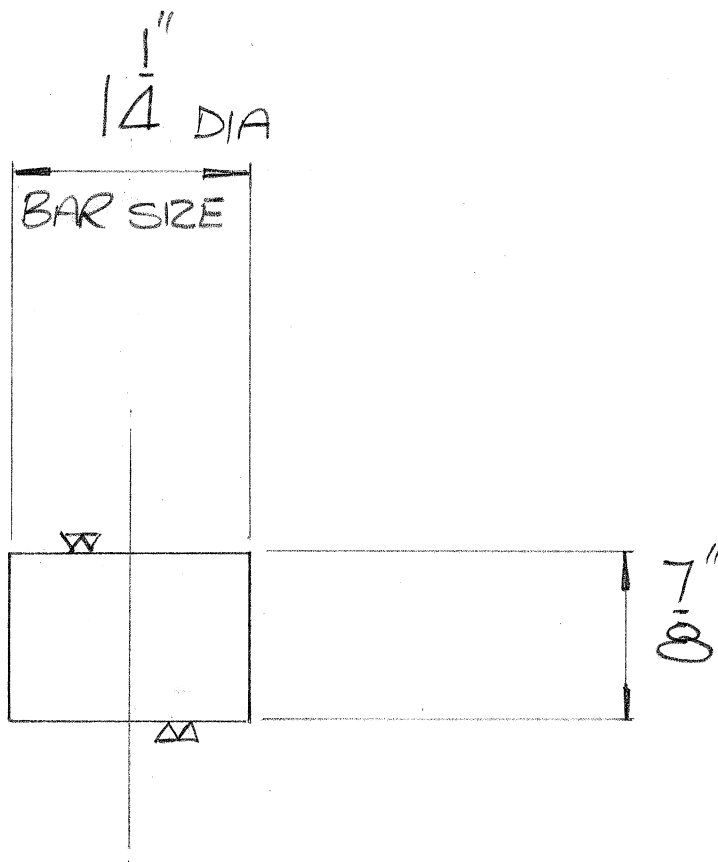
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN RD
CHECKED
PASSED
DATE 9.1.75.

MAT. M.S.
MAT. SIZE 1" DIA. x 2 5/8"
No. REOD. 1 SCALE FULL
DRAWING No. ML100/142.

IF IN DOUBT ASK

ALTERATIONS



NO CHAMFERS

MACHINE AT W.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

FRACTIONAL $\pm .010^{\circ}$ 4 PLACE DECIMAL $\pm .0005^{\circ}$

METAL LATHE HEADSTOCK - HOLE BUNG

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

DRAWN IV.

CHECKED

PASSED

DATE 7.9.76.

MAT. MILD STEEL

MAT. SIZE 1/4" DIA x 1" LONG.

No. REQD. 1

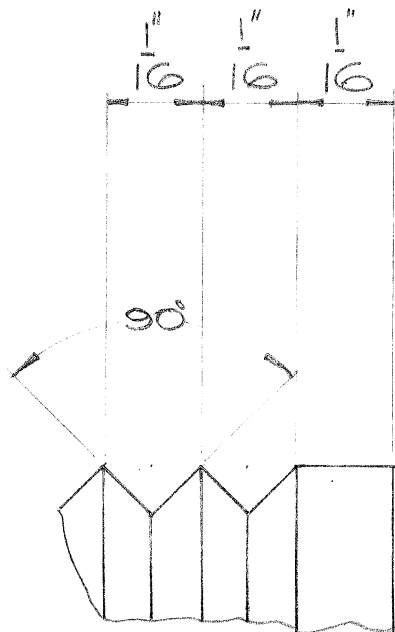
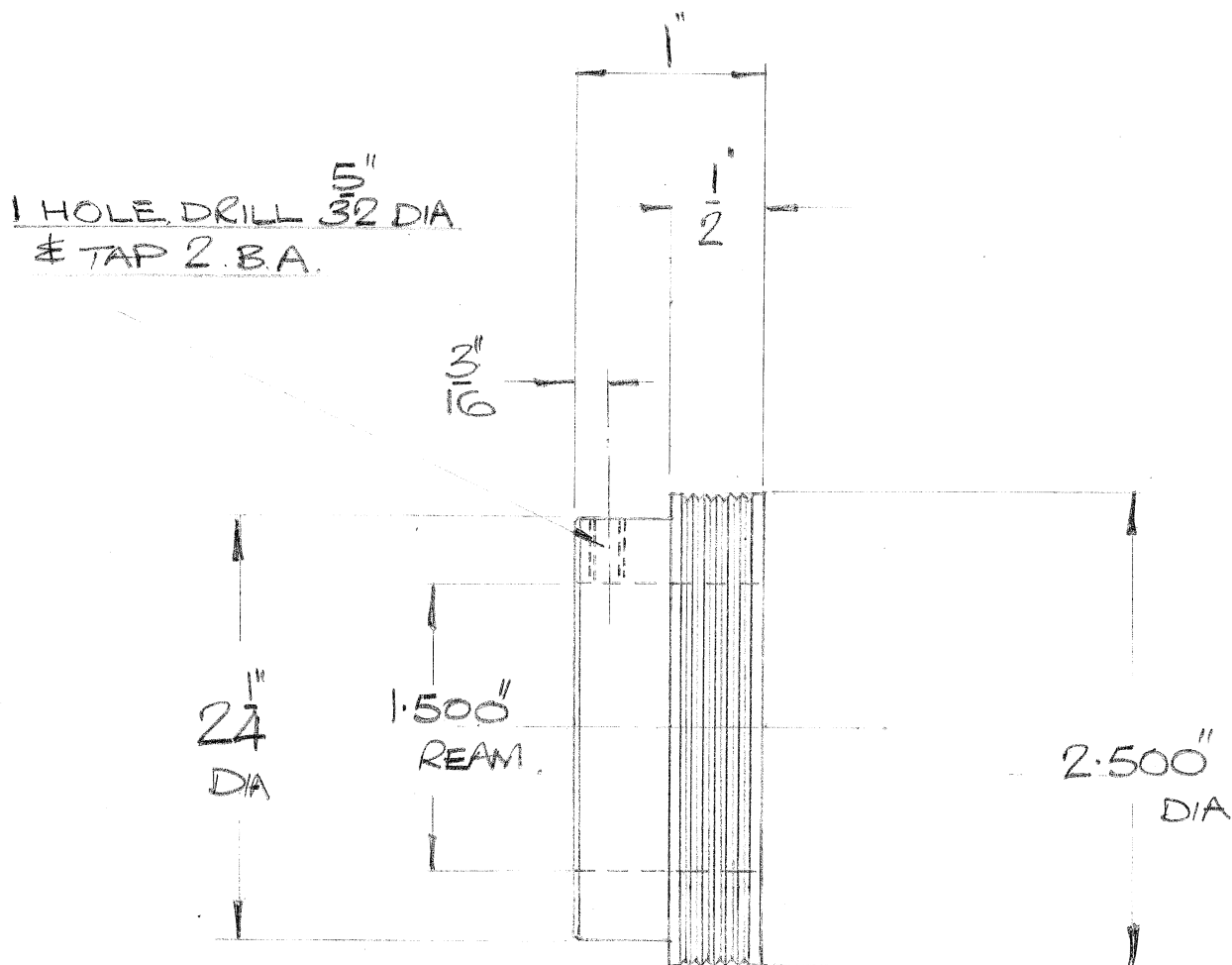
SCALE FULL

DRAWING No.

ML100/143

IF IN DOUBT ASK

ALTERATIONS



ENLARGED VIEW
OF GROOVES

MACHINE ALL OVER

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" METAL LATHE - GREASE RETAINING COLLAR

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

DRAWN *IV.*

CHECKED

PASSED

DATE 15.5.79

MAT. CAST IRON.

MAT. SIZE

No. REQD. ONE

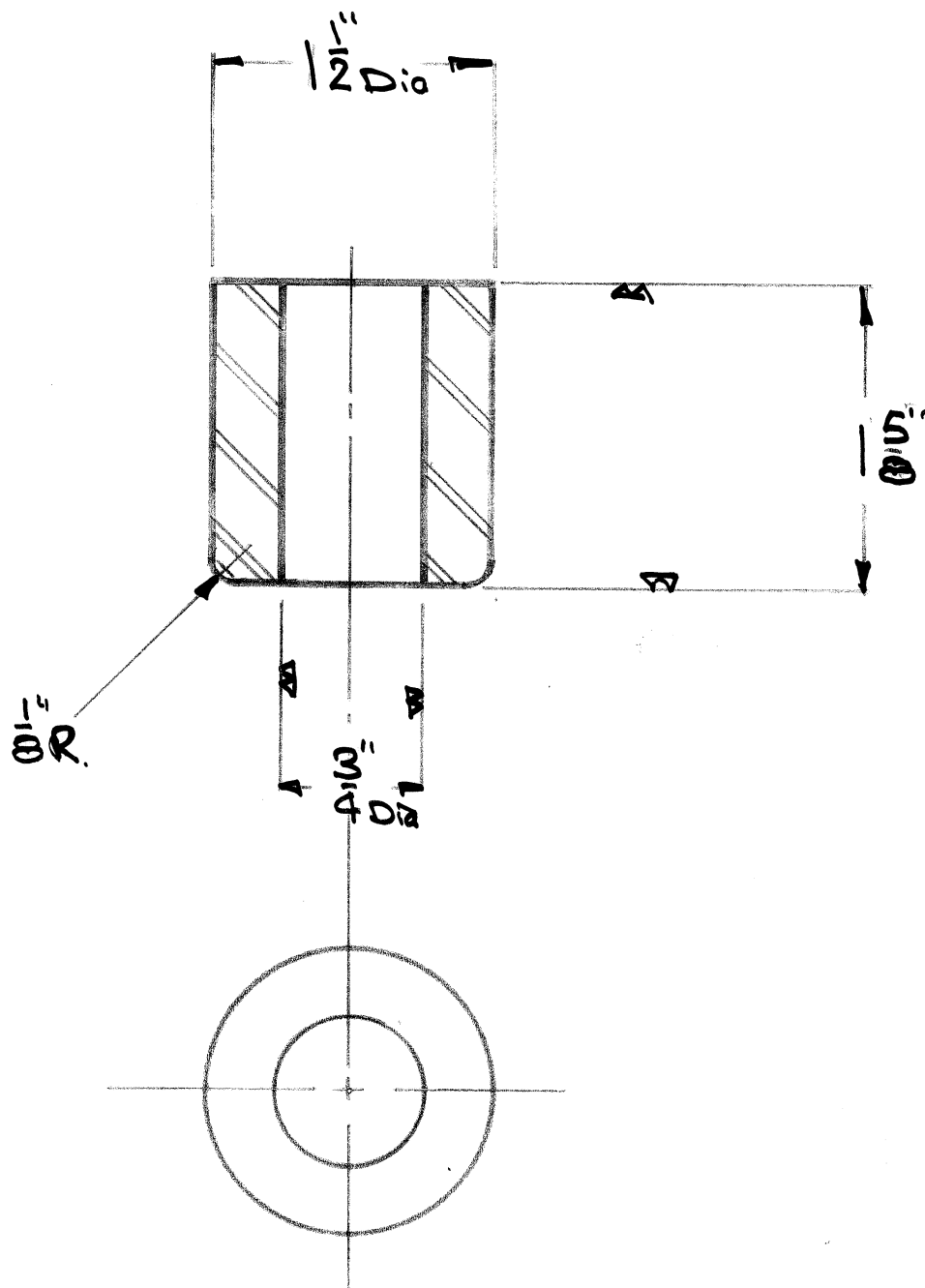
SCALE

DRAWING No.

ML100/147

IF IN DOUBT ASK.

ALTERATIONS



Remove all sharp corners - Machine at W

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" Viceroy Metal Lathe - Cabinet Foot.

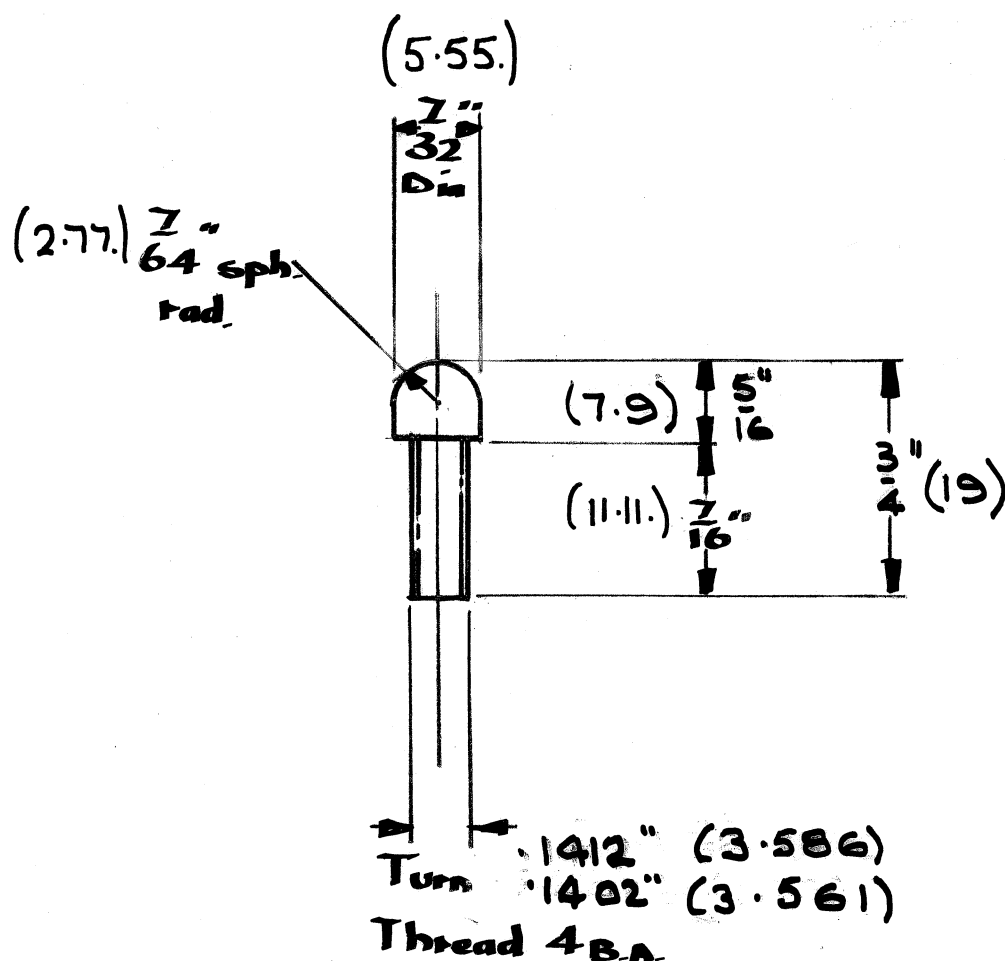
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN *IX*
CHECKED *[Signature]*
PASSED
DATE 20.1.70

MAT. M.S.
MAT. SIZE $1\frac{1}{2}$ " Dia x $1\frac{1}{16}$ " long.
No. REQD. 3 SCALE FULL
DRAWING No. ML100/207.

IF IN DOUBT ASK.

1099/6422-12-65
Rel. 19-8-65
1739/70.17.2.70



Machine all over

Metric dim's in brackets.

5" Viceroy Plain Metal Lathe - Adjustable-Micro-Switch Plunger

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

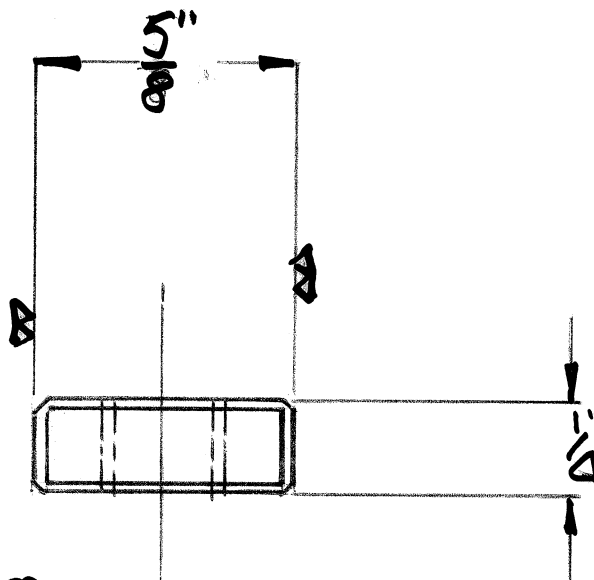
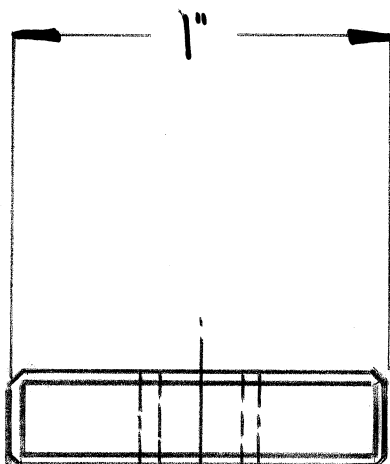
DRAWN
M. M. Sowden
CHECKED
B
PASSED
DATE
19.8.65

MAT. **M.S. (6.35) dia x (22.22)**
MAT SIZE **1/4" dia x 1"**
No. REQD. **1** SCALE **Full x 2**
DRAWING No.
ML100/216

IF IN DOUBT ASK.

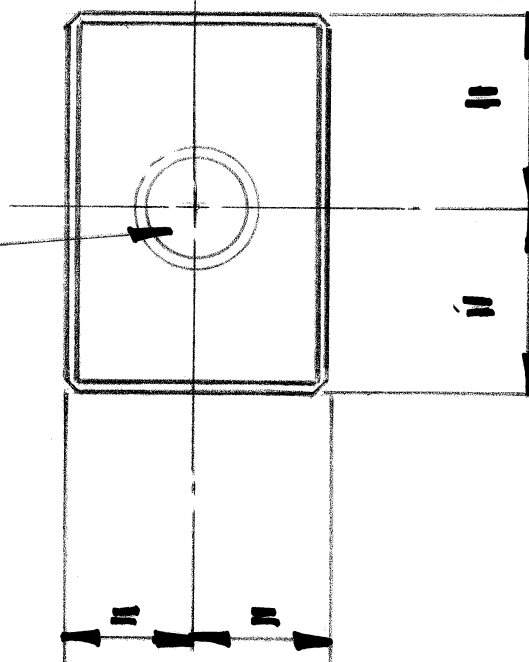
ALTERATIONS

1992/72-19-9-72.30



BREAK ALL SHARP CORNERS

1 hole drill, 1/4 dia
& tap 5/16 whit.



LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

ANGULAR $\pm 1^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

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

5" Viceroy Metal lathe - Coolant block Clamp.

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

DRAWN

[Signature]

CHECKED

[Signature]

PASSED

DATE

9.6.70

MAT. M.S.

MAT. SIZE 1" x 1/4" cutoff at 1/16"

No. REQD. 1.

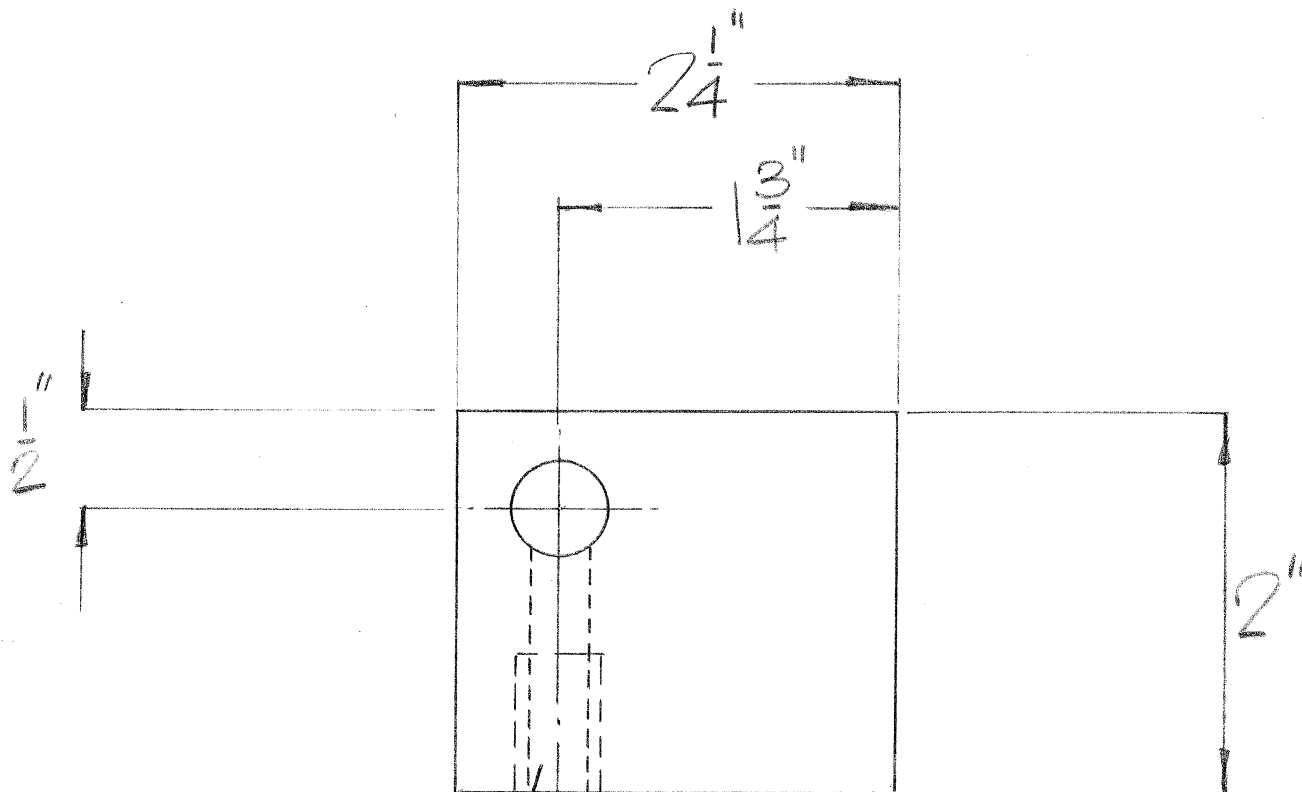
SCALE 2x FULL

DRAWING No.

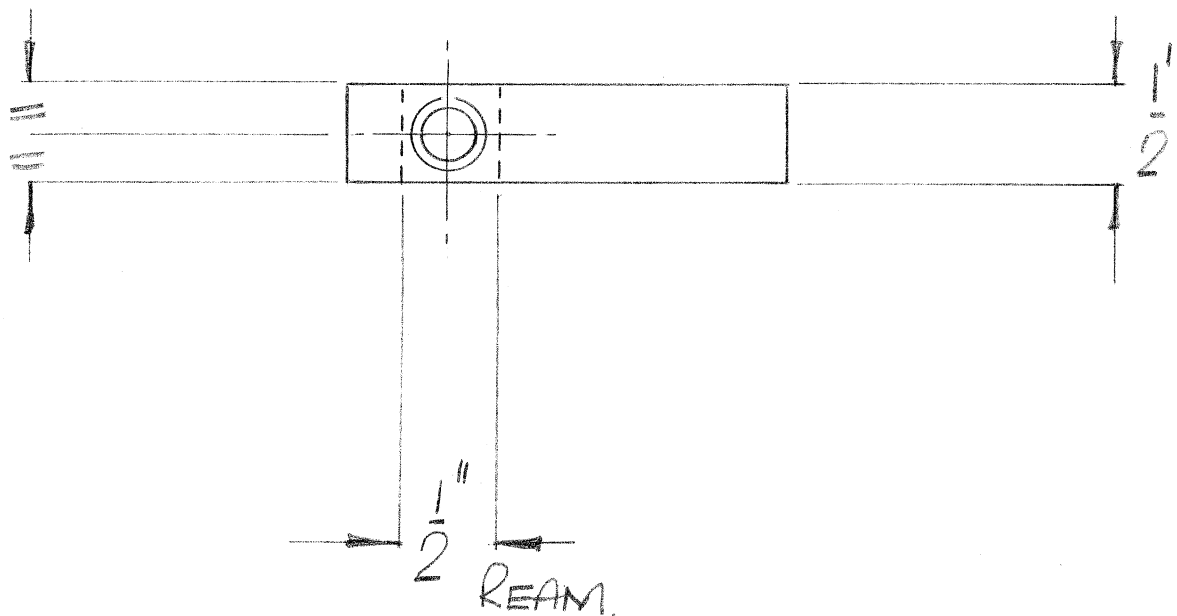
ML100/220.

IF IN DOUBT ASK

ALTERATIONS



5"
HOLE DRILL. $\phi 1/2$ &
TAP $3/8$ WHIT X $3/4$ DEEP.



REMOVE SHARP EDGES.

SAW CUT TO LENGTH.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

ANGULAR $\pm 1/2^\circ$ 3 PLACE DECIMAL $\pm .005$ "

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

5" VICEROY METAL LATHE - CONNECTING PIN SUPPORT.

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

DRAWN IV.

CHECKED

PASSED

DATE 22.11.75

MAT. MILD STEEL.

MAT. SIZE $2" \times 1/2" \times 2 1/4"$

No. REQD. 1.

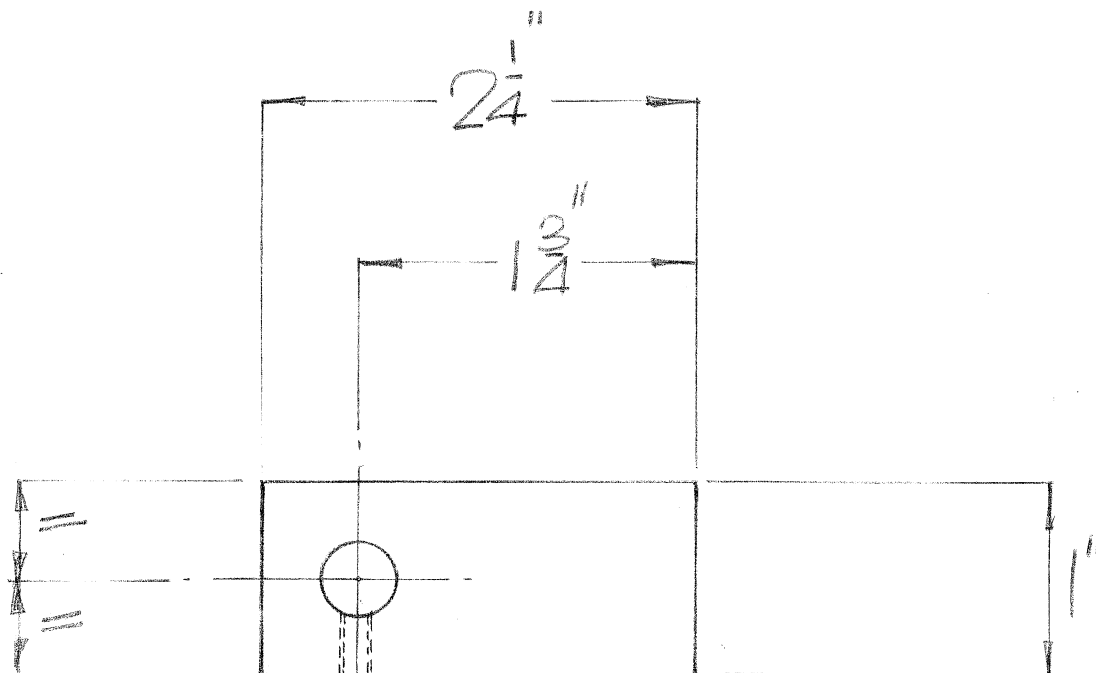
SCALE Full.

DRAWING No.

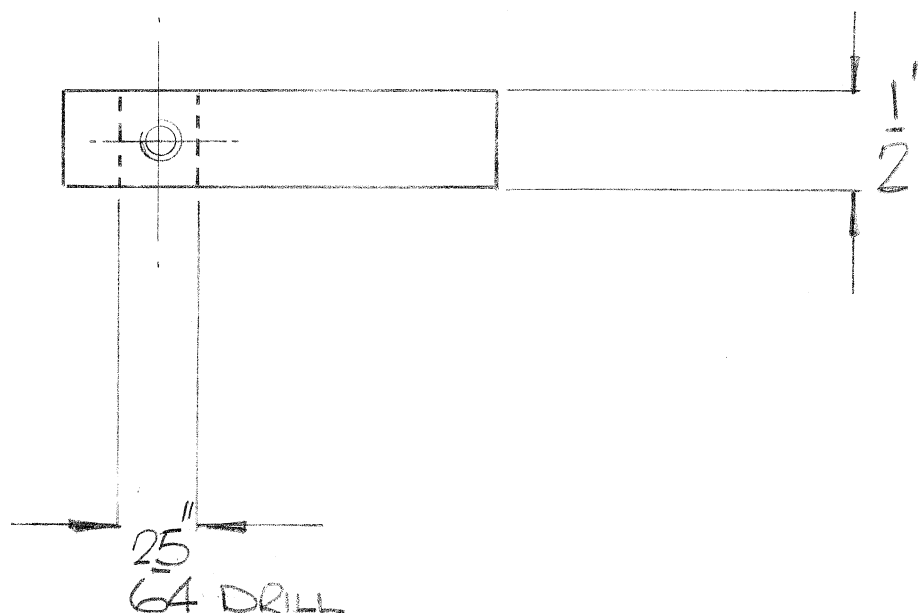
ML1000/221

IF IN DOUBT ASK

ALTERATIONS



1 HOLE DRILL $\frac{5}{32}$ DIA
TAP 2BA



REMOVE SHARP EDGES.

SAW CUT TO LENGTH.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" VICEROY METAL LATHE - PIVOT PIN SUPPORT.

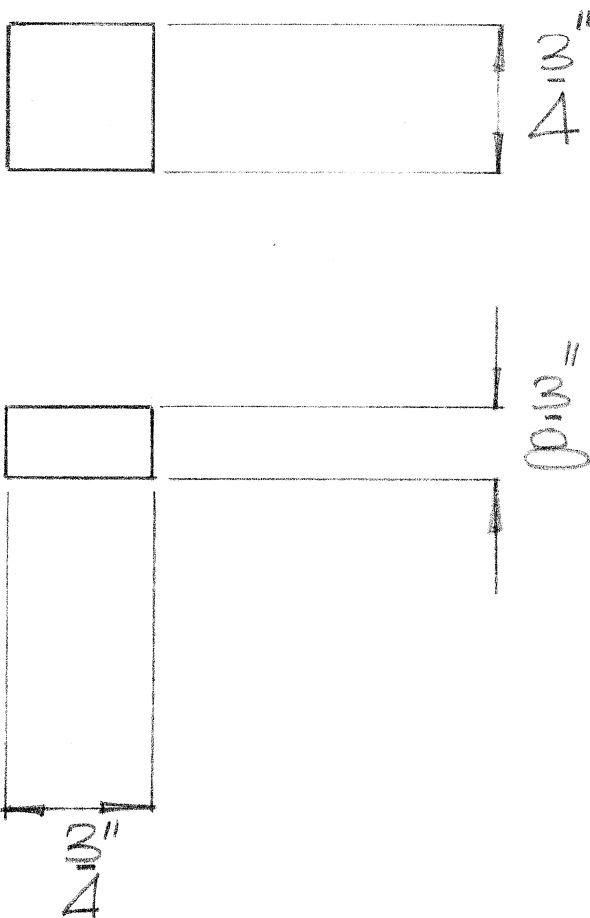
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN *IV.*
CHECKED
PASSED
DATE *22.11.75*

MAT. *MILD STEEL*
MAT. SIZE *1" x 1/2" x 2 1/4*
No. REOD. *2* SCALE *FULL*
DRAWING No. *ML100/222*

IF IN DOUBT ASK

ALTERATIONS



REMOVE SHARP EDGES

SAW CUT TO LENGTH

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" VICEROY METAL LATHE - MOTOR ADJUSTMENT STOP

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

DRAWN

CHECKED

PASSED

DATE

22.11.75

MAT. MILD STEEL

MAT. SIZE $3/8" \times 3/4" \times 3/4"$

No. REQD.

1

SCALE

FULL

DRAWING No.

ML100/223

ALTERATIONS

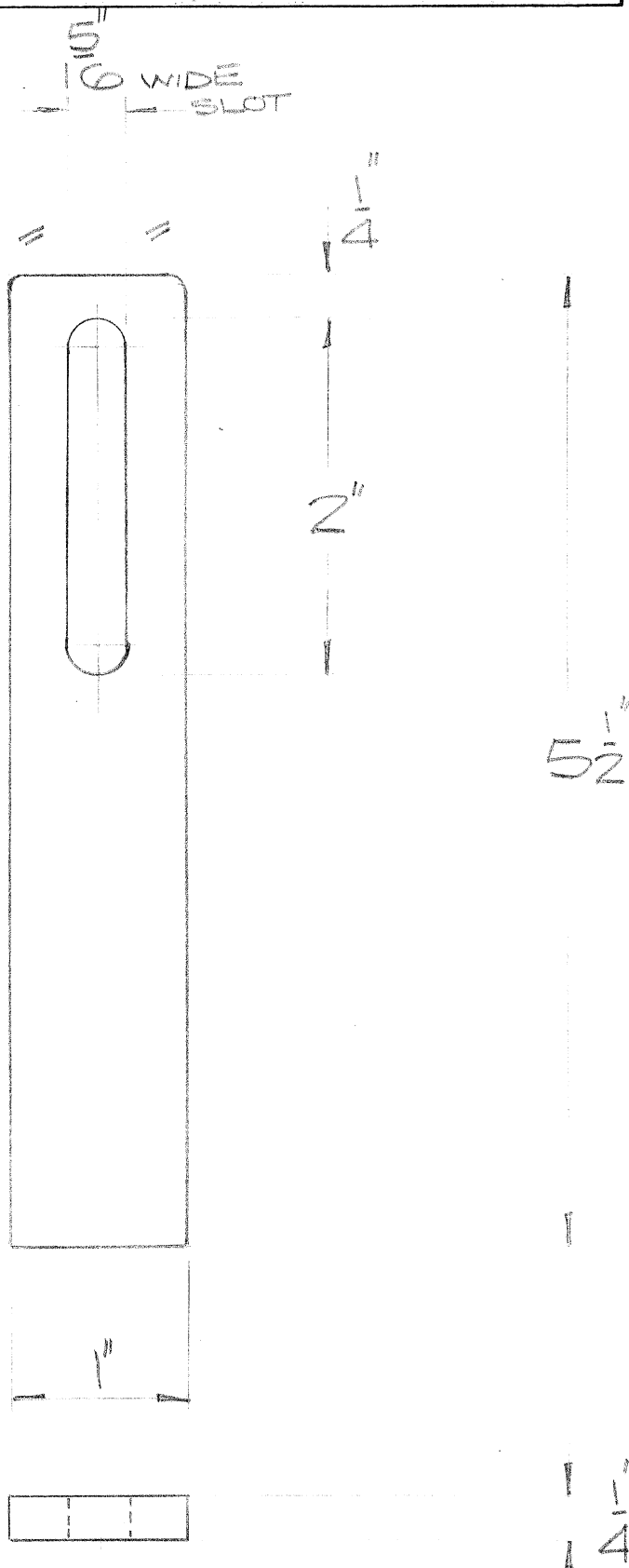


FRACTIONAL $\pm .010$ " 4 PLACE DECIMAL $\pm .0005$ "

No. ML 100/224

IF IN DOUBT ASK

ALTERATIONS



LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" VICEROY LATHE -

1 PHASE MOTOR
PLATFORM STEADY.

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

DRAWN IV.

CHECKED

PASSED

DATE 9-11-81

MAT. MILD STEEL FLAT (BLACK)

MAT. SIZE 1" x 1/4" x 5 1/2"

No. REQD. ONE

SCALE FULL

DRAWING No.

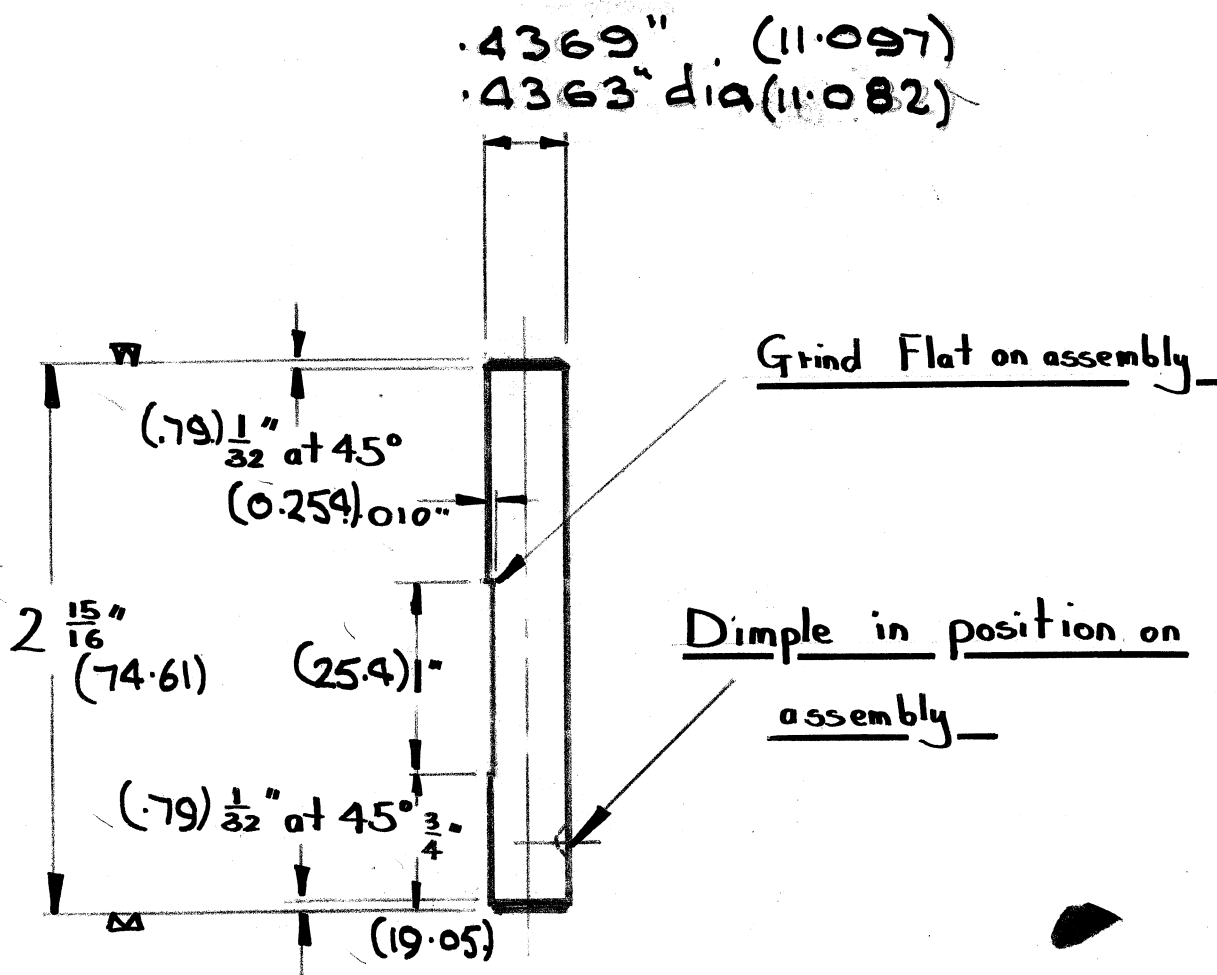
ML100/225

IF IN DOUBT ASK.

Redrawn 20.12.64

1367/6626.7.66

1609/68.24.868.TM



Machine at w

Cyanide Harden.

Metric dims in brackets.

5" Viceroy Metal Lathe : Pinion Shaft

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

DRAWN M. M. Sowden
CHECKED AS
PASSED
DATE 30.12.64

MAT. EN.8. (11.11) x (80.96)
MAT SIZE $\frac{7}{16}''$ std bar x $3 \frac{3}{16}''$ long
No. REQD. 1 SCALE Full
DRAWING No. ML 100/304

(3.97)

(12.7.)

1303/668.3.66 B.

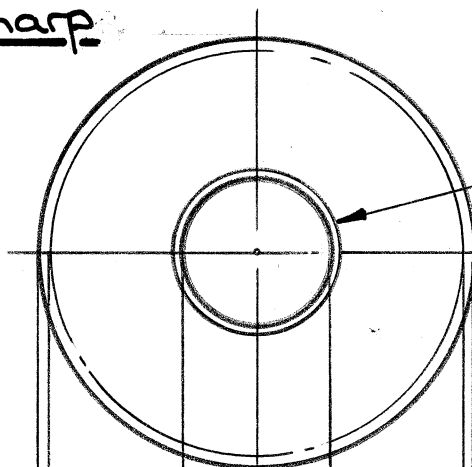
1903/71.29.10.71.R.D.

1934/72.28.2.72.R.D.

Drill $\frac{5}{32}$ " dia & tap 2 BA - $\frac{1}{2}$ & $\frac{1}{2}$ with item 305A

in posn

Remove all sharp corners.



Chfr $\frac{1}{16}$ at 45°

One side only.

Braze to ML128/4

for Half Nut

Knock off.

(1905.)

$\frac{3}{4}$ " Dia.
Ream.

2.150" P.C.D.
(54.61)

2.250" O/D.
(57.150)

Chfr $\frac{1}{8}$ at 15° Max

both sides.

(9.500)
(9.449)

.374"
.372"

43 Teeth - 20 D.P.

Whole tooth depth = .1079"

Cut after assy. with item 305A.

M/C all over.

Metric dim's in brackets.

5" Metal Turning Lathe - Apron Driving Gear.

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

DRAWN

A. S. Clarke.

CHECKED

E

PASSED

DATE

1.4.64.

MAT.

M.S.

MAT SIZE

2 $\frac{3}{8}$ " (60.325) Dia $\frac{5}{8}$ " (15.875)

No. REQD.

1

SCALE

Full.

DRAWING No.

M.L.100/305B.

IF IN DOUBT ASK.

ALTERATIONS

1473/678.6.67ms.

Redrawn D
11.7.68.

1902/71.29.10.71.R.D.

M/C all over

Centre both ends

Grind at G

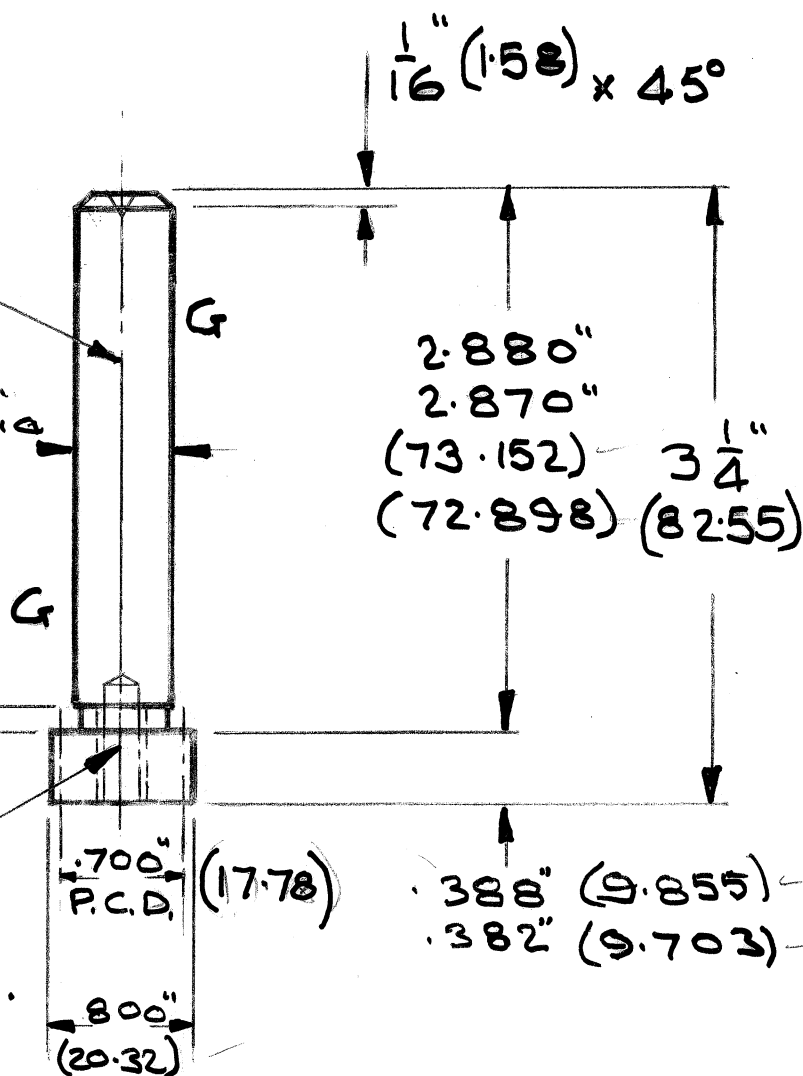
Metric dim's in brackets

Pin handwheel
to Pinion on
assembly.

(12.685) 4994" Dia
(12.669) 4988"

$\frac{1}{8}$ " (3.17) wide x
 $\frac{1}{32}$ " (0.79) deep u/c.

1 hole drill & tap
 $\frac{1}{4}$ Whit x $\frac{1}{2}$ (12.7) deep.



14 teeth: 20 D.P. Tooth thickness

.0785" Whole tooth depth .112"

Addendum .050"

5" Viceroy Metal Lathe: Handwheel Pinion

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

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

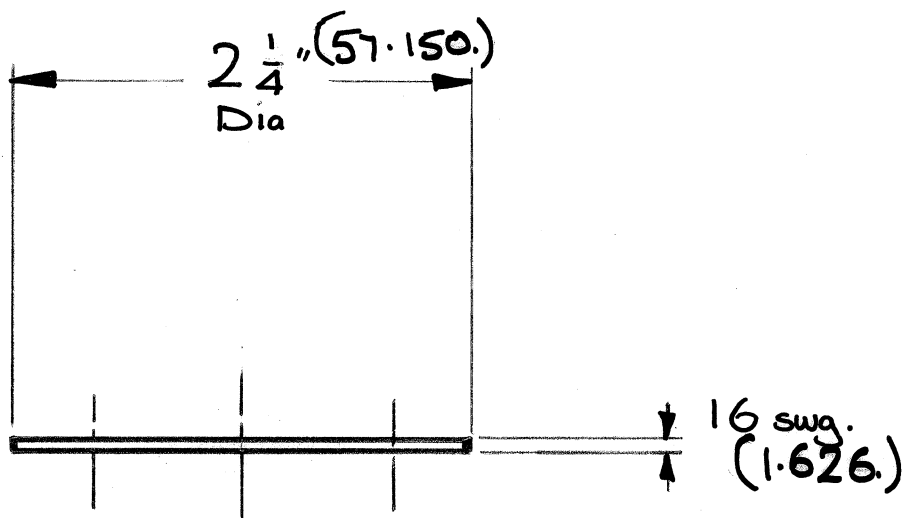
DRAWN
R. DERDOWSKI
CHECKED
PASSED
DATE
11.7.68

MAT. M.S.
MAT. SIZE $\frac{7}{8}$ " (22.22) dia x 3 $\frac{1}{2}$ " (88.9)
No. REQD. 1 SCALE Full
DRAWING No.
M.L.100/306

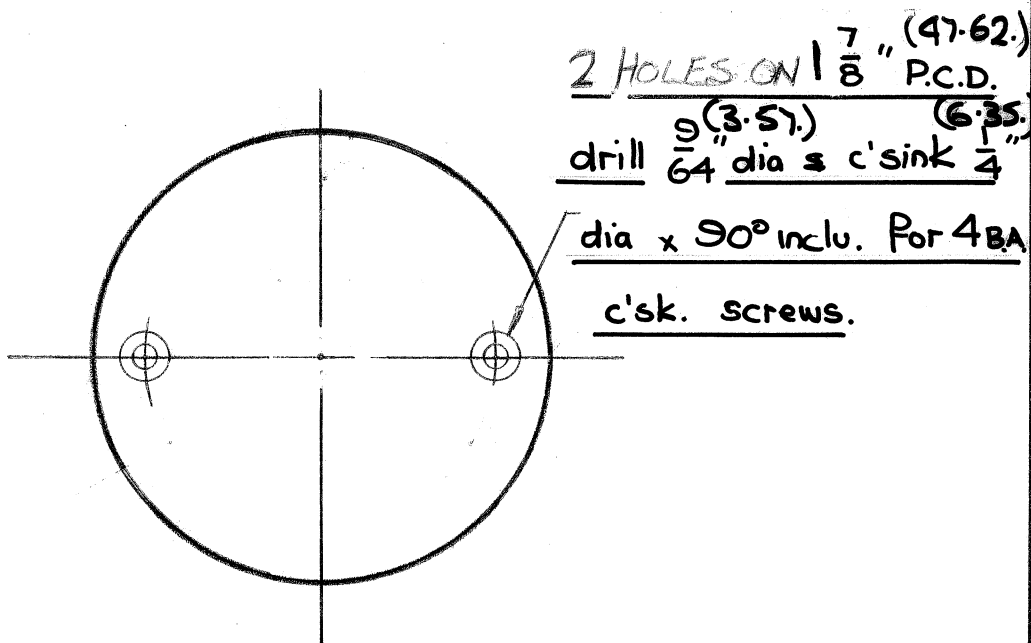
IF IN DOUBT ASK.

ALTERATIONS

2119/74. 17.10.74R



Metric dim's in brackets.



Remove all sharp corners.

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

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

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

5" Viceroy Metal Lathe : Apron Cover Plate.

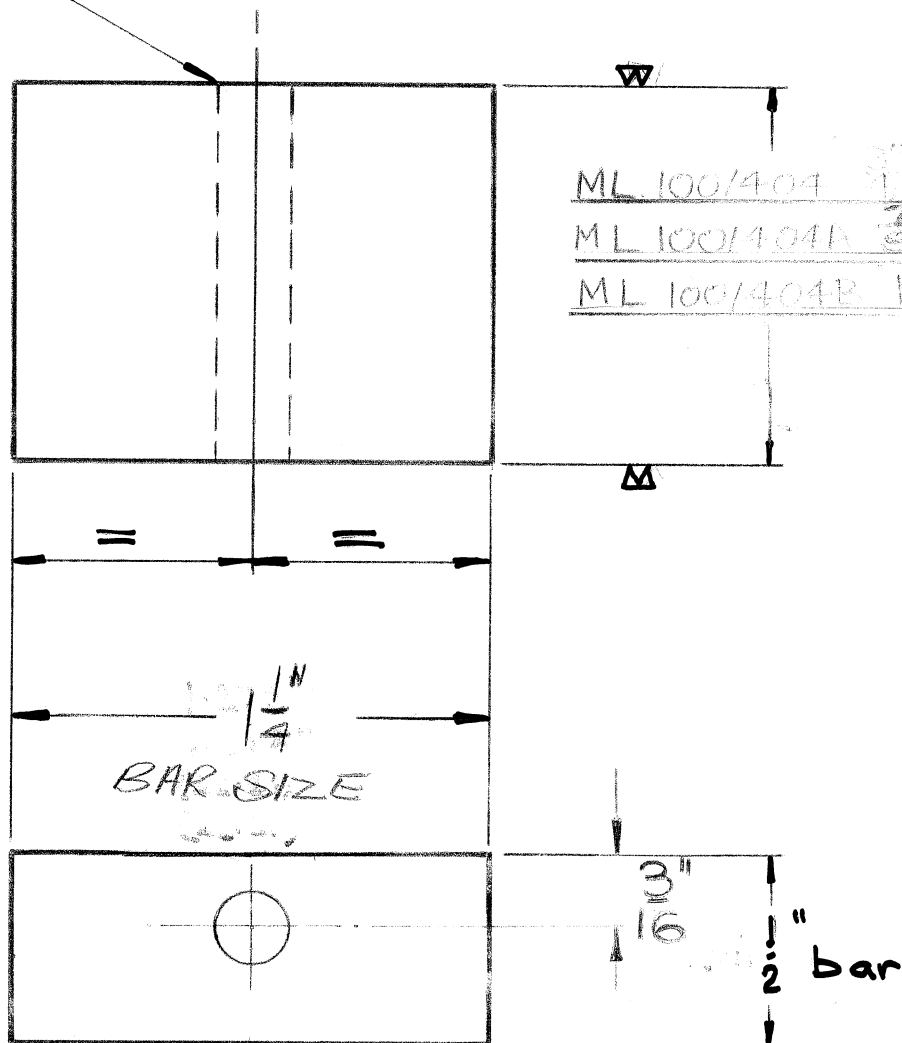
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN *M. M. Souden.*
CHECKED *[Signature]*
PASSED
DATE 2. 11. 67.

MAT. Sheet Steel. (162 x 57.1.)
MAT. SIZE 16 swg x $2\frac{1}{4}"$ Dia.
No. REQD. 1 SCALE Full
DRAWING No. ML100/309

IF IN DOUBT ASK.

1 hole drill
3"
16 dia.



ALTERATIONS

1201/66.3.1.66. MS.

1713/69.13.11.60. R.D.

Redrawn 13.11.69

2020/820873

2488/18 19.1.78
IV.

DR

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" Viceroy Metal Lathe - Bed Tenon.

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

DRAWN
R. Dendowski
CHECKED
PASSED
DATE
13.11.69.

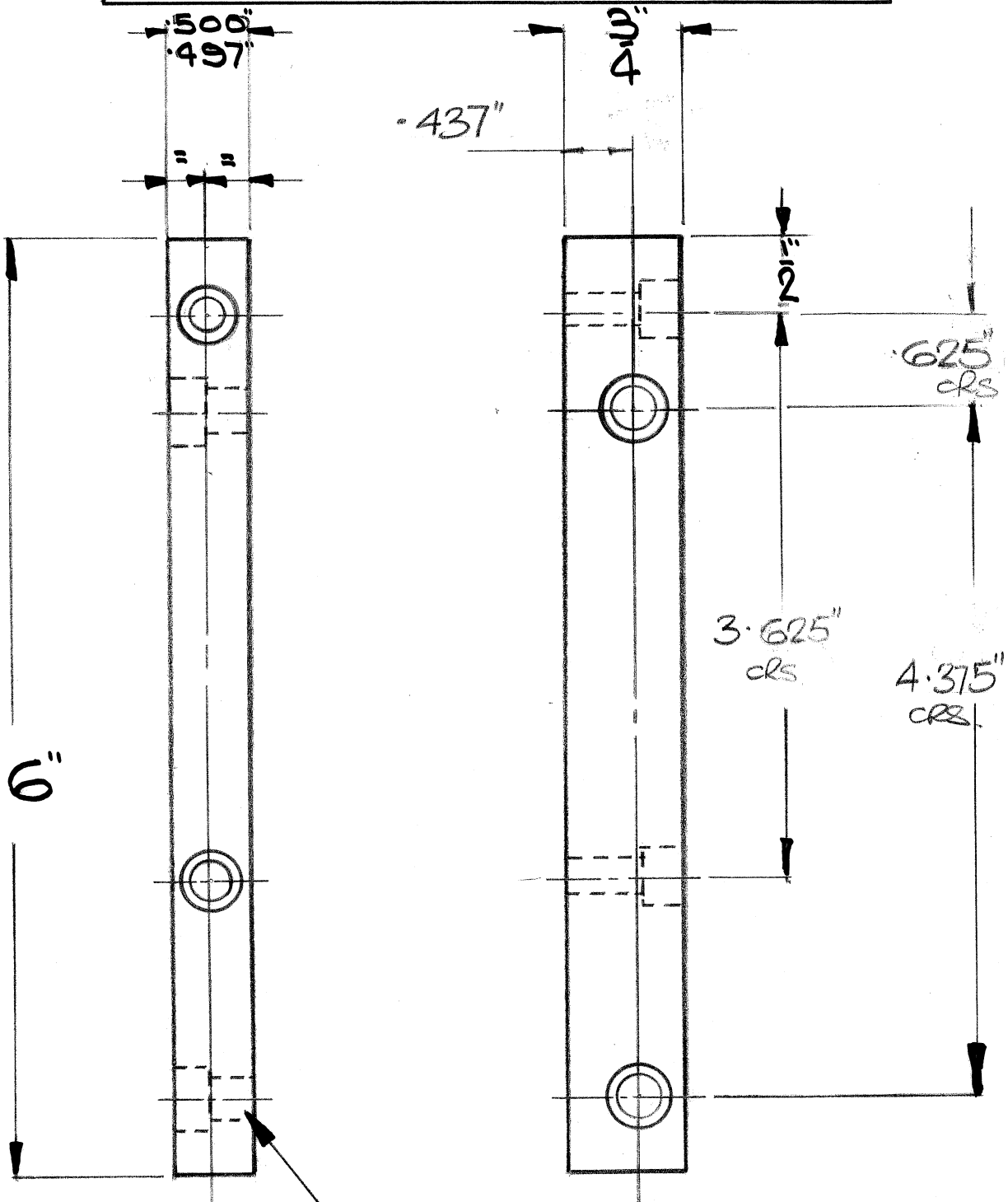
MAT. M.S.
MAT. SIZE 1/2" (12.7) x 1 1/4" (31.7) x 1 1/2" (38.1)
No. REQD. 2 SCALE Full x 2.
DRAWING No.
M.L.100/404.

IF IN DOUBT ASK.

ALTERATIONS

2368/77 4.4.77

2609/78 27.9.78



ML100/405A $\frac{3}{4}$ " INCREASE TO 1"
0.497" - 0.500" INCREASE TO
0.747" - 0.750"

4 holes drill $\frac{9}{32}$ " dia &
c/bore $\frac{13}{32}$ " dia x $\frac{1}{4}$ " deep.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

ANGULAR $\pm 1^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

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

5" Viceroy Metal Lathe Headstock STRIP

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

DRAWN *IV*
CHECKED *B*
PASSED
DATE 10.10.69.

MAT. M.S.
MAT. SIZE $\frac{1}{2} \times \frac{3}{4} \times 6$ " Long.
No. REQD. 1. SCALE Full.
DRAWING No. ML100/405.

ALTERATIONS



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

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

DENFORD MACHINE TOOLS LTD.

(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.

BRIGHOUSE,

YORKSHIRE.

DRAWN 11

CHECKED

PASSED

DATE _____

26.9.78

MAT. MILD STEEL

MAT. SIZE 1/4" DIA X 2" L.

No. REQD. ON

SCALE 2 x Full.

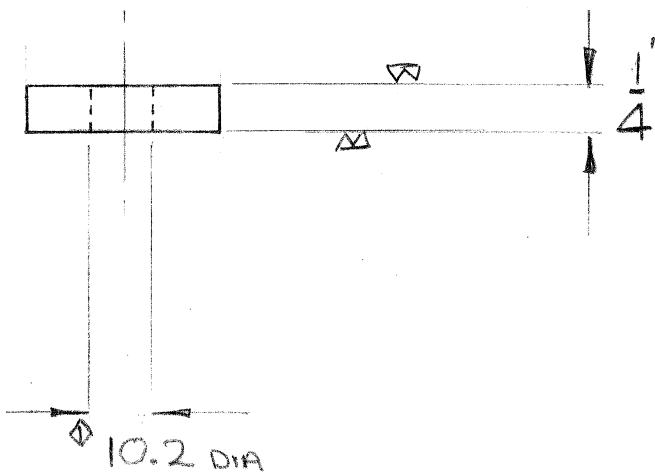
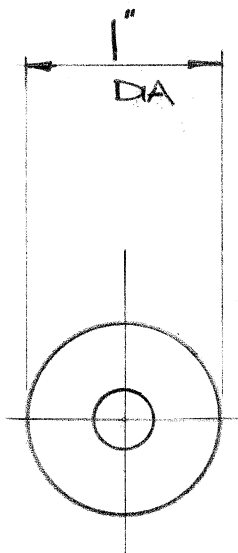
DRAWING No.

ML100/406

IF IN DOUBT ASK

ALTERATIONS

① 10.2 DIA WAS
1/32 DIA 16.12.85 AM



MACHINE AT W

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

280 VS LATHE - BED SPACER.

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

DRAWN IV.
CHECKED
PASSED
DATE 15-3-79

MAT. MILD STEEL
MAT. SIZE 1" DIA x 3/8"
No. REQD. 4 SCALE FULL
DRAWING No. ML.100/407

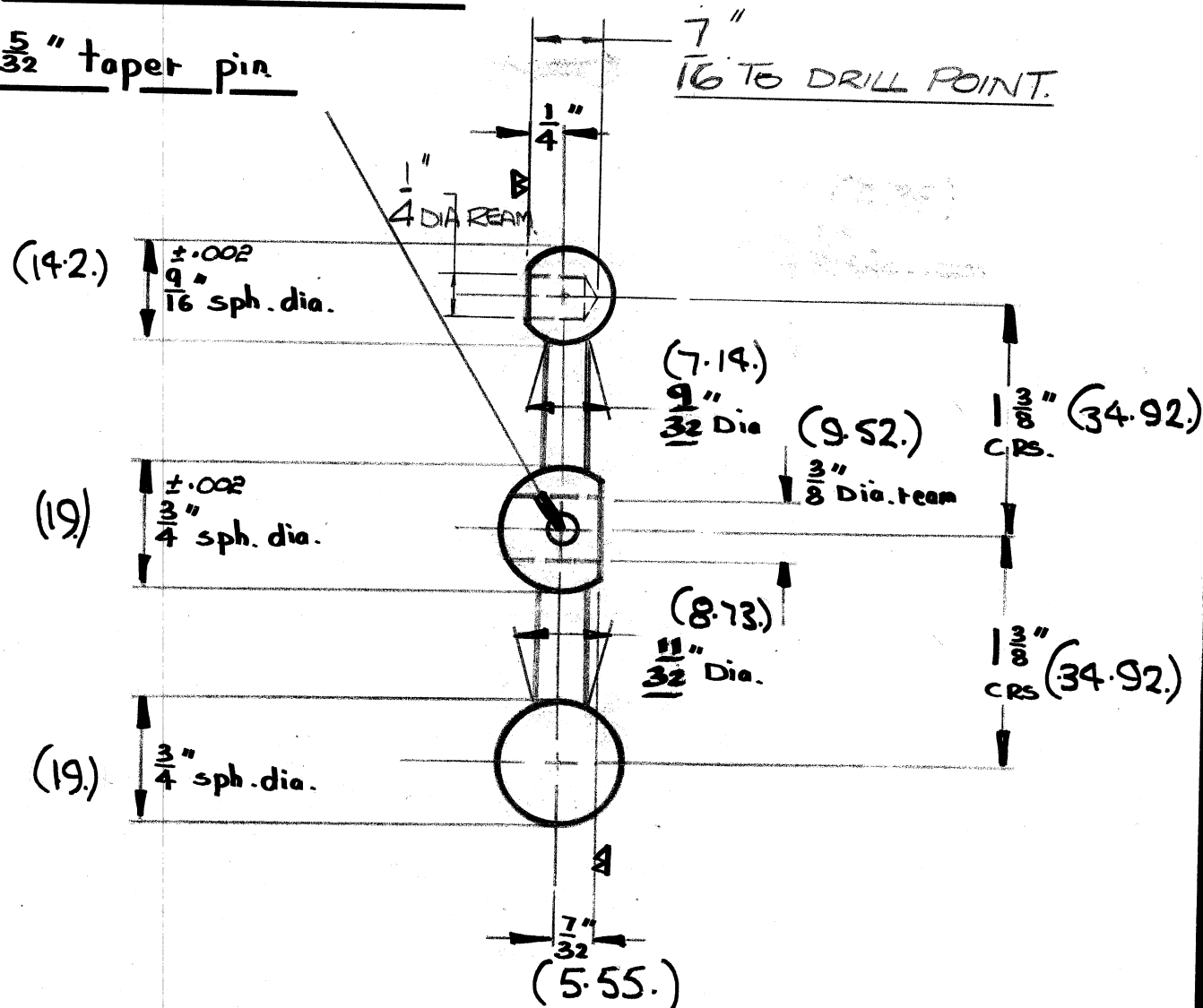
IF IN DOUBT ASK.

Redrawn 29.12.64
12271653-4-65
1953/72 23-372 JP
2152/75.9.6.75 RD

Metric dim's in brackets.

Drill & ream to suit

(3.9) $\frac{5}{32}$ " taper pin



Fine turn to form & machine flats.

Fit Item ML100/505B BOND WITH LOCTITE 35.

Chrome Plate.

5" Viceroy Metal Lathe : 2 $\frac{3}{4}$ " - 3 Ball Handle.

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

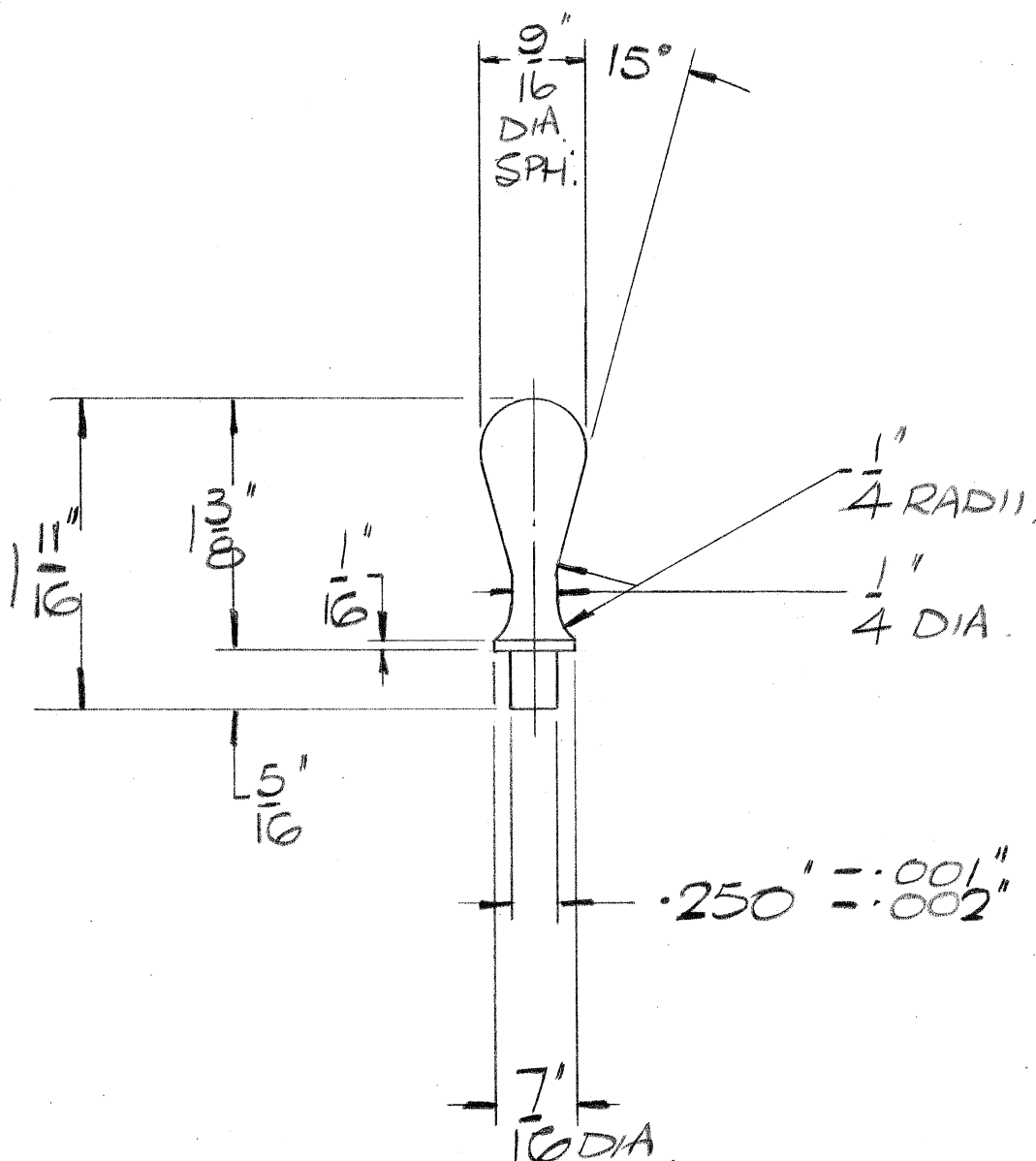
DRAWN M.M. Sowden
CHECKED AS
PASSED
DATE 29.12.64.

MAT. Mild Steel : Chrome Plate
MAT SIZE (19) $\frac{3}{4}$ " Dia (92) $3\frac{5}{8}$ " long.
No. REQD. 1 SCALE Full
DRAWING No. ML100/505A

IF IN DOUBT ASK

ALTERATIONS

REDRAWN
9.6.75 RD.
2152/75. 9.6.75 RD.



MACHINE ALL OVER - FINE FINISH.

BOND TO ITEM'S ML400/505A &

ML100/516 BEFORE CHROME PLATE.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" VICEROY METAL LATHE - 3 BALL HANDLE - KNOB

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

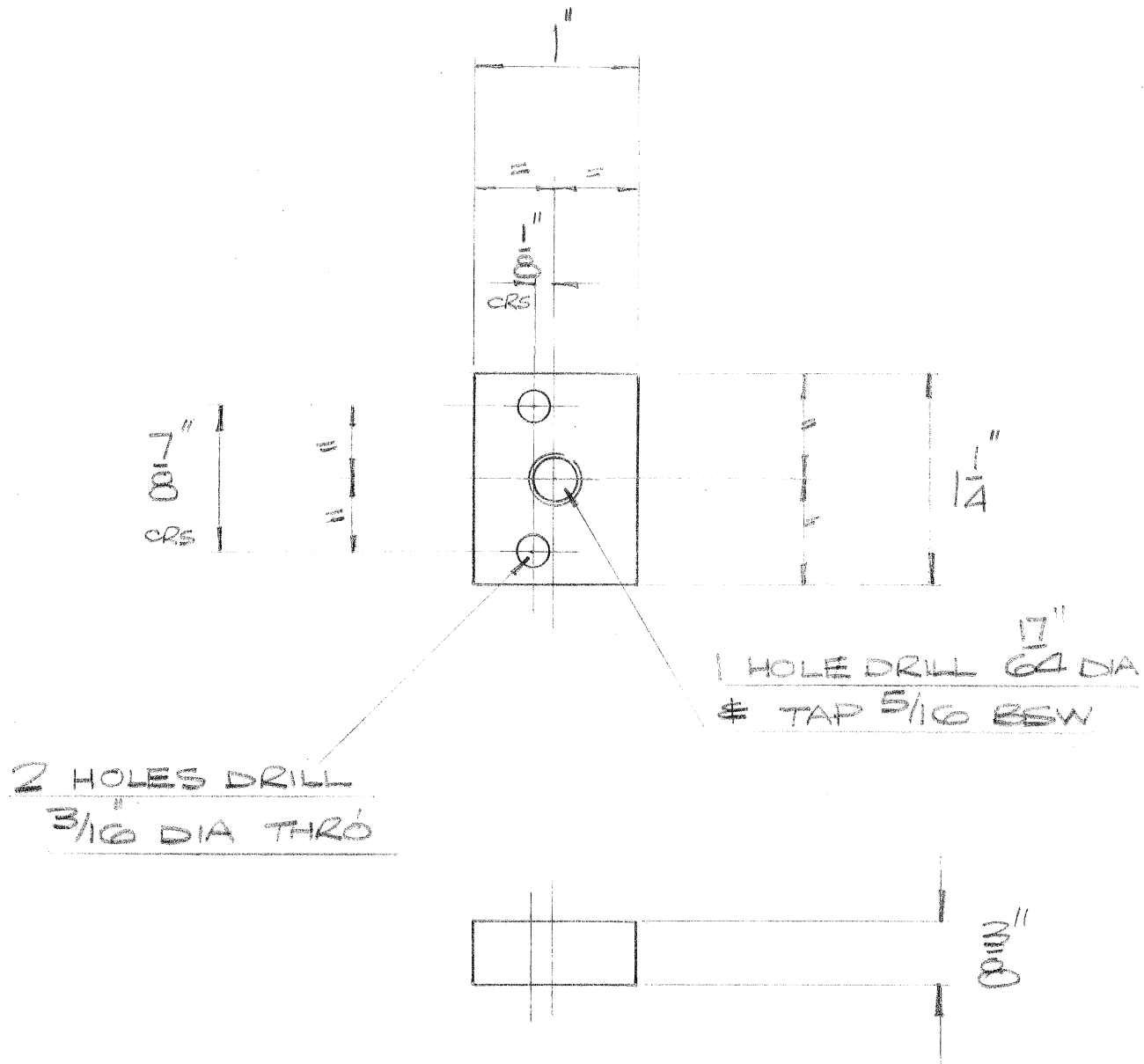
DRAWN RD
CHECKED
PASSED
DATE 9.6.75

MAT. M.S CHROME PLATE
MAT. SIZE 5/8" DIA. x 1 3/16"
No. REQD. 1 SCALE FULL
DRAWING No. ML100/505B.

IF IN DOUBT ASK

ALTERATIONS

2814/80 18.11.80
IV.



2 HOLES DRILL
3/16 DIA THRO

1 HOLE DRILL 1/16 DIA
\$ TAP 5/16 BSW

OIL BLACK

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

VIGEROY METAL LATHES - LOCKING PAD

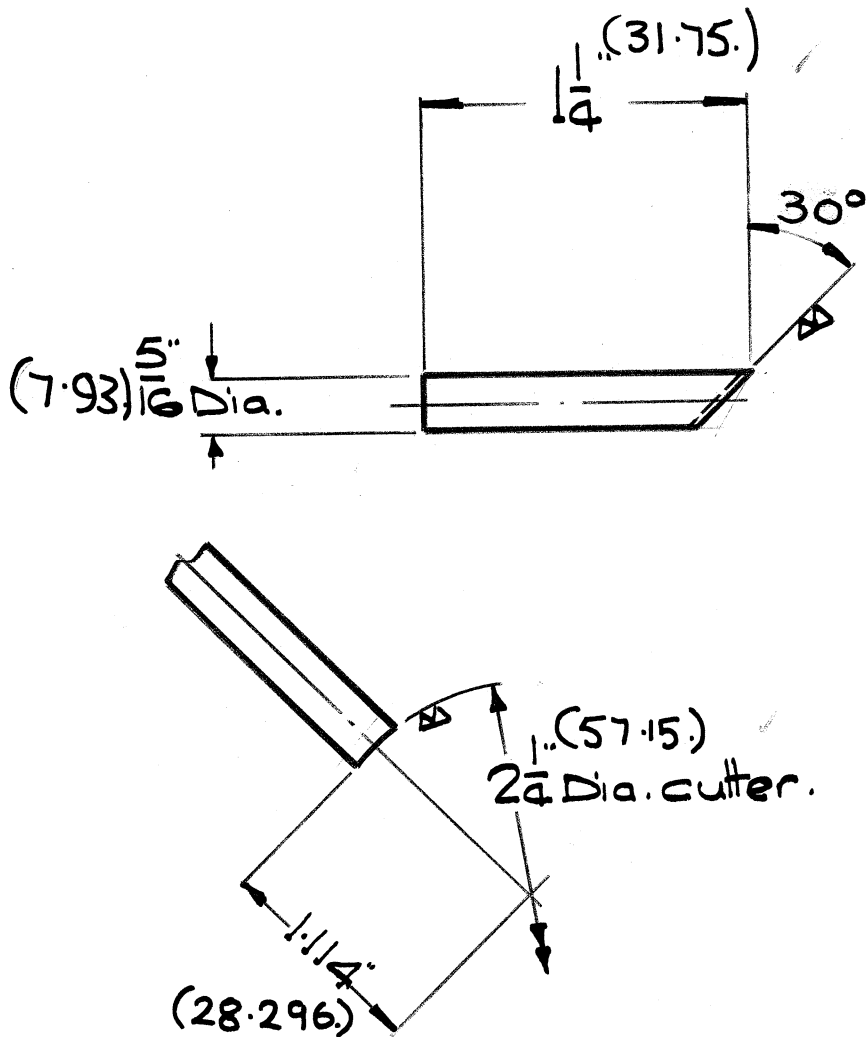
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN IV.
CHECKED
PASSED
DATE 18.11.80

MAT. MILD STEEL FLAT
MAT. SIZE 1" x 3/8" x 1/4" LONG
No. REQD. ONE SCALE FULL
DRAWING No. ML100/506-A

IF IN DOUBT ASK.

1477/67 16.6.67



M/C at W.

Cyanide harden.

Metric dim's in brackets.

5" Metal Turning Lathe - SW. SLIDE LOCKING PIN.

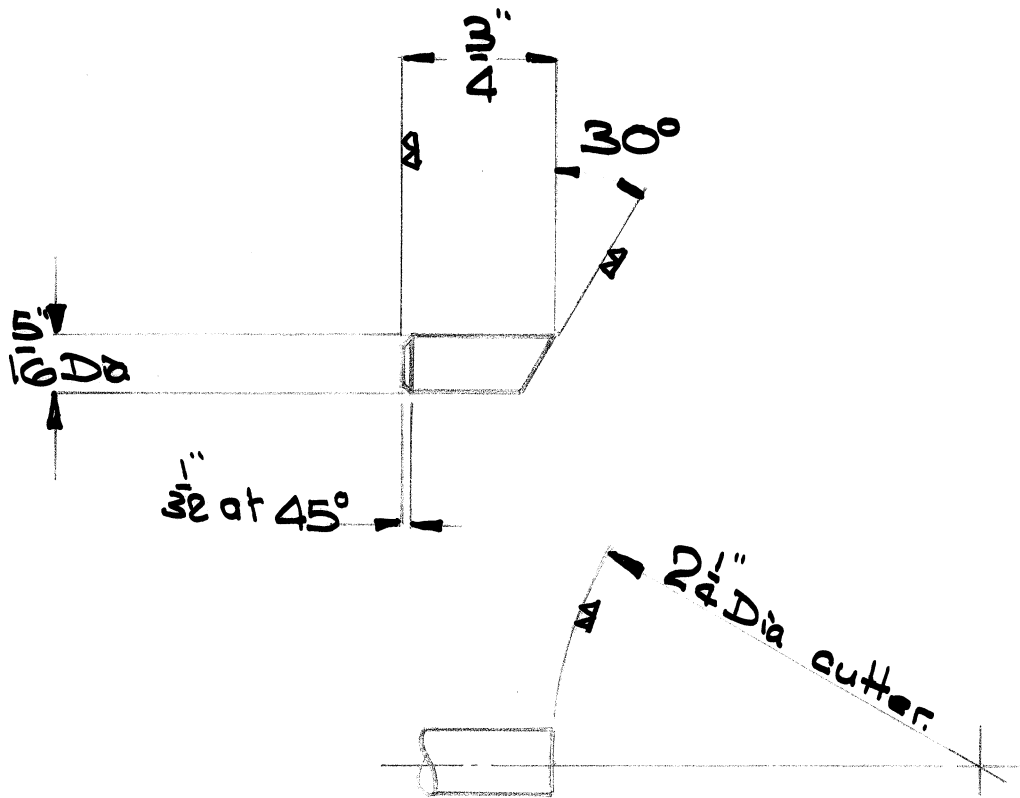
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN A. S. Clarke.
CHECKED AS
PASSED
DATE 1.4.64.

MAT. M.S. - CYAN. HDN.
MAT SIZE $\frac{5}{16}$ Dia x $1 \frac{1}{2}$ long (38.1)
No. REQD. 2 SCALE Full.
DRAWING No. M.L.100/507.

IF IN DOUBT ASK.

ALTERATIONS



M/c at W
Cyanide harden.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" Viceroy Metal lathe - Swivel slide front Locking Pin.

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

DRAWN

TD

CHECKED

TD

PASSED

DATE

18.9.70

MAT. M.S. - Cyan Hdn

MAT. SIZE 5/16 Dia x 7/8 Long

No. REQD. 1

SCALE FULL

DRAWING No.

ML100/507 A

IF IN DOUBT ASK.

ALTERATIONS

1229/65. 14.9.65.H.S.

Redrawn 1.11.65.H.S.

1559/68. 26.3.68.H.S.

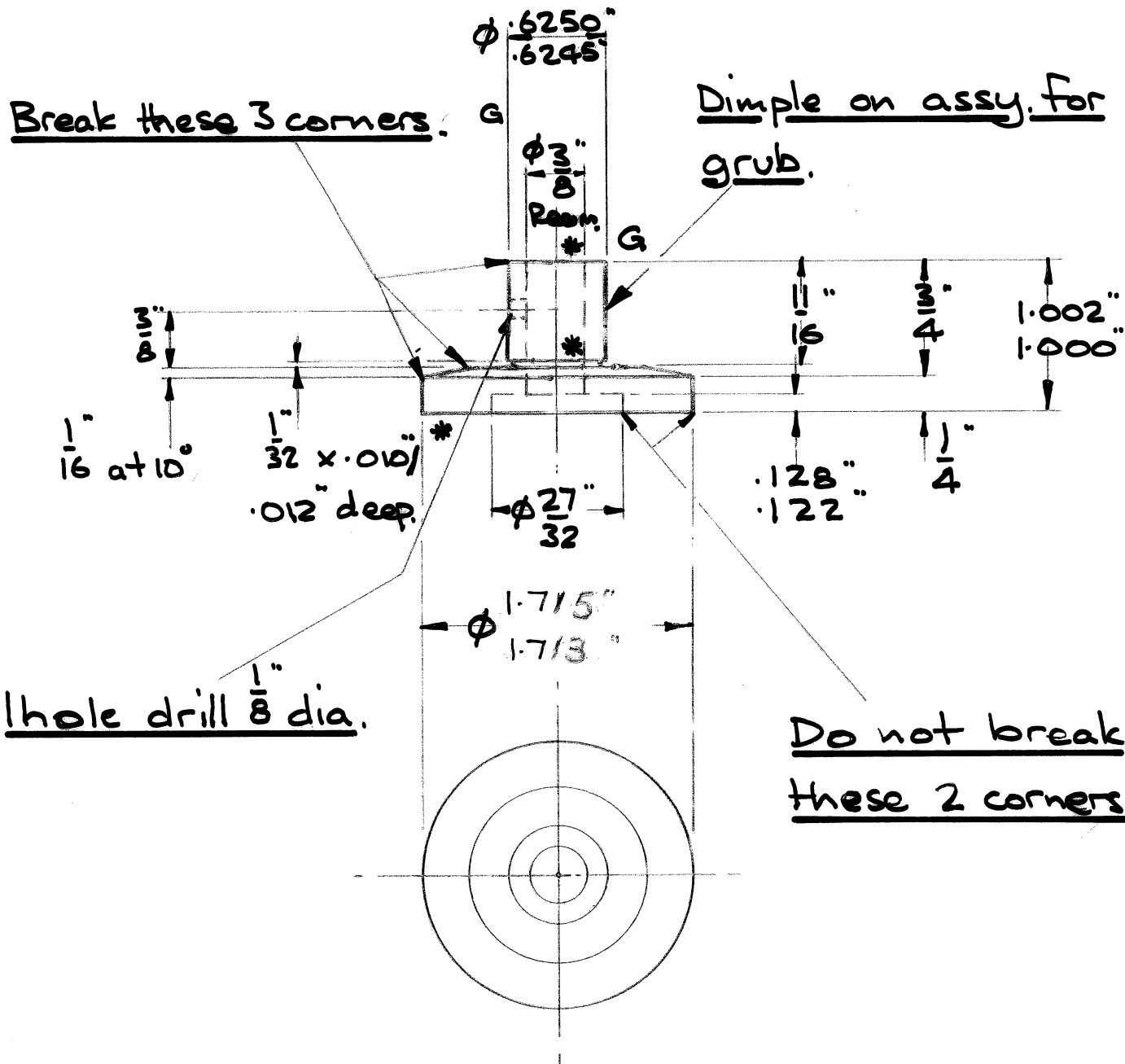
1837/71. 11.3.71. R.D.

1894/71. 16.10.71. R.D.

Redrawn 16.10.71.H.S.

1963/72. 19.6.72 R.D.

2020/735-3/73.H.S.



Machine all over - Grind at G.

* These faces must be parallel & square.

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

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

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

5" Viceroy Metal Lathe - Leadscrew Bush. ENG & MET.

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

DRAWN R.D.
CHECKED R.D.
PASSED
DATE 16.10.71.

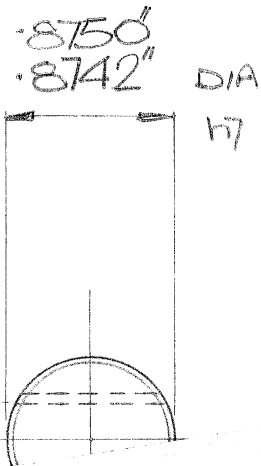
MAT. H.S.
MAT. SIZE $1\frac{5}{16}'' \text{dia} \times 1\frac{1}{4}''$
No. REQD. 1. SCALE Full.
DRAWING No. ML100/510A.

IF IN DOUBT ASK

ALTERATIONS

REDRAW 19.978
2598/78 18.978
2619/78 23.1078

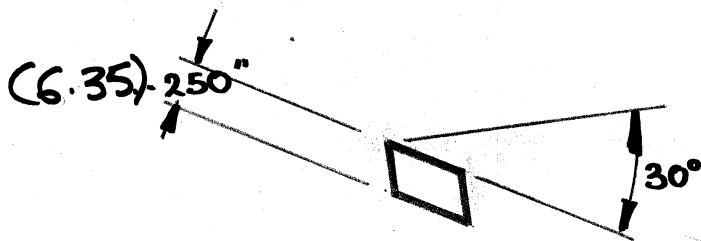
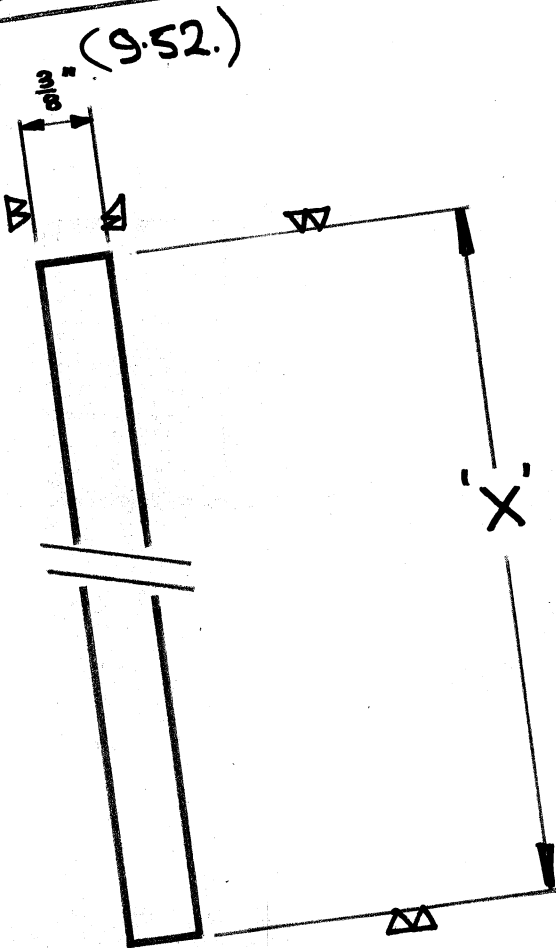
DRILL LETTER Y DIA
TAP 1/2 DIA - 10 T.P.I. P.T.H
R.H. ACME FORM.



IF IN DOUBT ASK.

Redrawn 31-12-64

Metric dim's in brackets.



Description	Item	Size 'X'	Nº OPP
Top Slide	A	6"	1
Cross Slide	B	7 7/8"	1

152.400.
200.025.

Gib strip

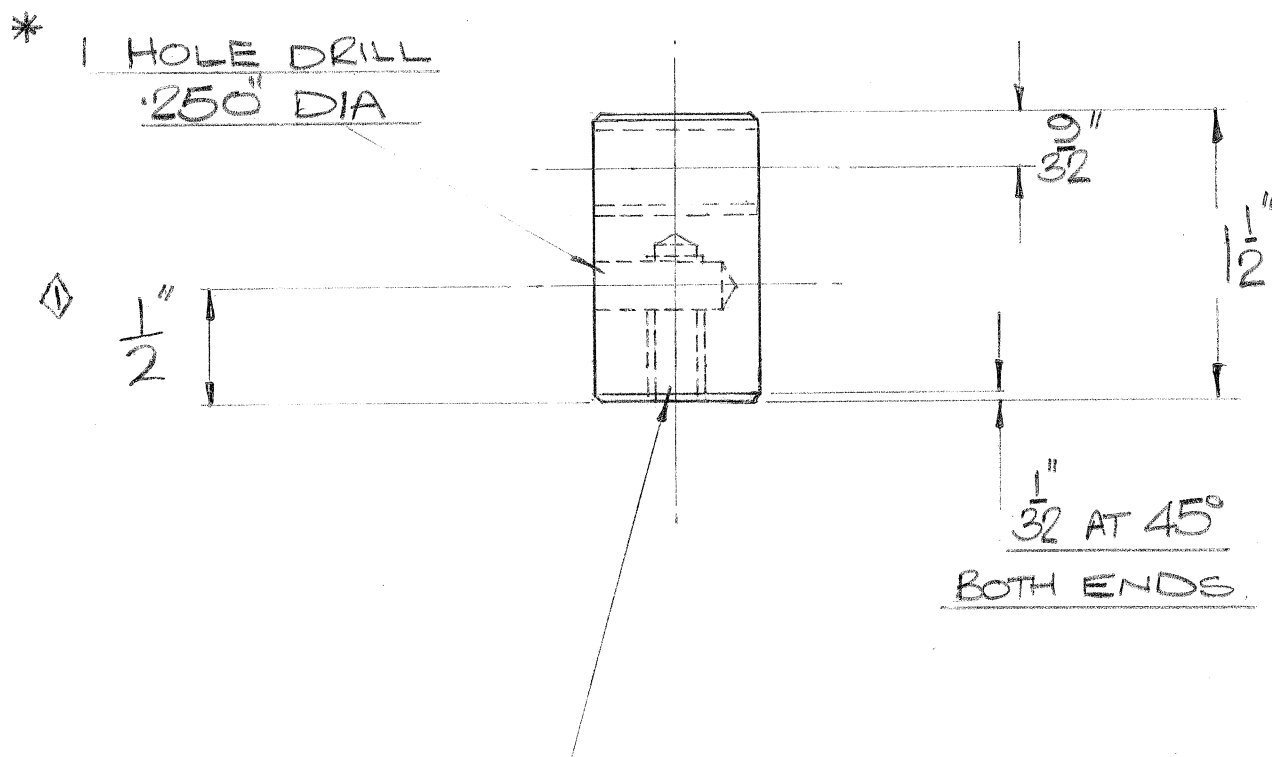
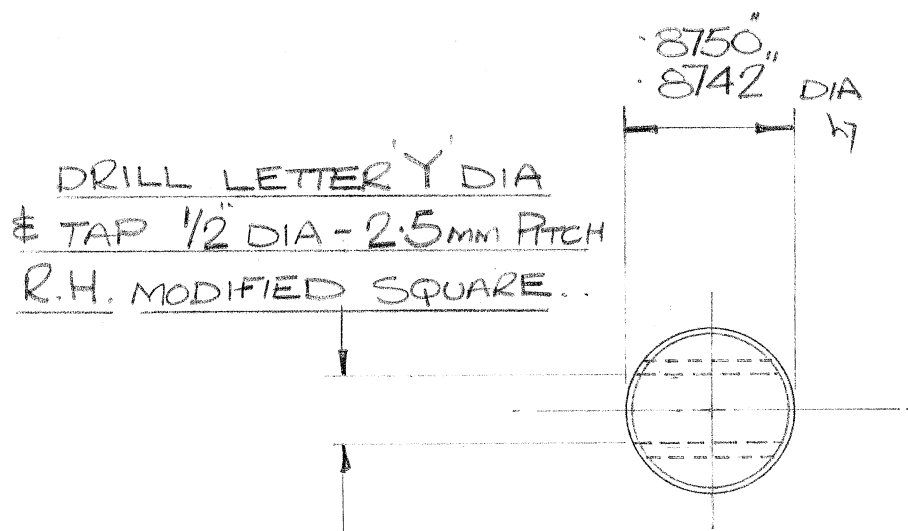
Metal Lathes

Mild Steel 6.35x12.7x158

IF IN DOUBT ASK

ALTERATIONS

REDRAWN 18.9.78
IV.
2598/78 18.9.78
IV.
2619/78 23.10.78
IV.
① 1/2" WAS 5/8"
18.3.85 A.M.



1 HOLE DRILL 6.8mm &
TAP M8 - 1 1/16" DEEP.

MACHINE ALL OVER

* DRILL IN SAME DIRECTION AS THE 1/2" THREAD

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" & 280 VS LATHES - TOP SLIDE FEEDNUT - METRIC

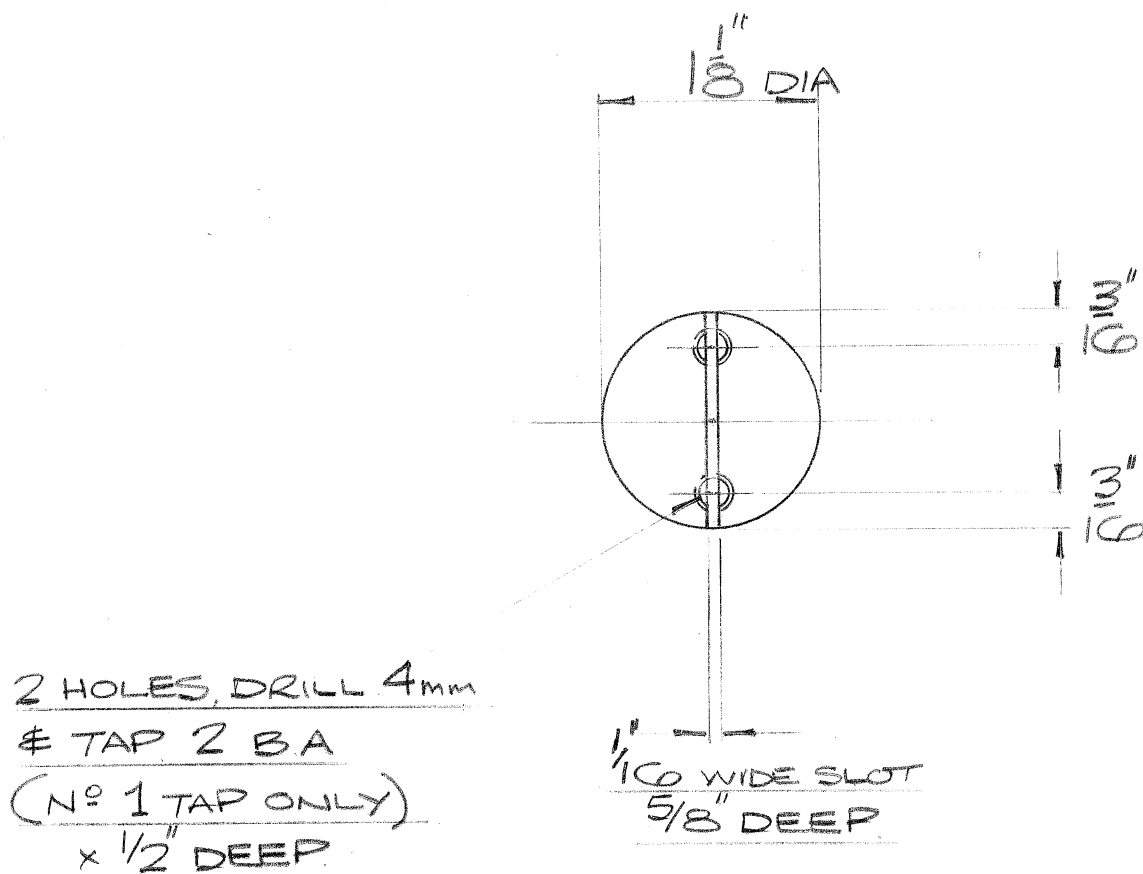
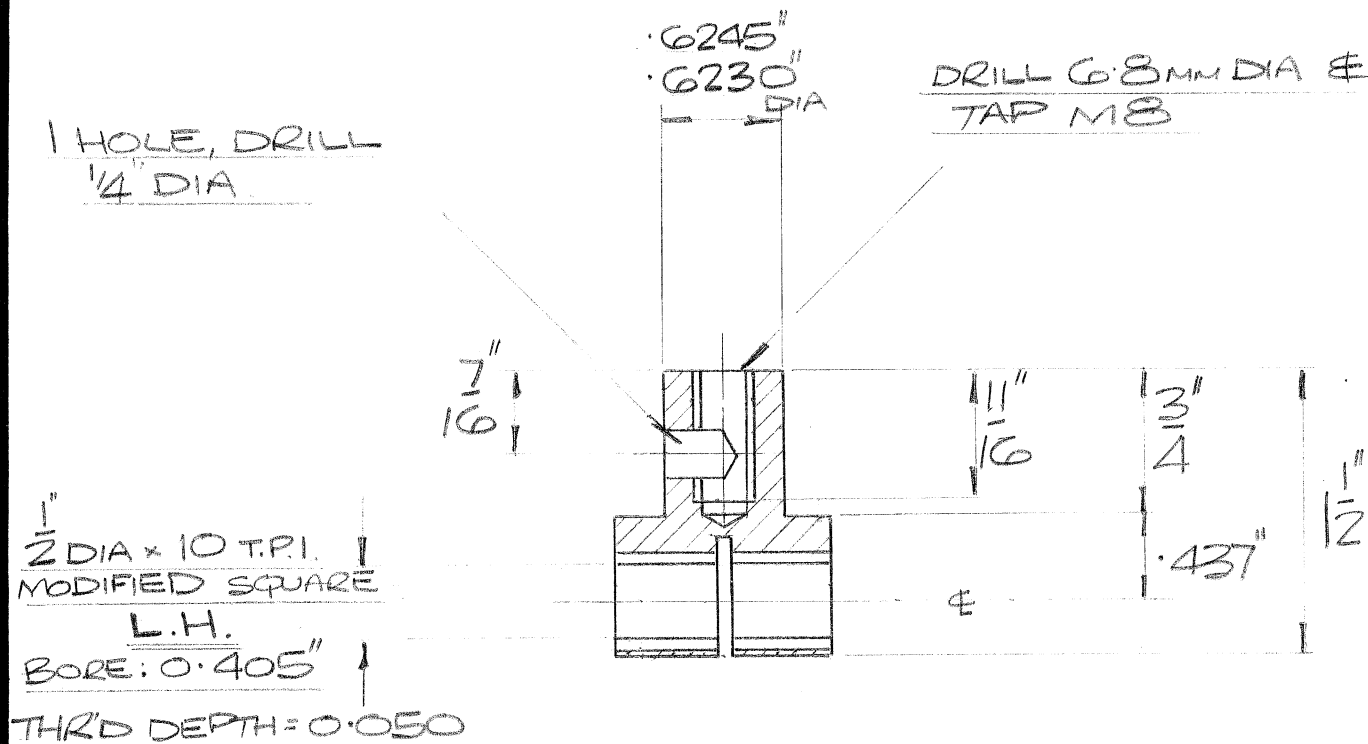
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN IV.
CHECKED
PASSED
DATE 18.9.78

MAT. PHOS BRONZE - CONTINUOUS CAST
MAT. SIZE 1" DIA x 1 3/4"
No. REQD. ONE SCALE FULL
DRAWING No. ML 100/511 B.

IF IN DOUBT ASK

ALTERATIONS



MACHINE ALL OVER

REMOVE ALL SHARP
CORNERS

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5 METAL LATHE - FEED NUT (ENGLISH)

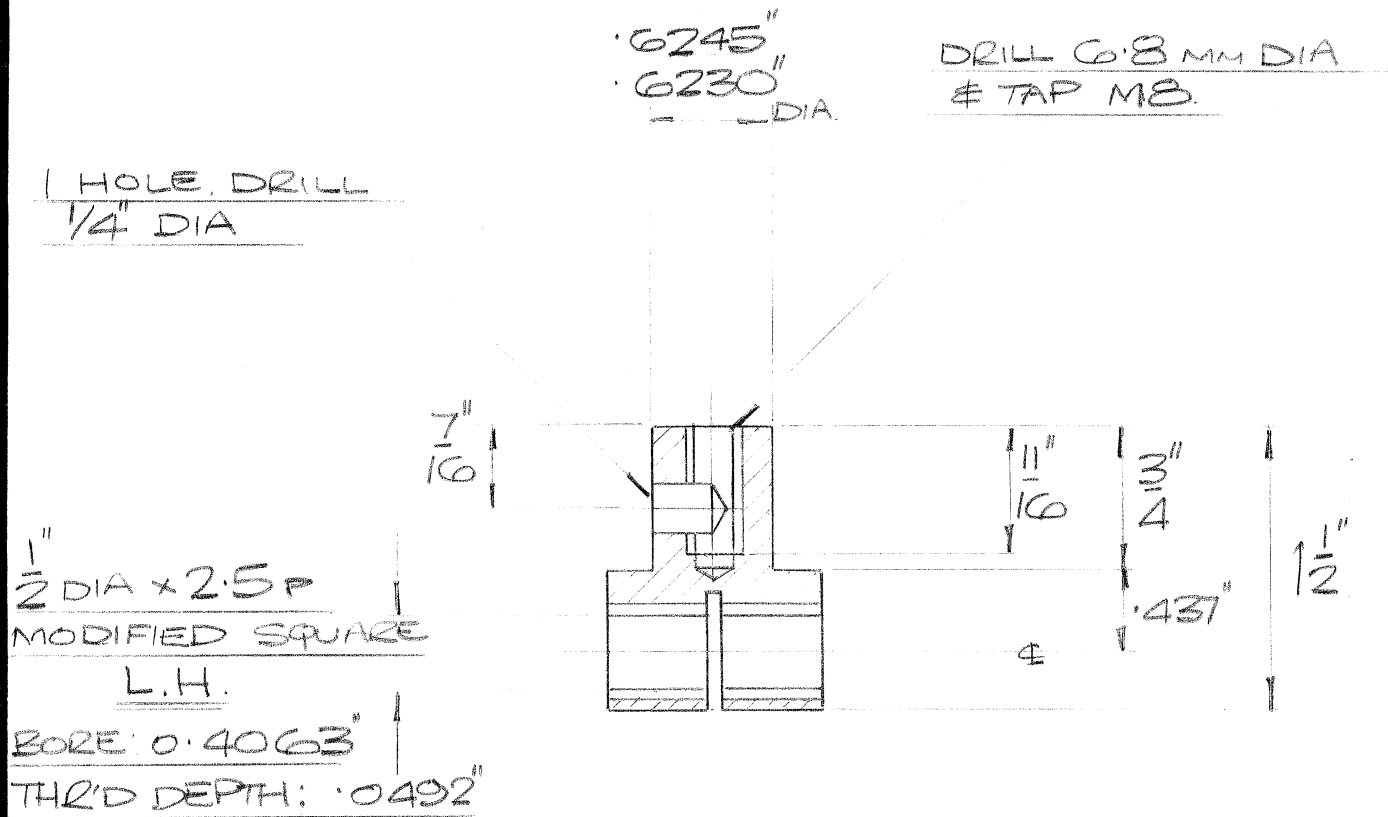
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN IV
CHECKED
PASSED
DATE 12.9.84

MAT. PHOS BRONZE, CONTINUOUS
CAST BAR.
MAT. SIZE $\frac{1}{4}$ " DIA x $1\frac{9}{16}$ " L.
No. REQD. ONE SCALE FULL
DRAWING No. ML100/512.C

IF IN DOUBT ASK

ALTERATIONS



2 HOLES, DRILL 4 mm
& TAP 2 B.A.
(Nº 1 TAP ONLY)
x $\frac{1}{2}$ " DEEP

MACHINE ALL OVER

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" METAL LATHE - FEED NUT (METRIC)

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

DRAWN IV
CHECKED
PASSED
DATE 12.9.84

MAT. P105 BRONZE, CONTINUOUS CAST
MAT. SIZE $\frac{1}{4}$ " DIA x $\frac{19}{16}$ "
No. REOD. ONE SCALE FULL
DRAWING No. ML 100/512.D

IF IN DOUBT ASK.

ALTERATIONS

1894/71.16.10.71.RD

Redrawn 20.10.71.RD

1963/72.19.6.72.RD

2020/735-378 JP

2291/76.8.6.76RD

⚠ Do not break
these 2 corners,

$\frac{1}{32}$ at 45°

Oil groove .020" deep
X $\frac{1}{16}$ wide.

1 hole ream 'C' dia.
to fit oiler L.D. $\frac{1}{4}$.
& spot face $\frac{1}{32}$ " dia

$\frac{1}{32}$ at 45° on
corner.

Machine all over. — Grind at 'G'

* These faces must be parallel & square.
Remove sharp corners.

5" Viceroy Metal Lathe:- Saddle Leadscrew Bush (Metric)

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

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

DRAWN RD.
CHECKED RD.
PASSED
DATE 20.10.71.

MAT. M.S.
MAT. SIZE $\frac{15}{16}$ dia x $4\frac{1}{16}$ long.
No. REQD. 1 SCALE Full.
DRAWING No. ML100/513A.

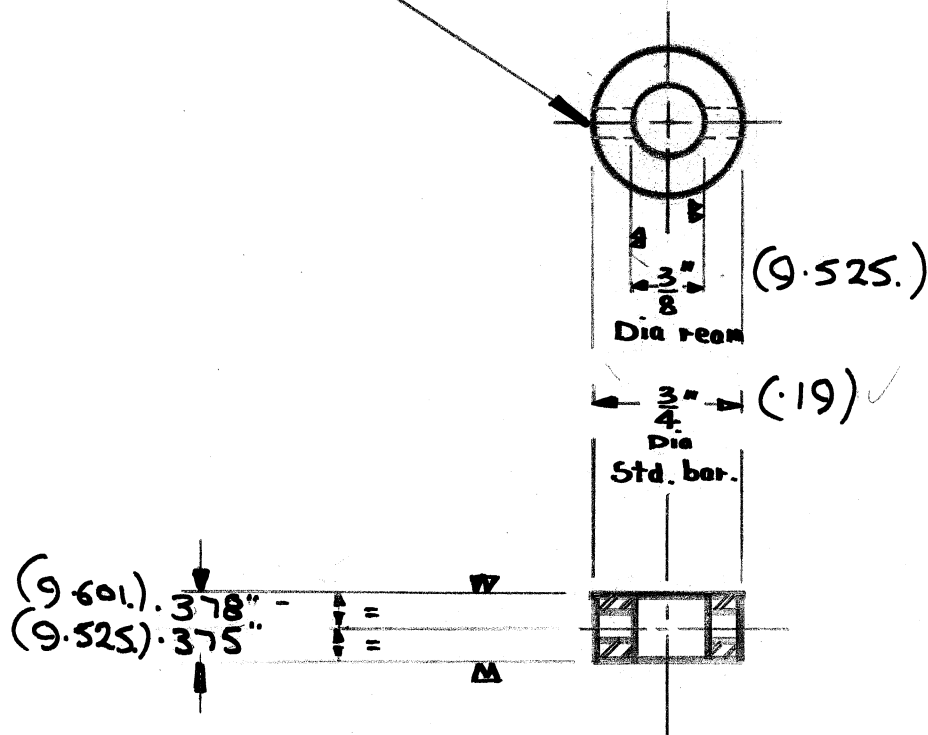
IF IN DOUBT ASK.

JM
R

1 hole drill & ream to suit

Metric dim's in brackets.

$\frac{5}{32}$ " (3.96.)
to per pin on assembly.



All faces must be parallel & square.

Remove all sharp edges. - M/c at w

5" Viceroy Metal Lathe : - Top & Cross Slide Bearing Collar

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

DRAWN M.M. Souden.
CHECKED AS
PASSED
DATE 26.1.65

MAT. Mild Steel (15.87.)
MAT SIZE $\frac{3}{4}$ " (19) Dia x $\frac{5}{8}$ " long
No. REQD. 2 SCALE Full
DRAWING No. ML 100/515

IF IN DOUBT ASK.

ALTERATIONS
ALTERATIONS

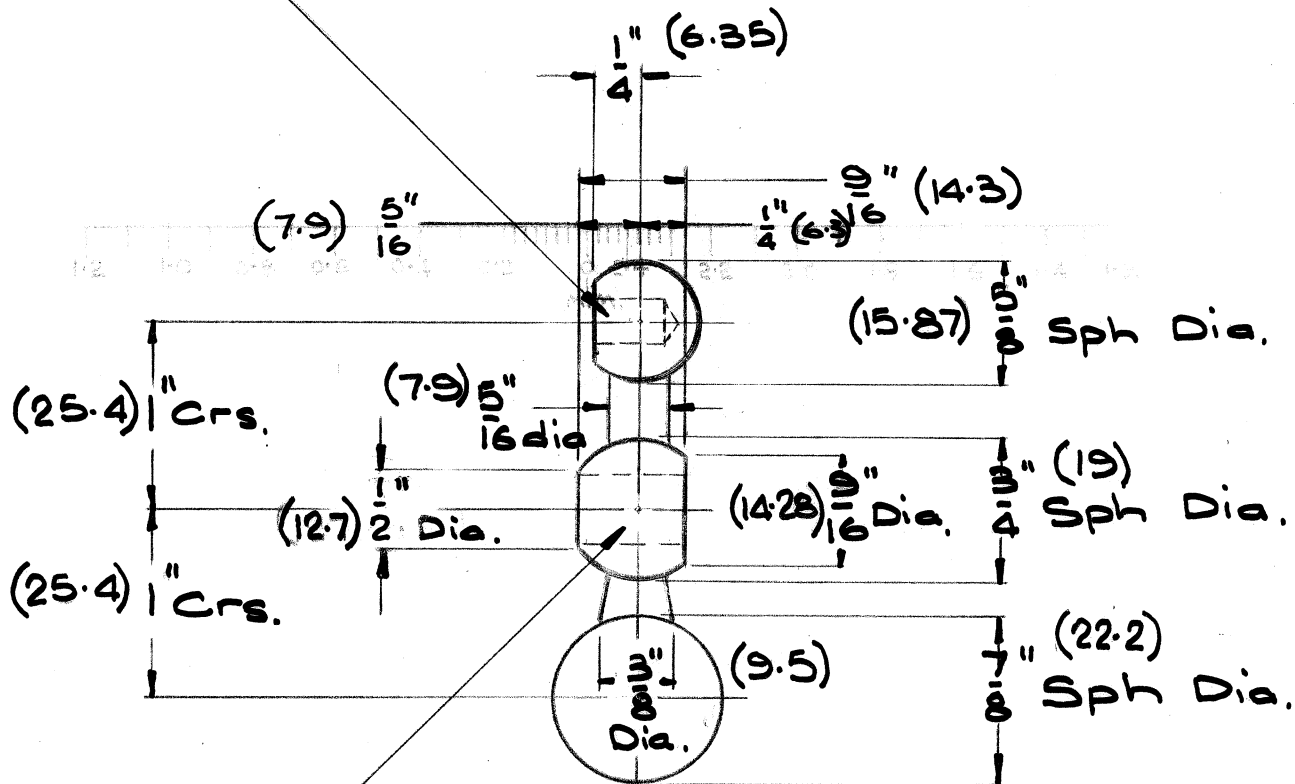
Redrawn 18.4.69.RP

1650/69.18.469.RP

2152/75.9.67SRD

Metric dim's in brackets.

1 hole drill & ream $\frac{1}{4}$ " Dia. x $\frac{7}{16}$ " DEEP TO DRILL POINT.



1 hole drill & ream $\frac{3}{8}$ " dia.

Machine all over - Fine Finish.

Fit Item M.L.100/505B BOND WITH LOCTITE 35.

Chrome Plate.

Remove all sharp corners.

LIMITS ON DIMENSIONS UNLESS
LIMITED OTHERWISE STATED.
OTHERWISE STATED.
ANGULAR $\pm \frac{1}{2}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
ANGULAR $\pm \frac{1}{10}^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$
FRACTIONAL $\pm .010$ 4 PLACE DECIMAL $\pm .0005$

5" Viceroy Metal Lathe - 3 BALL HANDLE.

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

DRAWN
R. D. Dewhurst
CHECKED
PASSED
DATE

MAT. Mild Steel: Chrome Plate
MAT. SIZE 1 (25.4) dia x 2 7/8 (73) Long
No. REOD. 1.
DRAWING No. M.L.100/516.

ALTERATIONS



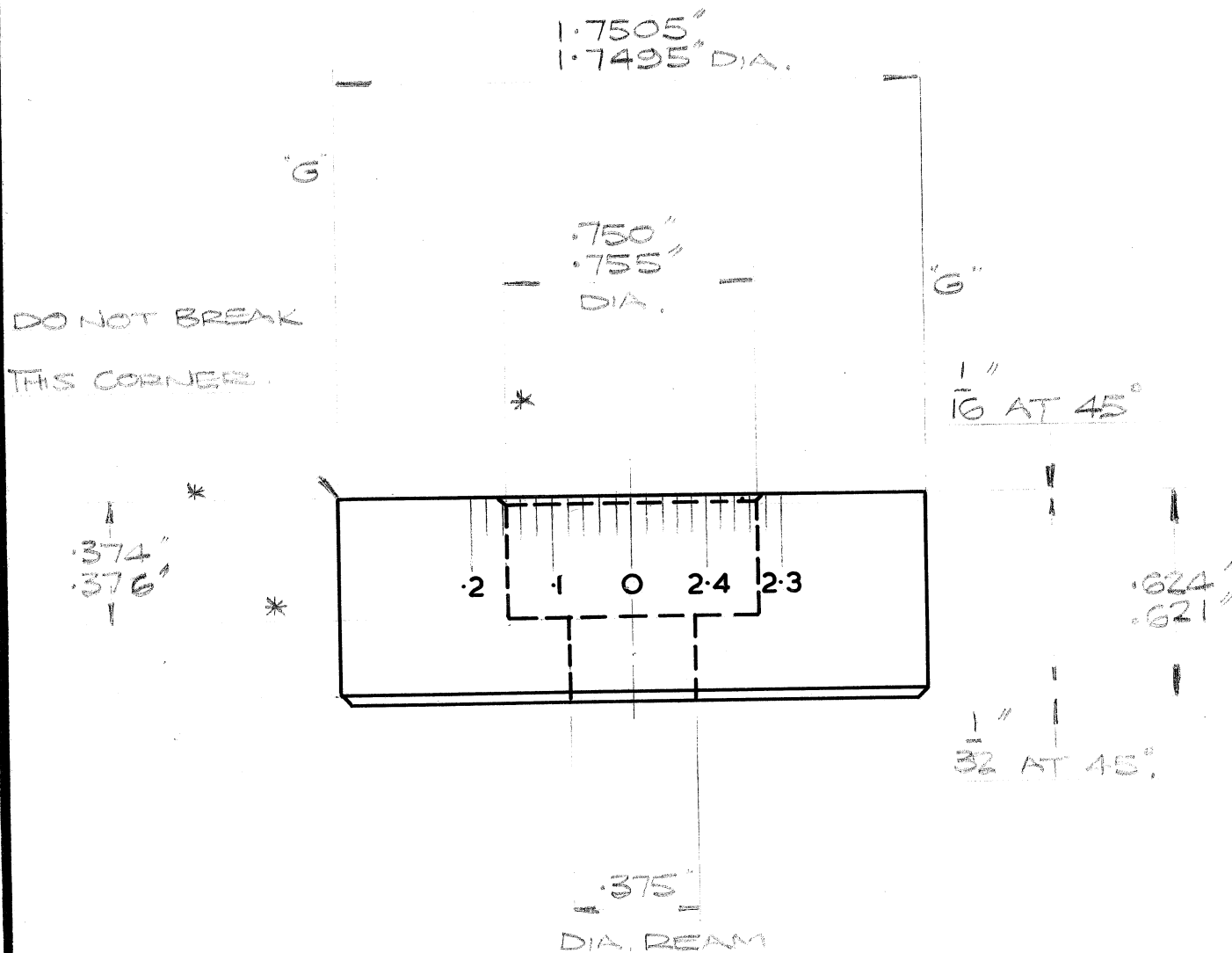
FRACTIONAL $\pm .010''$ 4 PLACE DECIMAL $\pm .0005''$

VICEROY METAL LATHES - TOP & CROSS SLIDE DIAL ENGLISH.

MAT. M.S. 124, 010	
MAT. SIZE 2" 5/8 x 7/8"	
No. REQD. 2	SCALE 2 x FULL
DRAWING No. ML100/520 C.	

IF IN DOUBT ASK

ALTERATIONS

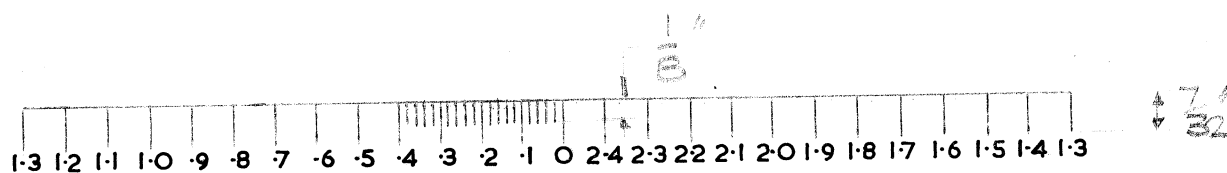


* THESE FACES MUST BE
PARALLEL & SQUARE.

MACHINE ALL OVER.

DULL CHROME FINISH.

GRIND AT "G".



125 EQUI-SPACED DIVISIONS
NUMBERS $\frac{3}{32}$ " HIGH.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

VICEROY METAL LATHES - TOP & CROSS SLIDE DIAL METRIC.

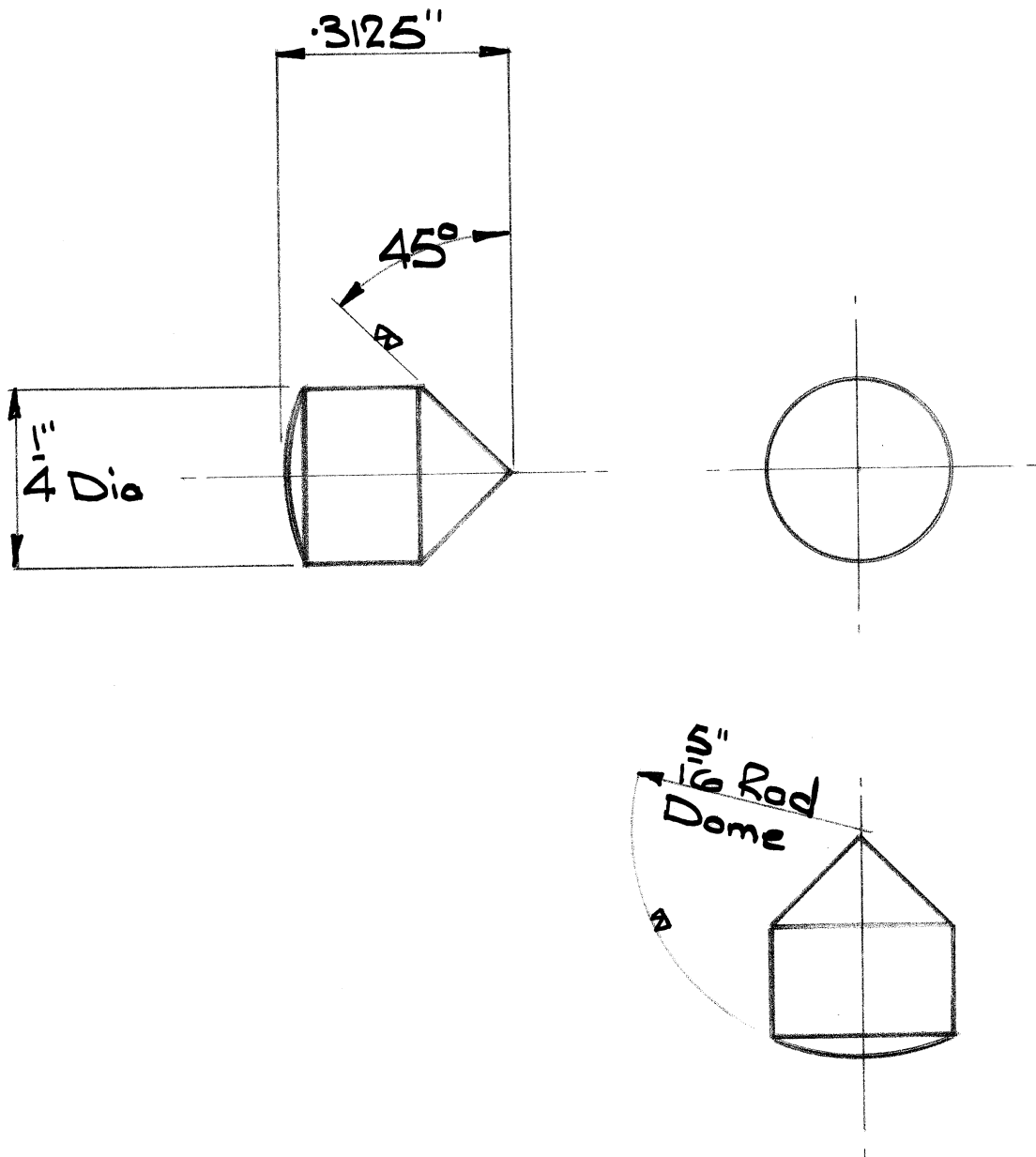
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN RD.
CHECKED
PASSED
DATE 4.11.78.

MAT. M.S.
MAT. SIZE $1\frac{3}{4} + .010$ " DIA $\times \frac{7}{8}$ "
No. REQD. 2 SCALE 2x FULL
DRAWING No. ML100/520D.

IF IN DOUBT ASK.

ALTERATIONS



Machine of W

Remove sharp corners.

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" Viceroy Metal Lathe. Feednut locking SLUG

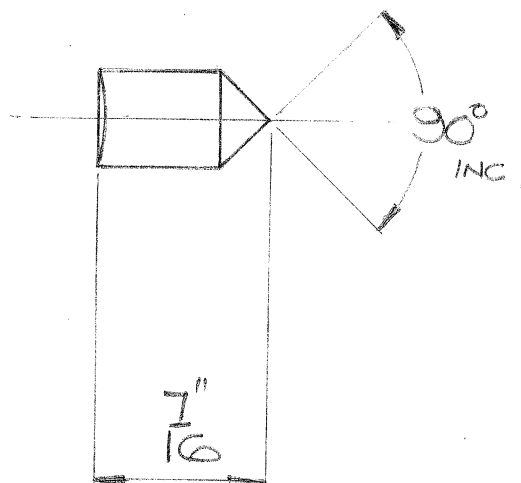
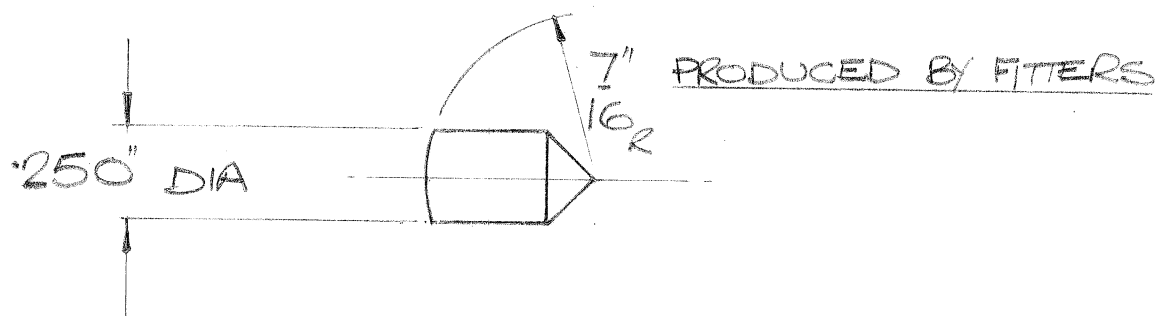
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN 
CHECKED 
PASSED
DATE 1.7.70

MAT. Silver Steel.
MAT. SIZE $\frac{1}{4}$ " Dia x $\frac{3}{8}$ " long.
No. REQD. 1 SCALE 4x Full.
DRAWING No.
ML 100/523

IF IN DOUBT ASK

ALTERATIONS



MACHINE AT W

LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

5" & 280XS LATHES - T/SIDE FEEDNUT LOCKING PLUG.

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

DRAWN IV.
CHECKED
PASSED
DATE 19.9.78

MAT. SILVER STEEL
MAT. SIZE 1/4" DIA x 1/2" L.
No. REOD. ONE SCALE 2x Full.
DRAWING No. ML.100/523.A.

IF IN DOUBT ASK.

ALTERATIONS

Redrawn 12.8.68

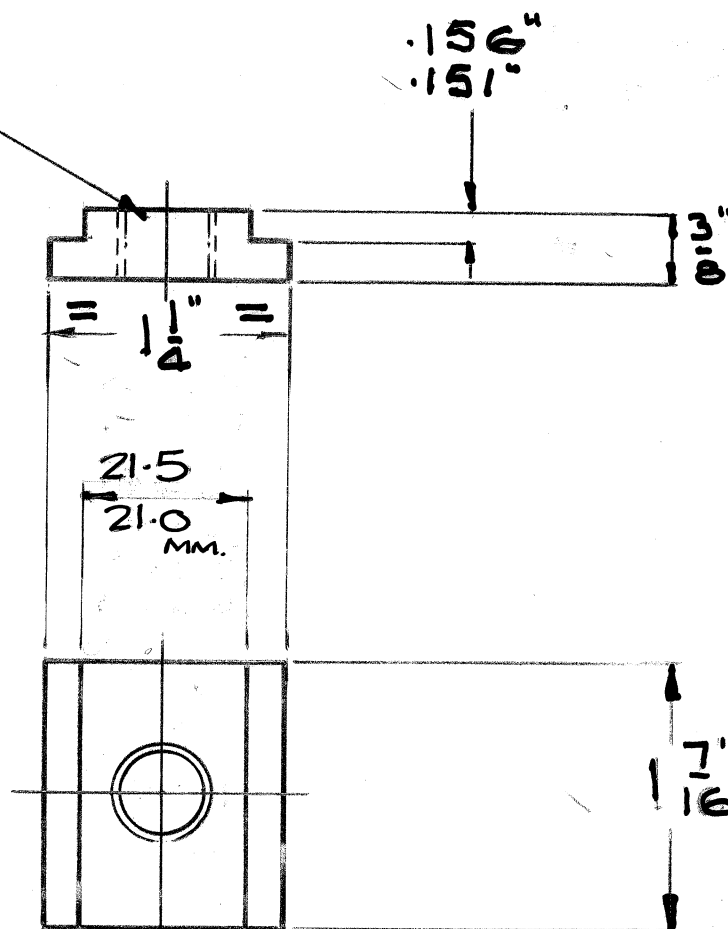
2044/73 DK

20-B-73

2788/80.15-2-80.W.

Top $\frac{1}{2}$ " whit.

M12



Machine all over

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.

ANGULAR $\pm 1^\circ$ 3 PLACE DECIMAL $\pm .005^\circ$

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

5" Viceroy Metal Lathe - TOOL POST TENON

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

DRAWN

R.D. Erdowski

CHECKED

★

PASSED

DATE

12.8.68.

MAT.

M. S.

MAT. SIZE

$\frac{1}{4} \times \frac{1}{16} \times \frac{3}{8}$ (31.75 x 42.86 x 9.53)

No. REQD.

1

SCALE

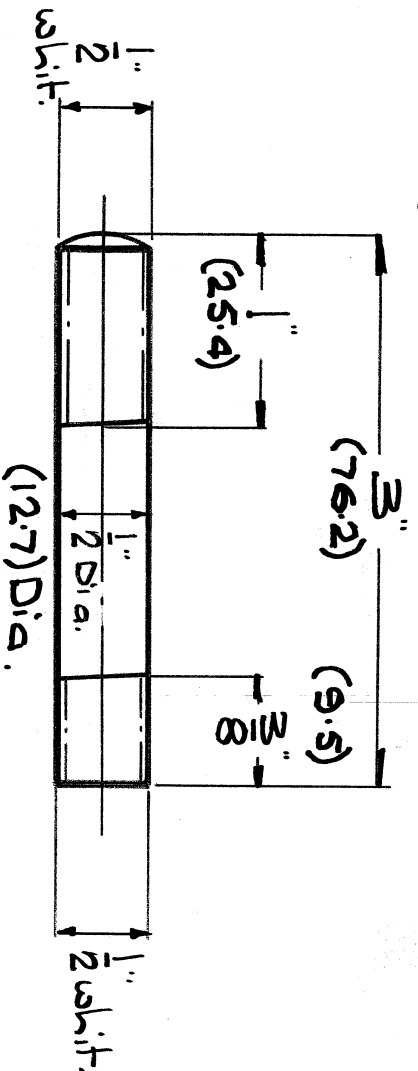
FULL

DRAWING No.

M.L.100/802.

IF IN DOUBT ASK.

TMM



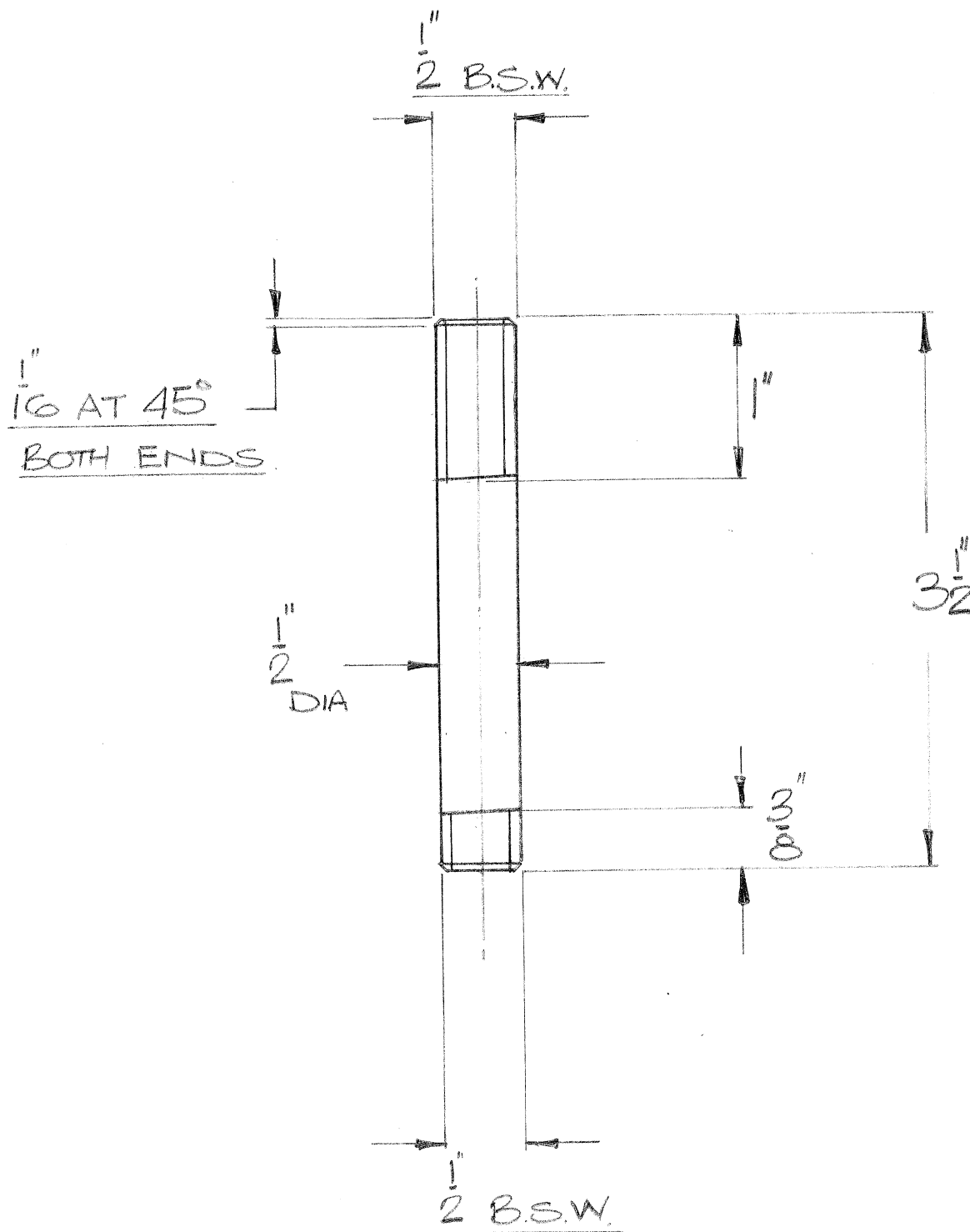
Metric dims. in brackets.

5" Viceney Metal Lathe - Tool Post Stud.

DENFORD MACHINE TOOLS LTD. (INC.) DENFORD SMALL TOOLS (BRIG) LTD. BRIGHOUSE, YORKSHIRE		DRAWN AsS Clarke		MAT. M.S. (12.7) STD. BAR x (9.5)	
CHECKED AS		PASSED		MAT SIZE 1/2" STD. BAR x 3 1/4"	
DATE 30.4.64.		DRAWING No. M.L. 100/803		No. REQD. 1 SCALE Full.	

IF IN DOUBT ASK

ALTERATIONS



LIMITS ON DIMENSIONS UNLESS
OTHERWISE STATED.

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

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

280 VS METAL LATHE - TOOL POST STUD

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

DRAWN IV.
CHECKED
PASSED
DATE 18.7.78

MAT. MILD STEEL
MAT. SIZE 1/2" DIA x 3 9/16 L.
No. REQD. ONE SCALE FULL
DRAWING No. ML.100/803 A

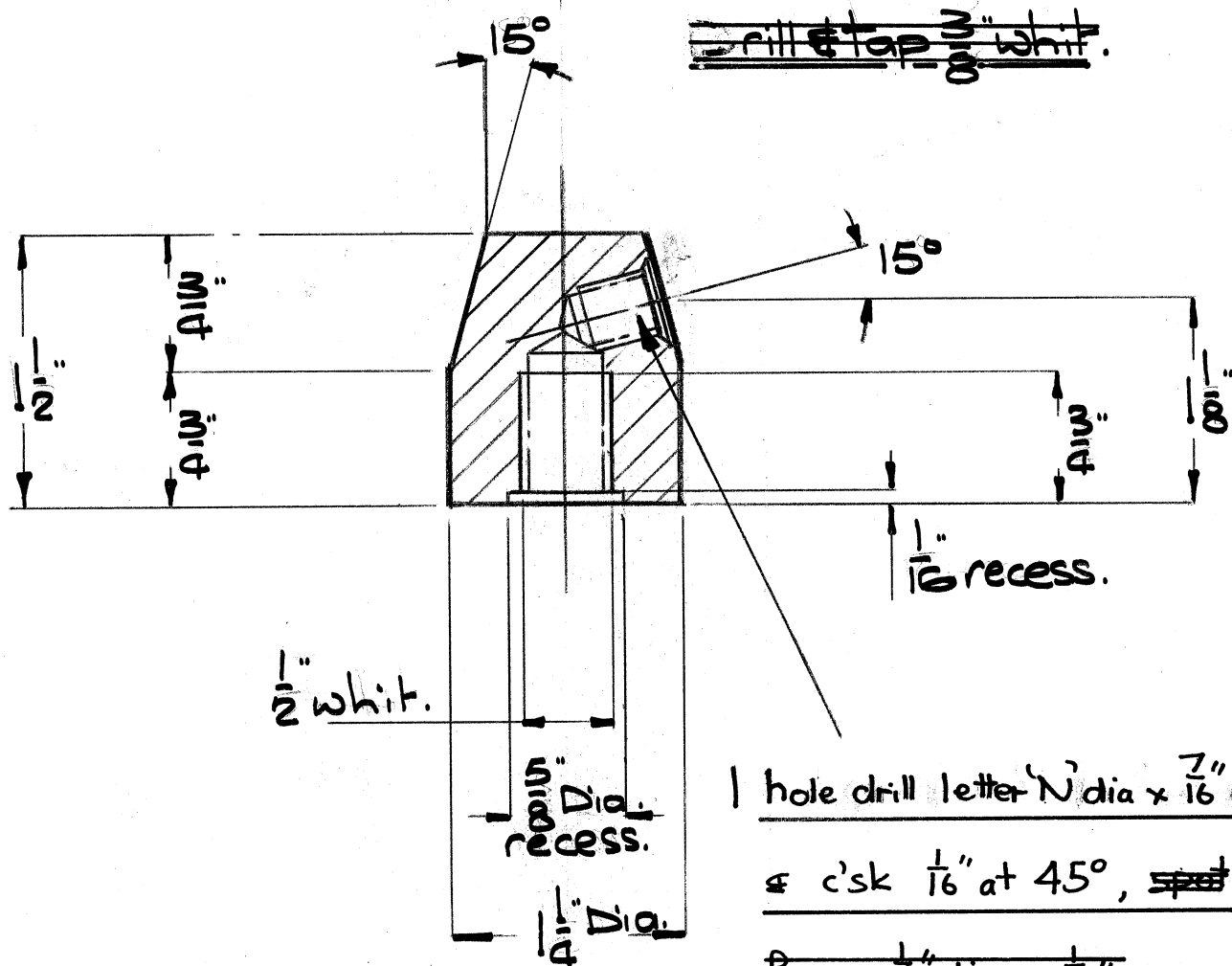
IF IN DOUBT ASK.

1117/65. 21.1.65. AS

1134/6523-2-65 B

1405/66 11.11.66 B

1481/67 28.6.67 B



Drill & tap 3/8" Whit.

1 hole drill letter 'N' dia x 7/16" deep

& c'sk 1/16" at 45°, spot

Face 1/2" dia x 1/32" deep &

tap 3/8" Whit. x 3/8" deep.

Machine all over.

Remove all sharp corners.

~~Cadmium plate.~~

Oil Blue

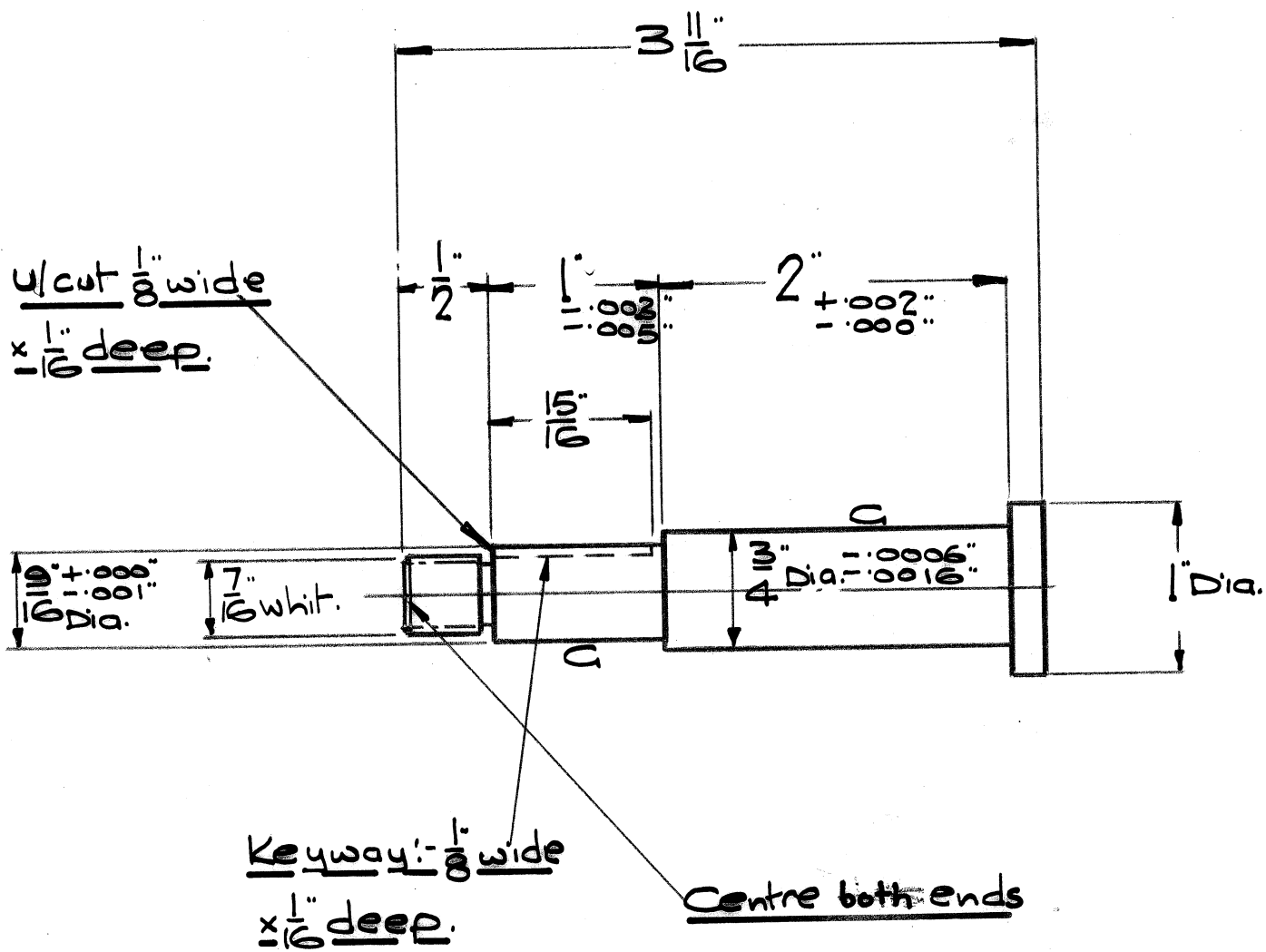
5" Viceroy Metal Lathe - TOOL POST HANDLE - CAP.

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

DRAWN A. S. Clarke
CHECKED AS
PASSED
DATE 21.1.65.

MAT. M.S.
MAT SIZE 1 1/4" Dia x 1 3/4" long.
No. REQD. 1 SCALE Full.
DRAWING No. M.L.100/805

IF IN DOUBT ASK.



Machine all over.

Cyanide harden.

Grind at C.

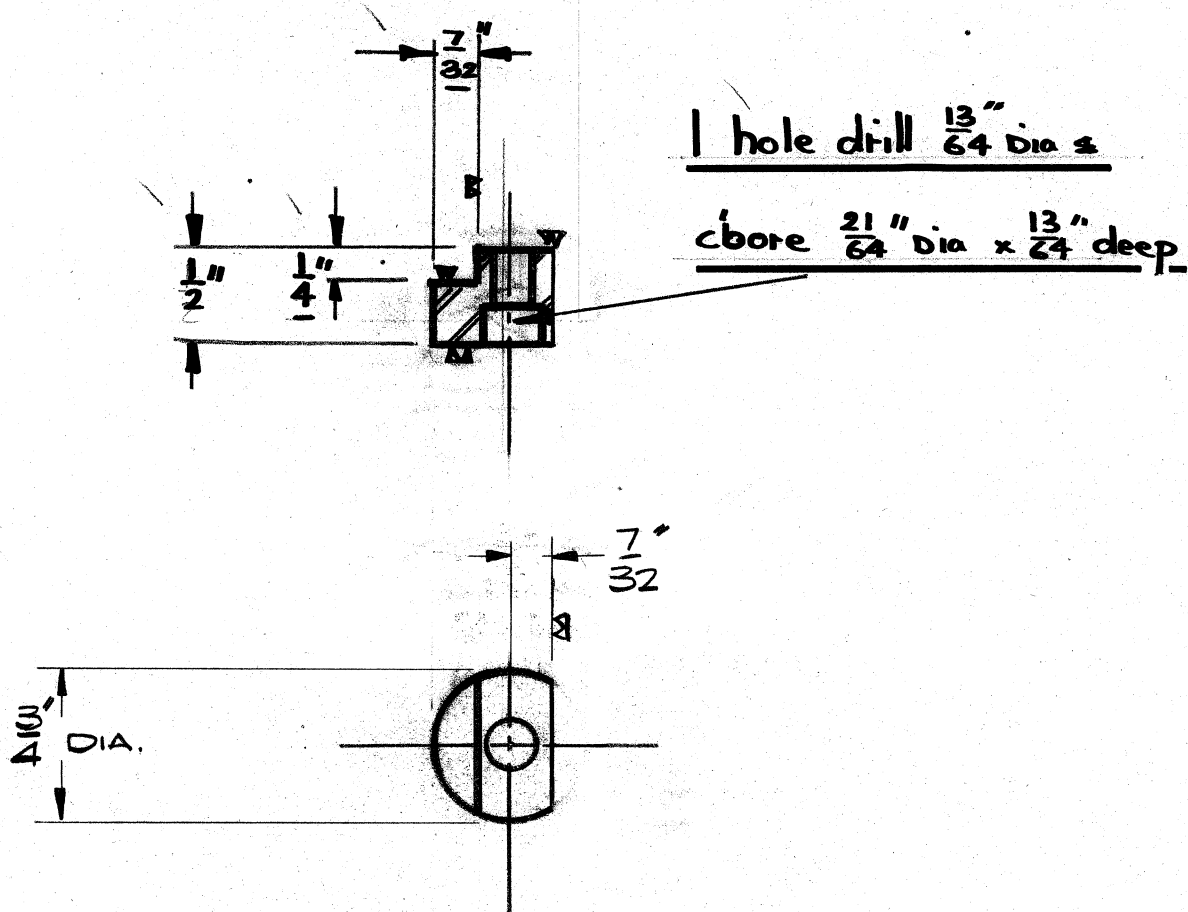
5" Viceroy Metal Lathe - INTERMEDIATE STUD.

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

DRAWN A.S. Parke.
CHECKED AS
PASSED
DATE 30.4.64.

MAT. M.S.
MAT SIZE 1" Dia. x $3\frac{15}{16}$ "
No. REQD. 1 SCALE Full.
DRAWING No. M.L. 105/102

IF IN DOUBT ASK.



Machine at w

5" Viceroy Metal Lathe : Reversing Bracket Stop.

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

DRAWN M.M. Souden
CHECKED
PASSED
DATE 26.1.65

MAT. Mild Steel
MAT SIZE $\frac{3}{4}$ " Dia x $\frac{3}{4}$ " long
No. REQD. 1 SCALE Full
DRAWING No. ML 105/104

1473/67 8.6.67

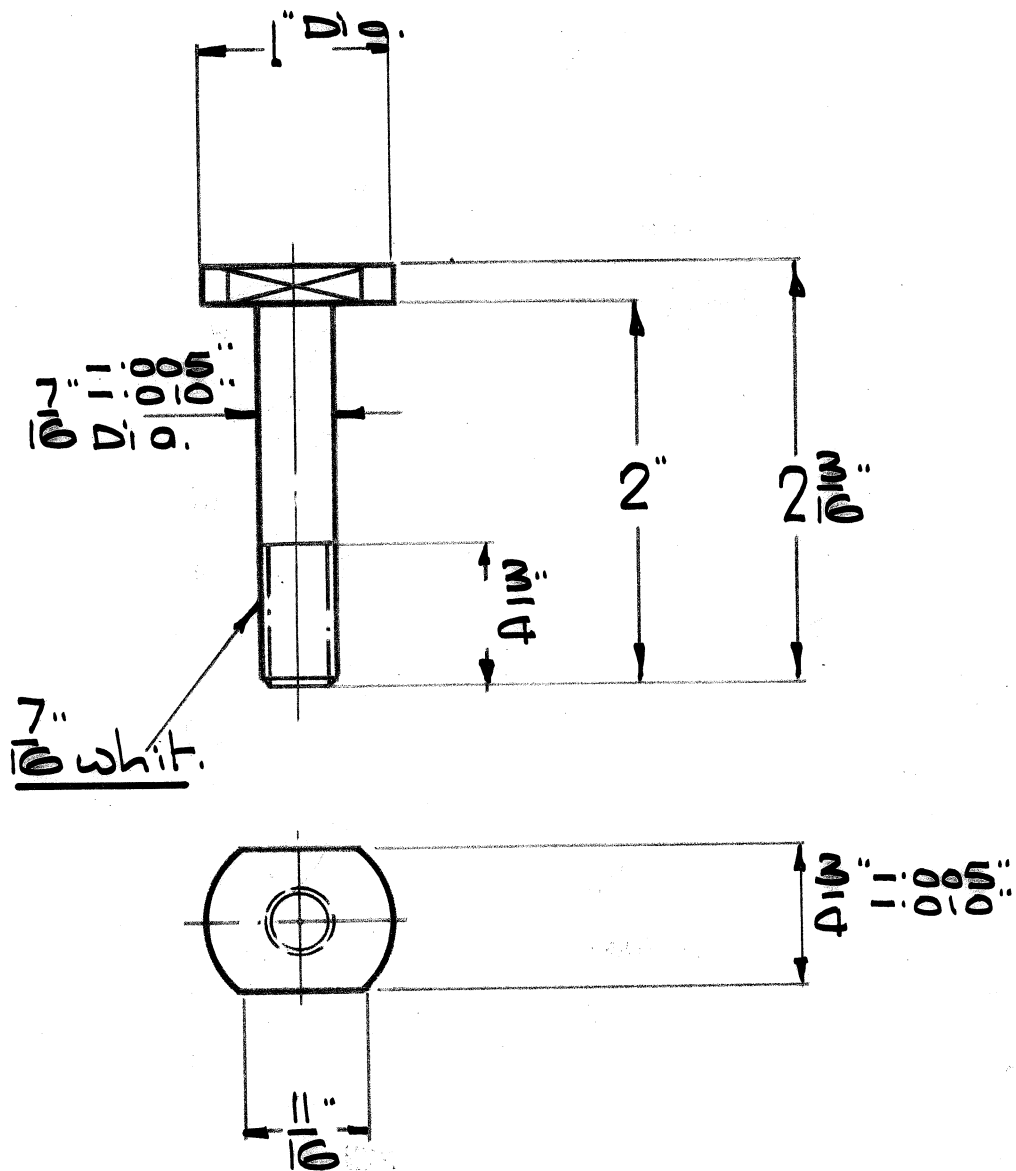
NO. TEETH	38
PITCH	20 D.P.
PRESS. L.	20°
P.C.D.	1.900"



5" Viceroy Metal Lathe - 38T STUD GEAR.

MAT.		M.S.
MAT SIZE		2 1/8" Dia. x 7/8"
No. REQD.	1	SCALE Full.
DRAWING No.		
M.L. 105/108		

IF IN DOUBT ASK.



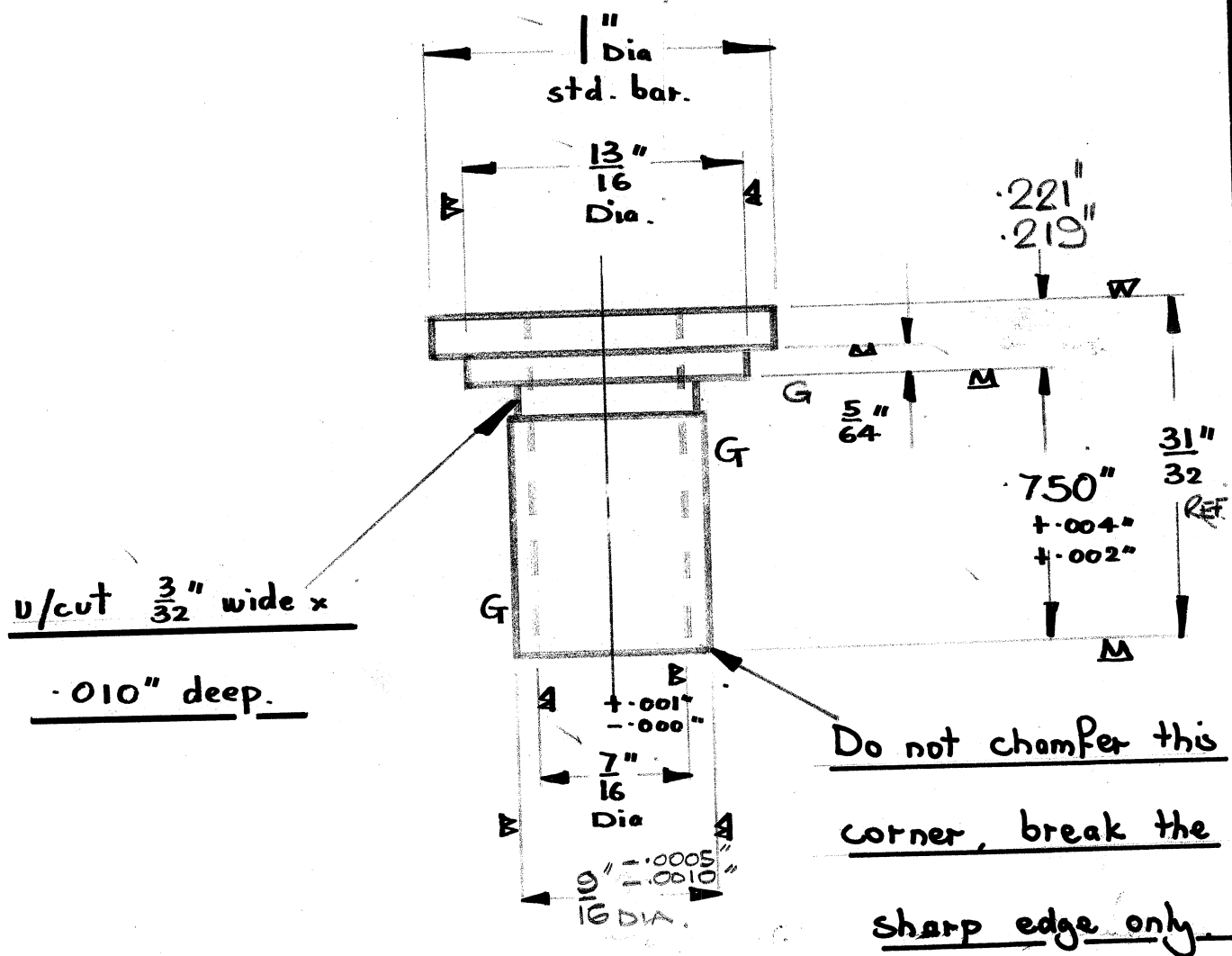
5" Viceroy Metal Lathe - INTERMEDIATE STUD.

BRITISH MACHINE TOOLS LTD.
(INCORPORATED IN THE UNITED KINGDOM)
LONDON, ENGLAND.
YORKSHIRE.

DRAWN A. S. Clark.
CHECKED [Signature]
PHASED
DATE 30.4.64.

MAT. M.S.
MAT SIZE 1" Dia. x 2 $\frac{7}{16}$ "
No. REQD. 2 SCALE Full.
DRAWING No. M.L.105/112 T2

IF IN DOUBT ASK.



Cyanide Harden

Grind at 'G'

Machine at 'W'

5" Viceroy Metal Lathe : Spacing Bush.

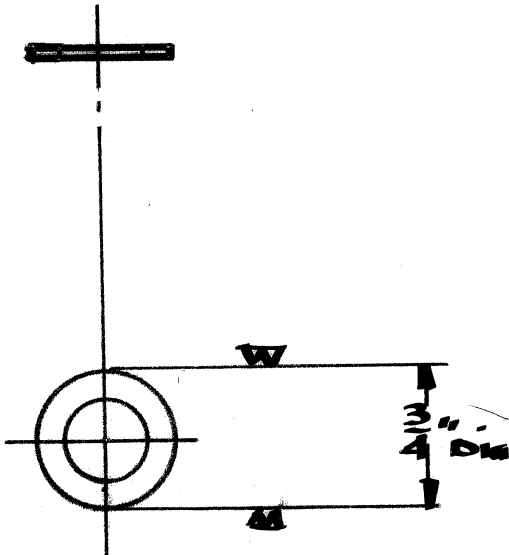
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN M. M. Souden
CHECKED
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.

Make from std 7/16" washer



Machine at w

5" Viceroy Screwcutting Lathe - Bright Washer

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

DRAWN
M.M. Sowden
CHECKED 
PASSED
DATE **19.8.65**

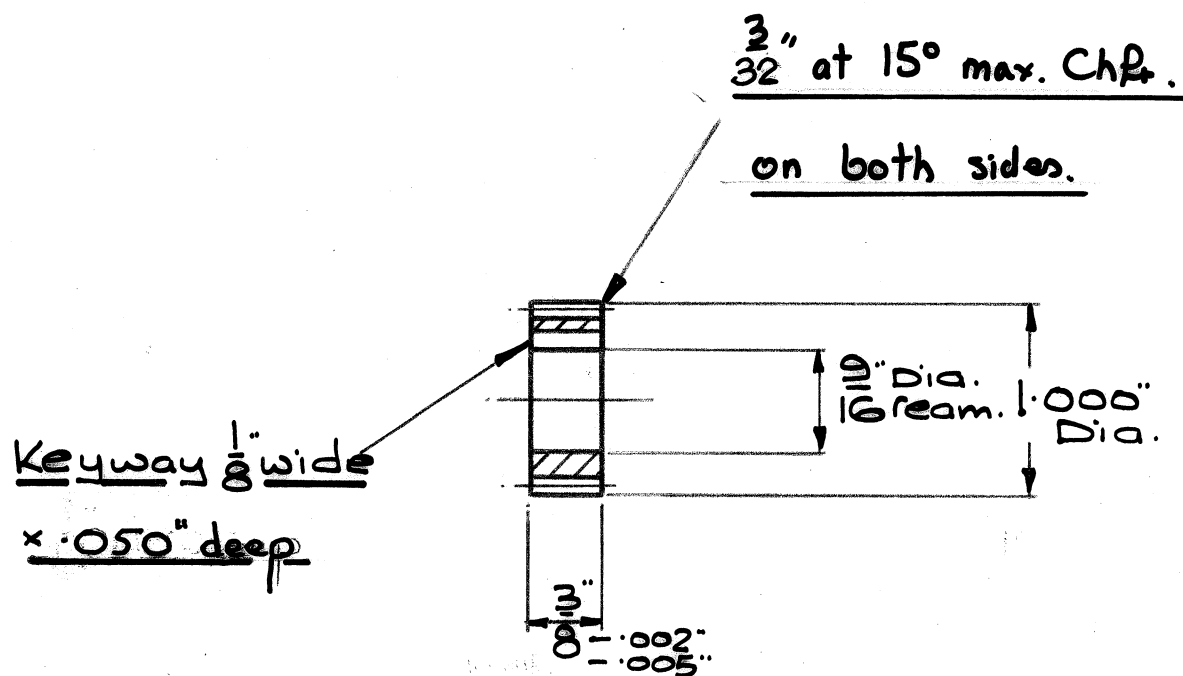
MAT. **M.S.**
MAT SIZE **7/16" dia std Bright Washer**
No. REQD. **2** SCALE **Full**
DRAWING No.
ML105/117

IF IN DOUBT ASK.

1303/66 8.3.66
1553/68 25.3.68

CALIPER SETTINGS	
ADD.	.0578"
WIDTH	.086"
	.084"

No. TEETH	16
PITCH	18 D.P.
PRESS L.	20°
P.C.D.	.8889"



Machine all over.

5" Viceroy Metal Lathe - 16T CHANGE WHEEL.

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

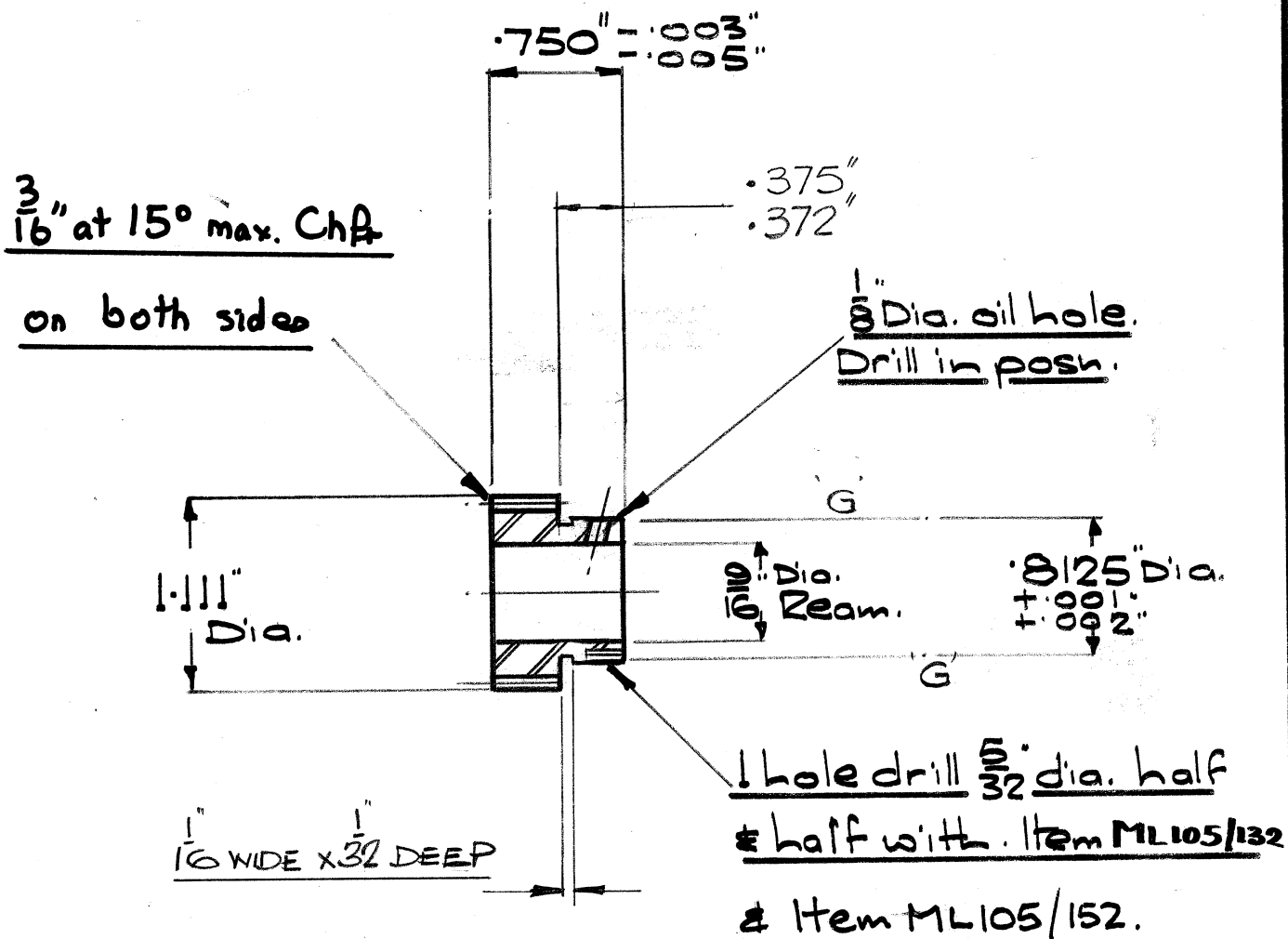
DRAWN A. S. Clarke.
CHECKED B.
PASSED
DATE 30.4.64.

MAT. M.S.
MAT SIZE 1 1/8" Dia. x 7/8"
No. REQD. 1 SCALE Full.
DRAWING No. M.L.105/119.

IF IN DOUBT ASK.

1303/66 8.3.66 D.

2531/78. 3478
11.



Caliper settings.	
Add.	$.0574''$
Width	$.086''$
	$.084''$

No. Teeth	18
Pitch.	18 D.P.
Press. L.	20°
P.C.D.	1.000"

Machine all over. GRIND AT 'G'

5" Viceroy Metal Turning Lathe - 18 T. CLEAR.

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

DRAWN Aas Clarke
CHECKED AS
PASSED
DATE 26.3.64.

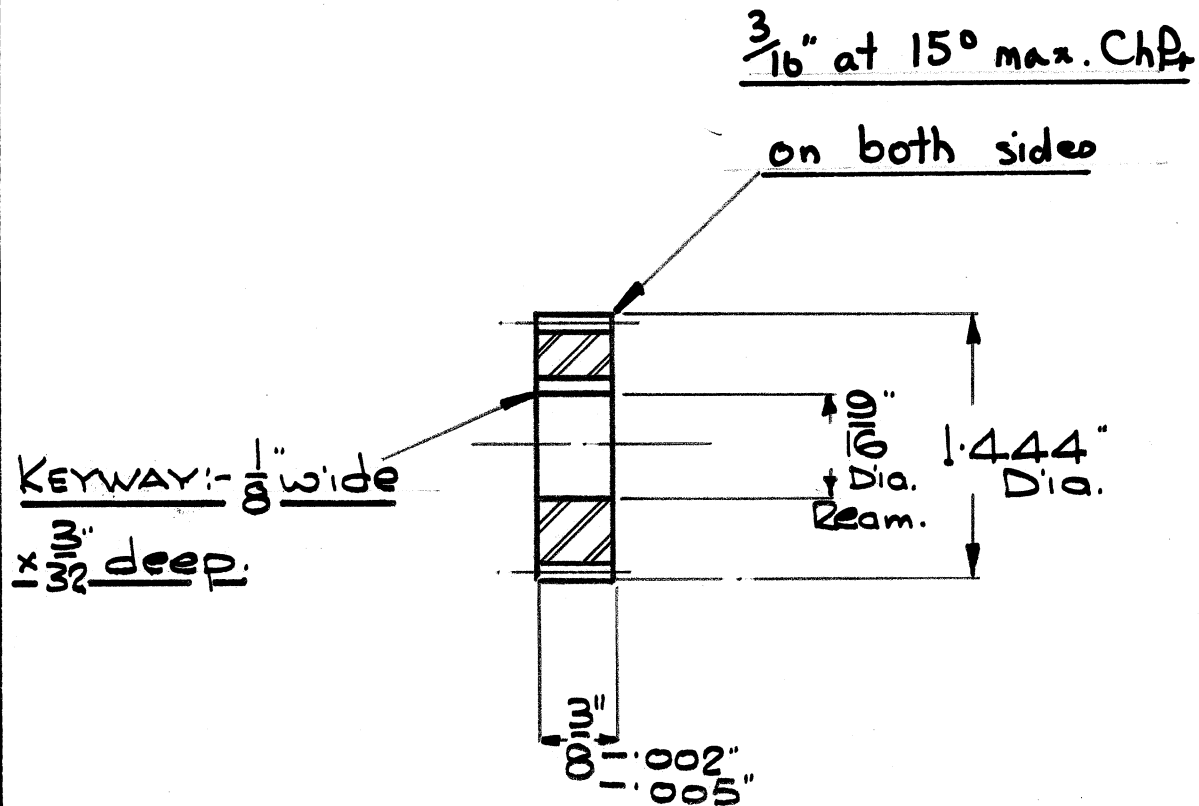
MAT. M.S.
MAT SIZE 1 1/4" Dia x 1"
No. REQD. 2. SCALE Full.
DRAWING No. M.L.105/120.

IF IN DOUBT ASK.

1303/66 8.3.66 D

CALIPER SETTINGS	
ADD.	.0569"
WIDTH.	.086"
	.084"

Nº. TEETH.	24
PITCH.	18 D.P.
PRESS. $\angle$	20°
P.C.D.	1.333"



Machine all over.

5" Viceroy Metal Turning Lathe - 24 T. CHANCE WHEEL.

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

DRAWN A.S. Clarke.
CHECKED AS
PASSED
DATE 26.3.64.

MAT. M.S.
MAT SIZE 1 1/2" dia. x 5/8"
No. REQD. 1 SCALE Full.
DRAWING No. M.L.105/121

IF IN DOUBT ASK.

Redrawn 1-6-65

1303/66 8.3.66 S.

Keyway : $\frac{1}{8}$ " wide

x $\frac{3}{32}$ " deep

$\frac{3}{16}$ " at 15° max. Chfr.

on both sides.

$\frac{9}{16}$ " Dia ream

1.888"
Dia

.375" .002"
.005"

No. of Teeth	32
Pitch	18 D.P.
Press. Angle	20°
P.C.D.	1.777"

Caliper Settings	
Add.	.0566"
Width	.086"
	.084"

Machine all over

5" Viceroy P.C.S. Lathe.

32 T. Change Wheel.

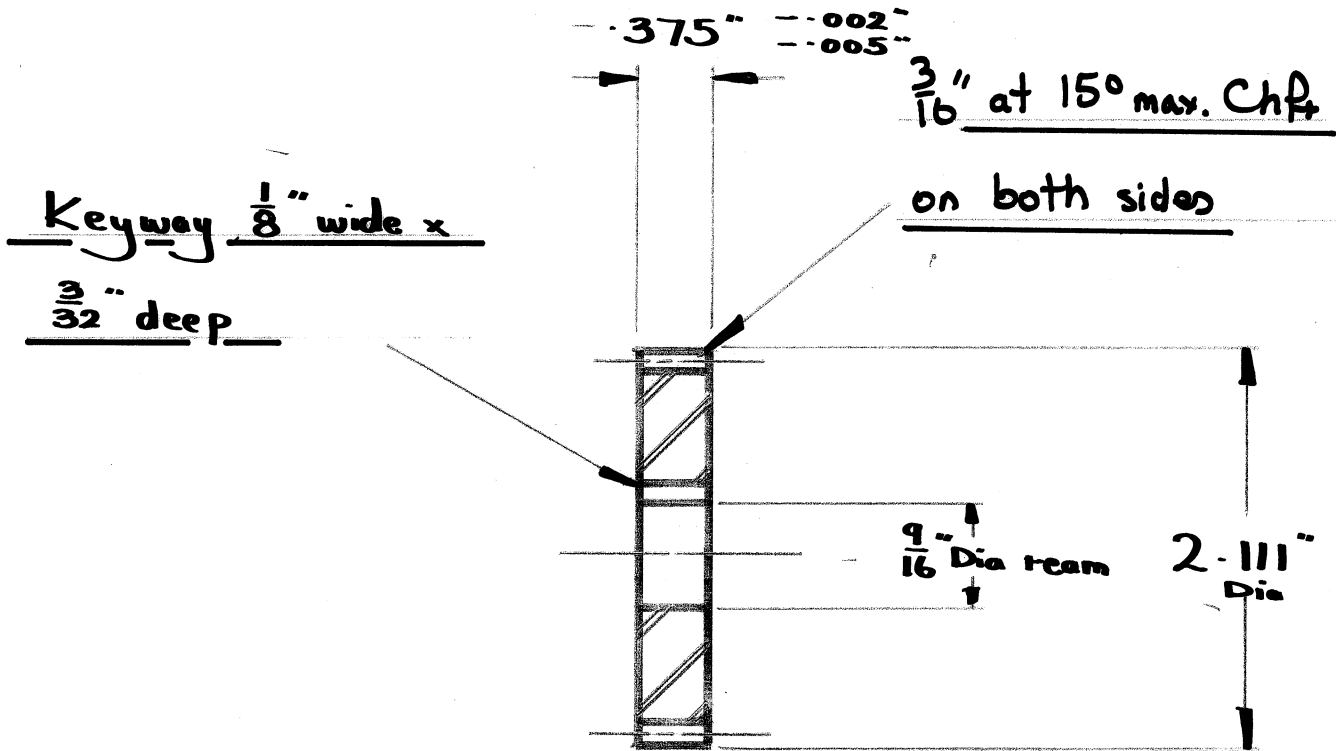
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN
M.M. Sowden
CHECKED **AB.**
PASSED
DATE **1-6-65**

MAT. **M.S.**
MAT SIZE **2" Dia x $\frac{5}{8}$ "**
No. REQD. **1** SCALE **FJI**
DRAWING No.
ML105/122

IF IN DOUBT ASK.

Redrawn 9-6-65
1303/66 8-3-66



Machine all over

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

N° of teeth	36
Pitch	18 D.P.
Press Angle	20°
P.C.D.	2.000"

5" Viceroy P.C.S. Lathe : 36 T. Change wheel.

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

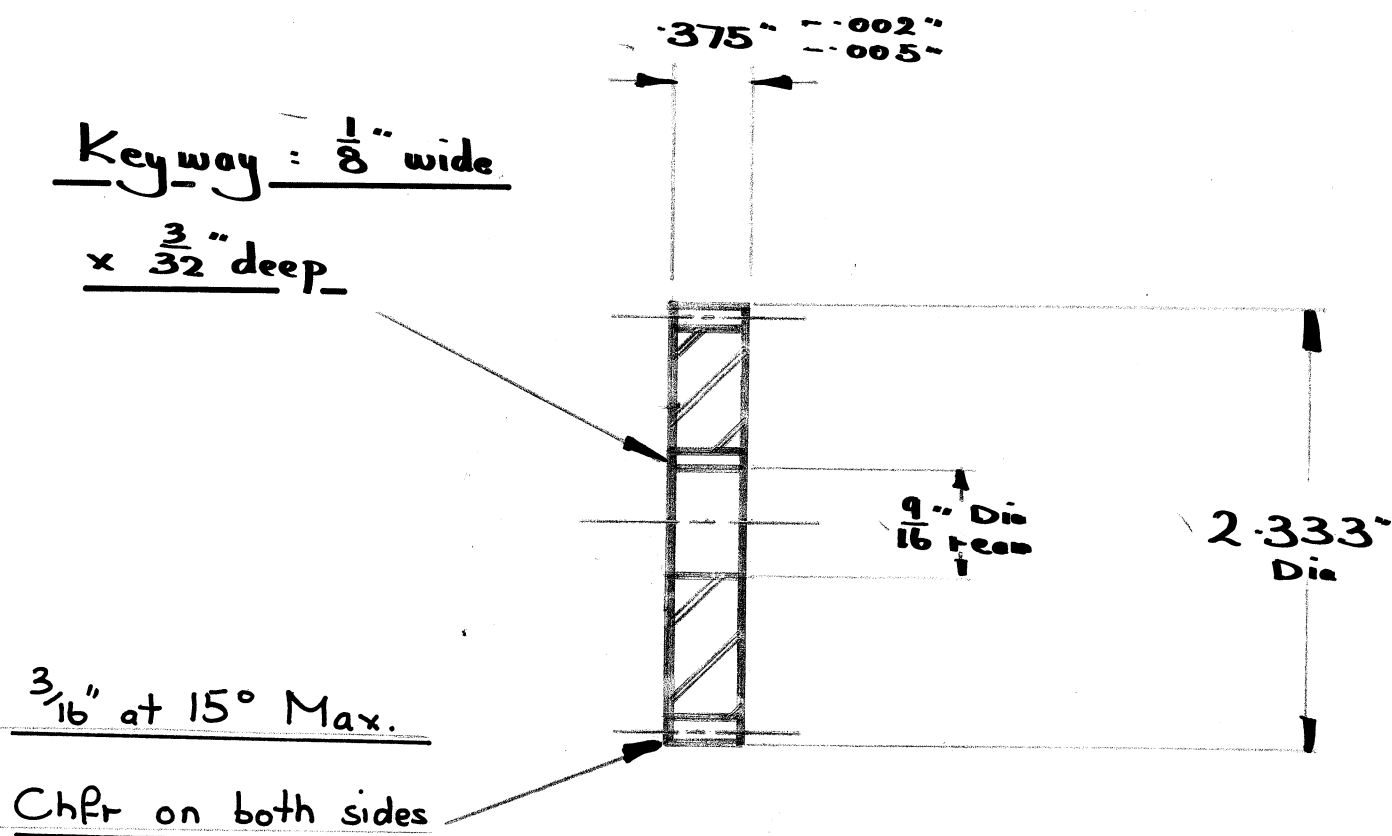
DRAWN
M.M. Sowden
CHECKED
PASSED
DATE
9-6-65

MAT. M.S.
MAT SIZE 2 1/4" x 5/8"
No. REQD. 1 SCALE Full
DRAWING No.
ML105/123

IF IN DOUBT ASK.

Redrawn 9-6-65

1303/66 8-3-66



Machine all over

Caliper Settings	
Add.	$-.0564$ "
Width	$-.086$ "
	$-.084$ "

N° of teeth	40
Pitch	18 D.P.
Press. Angle	20°
P.C.D.	2.222 "

5" Viceroy P.C.S. Lathe : 40 T. Change Wheel.

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

DRAWN
M.M. Sowden
CHECKED
PASSED
DATE
9-6-65

MAT. **M.S.**
MAT SIZE **$2\frac{1}{2}$ " D. x $\frac{5}{8}$ "**
No. REQD. **1** SCALE **Full**
DRAWING No.
M.L. 105/124

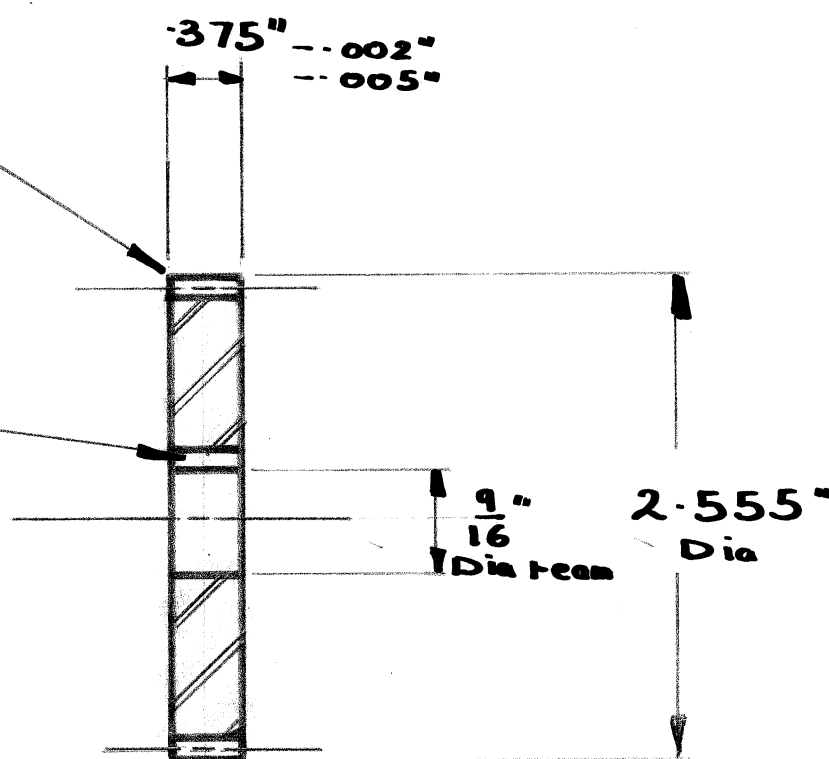
IF IN DOUBT ASK.

$\frac{3}{16}$ " at 15° max Chd

on both sides

Keyway $\frac{1}{8}$ " wide

x $\frac{3}{32}$ " deep



Machine all over

Caliper Settings	
Add	$.0563"$
Width	$.086"$
	$.084"$

N ^o of Teeth	44.
Pitch	18 D.P.
Press. $\angle$	20°
P.C.D.	2.444"

5" 'Viceroy' Metal Lathe : 44 T. Change Wheel

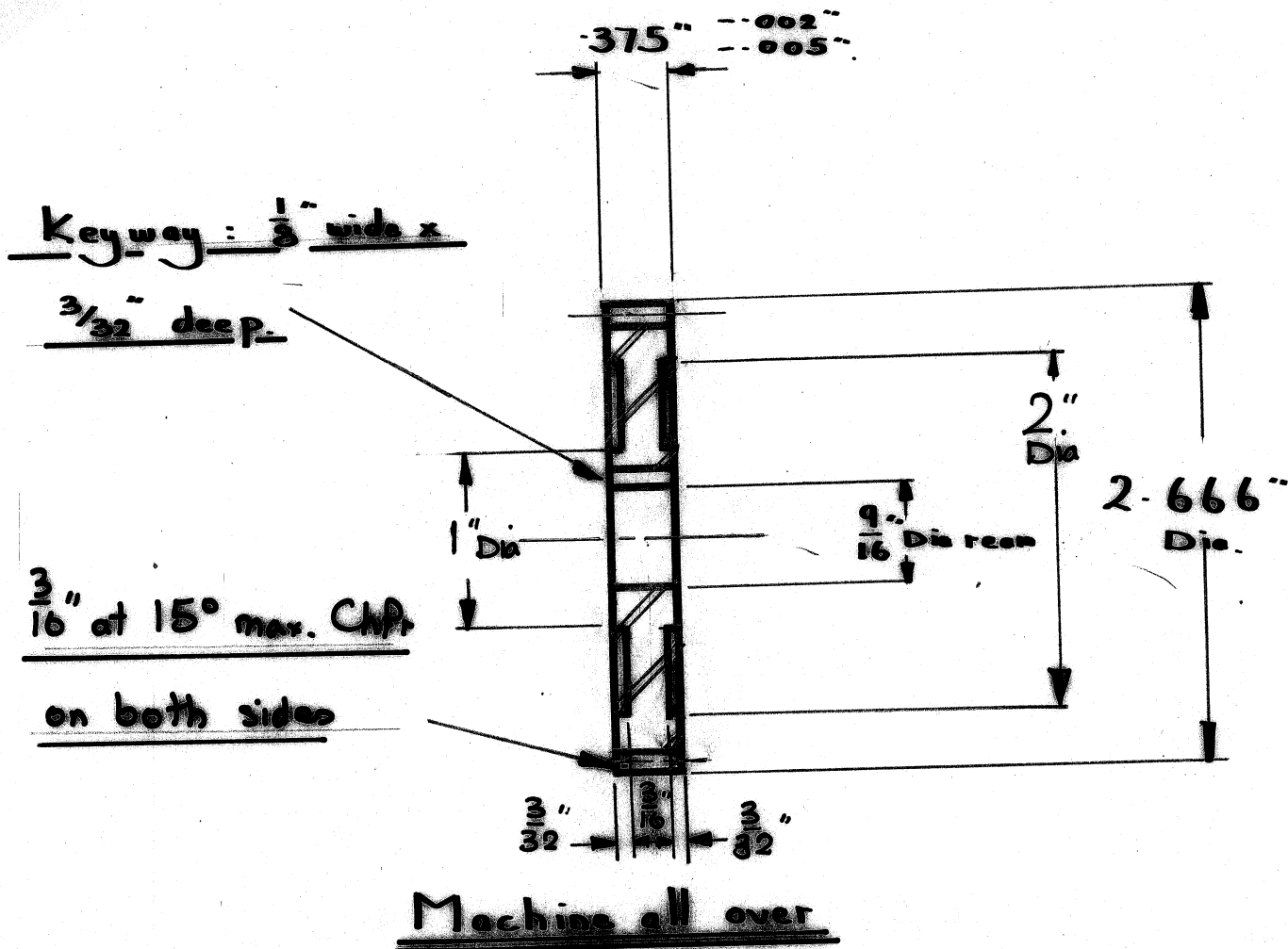
DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN
M.M. Soudan
CHECKED
AS
PASSED
DATE
16-3-65

MAT. **Mild Steel**
MAT SIZE **$2 \frac{5}{8}"$ Dia x $\frac{5}{8}"$**
No. REQD. **1** SCALE **Full**
DRAWING No.
ML 105 / 125

IF IN DOUBT ASK.

Ref. 9-6-65
105/126-2-613



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

N ^o of teeth	46
Pitch	18 D.P.
Press. Angle	20°
P.C.D.	2.555"

5" Viceroy P.C.S. Lathe : 46T. Charge Wheel

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(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
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DRAWN
M.M.S.
CHECKED
PASSED
DATE 9-6-65

MAT. C.I.
MAT SIZE Casting
No. REQD. 1 SCALE Full
DRAWING No. ML 105/126

1303/66 8-3-66 J

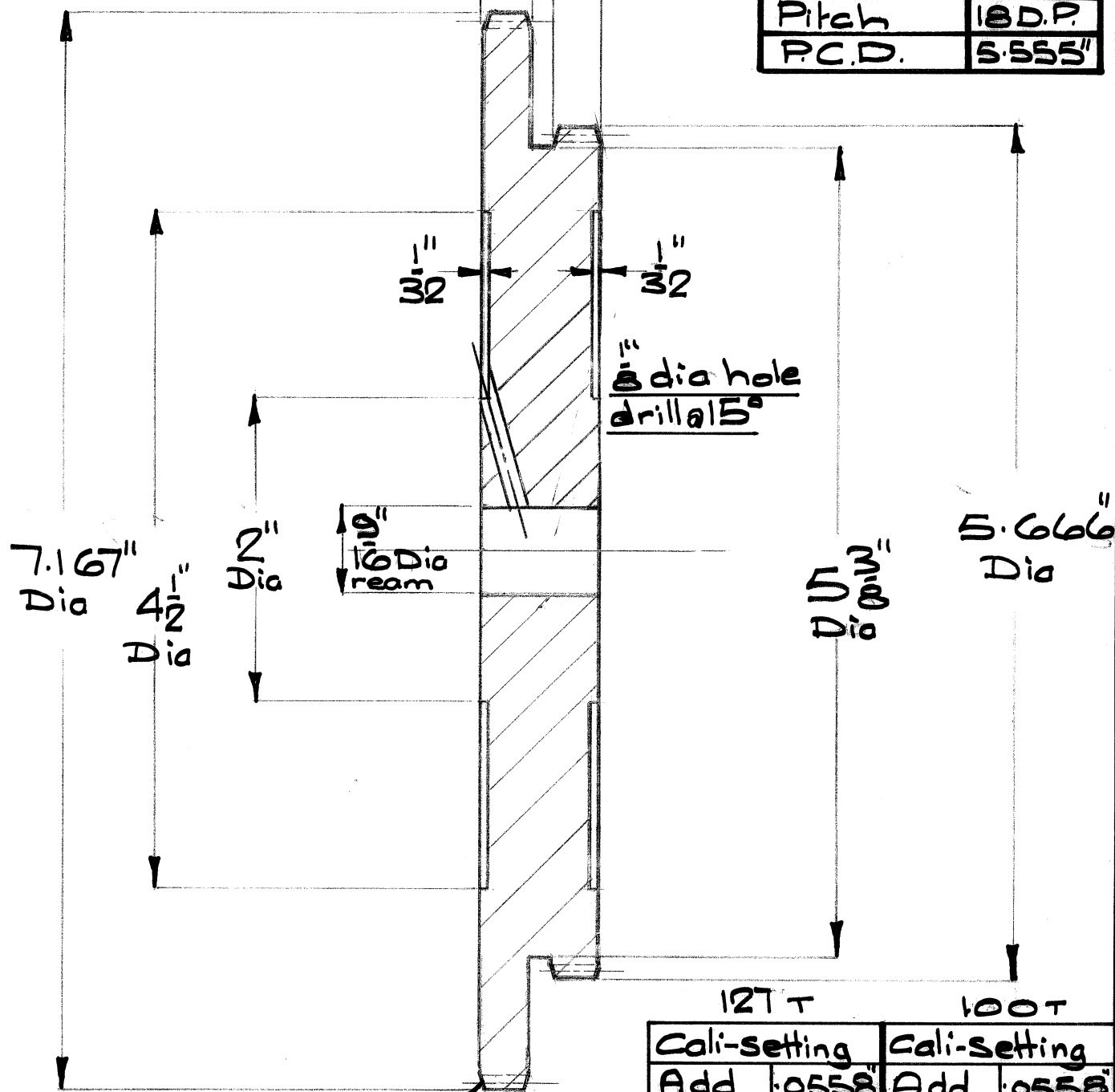
ML 105 / 127

IF IN DOUBT ASK.

Nº Teeth	127
Press. L.	20°
Pitch	18 D.P.
P.C.D.	7.056"

$\frac{.749}{.747}$
 $\frac{.310}{.307}$

Nº Teeth	100
Press. L.	20°
Pitch	18 D.P.
P.C.D.	5.555"



Break Corners

127 T	100 T
Cali-setting	Cali-setting
Add .0558"	Add .0558"
Width .086"	Width .086"
	Width .084"

5" Viceroy Metal Turning Lathe - 127T/100T GEAR.

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

DRAWN *JD*
CHECKED *JD*
PASSED
DATE 15.6.71

MAT. C.I.
MAT. SIZE CASTING
No. REQD. 1. SCALE FULL.
DRAWING No. ML 105/146.

ALTERATIONS
1855/71
Redrawn *JD*
1988/72-8-9-72 JA

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