

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. ML.100/100 (OPEN TOP HEAD)

1

TITLE: 5" METAL LATHE - HEADSTOCK

DATE

15.5.79.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML.100	101	B. HEADSTOCK	CI.	1	CASTING.
"	105	HANDLE	CI.	1	CASTING.
"	106	5" CATCHPLATE	CI.	1	CASTING
"	109	A. GEAR SHIFTER FORK	STEEL RATE	1	
"	109	B. GEAR SHIFTER SLIDING BODY	MS	1	
"	109	C. GEAR SHIFTER DOG INSERT	MS	1	
"	111	LOCKNUT	MS	2	
"	112	GEAR SHIFTER BUSH	MS.	1	
"	114	ECCENTRIC	MS.	1	
"	115	A. BACK GEAR SHAFT BUSH	MS	1	
"	116	GEAR CHANGE KNOB.	MS	1	
"	118	A. GEAR SHIFTER SHAFT	MS	1	
"	119	LOCATING PIN	MS	1	
"	120	CATCH PLATE DRIVING PIN.	MS	1	
"	122	A. MAIN SPINDLE	MS	1	
"	132	BACK GEAR WASHER	MS.	1	
"	136	SPINDLE BUSH.	MS.	1	
"	137	DRIVEN CLUTCH GEAR	CI.	1	CASTING.
"	138	29T CLUTCH GEAR	CI.	1	CASTING.
"	139	68T DRIVEN GEAR	CI.	1	CASTING.
"	140	BACK GEAR BARREL	CI.	1	CASTING.
"	141	A. BACK GEAR SHAFT.	MS.	1	
"	145	REAR CAP	CI.	1	CASTING
"	146	HEADSTOCK COVER	C.I.	1	CASTING.
"	147	GREASE RETAINING COLLAR	C.I.	1	CASTING.
ML.105	144	A. 42T SPINDLE GEAR.	MS.	1	
SP.134		LOCKING STUD	MS	1	
SP.143		REAR NOSE CAP	ALLUM	1	CASTING.
SP.144		SPINDLE LOCK - BODY	MS.	1	
SP.145		SPINDLE LOCK - COLLAR	MS.	1	
SP.150		FRONT NOSE CAP.	ALLUM	1	CASTING.
SP.151		RETAINING SCREW.	MS.	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. ML 100/100

B.O. PARTS.

DATE

29.4.70.

TITLE: HEADSTOCK ASSEMBLY.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>OILITE BUSHES.</u>			
		04/0163/8/1.500/-/99/5		1	
		Ref:- STD 193 x 2 1/4" long	Sintered Brass	1	Lubbrook.
		" :- SN 343 x 1 3/4" "	"	1	Lubbrook.
		" :- BS.7 x 1 1/2" long	"	2	"
		<u>BEARINGS.</u>			
		Cone LM 6704B } 1 1/4" Dia		1	Timken
		Cup LM 67010B } 1 1/4" Dia		1	" "
		Cone 19150 } 1 1/2" Dia.		1	"
		Cup 19268B } 1 1/2" Dia.		1	"
		REPLACED BY 19268 ON 26/9/74. RS.			
		<u>OILERS.</u>			
		LD. 3/8"		2	Kingfisher.
		<u>GREASE NIPPLES.</u>			
		ref:- H 4120 straight 1/4" drive fit		2	Kingfisher.
		" :- H 4154 angle 1/4" " "		1	"
		<u>C'isk Skt HD SCREWS.</u>			
		M5 x 15MM LONG.		2	Unbrako
		<u>Socket Cap SCREWS</u>			
		1/4" whit x 3/4" long.		3	"
		" x 1/2" "		3	"
		5/16" " x 1/4" "		4	"
		<u>GRUBS</u>			
		1/4" whit x 1/4" long knl cup pt		1	"
		" x " Dog pt		3	"
		" x " Cone		2	"
		" x 1/2" knl cup pt.		1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. ML100/100. B

DATE

29.4.70.

TITLE: HEADSTOCK ASSEMBLY.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
MU100	136	Spindle bush.	M.S.	1	1 3/4" D x 1 3/16"
"	137	Driven clutch gear.	C.I.	1	casting.
"	138	99T clutch gear.	"	1	"
"	139	68T Driving gear.	"	1	"
"	140	99T-38T Back gear barrel.	"	1	"
"	141	Back gear shaft.	M.S.	1	1 1/4" D x 8"
"	602	Countershaft Pulley	Alum	1	casting.
"	101	A. Headstock	C.I.	1	casting.
"	105	Handle	C.I.	1	casting.
"	109	Gear shifter Arrangement.	M.S.	1	See drg.
"	111	Locknut.	"	2	2" D x 9/16"
"	112	Gear shifter bush	"	1	1 3/4" D x 1 5/16"
"	114	Eccentric	"	1	1 1/2" D x 1 7/8"
"	115	Back gear shaft bush	"	1	1 3/8" D x 1 7/16"
"	116	Gear Change knob.	"	1	1" D x 1 1/4"
"	118	Gear shifter bush	"	1	1 1/2" D x 1 1/4"
"	119	Locating Pin	"	1	3/8" x 1 5/16"
"	120	Catch plate driving pin	"	1	5/16" D x 2 3/8"
"	122	Main Spindle.	"	1	1 3/4" D x 12 1/16"
"	125	Headstock cover.	sh. St.	1	8 7/8" x 6 3/4" x 1 6/16"
"	129	Thrust Washer	M.S.	1	1 3/4" D x 5/8"
"	132	Back gear washer	"	1	1 3/8" D x 3/8"
"	133	Spindle gear blank.	"	1	2 1/8" D x 1 1/4"
"	134	" Lock Guard.	Sh. St.	1	1 6 S.W.G.
"	109	A Gear Shifter fork	M.S. Plate	1	See B.O.
"	"	B " " Sliding Body.	M.S.	1	1 1/4" dia x 4 3/16"
"	"	C " " Dog Insert.	"	1	1 1/4" x 7/8" x 3/8"
"	144	68T GEAR OILITE BUSH.	SEE B.O.	2	B.O.
SP.	112	Soft Centre.	M.S.	1	1" dia x 4 5/8"
"	143	Rear Nose Cap.	Alum	1	casting.
CH	100	Nameplate.	Brass Sheet	1	
"	103	Back Gear chart.	"	1	
"	104	Spindle Lock Plate.	"	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No

1B

ASSY. DRG. No. ML100/100 B.O. Parts.

DATE

16-12-65

TITLE: 5" Viceroy Metal Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Grubs.</u>			
		2 BA. x $\frac{1}{4}$ " long	—	5	Unbrako
		$\frac{3}{16}$ " whit x $\frac{3}{8}$ " "	—	1	"
		kn. cup. pt. Dog pt.			
		<u>Spring</u>			
		$\frac{9}{32}$ " o.d., $\frac{3}{4}$ " F.L., 12 C.P.L., x 20 surg.	Spr. Steel	1	Airdele
		<u>Washers.</u>			
		$\frac{5}{16}$ " spring washers	—	4	
		<u>Nuts</u>			
		Std $\frac{1}{2}$ " whit. nut.	—	1	
		<u>Rivets</u>			
		had. brass - type U - $\frac{3}{16}$ " long	—	12	
		Phos. bronze - $\frac{3}{16}$ " dia x $\frac{3}{8}$ " "	—	2	Brak & Hickman
		<u>Key</u>			
		$\frac{5}{16}$ " sq x 2" long	Key Steel	1	
		$\frac{1}{4}$ " sq x $\frac{5}{8}$ " long	Key Steel	1	
		<u>Labels.</u>			
		CH100 24 surg x $4\frac{3}{8}$ " x $3\frac{1}{8}$ "	Brass	1	Brig. Eng.
		CH103 " x 5" x 1"	"	1	" "
		CH104 " x 2" x 1"	"	1	" "

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No

1C

ASSY. DRG. No. Headstock Ass. ML100/100 B.O. Parts.

DATE

14.4.66

TITLE: 5" Viceroy Metal Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Dowel.</u>			
		* $\frac{1}{4}"$ D. x 2" long taper pins	—	2	
		$\frac{3}{16}"$ D. x 1" long	—	2	
		* $\frac{3}{8}"$ D. x 1" " hdn.	—	1	
		<u>Scr slot Cheese hds.</u>			
		2 B.A. x $\frac{1}{2}"$ long	—	10	Unbrako.
		<u>Sk.t hd Cap screws</u>			
		2 BA x $\frac{5}{8}"$ long	—	1	Unbrako
		<u>Nuts</u>			
		Std 2 BA	—	2	
		" 2 BA wingnut	—	1	
		<u>Hinge</u>			
		1 $\frac{1}{2}"$ wide open x 2 $\frac{1}{2}"$ x 20 swg	—	1	
		* These dowels are drilled & fitted to the bed & h'dstock when all tests etc. are finished			
SP.150		Front Nose Cap	Aluminium	1	Hirst.
		<u>CIRCLIPS.</u>			
		ref :: 1400-2- $\frac{1}{4}$	—	1	ANDERTON.
ML100	109	A. Gear Shifter fork	H.S. Plate	1	Briggs.
		<u>Pin.</u>			
		$\frac{1}{4}"$ dia x $\frac{1}{2}"$ long	Silver Sinter	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Spindle lock Assembly ML100/100A

DATE

15.4.66

TITLE: 5" Viceroy Metal Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SP	144	Spindle lock Handle - Body	M.S.	1	1/2" x 1" x 2 1/4"
"	145	" " Collar	"	1	3/4" O x 7/8"
SP	134	Locking Stud	M.S.	1	5/16" O x 2 5/8"
<u>B.O. Parts Required</u>					
<u>Knob</u>					
		1 1/4" O. x 5/16" whit. *	—	1	Mc millan.
<u>Dowel.</u>					
		1/4" Dia x 5/8" long	—	1	
<u>Skt hd Shoulder Screw</u>					
		1/2" dia x 1" long x 3/8" whit	—	1	Unbrako.
* On TDS111GB use 1" dia ball x 5/16" whit.					
<u>Spring Washer.</u>					
		1/2" dia std spring washer	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Cabinet Assembly ML100/200

DATE

24-3-65

TITLE: 5" Viceroy Metal Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML100	201	Motor Pulley	Aluminium	1	Casting
"	202	Levelling Screw	M.S.	4	Std. 5" set screw
"					
"	204	A Cabinet	Sheet Steel	1	12 SWG
"	205	" Drain plug	Md Iron	1	Casting
"	206	Tray	"	1	"
"	221	CONNECTING PIN SUPPORT	M.S.	1	2" x 1/2" x 2 1/4"
"	222	PIVOT PIN SUPPORT	"	2	1" x 1/2" x 2 1/4"
"	215	Reversing Switch Handle Oil Blue	M.S.	1	1" Dia x 2 5/16"
"	216	Adjustable Micro-switch Plunger	"	1	1/4" Dia x 1"
"	218	A & B Cabinet Doors	Sheet St.	each	16. SWG.
"	223	MOTOR ADJUSTMENT STOP	M.S.	1	3/8" x 3/4" x 3/4"
SP	110	Extension stud	M.S.	1	5/16" Whit x 1 1/2"
"	112	Cabinet base	C.I.	1	Casting
"	114	Motor platform	"	1	"
"	115	Connecting Pin	M.S.	1	3/4" Dia x 2 3/16"
"	116	Washer	"	1	3/4" Dia x 5/8"
"	117	Swing bolt	"	1	5/8" Dia x 4"
"	118	Swivel screw	"	1	1/2" Dia x 1 1/2"
"	119	Handle	"	1	5/16" Dia x 4 1/2"
"	120	Link	"	1	3/4" x 3/4" x 2"
"					
"					
"	123	Lock bracket	Sheet Steel	1	16 SWG
"	124	Pivot Pin	M.S.	1	3/8" Dia x 5 3/8"
"					
"					
"	106	Hinge bush	M.S.	4	1/2" sq x 1"
"	107	Top & Bottom hinges	"	4	Plate & bar
"	109	Micro-switch bracket	Sheet Steel	1	2 3/4" x 2" x 12 SWG
"	108	Link Pin	M.S.	1	5/16" Dia x 1 1/4"
"					
"					
"		* Only on TDS1/1GB & TDS1/1 P.C.S. is this item std. equipment.			
"					
"					

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

ASSY. DRG. No. Cabinet Assembly ML 100/200 B.O. Parts.TITLE: 5" Viceroy Metal Lathes

SHEET No.

1A

DATE

10-8-65

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Motor</u>			
		$\frac{3}{4}$ H.p. Single Phase ref: 2310-HAF-1633A		1	Hoover
OR		$\frac{3}{4}$ H.p. 3 Phase ref: 2543-HAF-1633B		1	Hoover
		<u>Starter Motor</u>			
		Single Phase ref: ATF 2DI	—	1	Brook
OR		3 Phase ref: ATF 3BI	—	1	"
		<u>'V' Belting</u>			
		Type 'A' $\frac{1}{2}$ " x 40" x 3" 4" long.	—	1	Brannet
		<u>Locking Latch</u>			
		Ref: 60002.	—	1	Leeman & Foster
		<u>Spring Latch & Stud.</u>			
		Latch ref: SRV/1637/17/0	—	1	Stenor
		Stud ref: SBV/1648/17/0	—	1	"
		<u>Micro - Switch</u>			
		Type D.S.3. - 521	—	1	Burgess
		<u>Split Pins</u>			
		$\frac{3}{32}$ " dia x $\frac{3}{4}$ " long	—	2	
		<u>Circlips</u>			
		Type External 1400/ $\frac{3}{16}$ "	—	2	Anderton

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. Cabinet Assembly ML100/200 B.O. Parts

DATE

10-8-65

TITLE: 5" Viceroy Metal Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Knobs.</u>			
		1 1/4" Dia x 5/16" whit	—	2	McMillan.
		<u>Set Screws.</u>			
		1/4" whit x 3/4" long	—	2	
		5/16" " x 1" long	—	4	
		3/8" " x 1/2" long	—	4	
		<u>Nuts</u>			
		1/4" whit	—	2	
		1/4" whit locknuts	—	2	
		5/16" whit	—	8	
		2 B.A	—	2	
		<u>Washers</u>			
		1/4" whit	—	2	
		5/16" "	—	8	
		3/8" "	—	4	
		<u>Self-Tapping Screws</u>			
		N° 6 c'sk x 5/16" long	—	4	
		N° 6 x 1/2" long	—	3	*
		" x 3/8" long	—	3	
		N° 8 x 1/2" long	—	4	
		<u>Cheese Hds.</u>			
		2 B.A x 1/2" long	—	2	
		<u>Double Cable Clips</u>			
		Ref x 104B	—	2	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 C

ASSY. DRG. No. Cabinet Assembly ML100/200 B.O. Parts

DATE

10-8-65

TITLE: 5" Viceroy Metal Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Grommets</u>			
		$\frac{3}{4}$ " dia (only 2 used on TDS1/1GB a TDS1/1PCS Lathes)	—	3	Ret Ford.
		<u>Grubs</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long kn. cup pt.	—	2	Unbrako.
		$\frac{3}{8}$ " whit x $\frac{1}{2}$ " long " " "	—	1	"
		<u>Reversing Switch</u>			
		Type A *	—	1	Dewhurst
		<u>Rubber Washers.</u>			Porter Ltd.
		Type 'Spot' $\frac{5}{16}$ " dia	—	4	Dewty.
		* These items are only filled on TDS1/1GB a TDS1/1 P.C.S. lathes as std. equipment			
		<u>Spring.</u>			
		$\frac{3}{4}$ " F.L., $\frac{9}{32}$ " O.D., 17 S.W.G., 8 C.P.L.	Spring Steel	1	Airedale
		<u>Mills Pin</u>			
		$\frac{1}{8}$ " dia x $\frac{3}{4}$ " long	—	1	
		<u>Ball</u>			
		$\frac{5}{16}$ " dia	—	1	
		<u>Plug.</u>			
		$\frac{1}{2}$ " B.S.P. Malleable	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 D.

ASSY. DRG. No. Cabinet Assembly ML100/200 B.O. Parts

DATE

18.9.68.

TITLE: 5" Viceroy metal lathes.

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
	<u>Fused Isolator.</u>			
	Ref: M.E.M. 310 KA.		1	Wholesale Electro.
	<u>Isolator</u>			
	Ref: MEM. 310 AX.		1	"
	<u>Extra Equipment For Isolators.</u>			
	2 BA CH:HD: screws $\frac{1}{2}$ " long.		3	Gregory Sutcliffe.
	$\frac{3}{4}$ " conduit hex locknut.	Steel	1	Wholesale Electro.
	$\frac{3}{4}$ " conduit Male Insert - LP Bush.	Brass	1	"
	$\frac{1}{4}$ " RH:HD: screws $\frac{3}{4}$ " long. (Fused Isolator only.)		4	Gregory Sutcliffe.
	Herga - Air Switch		1	
	Herga - Bellows		1	
S/P 103	Micro-Switch Bracket			
	2 - C/SUNK Head Screws		2	Gregory Sutcliffe.
	2 BA x $\frac{1}{4}$ " LONG.			

TITLE: 5" Viceroy Metal Lathe

SHEET No.

1

DATE _____

5 . 9 . 66

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>To be used with cabinet parts lists.</u>			
ML100	208A	Coolant Connecting Pipe	MS. pipe	1	1/2" o.d. x 12"
"	214A	Pump Connecting block	M.S.	1	1 1/4" sq x 3 1/2"
"	217	Impellor Housing	Alumin.	1	Casting.
"	220	Coolant block clamp	M.S.	1	1/16" x 1/4" x 1 1/16"
SP	101A	Coolant tank	Sheet Steel	1	12 swg.
SP	164	1/4" GAS TAILPIECE ADAPTOR.	M.S. HEX. BAR	5.	3/16" AF. x 2" LONG
MVS 100	226	COOLANT PIPE BRACKET	M.S.	1	1" x 1" x 2 1/8" L

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. ML100/200B. B.O. Parts.

DATE

5.9.66

TITLE: 5" Viceroy Metal Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt hd Cap Screws.</u>			
		5/16" whit x 1 1/4" long	—	1	Unbrako.
		<u>Self tapping Screws.</u>			
		N° 8 x 1/2" long	—	1	
		<u>Washers.</u>			
		5/16" dia. "(Spat)"	—	1	Dowty.
		<u>Elbows.</u>			
		90° " : 1/4" " " " "	—	2	
		<u>Belt</u>			
"Flexicot"		Endless belt 1/4" dia x 19 1/2" P.C.D.	—	1	Flexicon
		<u>Pump.</u>			
		Impellor Pump Unit	—	1	Hoover.
		<u>Tubing</u>			
		Clear Braided 1/4" I.D. x 50" long	—	1	GriFlex
		Clear 1/4" I.D. x 15" long	—	1	"
		<u>Pipe Fittings.</u>			
		REF: ENOTS 25 9440 00	—	1	ENOTS.
		<u>THUMBSCREW.</u>			"
		1/4" WHIT. x 1/2" LONG.	—	1	"

SHEET No

1

DATE

2. 11. 67

H H LID S S

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. Apron Assembly ML 100/300 B.O. Parts.

DATE

23.11.64

TITLE: 5" Viceroy Metal Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>OILERS.</u>			
		Ref LD $\frac{1}{4}$	—	2	Kingfisher
		<u>GRUBS</u>			
		2 BA x $\frac{1}{4}$ " long Knurled Cup Pt	—	2	Unbrako.
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long Knurled Cup Pt	—	1	Unbrako
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long Dog Pt	—	1	Unbrako
		<u>C'SK SCREWS</u>			
		c'sk screws 4 BA x $\frac{1}{2}$ " long	—	2	Unbrako
		Allen c'sk screw $\frac{1}{4}$ " whit x $\frac{1}{2}$ " long	—	1	Unbrako.
		<u>Handwheel.</u>			
		5" Dia Handwheel	—	1	Rencol
		<u>Pins</u>			
		$\frac{3}{16}$ " Dia x 2" long taper Pin	—	1	
		<u>Locknuts</u>			
		Std. $\frac{1}{4}$ " whit Locknuts	—	2	—
		<u>Washers</u>			
		Std $\frac{1}{4}$ " washer.	—	2	—

SHEET No.

1

DATE _____

26-3-65

H H L O S S

TITLE: 5" Viceroy Metal Lathe.

SHEET No

1A

DATE

21-2-67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt hd cap screws.</u>			
		2 B.A. x $\frac{1}{2}$ " long	—	5	Unbrako
		$\frac{1}{4}$ " whit x 1" "	—	3	"
		<u>Chart.</u>			
		CH101 - 24swg x $2\frac{3}{4}$ " x $1\frac{3}{4}$ "	Brass	1	Brig Engr.
		<u>Pins.</u>			
		$\frac{3}{16}$ " dia x 1" long	—	2	Mills Pins.
		<u>Rivets</u>			
		Hdn. brass rivets type 'U' x $\frac{3}{16}$ " long	—	4	
		<u>Washers.</u>			
		Std $\frac{1}{4}$ " spring washers	—	3	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. COUNTERSHAFT ASSEMBLY ML100/600

DATE

11.2.76.

TITLE: 5" VICEROY METAL LATHE.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML100	602	COUNTERSHAFT PULLEY.	ALUMINIUM	1	CASTING.
SP128	C	BRACKET.	C.I.	2	CASTING.
SP129	A	SPINDLE.	M.S.	1	1 1/4" DIA. x 6 1/2"
SP161	A	ADJUSTING SCREW.	"	2	5/16" DIA x 2 1/2"
		B.O. PARTS REQUIRED.			
		BEARINGS.			
		DEEP GROOVE REF: 6205ZZ	—	2	FAG.
		GIRDLIPS.			
		EXTERNAL REF: - 1400/25MM	—	2	ANDERTON
		INTERNAL " " - 1300/52MM	—	2	"
		GEN. SKT. HD. SCREWS			
		3/16" WHIT x 3 1/4" LONG	—	4	UNERAC
		VEE BELT.			
		1" x 1/2" x 40" x 4" - 2 1/2" LONG	—	1	BRAMMER.
		NUTS			
		STD. 5/16" WHIT	—	4	
		WASHERS.			
		STD. 3/16"	—	4	
		PINS.			
		1/8" DIA. x 7/8" LONG SEL-LOK	—	2	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Tailstock Assy ML 100/700

DATE

TITLE: 5" Viceroy Metal Lathe.

26-3-65

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE	
ML100	701	Body	CI	1	Casting	
"	702	Shoe	"	1	"	
"	705	A/B Tailstock Barrel	A-English, B-Metric.	M.S.	1	15 ¹ / ₁₆ " D. x 11 ¹ / ₄ "
SP	131	5" Handwheel	C.I.	1	Casting	
"	132	Bush	Chrome Plate.	CI.	1	"
"	133	Clamp Handle	Oil blue.	M.S.	1	7 ¹ / ₁₆ " Dia x 4 ¹ / ₂ "
"	134	Locking Stud.	"	1	5 ¹ / ₁₆ " Dia x 2 ⁵ / ₈ "	
"	135	Clamp Pad.	"	1	1 ¹ / ₂ " x 1 ¹ / ₂ " x 2 ¹ / ₄ "	
"	137	Hard Centre	Cast Steel	1	Casting	
"	138	Tee key	K.S.	1	1 ¹ / ₄ " DIA x 5 ¹ / ₈ "	
"	139	A Top Locking Clamp	Brass	1	1 set from	
"	"	B Bottom " "	"	1	5 ¹ / ₈ " Dia x 2 ³ / ₄ "	
"	140	A Locking Handle	M.S.	1	3 ¹ / ₄ " D. x 2 ¹³ / ₁₆ "	
"	147	Clamp Eccentric	M.S.	1	3 ¹ / ₄ " D. x 3 ¹ / ₁₆ "	
"	148	" Pin	"	1	7 ¹ / ₈ " D. x 4 ¹ / ₂ "	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. Tailstock Assembly ML100/700 B.O. Parts.

DATE

26-3-65

TITLE: 5" Viceroy Metal Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Cap Screws.</u>			
		1/4" wh x 1/2" long	—	3	Unbrako
		<u>Grubs.</u>			
		2 B.A. x 1/4" long Kn cup pt	—	1	Unbrako
		1/4" wh. x 1/2" long Dog pt	—	1	"
		<u>Std. Hex Nuts.</u>			
		3/8" whit. (Wedgelock)	—	1	G.K.N.
		<u>Knobs.</u>			
		1 1/4" dia. topped 5/16" whit Cream	—	1	McMillan
		<u>Cirdips</u>			
		Ref. 5108/156	—	1	Salter
		<u>Sq. hd. Screws</u>			
		5/16" whit x 2" long - Dog pt.	—	2	Unbrako.
		<u>Oiler</u>			
		L.D. 1/4"	—	1	Kingfisher
		<u>Washer</u>			
		3/8" whit	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. GENERAL ART. ML.100/801.

DATE

TITLE: 5" VICEROY METAL LATHE - SINGLE WAY TOOLPOST

4.1.78

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML.100	801	TOOLPOST BODY	Mal. Iron.	1	
..	802	TENON	MS	1	
..	803	TOOLPOST STUD	MS	1	
..	805	TOOLPOST HANDLE - CAP.	MS	1	
SP.	142	HANDLE.	MS	1	
<u>B.O. PARTS.</u>					
<u>SQ. HD. SCREWS.</u>					
M8 x 30 LONG.				3	
<u>PLASTIC KNOB</u>					
REF: 1032.				1	RENOL

SHEET No.

1

DATE _____

4.1.78

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML.100	801	A. TOOLPOST BODY	MS	1	
1 "	802	TENON	MS	1	
"	803	TOOLPOST STUD	MS	1	
"	805	TOOLPOST HANDLE - CAP	MS	1	
SP.	142	HANDLE	MS	1	
<u>B.O. PARTS.</u>					
<u>SQ. HD. SCREWS</u>					
MB x 30 LONG.				6	
 <u>PLASTIC KNOB.</u>					
REF: 1032				1	RENCOL

SHEET No.

DATE _____

19-4-66

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML105	100	Headstock Assembly			
"	100	A End Drive Assembly			
"	100	B Feedbox Assembly			
"	100	C Reversing Brkt Assembly			
ML100	100	A Spindle-Lock Assembly - As Metal Lathe			
"	200	Cabinet Assembly - As Metal Lathe			
"	200	B Coolant Assembly - As Metal Lathe			
ML105	300	Apron Assembly			
"	400	Bed Assembly			
ML100	500	Compound Assembly - As Metal Lathe			
"	600	Countershaft Assembly - As Metal Lathe			
"	700	Tailstock Assembly - As Metal Lathe			
"	800	Toolpost Assembly - As Metal Lathe			

TITLE: 5" Viceroy Screwcutting Lathe.

SHEET No.

1A

DATE _____

14.4.66

[illegible]

TITLE: 5" Viceroy Screwcutting Lathe.

SHEET No.

1 B

DATE _____

14.4.66

[illegible]

See ML100/100 - Sheet 1B

FORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

Y. DRG. No. SP100.

SHEET No.

1

DATE

6.1.65

LE: Standard Parts (Used on one or more m/c's.)

No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
101	Coolant tank	Sheet steel	1	12 swg
102				
103	D Locking Handle	M.S.	1	$\frac{3}{4}$ " Dia x $2\frac{13}{16}$ "
103B	Locking Stud.	M.S.	1	$\frac{3}{8}$ " Dia x $1\frac{3}{4}$ "
103C	Pad.	Brass.	1	$\frac{1}{4}$ " Dia x $\frac{1}{2}$ "
106	Hinge Bush	M.S.	2	$\frac{1}{2}$ " sq x 1"
107	Door Hinge	"	2 or 4	bar & plate.
108	Link Pin.	"	1	$\frac{5}{16}$ " Dia x $1\frac{1}{4}$ "
109	Micro-switch Bracket	Sheet Steel	1	12 swg.
110	Extension Stud. (Std. Set Screw)	M.S.	1	$\frac{5}{16}$ " Whit x 1"
112	Soft Centre	M.S.	1	1" Dia x $4\frac{5}{8}$ "
113	Base plate	C.I.	1	Castings
114	Motor Platform	C.I.	1	Castings.
115	Connecting Pin	M.S.	1	$\frac{3}{4}$ " Dia x $2\frac{3}{16}$ "
116	Washer	M.S.	1	$\frac{1}{4}$ " Dia x $\frac{5}{8}$ "
117	Swing Bolt	"	1	$\frac{5}{8}$ " Dia x 4"
118	Snivel screw	"	1	$\frac{1}{2}$ " Dia x $1\frac{1}{8}$ "
119	Handle	"	1	$\frac{5}{16}$ " Dia x $4\frac{1}{2}$ "
120	Link	"	1	$\frac{3}{8}$ " x $\frac{3}{4}$ " x 2"
121	Stud	"	8	$\frac{5}{16}$ " Dia x $1\frac{5}{8}$ "
122	Cabinet Door	Sheet Steel	1	16 swg
123	Lock Bridges	Sheet Steel	1	16 swg.
124	Pivot Pin	M.S.	1	$\frac{3}{8}$ " Dia x $5\frac{3}{8}$ "
128	A Countershaft Bracket	C.I.	2	Castings
129	A Countershaft Spindle	M.S.	1	$1\frac{1}{4}$ " Dia x $6\frac{1}{2}$ "
130				
131	Tailstock Handwheel	C.I.	1	Castings
132	" Bush	"	1	"
133	" Clamp Handle Oil Blue.	M.S.	1	$\frac{7}{16}$ " Dia x $4\frac{1}{2}$ "
134	Locking Stud	"	8 or 1	$\frac{5}{16}$ " Dia x 2"
135	Tailstock Clamp Pad.	"	2	$2\frac{1}{4}$ " x 1"

ASSY. DRG. No. CH 100 Nameplates etc.

DATE

29-12-65

TITLE: Viceroy Machines.

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
100	M.L., W.L. etc - Nameplate	Brass	1	Br. Eng.
101	" " - Lubrication Chart	"	1	" "
102	" - Spindle Speed Chart	"	1	" "
103	" - Back Gear Chart	"	1	" "
104	" - Spindle Lock Plate	"	1	" "
105	" - F.S. & L.S. Selection Chart	"	1	" "
106	" - Change Lever Chart	"	1	" "
107	" - Quad. Sliding Gear "	"	1	" "
108	" - Top Lever & Dial Warning "	"	1	" "
109	" - Special Fine Feed Chart	"	1	" "
110	" - Gear Box Feed Chart	"	1	" "
111	" - " " Metric Transposing Gear Chart	"	1	" "
112	" - P.C.S. & Scr. English Thread Chart	Alum.	1	" "
113	" - Scr. Metric Thread Chart	Brass	1	" "
114	W.L. - Spindle speed chart	"	1	" "
115	16" Sh. - Nameplate	"	1	" "
116	10" Sh. - "	"	1	" "
117	16" Sh. - Dial	"	1	" "
118	16" & 10" Sh. - Lubrication Chart	"	1	" "
119	10" & 12" Gr. - Water Chart	"	1	" "
120	M.L., P.C.S. - Metric screw & power Feed Chart	"	1	" "
121	Turnmill Quill - Nameplate	"	1	" "
122	" Std Units - Fan Warning Chart	"	1	" "
123	" " " - Lubrication "	"	1	" "
124	" - Powerlock Chart	"	1	" "
125	" Quills Std. - Manufacture's Nameplate	Alum.	1	Casting
126	" Std Unit - Nameplate	"	1	"
127	" Quill - Patent No Chart	Brass	1	Br. Eng.
128	" R.A.A.-2:1, Power Capacity Warning Plate	"	1	" "
129	Grinders - Tool Grinder - Angle Indicator	"	1	" "
131	W.L. - Spindle Lock Plate	"	1	" "
130	Sharpedges - Lubricant Label	"	1	" "
132	Treadle Lathe Nameplate	"	1	" "

* Order these from Esso

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. SP100

DATE

9.5.86

TITLE: Standard Parts.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SP	136				
"	137	Hard Centre	Cast Steel	1	Casting.
"	138	Tee Key	Key Steel	1	1/4" sq x 5/8"
"	139	A & B Top & Bottom Locking Clamp	Brass	1	5/8" D. x 2 1/8"
"	140	A Locking Handle	M.S.	1	3/4" D. x 2 13/16"
"	142	Handle	M.S.	1	7/16" D x 3 1/2"
"	143	Rear Nose Cap.	Alum	1	Casting
"	144	Spindle Lock Handle - Body	M.S.	1	1/2" x 1" x 2 1/4"
"	145	" " Collar	"	1	3/4" D. x 7/8"
"	146	Cover Plate	Sh. St.	1	12 swg.
"	147	Clamp Eccentric	M.S.	1	3/4" D. x 3 1/16"
"	148	" Pin	"	1	7/8" D. x 4 1/2"
"	149/1	Dust extractor case 1 1/2" x 19" x 1 1/2"	Sh. St.	5x1	16" x 22" x 1 1/2"; 16" x 7" x 3/4"; 8" x 8" x 1/2"; 12 1/2" x 19"
"	149/2	Bottom case cover	M.S.	1	8" x 8" x 1/8"
"	149/3	Dust bag	Nylon	1	-
"	149/4	Dust bag baffle plate	M.S.	2x1	7" x 7" x 1/32"; 1 1/2" x 18" x 1/2"
"	149/5	Extractor case top cover	M.S.	3x1	8" x 8" x 1/32"; 1 1/2" x 10" x 1/2"
"	150	Front Nose cap.			
"	151	Spindle lock retaining screw			
"	152	Travelling steady T. bolt.			
"	153	" Eyesheild "			
"	154	Twin Foot Knock off:- Foot			
"	155	" " " Foot Bass			
"	156 A	" (WL) " Bar			
"	156 B	" (Grinder & Polisher) " Bar			
"	156 C	" (12" Grinder) " Bar			
"	157	" " Micro switch Trip.			
"	158	" " Balance weight.			
"	159				
"	160				
"	161	Countershaft spindle adjusting Screw.			
"	159	Micro Switch Brk. Plate.	Sh. Steel	1	2 7/8" x 2" x 1/16"

SHEET No.

2

DATE

19.9.66

	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
33	3" Grinder Safe Spindle Speed	—	1	Metal-Cal
134	10" " " " "	—	1	" "
35	12" " " " "	—	1	" "
136	Indicator plate ML. 2 speed Fld box	Brass	1	Brig Engr.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. CH100

DATE

16-8-65

TITLE: Old drg nos For Chart N^o's.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
CH	100	was SP143			
"	101	" GM102 /45			
"	102	" ML 115/968 A & B.			
"	103	" ML 100 / 130			
"	104	" ML 105/146			
"	105	" ML 110/115			
"	106	" ML 115 /967			
"	107	" ML 115/966			
"	108	" ML 115/965			
"	109	" ML 111 /4			
"	110	" ML 115/964			
"	111	" ML 114 /8			
"	112	"			
"	113	"			
"	114	"			
"	115	" SH5003/27			
"	116	" SH100 -30			
"	117	" SH5003/28			
"	118	"			
"	119	" GM114/7			
"	120	"			
"	121	"			
"	122	"			
"	123	"			
"	124	"			
"	125	" FM 5000 / 28			
"	126	" FM 5000 / 12			
"	127	"			
"	128	NEW			
"	129	"			
"	130	"			
"	131	"			
"	132	"			
"	133	"			
"	134	"			
"	135	"			

SHEET No

ASSY. DRG. No. CH100

1B

TITLE: Old drug no's. Per chart no's.

DATE _____

29-11-66

[illegible]

SHEET No. 1.

DATE
21. 12. 7

21. 12. 7

HH LTD S/P 8791

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A.

ASSY. DRG. No. CL100 (B.O. Parts).

DATE

21.12.71

TITLE: $\frac{1}{2}$ / $\frac{1}{3}$ H.P. Clutch Unit.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		Fly-wheel Fan ref:-730060.	—	1	Weaver.
SK27A		Motor-1ph or 3ph ($\frac{1}{2}$ / $\frac{1}{3}$ H.P.)	—	1	"
		<u>Clutch Unit.</u>			
		Brake ref:- 86-121-06-A1	—	1	Binder.
		Clutch" :- 86-051-06002.	—	1	"
		Armature & Hub. ref:- 86-000-06-A1500	—	1	"
		Clutch/Brake Outlet plug/grommet.	—	1	$\frac{3}{8}$ " dia.
		<u>Bearings.</u>			
		Ref :- 6202ZZ (Sealed for life).	—	2	Fag.
		<u>C/Clips.</u>			
		Type 1400/15mm. (External).	—	1	Anderton
		" 1300/35mm. (Internal).	—	1	"
		$7\frac{1}{2}$ " dia Jubilee Clip. (CAD.)	—	2	—
		<u>Nuts.</u>			
		$\frac{1}{2}$ " B.S.F. (L.H.) Nyloc Nut.	—	1	
		$\frac{1}{4}$ " Whit.	—	2	
		2 B.A.	—	4	
		$\frac{1}{4}$ " B.S.F.	—	4	
		<u>Washers.</u>			
		Std. $\frac{1}{4}$ " dia.	—	9	
		" $\frac{1}{2}$ " dia.	—	1	
		" $\frac{3}{16}$ " Split washer	—	4	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18.

ASSY. DRG. No. CL100 (B.O. Parts).

DATE

21. 12. 71.

TITLE: $\frac{1}{2}$ / $\frac{1}{3}$ H.P. Clutch Unit.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>SK'T HD. Button Hd. Screw.</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long.	—	4	
		2 B.A. x $\frac{5}{8}$ " long. (UNBRAKO)	—	1	
		<u>Set Screws.</u>			
		$\frac{1}{4}$ " whit x $1\frac{1}{4}$ " long.	—	4	
		<u>Label.</u>			
		'Trustop.	—	1	
		<u>Keys.</u>			
		$\frac{1}{8}$ " Sq. x $5\frac{1}{8}$ " long.	—	2	
		$\frac{1}{8}$ " " x $3\frac{1}{4}$ " "	—	1	
		<u>Pins.</u>			
		Self-lac Pin $\frac{1}{8}$ " dia x $3\frac{1}{4}$ " long	—	1	
CL100	1A	Drive End Frame.	—	1	
"	2A	" " " Cover.	—	1	
"	3	Over/All Unit Cover.	—	2	Armshire
"	15	Aluminium Ref:- 384 H.R.	—	2	Expamet
"	16	Terminal Box Cover.	—	1	Armshire
"	17	Trans/Rect. Unit & Powder Puff.	—	1	Herga.
		<u>Grommets.</u>			
		$3\frac{1}{4}$ " dia.	—	2	
		$3\frac{1}{8}$ " dia.	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. SM100 HEADSTOCK ASSEMBLY

DATE

TITLE: TDS 25 VICEROY DISC & BELT SANDING MK

19-2-73

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SM100	1A	MAIN SPINDLE-TDS 25	M.S.	1	1 1/2" Ø x 11 1/8"
"	1B	" " -TDS 25 DD	"	1	1 1/4" Ø x 12 1/2"
"	1C	" " -TDS 25 DBS	"	1	1 1/4" Ø x 10"
"	2	BELT DRIVING DOG OBSOLETE	"	1	1 5/8" Ø x 1 1/2"
"	3	" DRIVEN DOG "	"	1	1 5/8" Ø x 7/8"
"	4	" MALE SWIVEL PLATE	G.I.	1	CASTING
"	5	" FEMALE SWIVEL PLATE	G.I.	1	"
"	6	" RETAINING TAB	STEEL TUBE	1	1 1/2" Ø x 5 3/4" x 1/2"
"	7	" BACKPLATE	ALUM	1	CASTING
"	8	" " " SWIVEL BRKT	M.S. PLATE	1	7 1/2" x 4" x 1/2"
"	9	" " " BRACKET	G.I.	1	CASTING
"	10	" " " SUPPORT ARM	M.S.	1	1/2" x 3/8" x 2 1/4"
"	11	" DUST FUNNEL & GUARD	M.S. PLATE	1	20 S.W.G.
"	12	DUST NOZZLE ADAPTOR	STEEL TUBE	2	1 1/2" Ø x 1 5/16" x 1"
"	13	DISC ADAPTOR (L.H. THRD)	M.S.	1	1 3/4" Ø x 2"
"	14	A) OBSOLETE REPLACED BY SM100/38			
"	15	DISC OUTER END COVER	G.I.	1	CASTING
"	16	A) OBSOLETE REPLACED BY SM100/31			
"	17	DISC TABLE SUPPORT	G.I.	2	CASTING
"	18	DISC TABLE	G.I.	1	CASTING
"	19	OBSOLETE			
"	20	OBSOLETE			
"	21	A) OBSOLETE REPLACED BY SM100/39			
"	22	BELT BACKPLATE BRKT (R.H. UNIT)	G.I.	1	CASTING
"	23	" SANDER END GUARD	S. STEEL	1	18 S.W.G.
"	24	" " GUARD	SHEET STEEL	1	18 S.W.G.
"	25	DISC ADAPTOR (R.H. THREAD)	M.S.	1	1 3/4" Ø x 2"
"	26	SANDING DISC (R.H. THREAD)	ALUM	1	CASTING
"	27	SPINDLE PULLEY	G.I.	1	"
"	28	MOTOR PULLEY	ALUM	1	"
"	29	A) DISC RETAINING COVER	M.S.	1	2 1/2" Ø x "
"	30	TIE BAR FOR BELT UNIT	M.S.	1	1" x 3/4" x 14"
"	31	HEAD STOCK	G.M108/2	1	
"	37	DISC TABLE SIDE SUPPORT	G.I.	1	CASTING
"	38	DISC GUARD	SHEET STL	1	14 S.W.G.
"	39	DISC DUST FUNNEL	" "	1	20 S.W.G.

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 $\frac{1}{4}"$
"	6	Front " "	"	1	2"sq. x $\frac{1}{8}"$
"	7	Bearing Spacer.	M.S.	1	$\phi 7\frac{1}{8}" \times 15\frac{1}{8}"$
"	8	Grinding Wheel Hub.	Hall. Iron	1	$\phi 2\frac{1}{4}" \times 1\frac{1}{4}"$
"	9	Locking Ring.	" "	1	$\phi 2\frac{1}{4}" \times \frac{1}{2}"$
"	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	$5\frac{1}{4}" \times 3\frac{1}{4}" \times \frac{1}{16}"$
"	14	Compound Slide Gib Strip.	"	1	$6\frac{1}{8}" \times 3\frac{1}{4}" \times \frac{1}{16}"$
"	15A	T/Slide & C/Slide Feednut (English)	Phos. Bro.	2	$\phi 7\frac{1}{8}" \times 1\frac{1}{8}"$
"	15B	" " " " (Metric)	"	2	" x "
"	16	Compound Slide End Plate.	C.I.	1	Casting.
"	17	Top Slide " "	"	1	"
"	18	Corner Block.	M.S.	1	$13\frac{1}{4}" \text{sq.} \times 5\frac{1}{8}"$
"	19	Collet Block Location Pin.	EN8	1	$\phi 3\frac{1}{8}" \times 13\frac{1}{4}"$
"	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	$\phi 3" \times 13\frac{1}{8}"$
"	23	Locknut.	M.S.	1	$\phi 2\frac{1}{4}" \times 3\frac{1}{4}"$
"	24	Location Pin. REDRAWN 12-2-73	Silver St.	1	$\phi \frac{1}{4}" \times 2\frac{3}{4}"$
"	25	Lever	B.D.H.S.	1	$\phi 3\frac{1}{16}" \times 13\frac{1}{16}"$
"	26	Drill Location Bar.	"	1	$\phi 7\frac{1}{16}" \times 5"$
"	27	" " Plate REDRAWN 4-4-73	M.S. Plate	1	$2\frac{1}{4}" \times \frac{1}{2}" \times \frac{1}{16}"$
"	28	Collet Block Swivel Pin REDRAWN 9-2-73	Silver St.	1	$\phi 5\frac{1}{8}" \times 13\frac{1}{4}"$
"	29	Drill Location Bar Housing. REDRAWN 4-4-73	M.S. & pbt	1	See Drg.
"	30	Location Pin Handle.	M.S.	1	$\phi 7\frac{1}{16}" \times 3\frac{1}{4}"$
"	31	Brg. Housing Swivel Pin	"	1	$\phi 3\frac{1}{4}" \times 2\frac{1}{4}"$
"	32	Wheel Guard.	Sh. Steel	1	20 S.W.G.
"	33	Pulley "	" "	1	" "
"	34	Friction Plates.	M.S.	2	$\phi 13\frac{1}{8}" \times \frac{1}{4}"$

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. DSM100

DATE

4.10.72

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

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	$2\frac{1}{8} \times 1\frac{3}{4} \times 1\frac{1}{2}$
"	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 1/2
"	509B	" (Metric)	"	2	" x "
"	510A	" Bush.	"	2	$\phi 1\frac{5}{16} \times 1\frac{1}{4}$
"	515	Top & Cross Slide Brg' Coller	"	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	$1\frac{1}{2} \times \frac{1}{2} \times 4$
"	47	SPIGOT FOR GENTRE CARRIER	M.S.	2	$1" \phi \times 2\frac{1}{4}$
"	48	CENTRE	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 : 16 X L037F.	—	1	Kenyon
		" " : 32 X L037.	—	1	"
		Belt ref : 90 X L : 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.

18

ASSY. DRG. No. DSM 100

DATE

6.10.72

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

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.

1C.

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

DATE

6.10.72

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

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>			
		Multibore range: 3mm (1/8") to 25mm (1")	—	8	Crawford
			ORSOLETE	44-73	
		<u>Hand wheel.</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.
		<u>CHUCK.</u>			
		1/2 JAW SELF CENTRING 85mm		1	FRATT BURN
		DIA CHUCK CAPACITY 1.5mm-25mm			

SHEET No.

DATE _____

19.4.66

RG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
100	100	Headstock Assembly			
"	100 A	Spindle - Lock Assembly			
"	100 B	Feedbox Assembly			
"	200	Cabinet Assembly			
"	200 B	Coolant Assembly			
"	300	Apron Assembly			
"	400	Bed Assembly			
"	500	Compound Assembly			
"	600	Counter-shaft Assembly			
"	700	Tailstock Assembly			
"	800	Toolpost Assembly			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. Headstock Ass. ML105/100 B.O. Parts.

DATE

14.4.66

TITLE: 5" Viceroy Screwcutting Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Dowel.</u>			
	*	1/4" d x 2" long taper pin	—	2	
		3/16" dia x 1" long	—	2	
	*	3/8" d x 1" long hdn	—	1	
		<u>Scr. Slot Cheese Hd.</u>			
		2 B.A. x 1/2" long	—	6	Unbrako.
		<u>Micro-Switch.</u>			
		Ref DS3 - 521	—	1	Burgess
		<u>S'kt hd. C'sk Screws.</u>			
		2 B.A x 3/16" long	—	6	
		2 B.A. x 1/2" long	—	6	
		<u>Hinge.</u>			
		ref: 1838: 1 1/2" wide open x 2 1/2" long x 16 way.	—	2	TCNS.
		* These pins are drilled & fitted to the bed & h'dstock when all tests are finished.			
		<u>Nat Nylon Pegaline Catchers</u>			
		ref: GB.1166	—	1	Greenman & Berger
SP150		Front Nose Cap	Aluminium	1	Hirst.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. End Drive Assembly ML105/100A

DATE

15.4.66

TITLE: 5" Viceroy Screwcutting Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML105	110	Quadrant	CI	1	Casting
"					
"	112	Quadrant Intermediate Stud. Cyanide Hdn	MS	2	1" D x 2 7/16"
"	113	Spacing Bush " "	"	2	1" D x 1 1/4"
"	117	Washer	"	3	Std 7/16" washer
"	118	Guard	Alum.	1	Casting
"	118 B	Swing Cover Plate	Sheet St.	1	13 1/4" D. x 12 swg.
"	119	16 T. Change Wheel.	M.S.	1	1 1/8" D x 5/8"
"	120	18 T. " " Coupled.	"	2	1 1/4" D x 1"
"	121	24 T. " "	"	1	1 1/2" D x 5/8"
"	122	32 T. " "	"	1	2" D x "
"	123	36 T. " "	"	1	2 1/4" D x "
"	124	40 T. " "	"	1	2 1/2" D x "
"	125	44 T. " "	"	1	2 5/8" D x 5/8"
"	126	46 T. " "	CI	1	Casting
"	127	48 T. " "	"	1	"
"	128	52 T. " "	"	1	"
"	129	54 T. " "	"	1	"
"	130	56 T. " "	"	1	"
"	131	60 T. " "	"	1	"
"	132	72 T. Gear	"	1	"
"	133	80 T. Change Wheel	"	1	"
"	140 A	100 T. Gear	"	1	"
"					
"	145	Guard Fill-in Plate	Sh. Steel	1	12 swg.
"	152	66 T. Gear.	C.I.	1	Casting.
CH160		Screw Thread Chart	Alum.	1	See B.O.
		<u>Additional Wheels Req. For Metric Threads.</u>			
ML105	135	18 T. Change Wheel.	MS	1	1 1/4" D x 5/8"
"	136	20 T. " "	"	1	1 1/4" D x "
"	137	22 T. " "	"	1	1 3/8" D x "
"	138	26 T. " "	"	1	1 5/8" D x "
"	139	28 T. " "	"	1	1 3/4" D x "
"	140	100 T. " "	CI	1	Casting.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. End Drive Assembly ML105/100A.

DATE

15.4.66

TITLE: 5" Viceroy Screencutting Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML105	146	127T/100T change wheel	CI	1	Cast ing
		<u>Change Wheels req. when Metric only fitted.</u>			
ML105	119	16 T. Change Wheel.	MS	1	1 1/8" D x 5/8"
"	120	18 T. " "	"	1	1 1/4" D x 1"
"	121	24 T. " "	"	1	1 1/2" D x 5/8"
"	122	32 T. " "	"	1	2" D x "
"	123	36 T. " "	"	1	2 1/4" D x "
"	124	40 T. " "	"	1	2 1/2" D x "
"	125	44 T. " "	"	1	2 5/8" D x "
"	126	46 T. " "	CI	1	Cast ing
"	128	52 T. " "	"	1	"
"	129	54 T. " "	"	1	"
"	130	56 T. " "	"	1	"
"	132	72 T. Gear	"	1	"
"	133	80 T. Change wheel.	"	1	"
"	134	80 T. Gear	CI	1	"
"	135	18 T. Change Wheel.	MS	1	1 1/4" D x 5/8"
"	136	20 T. " "	"	1	1 1/4" D x "
"	137	22 T. " "	"	1	1 3/8" D x "
"	138	26 T. " "	"	1	1 5/8" D x "
"	139	28 T. " "	"	1	1 3/4" D x "
"	140	100 T. " "	CI	1	Cast ing
"	141	100 T. Gear	"	1	"
"	142	127 T. " "	"	1	"
"	146	127/100T Gear	"	1	"
		<u>B.O. Parts Required.</u>			
		<u>Nuts.</u>			
		Std 7/16" whit - Harden.	—	3	
		<u>Collar hd. Sq. Set Screw.</u>			
		3/8" whit x 2" long	—	1	Unbrako.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No

3

ASSY. DRG. No. End Drive Assembly ML105/100A

DATE

15.4.66

TITLE: 5" Screwcutting Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt hd. c'sk screws.</u>			
		4 BA x 1/2" long <u>Scr. Slot Cheese hds</u>	—	1	Unbrako.
		2 B.A. x 1/2" long	—	5	Unbrako.
		<u>Self tapping screws.</u>			
		Nº 6 x 3/8" long	—	1	
		<u>Rivets.</u>			
		Hdn brass type U x 3/16" long	—	4	
		<u>Knob.</u>			
		1 1/4" Dia x 5/16" whit	—	1	Mc millan.
		<u>Set Screw.</u>			
		5/16" whit x 3/4" long	—	1	
		<u>Chart.</u>			
		CH 160 - 22 swg. x 5 1/8" x 5 1/16"	Alum.	1	Brig Eng.

TITLE: TDS 1. 5" Viceroy Screwcutting Lathe

SHEET No.

DATE _____

21.2.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML105	405	Feed box	C.I.	1	Casting
ML105	111	Quadrant Bracket	C.I.	1	Casting
"	402	Leadscrew	M.S.	1	3/4" Dia x 45"
"	403	" Collar	"	1	1 1/4" Dia x 3/4"
"	404	Spacing Collar	"	1	1" Dia x 5/8"
CH	102	Spindle Speed Chart	Brass	1	See B.O. Parts.

SHEET No.

1A.

DATE _____

21. 2.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Rivets.</u>			
		Hdn. brass rivets type 'U' x $\frac{3}{16}$ " long	—	4	
		<u>Skt hd cap screws</u>			
		$\frac{1}{4}$ " whit x $1\frac{1}{2}$ " long	—	2	Unbrako
		<u>Scr. slot cheese hd.</u>			
		2 B.A. x $\frac{1}{2}$ " long	—	2	Unbrako.
		<u>Oilers.</u>			
		Ref L.D. $\frac{1}{4}$ "	—	2	Kingfisher
		<u>Key.</u>			
		$\frac{1}{8}$ " sq x $\frac{1}{16}$ " long	—	1	Key Steel.
		<u>Chart.</u>			
		CH102 - 24 swg x $2\frac{3}{8}$ " x $3\frac{1}{2}$ "	Brass	1	Brig Engr.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No

1

ASSY. DRG. No. Reversing Bracket Arrangement ML105/100C

DATE

30.7.66

TITLE: T.D.S.1/1PCS & T.D.S.1 5" Viceroy Screwcutting Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML105	101	Reversing Bracket	CI	1	Casting
"	102	Intermediate Stud	M.S.	1	1" Dia x 3 ⁵ / ₁₆ "
"	104	Reversing bracket stop	"	1	" x 3/4"
BVS 115	993	Locating Pin Plunger	Silver Steel	1	1/2" dia x 2 ³ / ₄ "
ML105	107	28T. Reversing Gear	M.S.	2	15/8" dia x 3/4"
"	108	38T. Stud Gear	M.S.	1	2 1/8" dia x 7/8"
"	117	Bright Washer	"	1	Std 7/16" washer
"	119	16T. Change Wheel. *	"	1	1 1/8" dia x 5/8"
MVS 105	109	IDLER STUD.	"	2	3/4" dia. x 1 7/8"
		* For list of other std. stud gears see CH112.			
		<u>B.O. Parts Required.</u>			
		<u>Nuts.</u>			
		Std. 7/16" whit nut	—	1	
		" 5/16" " locknuts	—	2	
		<u>Key.</u>			
		1/8" sq x 15/16" long	—	1	
		<u>Knob.</u>			
		REF: VTR.40B M8	—	1	ELESA
		<u>Skt hd Cap Screw.</u>			
		2 B.A. x 5/8" long	—	1	Unbrako.
		<u>Oiler</u>			
		Ref L.D. 1/4"	—	1	Kingfisher
		<u>Spring</u>			
		7/16" O.D. x 11/16" F.L. x 6 C.P.I. 17swg. Ground Ends		1	
		<u>BEARING</u>			
		REF:- 60002RS		2	FAG.
		C/CLIP REF:- 1300/1"		2	ANDERTON.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Spindle lock Assembly

DATE

TITLE: 5" Viceroy screwcutting Lathe

15.4.66

[illegible]

SHEET No.

DATE _____

CUT OFF SIZE

[illegible]

TITLE: 5" Viceroy Screwcutting Lathe

SHEET No.

i

DATE _____

[illegible]

SHEET No.

1

DATE _____

8. 11. 67

M M L'P 5 5

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. Apron Assembly ML105 B.O. Parts

DATE

25.11.64

TITLE: 5" Viceroy Screwcutting Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>OILERS</u>			
		Ref. LD $\frac{1}{4}$	—	2	King Fisher
		<u>GRUBS.</u>			
		2 BA x $\frac{1}{4}$ " long Cup Pt	—	2	Unbroko.
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long Knurled Cup Pt	—	1	"
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long Dog Pt	—	1	"
		$\frac{5}{16}$ " whit x $\frac{1}{4}$ " long Dog Pt	—	1	"
		<u>C'SK SCREWS</u>			
		Allen c'sk screw $\frac{1}{4}$ " whit x $\frac{1}{2}$ long	—	1	Unbrako
		<u>Handwheel</u>			
		5" Dia Handwheel	—	1	Rencol.
		<u>SPRING</u>			
ML105	305	$\frac{3}{16}$ " O.D. x $\frac{9}{64}$ " I.D. x $\frac{7}{16}$ " F.L x 24swg. x 6 coils	Spring Steel	1	Airdale
		<u>Washers</u>			
		Std. $\frac{1}{4}$ " washer	—	2	—
		<u>Nuts.</u>			
		Std $\frac{5}{16}$ " whit. nuts	—	2	Sutcliffe.
		Std $\frac{1}{4}$ " whit locknut	—	2	
		<u>Pins.</u>			
		5/16" D x 3/4" long Sel-lok pins	—	2	Unbrako.
		3/16" D x 2" long Taper Pin	—	1	

SHEET No.

1

DATE _____

21.2.67

H H L D S S

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. Bed Assy. ML105/400

B.O. Parts

DATE

21.2.67

TITLE: 5" Viceroy Screwcutting Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt hd Cap screws.</u>			
		2 B.A. x $\frac{1}{2}$ long	—	5	Unbrako
		5 $\frac{1}{16}$ " Whit x 1" "	—	1	"
		$\frac{1}{4}$ " " x 1" "	—	3	"
		<u>Oilers</u>			
		L.D. $\frac{1}{4}$ "	—	1	Kingfisher
		<u>Chart.</u>			
		CH101 - 24swg x $2\frac{3}{4}$ " x $1\frac{3}{4}$ "	Brass	1	Brig Engr.
		<u>Mills Pins</u>			
		3 $\frac{1}{16}$ " Dia x $1\frac{1}{4}$ " long	—	1	Mills Pins
		" x 1" "	—	2	" "
		<u>Key</u>			
		$\frac{1}{8}$ " sq x $\frac{1}{16}$ " long	—	1	Key Steel.
		<u>Rivets</u>			
		Hdn brass rivets type 'U' x $\frac{3}{16}$ " long	—	4	
		<u>Spring Washers</u>			
		Std. $\frac{1}{4}$ " Whit spring washers	—	3	

SHEET No

DATE _____

DRG. No.

DESCRIPTION

MATL.

No.
OFF

CUT OFF SIZE

See ML 100/600

SHEET No.

1

DATE _____

[illegible]

SHEET No.

1

DATE _____

[illegible]

SHEET No.

DATE _____

19.4.66

MEMPHIS 5 5

TITLE: 5" Viceroy P.C.S. Lathe

SHEET No.

1A

DATE _____

15.4.66

[illegible]

TITLE: 5" Viceroy P.C.S. Lathe.

SHEET No.

1B

DATE _____

15.4.66

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. Headstock Ass. ML110/100 B.O. Parts

DATE

15.4.66

TITLE: 5" Viceroy P.C.S. Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Dowels.</u>			
		1/2" dia x 1 1/2" long	—	1	
	*	1/4" dia x 2" long taper pin	—	2	
		3/16" dia x 1" long	—	2	
	*	3/8" dia x 1" " Hdn.	—	1	
		<u>Scr Slot Cheese Hds.</u>			
		2 BA x 1/2" long	—	6	Unbrako
		<u>Micro - Switch.</u>			
		Ref DS3-521.	—	1	Burgess.
		<u>Scr Slot C'sk Screws.</u>			
		4 BA x 3/8" long	—	2	Unbrako
		<u>Hinges.</u>			
	ref: 1938 :	1 1/2" wide open x 2 1/2" long x 16 swg	—	2	TCNS
		<u>Key.</u>			
		1/8" sq x 1/2" long	key St	1	
		<u>Nuts & Washers.</u>			
		Std 3/8" whit nut & std washer	—	1 each.	
		<u>Rivets</u>			
		hdn brass type 'U' x 3/16" long	—	4	

TITLE: 5" Viceroy P.C.S. Lathe.

SHEET No

1D

DATE _____

15.4.66

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Knob.</u>			
		1" dia x 5/16" whit	—	1	McMillan.
		* These pins are drilled & fitted to the bed & headstock when all tests are finished.			
		<u>5'kt. hd. C'sk. Screws.</u>			
		2 B.A. x 3/16" long	—	6	
		2 B.A. x 1/2" long	—	6	
		Not. Nylon Pegaline Catches			
		Ref:— G.B. 1166	—	1	Greenman & Berger
SP150		Front Nose Cap	Aluminium	1	Hirst.
ML100	100	A. Gear Shifter fork.	M.S. Plate	1	Briggs.

SHEET No.

DATE _____

15.4.66

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Reversing Bracket Assembly

DATE _____

TITLE: 5" Viceroy P.C.S. Lathe

15.4.66

[illegible]

SHEET No.

DATE _____

15.4.66

[illegible]

SHEET No.

DATE _____

CUT OFF SIZE

[illegible]

TITLE: 5" Viceron P.C.S. Lathe

SHEET No.

1

DATE _____

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. ML.110/300.B.

ONE

TITLE: P.C.S. APRON MK II

DATE

16.3.78

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML.110	301	C. APRON BODY.	C.I.	1	CASTING.
"	302	APRON DRIVING GEAR	M.S.	1	
"	303	APRON PINION	"	1	
"	304	CROSS SLIDE DRIVING GEAR	"	1	
"	305	CROSS SLIDE GEAR PINION	"	1	
"	306	CROSS SLIDE GEAR SHAFT	"	1	
"	307	HANDWHEEL PINION	"	1	
"	308	WORM	"	1	
"	309	WORM GEAR	C.I.	1	BAR.
"	310	CHIMNEY GEAR	M.S.	1	
"	311	WORM GEAR SHAFT	"	1	
"	312	WORM DRIVING GEAR	"	1	
"	313	FEEDSHAFT GEAR	"	1	
"	315	WORM SHAFT	"	1	
"	318	WORM CARRIER LIFTER	"	1	
"	319	APRON DRIVING GEAR SHAFT	"	1	
"	320	CHANGE GEAR	"	1	
"	321	WORM CARRIER	C.I.	1	CASTING.
"	325	LOCKING PIN	Silversteel	1	
"	326	C. S' CUTTING LEVER BOSS	M.S.	1	
MVS 110	345	APRON SHIFTER	M.S.	1	
"	346	SELECTOR KNOB.	"	1	
"	347	OIL SIGHT EXTENSION	"	1	
"	348	FEED BOSS			
"	349	SELECTOR SHAFT	"	1	
"	355	APRON COVER PLATE	SHEET STEEL	1	
"	356	SELECTOR SHAFT BUSH	M.S.	1	
MVS 115	379	TRIP LEVER	Alum	2	CASTING.
ML.100	117	RETAINING PLATE.	MS	1	
ML.105	301	HALF NUTS [A= METRIC]	C.I.	PAIR	CASTING.
"	302	HALF NUT STUDS	MS.	2	
"	306	S' CUTTING LEVER CATCH	"	2	

DENFORD MACHINE TOOLS, BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. ML 110/300.085

TWO

TITLE: P.C.S. APRONI MK III

DATE

16-3-78.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SP	170	HANDWHEEL CAP SCREW ONE	C.I.	1	CASTING.
SP	176	HANDWHEEL HANDLE UNIT.	MS.	1	
CH	218	APRON PLATE SCREWS	ALUM	1	BOUGHT OUT.
"	223	D. DIRECTION CHANGE INSERT	"	11	" "
		4 B.A x 1/4"		11	
		SLOTTED 1/5" SUNK SCREW			
		4 B.A x 1/4"		1	
		GRUB SCREWS			
		5/16" B.S.W x 3/8" DOG PT.		2	
		" " x " KNUBBED CUP		2	
		1/4" B.S.W. x 3/8" KNUBBED CUP		4	
		" " x 1/4" DOG PT.		1	
		2 B.A x 5/16" CONE PT.		1	
		2 B.A x 1/4" KNUBBED CUP		1	
		2 B.A x 3/16" CONE PT.		4	
		GROOVE PINS			
		1/8" DIA x 1 1/2" L.		2	
		1/8" DIA x 1" L.		2	
		SEL-LOK PINS			
		1/8" DIA x 1 1/2" L.		2	
		TAPER PIN			
		3/16" DIA x 1 1/4" L.		1	
		GROUND DOWELS			
		5/16" DIA x 3/4" L.		2	
		GIRCLIPS			
		REF: 1500-396.E.		1	Anderton
		REF: 1400-518		1	" "

SHEET No.

FOUR

DATE: _____

16.3.78.

W.Y.O.B.

SHEET No.

DATE _____

18.4.66

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML110	401	Leadscrew & Feedshaft Bracket	C.I.	1	Casting.
"	405	Leadscrew Collar	M.S.	1	7/8" O x 3/4"
ML100	402	Bed	C.I.	1	Casting
"	403	Rock	M.S.	1	1/2" O x 26 1/4"
"	404	Bed Tenon	"	2	1/2" x 1 1/4" x 1 1/16"
SP	134	Locking Stud.	M.S.	4	5/16" O. x 2 5/8"
CH	101	Lubrication Chart	Brass Sheet	1	See B.O.
CH	102	Spindle Speed Chart.	"	1	" "

SEE
MIS & BVS
PART LISTS

SEE MUS & BVS
PART 1

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No

1A

ASSY. DRG. No. Bed Ass. ML110/400 B.O. Parts.

DATE

18.4.66

TITLE: 5" Viceroy P.C.S. Lathe.

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
	<u>Skt hd. Cap. Screws.</u>			
	2 B.A. x 1/2" long	—	5	Unbrako.
	1/4" whit x 1" "	—	3	"
	5/16" " x " "	—	1	"
	<u>Bearings.</u>			
	Thrust Brgs ref NTA-815	—	2	Torrington
	" Race " TRA-815	—	4	"
	<u>Oilers.</u>			
	Ref L.D. 1/4	—	2	King Fisher
	<u>Pins.</u>			
	3/16" D x 1" long Mills Pins	—	2	
	<u>Chart.</u>			
	CH101 : 2 3/4" x 1 3/4" x 24 swg.	Brass Sheet	1	Brig. Engr.
	CH102 : 3 1/2" x 2 3/8" x 24 "	"	1	" "
	<u>Rivets.</u>			
	Hdn brass type 'U' x 3/16" long	—	4	
	<u>Spring Washers.</u>			
	1/4" std spring washers	—	3	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No.

ML 110/400.B.

Two.

DATE

TITLE:

TWO SPEED FEEDBOX

5.5.77

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		BOUGHT OUT ITEMS.			
		SKT HD CAP SCREWS.			
		1/4" WHIT x 1 1/2" LONG		2	
		C/SUNK SKT HD SCREWS			
		1/4" WHIT x 1/2" LONG		1	
		GRUB SCREWS.			
		1/4" WHIT x 1/4" LONG DOG PT		2	
		" x " CONE PT		1	
		2 B.A x " KN CUP PT		4	
		KEYS			
		1/8" SQ x 1 1/16" LONG		1	
		1/8" SQ x 1 1/2" "		2	
		3/16" SQ x 7/16" "		1	
		3/16" SQ x 5/4" "		1	
		SPRINGS			
		1/2" I.D - 1" FL - 6 C.P.I - 14 1/2" LG - GROUND ENDS		1	
		3/16" I.D - 5/8" FL - 9 C.P.I - 20 1/2" LG - " "		2	
		CIRCLIPS			
		REF: 700/75		1	
		" 1400, 3/4"		1	
		" 1400/ 9/16"		1	
		" 1500/ 468 E		4	
		PINS			
		1/16" DIA x 3/8" LONG		1	
		5/32" DIA TAPEX x 1 3/8" LONG		1	
		1/8" DIA SHEAF PINS x 1 1/2" REF: G.P.3		1	
		EL-LOK PIN 1/8" DIA x 1 1/2" LONG		2	

SHEET No.

ML 110/400B.

THREE

TWO SPEED FEED BOX

DATE _____

5. 77.

KEYWORDS

SHEET No.

1

DATE _____

M M L D E E

SHEET No.

DATE _____

DRG. No.	DESCRIPTION	MATL.	Nb. OFF	CUT OFF SIZE
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See ML 100/600

SHEET No.

DATE _____

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
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See ML 100/700

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Toolpost Assembly ML 100/800

DATE _____

TITLE: 5" Viceroy P.C.S. Lathe

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No

ASSY. DRG. No. Units Required For 1 Lathe

DATE

TITLE: 5" Viceroy G.B. Lathe ML115.

19.4.66

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML115	100	Headstock Assembly.			
"	100	A End Drive Assembly			
"	100	B Reversing Brkt Assembly			
ML100	100	A Spindle - Lock Assembly - As Metal Lathe			
"	200	Cabinet Assembly - As Metal Lathe			
"	200	B Coolant Assembly - As Metal Lathe			
ML110	300	Apron Assembly - As P.C.S. Lathe			
"	400	Bed Assembly - As P.C.S. Lathe			
ML100	500	Compound Assembly - As Metal Lathe			
"	600	Countershaft Assembly - As Metal Lathe			
"	700	Tailstock Assembly - As Metal Lathe			
"	800	Toolpost Assembly - As Metal Lathe			
ML115	900	Gear Box Assembly			

TITLE: 5" Viceroy G.B. Lathe.

SHEET No.

2

DATE _____

16. 4. 66

[illegible]

SHEET No

ASSY. DRG. No. Headstock Assembly ML115/100 B.O. Parts

TITLE: 5" Viceroy G.B. Lathe.

DATE _____

[illegible]

SHEET No

ASSY. DRG. No. Headstock Assembly ML115/100 B.O. Parts.

TITLE: 5" Viceroy G.B. Lathe.

16.4.66

[illegible]

SHEET No

ASSY. DRG. No. Headstock Assembly ML115/100 B.O. Ports.

DATE _____

TITLE: 5" Viceroy G.B. Lathe.

16-4-66

[illegible]

TITLE: 5" Viceroy G.B. Lathe.

SHEET No

1D

DATE

16-4-bb

[illegible]

SHEET No

DATE _____

15.4.66

[illegible]

SHEET No.

ASSY. DRG. No. Saddle - Top - Swivel & Cr. Slide Assembly

TITLE: 5" Viceroy G.B. Lathe.

[illegible]

SHEET No.

DATE _____

TITLE: 5" Viceroy G.B. Lathe.

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No.

ML.115/100. A

(5" LATHE)

TWO.

DATE

TITLE: END DRIVE ASSEMBLY - BOUGHT OUT PARTS.

4.4.78.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>SET SCREW</u>			
		3/8" WHT X 1 1/2" LONG		1	
		<u>C/SUNK CAP HD SCREWS</u>			
		1/4" WHIT X 3/8" LONG		1	
		M5 x 15 LONG		2	
		<u>C/SUNK MACHINE SCREWS</u>			
		4 B.A x 3/8" LONG		4	
		<u>RD. M/C. HEADS</u>			
		M4 x 10 LONG		2	
		<u>SKT. BUTTON HEADS</u>			
		2 B.A x 3/8" LONG		12	
		<u>GRUB SCREWS</u>			
		2 B.A x 1/4" LONG, CONE PT.		4	
		<u>NUTS</u>			
		2 B.A STD.		6	
		4 B.A STD.		2	
		<u>WASHER</u>			
		3/8" STD.		1	
		2 B.A. STD.		6.	
		<u>RIVETS</u>			
		HDN BRASS, TYPE 'U' x 3/16" LONG.		4	
		<u>STEEL BALL</u>			
		3/16" DIA		1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

ASSY. DRG. No. ML.115/100.A.

(5" LATHE)

SHEET

0

DATE

4.4.70

TITLE: END DRIVE ASSEMBLY

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML.115	903	QUADRANT	C.I.	1	CASTING
"	908	A. 64T QUADRANT GEAR	C.I.	1	CASTING
"	909	A. 66T QUADRANT GEAR	C.I.	1	CASTING
"	943	A. 64T & 22T QUAD' GEAR SHAFT		1	
"	944	A. 22T QUADRANT GEAR		1	
"	945	A. 24T QUADRANT GEAR		1	
"	946	A. 66T & 24T QUAD' GEAR SHAFT		1	
"	970	D. END DRIVE GUARD.		1	
"	995	QUADRANT RETAINING SPRING		2	B.O.
"	997	66T GEAR (WITH BOSS)	C.I.	1	CASTING.
"	998	66T GEAR	C.I.	1	CASTING.
"	1004	SHEAR KEY.		1	
ML.100	117	RETAINING RATE		2	
MVS 115	971	END GUARD HANDLE		1	
CH.	107	QUAD' SLIDING GEAR CHART		1	B.O.
<u>BOUGHT OUT PARTS</u>					
<u>HINGES</u>					
		Nº 8383 A. BUTT. 2 1/2". RAIN STEEL		2	
<u>DOOR CATCH</u>					
		NAT NYLON PEGALINE			GREENMAN
		REF: CB-1166.		1	BERGER.
<u>HOLE PLUG.</u>					
		REF: 211-E1062-01 BLACK		1	HARMSWORTH.
<u>KEY.</u>					
		1/8" SQ x 25/32" LONG.		1	
<u>OILITE BUSHES.</u>					
		REF:- CT174 x 3/4" LONG.		4	HANG. BR.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET

ASSY. DRG. No. Reversing Bracket Amt. ML115/100B

DATE

TITLE: TDS 1/1 G.B. 5" Viceroy G.B. Lathe

30.7.66

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML105	101	Reversing Bracket	Cl.	1	Casting
"	104	Reversing Bracket Stop	"	1	" x 3/4"
BVS 115	993	Locating Pin Plunger	Silver Steel	1	1 1/2" Dia x 2 3/4"
ML105	107	28T. Reversing Gears.	M.S.	2	1 5/8" D. x 3/4"
"	108	38T. Stud Gear	M.S.	1	2 1/8" D. x 7/8"
ML115	948	24 T. Stud Gear	M.S.	1	1 3/4" dia x 5/8"
ML115	949	Intermediate Stud	M.S.	1	1" dia x 4 5/16"
"	950	Stud Gear Spacer	"	1	" x 5/8"
MVS105	109	IDLER STUD.	"	2	3/4" DIA x 1 7/8"
<u>B.O. Parts req.</u>					
<u>Nuts.</u>					
		Std. 5/16" whit locknuts	—	2	
		STD 3/8" WHIT & STD. WASHERS	—	1 OFF EACH	
<u>Oiler</u>					
		Ref L.D. 1/4"	—	1	King Fisher.
<u>Skt hd Cap Screw.</u>					
		2 B.A x 5/8" long	—	1	Unbrako
<u>Key.</u>					
		1/8" sq x 1 3/8" long	—	1	
<u>Knob.</u>					
		REF: VTR. 40B M8		1	ELESA.
<u>Spring.</u>					
		1/2" O.D. x 1 1/6" F.L. x 6 C.P.I. x 17 swg. x Ground Ends		1	

SHEET No.

ASSY. DRG. No. ML 115/100B.

TITLE: REVERSING BROKT. ART. - B.O. PARTS.

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Gear Box Assembly M.L.115/900.

DATE

8.9.71.

TITLE: 5" Viceroy English G.Box Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML115	901	Gear Box Body.	C.I.	1	Casting.
"	902	B. " " Cover Plate.	"	1	"
"	904	B. "Change Handle.	"	1	"
"	905	" Box Quadrant Bracket.	"	1	"
"	906	Tumbler Carrier Body.	M.S.	1	1 1/2" ϕ x 5 3/16"
"	910	A. " " End - Plain.	C.I.	1	Casting.
"	"	B. " " " - Gear.	"	1	"
"	911	" Gear.	M.S.	1	2 1/8" ϕ x 7/8"
"	912	A " " Driving Shaft.	"	1	1 1/8" ϕ x 9 1/2"
"	913	Dog Gear Trip Lever.	C.I.	1	Casting.
"	915	" " Change Lever.	M.S.	2	1/2" ϕ x 1 1/2"
"	916	" " " Bush.	"	2	1 1/4" ϕ x 5/8"
"	919	Sliding Gear Shaft.	"	1	9/16" ϕ x 6 7/8"
"	923	" Dog " .	"	1	3/4" ϕ x 7"
"	924	A. Driving Gear & Dog Insert.	"	1	2 1/2" ϕ x 13/16"
"	926	Sliding Shaft Driven Gear.	"	1	1 1/2" ϕ x 9/16"
"	927	A. Shaft Driving Gear & Collar.	"	1	2" ϕ x 15/16"
"	928	Sliding Dog & Gear.	"	1	1 7/8" ϕ x 13/16"
"	930	Fixed " & " .	"	1	13/8" ϕ x 1 1/8"
"	931	Gear Train Shaft.	"	1	3/4" x 7"
"	932	" " - 32T. Gear.	"	1	2 1/2" ϕ x 9/16"
"	933	" " - 28T. "	"	1	2 1/4" ϕ x "
"	934	" " - 26T. "	"	1	2 1/8" ϕ x "
"	935	" " - 24T. "	"	1	1 7/8" ϕ x "
"	936	" " - 23T. "	"	1	" x "
"	937	" " - 22T. "	"	1	1 3/4" ϕ x "
"	938	" " - 20T. "	"	1	1 5/8" ϕ x "
"	939	" " - 18T. "	"	1	1 1/2" ϕ x "
"	940	" " - 16T. "	"	1	1 3/8" ϕ x "
"	941	" " Spacing Collar.	"	1	1 1/2" ϕ x 3/4"
"	942	" " Locking Nut.	"	1	5/16" ϕ S.F. Locknut
"	947	Quadrant Leaf Spring.	"	1	1 1/16" x 3/8" x 18 S.W.G.
"	952	A. Selector Dial Shaft.	"	1	1 1/8" ϕ x 3 3/16"
"	953	Rack Moving Gear.	"	1	1 3/8" ϕ x 5/8"
"	955	Gear Selector Dial.	"	1	2" ϕ x 1 1/4"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. Gear Box Assembly ML115/900

DATE

8.9.71.

TITLE: 5" Viceroy English G.Box Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML115	956	Rack Shaft.	M.S.	1	1 1/2" ϕ x 7 1/2"
"	957	Tumbler Trip Lever.	M.S. Plate	1	3 1/16" x 1 1/4" x 2 5/8"
"	958	Rack.	M.S.	1	1" Sq. x 3 1/2"
"	959	Tumbler Shaft.	Silver St.	1	1 1/2" ϕ x 5 5/16"
"					
"	979	Trip Lever Handle Boss.	M.S.	2	1 1/4" ϕ x 1"
"	982	Sliding Gear Trip Lever.	C.I.	1	Casting.
"	984	Fool Proof Pin Stop - Housing.	"	1	"
"	985	" " " "	M.S.	1	1 1/2" Sq. x 3"
"	986	Back Cover Plate.	M.S. Plate	1	3 7/8" x 5 1/16" x 16.50g
"	987	Fool Proof Pin.	Silver St.	1	2.50" ϕ x 2 7/8"
"	988	Gear Handle Stud.	M.S.	2	5/16" ϕ x 2 1/4"
"	989	Fool Proof Spring.	Spring St.	1	See B.O.
"	990	Tumbler Driving Shaft Bush.	C.I.	1	2" ϕ x 1 3/4"
"	991	A. Gear Train Shaft Bush.	"	1	1 3/4" ϕ x 2"
"	"	B. " " " "	"	1	" x 1 1/8"
"	992	A. Sliding Dog " "	"	1	" x 1"
"	"	B. " " " "	"	1	" x 1 3/8"
"	993	Gear Change Lever Plunger.	Silver St.	1	3/16" ϕ x 2 3/4"
"	994	Carrier Moving Gear.	M.S.	1	1 1/2" ϕ x 1 3/4"
"	996	A SHEAR BUSH	M.S.	1	1 3/8" ϕ x 1 3/8"
"	999	RETAINING PLATE	M.S.	1	1 3/8" ϕ x 3/16"
"					
ML110	101	Sliding Gear.	"	1	1 1/2" ϕ x 1 9/16"
"	103	Leadscrew " .	"	1	" x 1 5/16"
"	107	Kicker Pin .	"	2	3/8" DIA. x 1"
"					
"	403	A. Feed shaft.	"	1	5/8" ϕ x 42"
"	404	Leadscrew.	"	1	3/4" ϕ x 38 1/16"
"					
"	407	Feed shaft Dog Drive .	"	1	1 3/8" ϕ x 1 1/8"
"	408	Driven Dog Gear.	"	1	1 1/2" ϕ x 1 3/16"
CH106		Change Lever chart.	—	1	See B.O.
CH108	B.	Top Lever & Dial Warning chart.	—	1	" "
CH110		Screw Thread & Feed Chart.	—	1	" "

TITLE: 5" JICEROY ENGLISH G/BOX LATHE.

SHEET No.

3

DATE _____

18.3.75

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A.

ASSY. DRG. No. G.B. Assembly ML115/900 B.O. Parts.

DATE

7.9.71.

TITLE: 5" Viceroy English G. Box Lattice.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Socket Head Cap Screws.</u>			
		2 B.A. x 5/8" Long.	—	3	Unbrako
		" x 1/2" "	—	2	"
		" x 1" "	—	1	"
		<u>C'SK S'Kt Head Screws.</u>			
		2 B.A. x 1/2" Long.	—	10	Unbrako
		" x 1/4" "	—	4	"
		1/4" whit x 1/2" Long.	—	1	"
		<u>Grubs.</u>			
		4 B.A. x 3/8" Long Kind Cup Pt.	—	2	
		2 B.A. x 1/4" " " " "	—	8	
		<u>Keys.</u>			
		1/8" Sq x 1/4" Long.	—	2	
		" " x 3/8" "	—	1	
		3/16" " x " "	—	1	
		" " x 1/2" "	—	1	
		" " x 13/16" "	—	1	
		" " x 23/8" "	—	1	
		" " x 3 1/4" "	—	1	
		" " x 3 5/8" "	—	1	
		1/8" " x 3/4" "	—	1	
		<u>Bearings.</u>			
		Brig ref:- N.T.A 815	—	1	Torrington
		Thrust race ref:- T.R.A. 815	—	2	"
		<u>Oil Level Glass.</u>			
		Ref:- IC4610	—	1	Tecalemit.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B.

ASSY. DRG. No. G.B. Assembly ML115/900, B.A. Parts.

DATE

7.9.71.

TITLE: 5" Viceroy English G. Box Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Nuts.</u>			
		Std 2 B.A.	—	1	
		" 5/16" Whit.	—	1	
		<u>Washers.</u>			
		Std 1/4" washer.	—	1	
		" 5/16" "	—	1	
		" 3/16" "	—	1	
		5/16" Aluminium Washer	—	2	
		1/4" Spring "	—	1	
		<u>Pins.</u>			
		Taper Pin 3/16" dia x 1 3/8" Long	—	1	
		Sel-lok Pin 1/8" dia x 7/8" "	—	1	
		" " " " " 1 1/4" "	—	2	
		" " " " " 1 1/2" "	—	1	
		<u>Skt. Hd. Button Screw.</u>			
		2 B.A. x 3/8" Long.	—	1	
		<u>Knobs.</u>			
		1" Dia x 5/16" Whit	—	3	M ^c . Millan.
		<u>Charts.</u>			
CH106		28 S.W.G. 4 3/8" x 3/8"	Brass Plt.	1	Brig Engr.
CH108	B	22 " x 6 3/8" x 1 1/2"	Alum "	1	" "
CH110		24 " x 5" x 3/4"	Brass Plt	1	" "
		<u>Rivets.</u>			
		Hdn. Brass type 'U' x 3/16" Long	—	13	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C.

ASSY. DRG. No. G.B. Assembly ML115/900. B.O. Parts.

DATE

7.9.71.

TITLE: 5" Viceroy English G.Box Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Oilite Bushes.</u>			
		Ref:- SNO30 x $\frac{1}{16}$ " long.	—	1	Bound Brooke.
		<u>Balls.</u>			
		5/32" dia Ball.	—	1	
		3/16" " "	—	1	
		<u>Circlips.</u>			
		Ref:- 1500 396 E	—	2	Anderton
		" :- 1500 E 468	—	3	"
		LH. ref :- 700/75	—	1	"
		RH. " :- 1400 3/4"	—	1	"
		<u>'O' Rings.</u>			
		Ref:- 2050	—	1	Angus
		" :- 2075	—	1	"
		<u>Springs.</u>			
		1/2" O.D. 1/16" FL. 17 S.W.G. 6 C.P.I.	—	1	Spring Steel.
		1/2" I.D. 1" FL. 14 SW.G. 6 C.P.I. Ground Ends	—	1	" "
ML115	989	3/32" O.D. 1 1/2" FL. 20 SW.G. 12 C.P.I. " "	—	1	" "
		3/16" O.D. 5/8" FL. 20 SW.G. 9 C.P.I. " "	—	1	" "
		<u>Slug.</u>			
		1/8" dia x 1 1/4" Long.	—	1	
		<u>Scr Slot C'sk Screw.</u>			
		4 B.A. x 1/2" Long	—	4	
		1/4" whit x 1/2" "	—	1	

SHEET No.

1D.

DATE _____

7.9.71.

H.M. LTD. S/P 8791

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Extra Equipment.

DATE

TITLE: 5" Viceroy Metal Lathe.

22.2.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML101		Fixed Steady			
ML102		Travelling Steady			
ML103		Two Speed Feedbox			
ML104		Plain Saddle Stop			
ML106		C.S. Thread Cutting Stop			
ML107		Collet Attachment			
ML108		Taper Turning Attachment			
ML109		Thread Dial Indicator			
ML111		Fine Feed Assembly			
ML112		19 T.P.I. Quadrant Assembly			
ML113		American Toolpost			
ML114		Metric Transposing Assembly - G.B.			
ML116		Saddle Stop			
ML117		Rear Parting - OFF Toolpost.			
ML118		Boring Table			
ML119		4 Way Toolpost			
ML121		Polishing Spindle			
ML122		8" Dia Faceplate			
ML123		Eyeshield.			
ML124		ear splat guard			
ML126		Copying Attachment			
ML127		P.C.S Automatic knock off.			
ML128		Screwcutting Half Nut Knock OFF.			
ML129		Collet Attachment (New Type).			

SHEET No.

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DATE _____

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SHEET No.

DATE _____

DATE _____

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SHEET No.

ASSY. DRG. No. Travelling Steady ML 102 B.O. Parts.

TITLE: 5" Viceroy Metal Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		HEX HD. SET SCREWS,			
		$\frac{5}{16}$ " WHIT x $1\frac{1}{2}$ " LONG,		1	
				1	
		<u>Washers.</u>			
		Standard $\frac{5}{16}$ " washer		1	
		<u>Grubscrews</u>			
		4 B.A. x $\frac{1}{4}$ " long		2	
		$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long - dog pt		2	
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long - dog pt		2	

DATE _____

22. 2. 67

TITLE: 5" Viceroy Metal Lathes

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SHEET No

ASSY. DRG. No. Collet Attachment ML107

TITLE: 5" Viceroy Metal Lathes.

[illegible]

SHEET No.

ASSY. DRG. No. Collet Attachment ML107 B.O. Parts

TITLE: 5" Viceroy Metal Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML107	1	Handwheel. C.I. Casting	—	1	Lockwoods
"	4	Drawbar. Hydraulic Tube	—	1	McNay's.
		<u>Grubs.</u>			
		2 B.A. x 3/16" long kn. cup pt.	—	2	Unbrako
		<u>Collets.</u>			
		7-std. 24° incl angle x 1/8", 3/16", 1/4", 5/16", 3/8", 7/16" & 1/2" dia.	—	1 each	Crawford.

SHEET No.

ASSY. DRG. No. Taper Turning Attachment

DATE _____

TITLE: 5" Viceroy Metal Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML108	1	Base bracket	C.I.	1	Casting
"	2	Base Slide	"	1	"
"	3	Setting Plate	"	1	"
"	4	Support Bracket	"	1	"
"	5	Junction Plate	"	1	"
"	6	Top Slide	"	1	"
"	7	Cross Slide Screw	M.S.	1	3/4" dia x 16 13/16"
"	8	Base Bracket Bush	"	1	7/8" dia x 6 3/4"
"	9	Cross Slide Gear & Shaft	"	1	7/8" dia x 8 3/8"
"	10	Top Slide Insert	"	1	1 3/8" dia x 3 3/8"
"	11	Base Bracket Grib.	"	1	1/8" x 1/2" x 6 1/2"
"	12	Top Slide Grib.	"	1	1/8" x 3/8" x 3 1/2"
"	14	Base Plate Rod.	M.S.	1	3/4" dia x 6 1/4"
"	15	Screw Locking Collar	"	1	3/4" dia x 5/8"
"	16	Locking Collar	"	1	1 1/4" dia x 1/2"
"	17	Pivot Pin	"	1	5/8" dia x 1 1/4"
"	18	Saddle Support Bracket	"	2	1/2" x 1" x 15/16"
"	19	Saddle Grib.	"	1	3/8" x 1 1/2" x 10 3/4"
"	20	Locking Handle	Mall. Iron	1	Casting.

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DATE _____

CUT OFF SIZE

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22.2.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML109	1	Body	M.S.	1	1 1/2" sq x 2 5/8"
"	2	Dia I Indicator	"	1	1" dia x 2 5/8"
"	3	Indicator Wormwheel	Cent. C.I.	1	1 1/2" dia x 1 1/8"
"	4	Indicator Location peg	M.S.	1	3/8" dia x 1 5/8"
"	5	Bush *	"	1	5/8" dia x 15/16"

* For use only when Indicator is fitted to Screwcutting Lathe.

B.O. Parts Required.

Grubs

2 B.A. x 3/8" long kn. cup pt
1/4" whit x 1/4" long " " "

Oiler

L.D. $\frac{1}{4}$ "

King Fisher.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Fine Feed Assembly

MLIII

DATE

23.2.67

TITLE: 5" Viceroy Metal Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
MLIII	1	100 T. Gear	C.I.	1	Casting
"	2	127 T. Gear	"	1	"
"	3	16 T. Gear	M.S.	1	1 1/8" dia x 1"
CH	109	Fine Feed Chart	Brass	1	See B.O. Parts
1950/72. 11312					
<u>B.O. Parts Required.</u>					
<u>Grubs</u>					
		2 B.A. x 1/4" long	kn cup pt.	2	Unbrako
<u>Rivets</u>					
		Type 'U' x 3/16" long	—	4	
<u>Chart</u>					
		CH109 24swg x 3 1/2" x 1 3/4".	Brass.	1	Brdg. Engr

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ML 113

1-4-66

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B.O. Parts Required.

Sq. hd. screws.

3/8" wh. x 1 1/2" long	dog pt.	—————	1	Unbrako.
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DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. ^{ENGLISH}
^{METRIC} Transposing Gear Set Up. ML114

DATE

4.6.66

TITLE: 5" Viceroy G.B. Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		ENGLISH TO METRIC			
ML114	1A	QUADRANT	C.I.	1	CASTING
"	3	Intermediate Stud	M.S.	1	1" ϕ x 3" $\frac{1}{8}$ "
"	4A	64T. Screw Gear	C.I.	1	Casting
"	5	Spacer	M.S.	1	1" ϕ x 1"
"	6	64T. Stud Gear	Centr. C.I.	1	3 $\frac{3}{4}$ " ϕ x 5 $\frac{1}{8}$ "
"	7	66T " "	"	1	4" ϕ x 5 $\frac{1}{8}$ "
BVS 114	5A	Locating Pin Plunger.	Silver St.	1	1 $\frac{1}{2}$ " ϕ x 3 $\frac{1}{4}$ "
ML105	113	Spacing Bush	Cyanide Hdn. M.S.	1	1" ϕ x 1 $\frac{1}{4}$ " long
"	117	Bright Washer	"	1	7/16" std washer.
"	119	16T. Change Wheel	"	1	1 $\frac{1}{8}$ " ϕ x 5 $\frac{1}{8}$ "
"	121	24T " "	"	1	1 $\frac{1}{2}$ " ϕ x " "
"	127	48T. " "	C.I.	1	Casting.
"	130	56T. " "	"	1	"
"	131	60T " "	"	1	"
"	138	26T " "	M.S.	1	1 $\frac{5}{8}$ " ϕ x 5 $\frac{1}{8}$ "
"	142	127T. Gear	C.I.	1	Casting.
"	147	127T/120T Gear.	C.I.	1	Casting.
CH	141	Metric Transposing Gear Chart	Brass Sheet	1	See B.O. List.
		METRIC TO ENGLISH			
ML114	1A	QUADRANT	C.I.	1	CASTING
"	3	INTERMEDIATE STUD	M.S.	1	1" ϕ x 3 $\frac{1}{8}$ "
"	5	SPACER	M.S.	1	1" ϕ x 1"
"	10	48T GEAR	C.I.	1	CASTING
"	9	135T/127T GEAR	C.I.	1	"
"	8	LOCATING PIN PLUNGER	SILVER ST	1	1 $\frac{1}{2}$ " ϕ x 3 $\frac{1}{4}$ "
"	13	49T STUD GEAR	C.I.	1	CASTING
ML105	113	SPACING BUSH CYANIDE HON	M.S.	1	1" ϕ x 1 $\frac{1}{4}$ "
"	117	BRIGHT WASHER	"	1	7/16" STD WASHER
"	127	48T STUD GEAR	C.I.	1	CASTING
"	128	52T " "	"	1	"
"	129	54T " "	"	1	"
CH	160	ENGLISH TRANSPOSING GEAR CHART	BRASS SHEET	1	SEE B.O. PARTS

SHEET No

ASSY. DRG. No. **ENGLISH** **METRIC** Transposing Gear Set up ML114

DATE _____

6.6.66

TITLE: 5" Viceroy G.B. Lathe.

B.O. Ports.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Chart.</u>			
ENG-MET	→ CH 141	5" x 3 1/4" x 24 wdg.	ALUM.	1	Brig. Engr.
MET-ENG	→ CH 160	5" x 3 1/4" x 24 gwg	"	1	" "
		<u>Rivets</u>			
		Hdn brass rivets - Type U x 3/16" long	—	4	
		<u>Grubs.</u>			
		2 B.A. x 1/4" long	—	2	Unbrako.
		<u>Nuts & Washers.</u>			
		Std 7/16" whit nuts (Hdn)	—	1	
		Std 7/16" washers	—	2	
		<u>Set Screw</u>			
		7/16" whit x 2 1/4" long	—	1	

DATE _____

22.2.67

TITLE: 5" Viceroy Metal Lathes.

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SHEET No.

DATE _____

4.1.78

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML.100	802	TENON	MS	1	
"	803	TOOL POST - STUD	MS	1	
"	805	TOOL POST HANDLE - CAP	MS	1	
ML.119	1A	TOOL POST BODY	MS.	1	
SP.142		HANDLE	MS.	1	
<u>B.O. PARTS</u>					
<u>SQ. HD. SCREWS.</u>					
M8 x 30 LONG.				8	
 <u>PLASTIC KNOB.</u>					
REF :- 1032,				1	RENCOL.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1.

ASSY. DRG. No. ML123A.

DATE

1. 8. 75.

TITLE: EYESHIELD ATTACHMENT.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML123	1A.	EYESHIELD STEM.	M.S.	1	1/4" x 3/4" x 13"
"	3A.	" " BASE.	"	1	3/8" x 1 1/4" x 2 1/4"
"	4A	" HINGE SUPPORT.	"	1	1/8" x 5/8" x 7 1/2"
"	5	" GLASS	OROGGLASS	1	BRAD ^D . GLASS CO.
ML100	220	COOLANT BLOCK CLAMP.	M.S.	1	1/4" x 1" x 1/16"
<u>B.O. PARTS REQUIRED.</u>					
ML123	5	GLASS, 5 1/32" x 5 3/4" x 7 3/4".	OROGGLASS	1	BR. GLASS CO.
<u>HINGE.</u>					
1 1/2" WIDE x 7 5/8" x 20 S.W.G.			—	1	
<u>SKT. BUTTON HD SCREW</u>					
2 BA. x 1/2" LONG.			—	2	
<u>NUTS.</u>					
STD. 2 BA.			—	2	
<u>SET SCREW.</u>					
5/16" WHIT. x 1" LONG.			—	1	
<u>WASHER.</u>					
STD. 5/16"			—	1	

SHEET No.

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DATE _____

20-1-69

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DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A.

ASSY. DRG. No. Copying Atch B.O. Parts.

DATE

21. 1. 69.

TITLE: 5" Viceroy Metal lathes. ML126

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Set Screws.</u>			
		1/2" whit x 1" long.	—	4.	
		<u>Cap Head.</u>			
		1/4" whit x 1" long.	—	2	unbrako.
		3/16" whit x 3/4" long.	—	2	"
		<u>Countersunk Screw.</u>			
		5/16" whit x 3/4" long	—	2	unbrako.
		<u>Collar head screw</u>			
		5/16" whit x 1/2" long.	—	2	unbrako.
		<u>Nuts & Washers.</u>			
		5/16" whit locknut.	—	2	
		5/16" std. washer.	—	4.	
		<u>Springs.</u>			
ML126	16	Closed tension - 17 S.W.G.			
		18. C.P.I. - 1/2" Dia - 7/16" eye hook.			
		2 1/4" long.			
		<u>Bearing</u>			
		ref:			
		Fag - 624.2Z.			
		or KOYO - 624 ZZ.			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

ASSY. DRG. No. Copying Attch. B.O. Parts.

TITLE: 5" Viceroy Metal lathes. M.L. 126

SHEET No.

1B.

DATE _____

21-1-69

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TITLE: 5" Viceroy P.C.S. Metal lathe.

1

25.2.70

H.W. LTD. S/P 8791

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Half Nut Knock Off. M.L.128.

DATE

TITLE: 5" Viceroy Screwcutting Lathe.

27.2.70.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
M.L.128		Arrangement.			
"	1	Apron.	C.I.	1	Casting.
"	2	Rack.	B.M.S.	1	10 ³ / ₈ " x 3 ¹ / ₄ " x 1 ¹ / ₂ "
"	4	Apron Pinion.	ENB.	1	1 ¹ / ₈ " dia x 2 ¹ / ₈ "
"	6	Handwheel Pinion.	"	1	1" x 3 ³ / ₄ "
		For Rest of parts see M.L.105/300.			
		<u>B.O. Parts.</u>			
		<u>Springs.</u>			
		Spring 9 ¹ / ₂ " o/d x 205. W.G. x 12 C.P.I. 1 ¹ / ₄ F.L. Ground Ends.			
		<u>Grub Screws.</u>			
		4 B.A. x 1 ¹ / ₄ " Cone Point	—	2	Unbrake.
		<u>Locknuts.</u>			
		1 ¹ / ₂ " Whit.	—	2	STD.
		Screwed Rod 1 ¹ / ₄ " Whit x 3 ¹ / ₄ " long.			
M.L.127	2A	Auto Knock Off Stop: Top Vee Clamp	M.S.	1	2 ¹ / ₄ " x 1" x 3 ¹ / ₄ "
"	2B	" " " " : Bottom Striking Plate	"	1	1 ⁵ / ₈ " x 1" x 1"
"	2	PCS. & Screwcutting Knock off Gear	"	1	2 ¹ / ₄ " dia x 3 ¹ / ₈ "
HL100	305	B. Apron Driving Gear.	"	1	2 ³ / ₈ " dia x 5 ¹ / ₈ "

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. ML 130

DATE

TITLE: 5" VICEROY METAL LATHE-MILLING ATTACHMENT

23-3-72

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML130		ARRANGEMENT			
"	1	MILLING ATT - SWIVEL PLATE SLIDE	C.I	1	CASTING
"	2	" " - SWIVEL TENON PLATE	C.I	1	CASTING
"	3	" " - SWIVEL VICE	C.I	1	CASTING
"	4	" " - VERTICAL SLIDE	C.I	1	CASTING
"	5	" " - ADJUSTING SCREW	M.S.	1	3/4" DIA x 10 1/2"
"	6	" " - BUSH FOR SCREW	M.S.	1	1 3/4" DIA x 2 1/16"
"	7	" " - SLIDE NUT	PHOS. B.	1	1 1/4" DIA x 1 9/16"
"	8	" " - LOOSE TENON	M.S.	1	7/8 x 3/8 x 3 1/2"
"	9	" " - GIB STRIP	M.S.	1	1/4 x 1/2 x 3 1/2"
"	10	" " - LOCK PIN	M.S.	2	1/4" DIA x 1 9/16"
"	11	" " - GRADUATED COLLAR	SPRING ST.	1	B.O. PART
"	12	" " - NYLON PAD	NYLON	1	3/8" DIA x 5/8"
"	13	" " - VEE CLAMP	M.S.	2	3/16" x 1"
		OTHER PARTS REQUIRED			
ML100	505 A	2 3/4" - 3 BALL HANDLE	M.S.	1	3/4" DIA x 3 5/8"
"	505 B	3 BALL HANDLE - KNOB	M.S.	1	5/8" DIA x 2 1/4"
"	520 B	TOP & CROSS SLIDE DIAL (METRIC)	M.S.	1	1 5/16" DIA x 7/8"
"	515	TOP & CROSS SLIDE BEARING COLLAR	M.S.	1	3/4" DIA x 5/8"
"	523	FEED NUT LOCKING SLUG	SILVER ST.	1	1/8" DIA x 3/8"
"	802	TOOL POST TENON	M.S.	1	1 1/4 x 1 1/16 x 3/8"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. ML 130

DATE

23-3-72

TITLE: 3" VICEROY METAL LATHE MILLING ATT.

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
	<u>B.O. PARTS.</u>			
	<u>BEARINGS</u>			
	THRUST BEARING REF N.T.A613		2	TORRINGTON
	THRUST RACES REF TRA613		4	..
	<u>PINS</u>			
	1/8" DIA MILLS		2	
	<u>WASHERS</u>			
	3/8" DIA SPRING WASHER		1	
	<u>GRUB SCREWS</u>			
	2 BA x 1/4" LONG		1	UNBRAKO
	1/4" WHIT x 1/2" LONG		1	
	5/16 WHIT x 3/8" LONG		2	
	2 B.A. x 1/2" LONG NYLON INSERT		2	
	<u>CONE PT. SCR.</u>			
	5/16 B.S.F.		1	
	<u>LOCK NUTS</u>			
	2 B.A.		2	STD.
	<u>OILERS</u>			
	L D 1/4"		1	KINGFISHER

TITLE: 5" VICE ROY METAL LATHE - MILLING ATT

SHEET No.

18

DATE _____

23-3-72

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>B.O. PARTS - CONT.</u>			
ML130	11	GRADUATED COLLAR	SPRING STEEL	1	
		<u>CAP SCREWS.</u>			
		2 BA x $\frac{1}{2}$ " LONG		2	UNBRAKO

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No.

ML 131

DATE

TITLE:

TAP & DIE HOLDER

18-8-72

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML131	1	TAP & DIE HOLDER - BODY	M.S.	1	1 3/4" x 3 3/4"
"	2	" " " " " - TAIL STOCK ADAPTOR	EN8	1	1 1/2" x 6 1/2"
"	3	" " " " " - 2 BA TAP COLLET	EN8	1	1 1/2" x 1 1/2"
"	4	" " " " " - 1/4" TAP COLLET	EN8	1	1 1/2" x 1 1/2"
"	5	" " " " " - 5/16" TAP COLLET	EN8	1	1 1/2" x 1 1/2"
"	6	" " " " " - 3/8" TAP COLLET	EN8	1	1 1/2" x 1 1/2"
"	7	" " " " " - GUIDE RAIL	M.S.	1	3/2" x 7/8" x 5"
"	8	" " " " " - GUIDE ROD	M.S.	1	3/2" x 4 1/4"
SP142		HANDLE (FOR MANUAL TAPPING)	M.S.	1	7/16" DIA x 3 1/2"
<u>BOUGHT OUT PARTS</u>					
<u>CAP SCREWS</u>					
		2 BA x 1/2" LONG		3	
		2 BA x 3/4" "		1	
<u>PLASTIC KNOB</u>					
		1" DIA. x 5/16" WHIT		1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1.

ASSY. DRG. No. ML.132.

DATE

20.2.78.

TITLE: UNIVERSAL MILLING & DRILLING UNIT.

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML.132 1	TABLE.	C.I.	1	CASTING.
" 2	SPIGOT.	M.S.	1	
" 3	PACKING PLATE.	M.S.	1	
" 4A	STARTER BOX BRACKET.	M.S.	1	
" 5	CAPACITOR HOLDER	M.S.	1	
" 6	ANGLE PLATE	C.I.	1	CASTING
MVS.100/525.A	SWIVEL SLIDE LOCKING PIN,	MS.	2	
ML.132 7	A&B - BORING BARS (MOD ORDER)	MS	1 SET	
	<u>B.O. PARTS REQUIRED.</u>			
	<u>UNIVERSAL MILLING HEAD.</u>		1	EMCO.
	REF: F5201 M. - 1 PHASE.			
	REF: F5203 M. - 3 PHASE.			
	<u>SKT. HD CAP SCREWS.</u>			
	M12 x 30 MM LONG.		4	
	M10 x 20 MM "		4	
	M8 x 20 MM "		1	
	<u>SKT. SET SCREWS.</u>			
	M10 x 10 MM LONG.		2	
	<u>CHEESE HD SCREWS</u>		2	
	2 B.A. x 1/2" LONG		2	
	<u>C/SUNK SCREWS.</u>			
	2 B.A x 1/2" LONG.		2.	
	<u>WASHERS.</u>			
	M12 x FORM 'A'		4	
	<u>DOWELS.</u>			
	1/4" DIA x 1 1/4" LONG.		1	

SHEET No.

DATE _____

14.36

H.M. LTD. S/P 8791

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Headstock Ass M/L 105/100 B.O. Parts

DATE _____

TITLE: 127^m/m Viceroy Screwcutting lathe.

142.60

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. HEADSTOCK ASS ML105/100.

DATE _____

143.65

TITLE: 127"lm Viceroy Srewcutting lathe

[illegible]

SHEET No.

1

DATE 17 3 69

[illegible]

SHEET No.

1

DATE 17-3-69

[illegible]

SHEET No. 1A

DATE
17.3.69.

CUT OFF SIZE

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Bed Assembly ML105/400A.

DATE _____

TITLE: 127^{mm} Viceroy Screwcutting lathe.

17-3100

[illegible]

SHEET No.

1

DATE
17 3-69

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. Compound Ass ML100/500A B.C.Parts

DATE _____

173-60

TITLE: 127^m/m Viceroy Screwcutting lathe.

[illegible]

SHEET No.

100

DATE _____

[illegible]

SHEET No.

1A

DATE _____

18.3.69

TITLE: 127^m/m Viceroy Screwcutting lathe

[illegible]

SHEET No.

DATE _____

18.7.50

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. Feedback Assembly ML105/100F

DATE _____

TITLE: 127^{mm} Viceroy Screwcutting Lathe ML105.

18.2.69

[illegible]

SHEET No.

ASSY. DRG. No. Feedbox Assy ML 105/100 F.B.O. Parts

TITLE: 12 1/2" Viceroy Screwcutting Lathe ML105

DATE _____

[illegible]

SHEET No.

DATE _____

25.10.69.

[illegible]

SHEET No.

ASSY. DRG. No. WM100 100 (See ML100/100B from 14.3.72)

DATE _____

TITLE: Headsack Assy. With new WM 100/102B

14-3-72

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WM100	102	B. Main Spindle	M S	1	17/8" d. x 12 5/16"
"	103	B Lock nut	"	2	2" d. x 9/16"
"	107	B. Spindle Lock Bush	"	1	2 1/4" d x 1"
All other parts required are as standard Metal lathe but deleting :- ML 100 / 122 " / 111 " / 133					

SHEET No.

DATE:

6.11.69.

DRG. No.

MATL.

No.
OFF

CUT OFF SIZE

" 1B.

10.

SHEET No.

1

DATE _____

6.11.69.

[illegible]

SHEET No.

1

DATE _____

6.11.69.

[illegible]

SHEET No.

1

DATE
6.11.69.

[illegible]

SHEET No.

1

DATE _____

15.6.70.

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1.

ASSY. DRG. No. LEADSCREW DRIVE Assy WM. 100/400A

DATE

15.6.70.

TITLE: 5" Viceroy combination lathe. B.O. Parts.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>CHAIN.</u>			
		Pitch .250", A.S. N° 25.			
		Renolds ref:- 129 023, Full length of chain 16 1/2" x 1 crank link & 2 split links.			
		<u>Phosphor BUSHES.</u>			
		1/2" bore 5/8" O/D x 3/4" long.	Phos Brz	1	
		3/4" " 1" " x 1 1/8" "	"	1	
		<u>THRUST BEARINGS</u>			
		Torrington BRG's ref:- N.T.A. B15.		2.	
		" RACE ref:- T.R.A. B15.		4.	
		<u>SCREWS.</u>			
		HEX. SKT. 1/2" Dia x 1 1/2" long. 3/8" whit.		1	Unbrako.
		SKT. HD. CAP 5/16" whit x 1" long		1	"
		<u>GRUBS</u>			
		2 BA x 1/4" long - Dog point		4	Unbrako.
		2 BA x 1/4" " - Knurl cup		2	"
		<u>KEY.</u>			
		1/8" sq x 3/4" long.	Key SH.	1	
		<u>PIN.</u>			
		SEL-LOK 1/8" Dia x 7/8" long		1	

SHEET No.

1.

DATE _____

6.11.69.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
ML 100	501	Cross slide Spigot Insert	M.S.	1	2 1/2" x 1 1/2"
"	502	Compound clamp.	M.S.	1	3 1/2" D x 2"
"	503	" " handle.	M.S.	1	5" D x 2 1/2"
"	504	" " lever.	"	1	7/8" D x 3 1/2"
"	505	SW. Slide locking Pin	"	2	5/16" D x 1 1/8"
For all other parts see ML 100/500 but delete parts :-					
ML 100/503					
"	508A				
"	509A				
"	510				
"	511				
"	515	1 1/2"			
"	516				
"	520	1 1/2"			
"	507				

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A.

ASSY. DRG. No. Compound Ass WM.100/500 B.O. Parts

DATE

6.11.69.

TITLE: 5" Viceroy COMBINATION LATHE.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		See ML.100/500 B.O. Parts.			
		sheet 1A.			
		But delet :-			
		<u>Bearings</u>			
		Needle thrust brg ref:- N.T.A. 613		1	Torrington.
		Thrust race ref:- T.R.A. 613		2	
		<u>Spring washer</u>			
		STD $\frac{3}{8}$ " washer		1	Air dale.
		<u>Grubs</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long cup pt.		1	Unbroko.
		" x " " " drg pt.		1	"
		2 B.A. x " " " kno cup pt.		1	"
		" x $\frac{7}{8}$ " " nylon insert		4	" "
		<u>Nuts.</u>			
		2 B.A. nut.		4	Sutcliffe.
		<u>Pins.</u>			
		$\frac{1}{8}$ " D x 1" long.		2	Mills pins.

SHEET No.

1

DATE _____

7.11.69.

[illegible]

SHEET No.

1

DATE _____

7.11.69.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WH100	801	Outrigger adaptor *	M.S.	1	7 1/2" x 2 3/4" x 3/4"
"	802	" CLAMP	M.S.	1	1" φ x 3 5/8"
		All other parts are as.			
		WL100/800 sheet 1.			
		* USED ON LONG BED ONLY.			
		<u>B.O. Parts.</u>			
		<u>Cap Hd. Screws.</u>			
		5/16" whit x 3/4" long.		2.	Unbrako.
		All other parts are as.			
		WL100/800 sheet 1A.			

ASSY. DRG. No. General Assembly

DATE

TITLE: 12" D.E. Cabinet Grinding M/c

TDS II.

10.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM102	5	Outer End Cover	C.I.	2	Casting
"	7	Spindle Pulley	"	1	"
"	13	Outer Disc	Mall. Iron	4	"
"	15	Pivot Pin	M.S.	2	3/4" D. x 3 3/4"
"	17	Locking bolt	"	2	5/8" D. x 2 1/2"
"	18	" pin	"	2	1/2" D. x 2 7/8"
"	23	Distance Piece	"	2	1 1/4" D. x 7/8"
"	31	Headstock Cover	Sh. Steel	1	16 swg.
GM106	9	Crank Bolt	M.S.	1	3/8" D. x 8"
GM107	1	Cover Plate	Sh. Steel	1	12 swg.
GM110	1	R.H. Wheel Guard	C.I.	1	Casting
"	2	L.H. " "	"	1	"
"	3	Toolrest Bracket	"	2	"
"	4	Toolrest	"	2	"
"	5	Motor Pulley	Alum	1	"
"	6	Spindle	M.S.	1	1 1/4" D. x 19 3/4"
"	10	Moving Spark Guard	Alum.	2	Casting
"	11	Headstock	C.I.	1	"
"	12	Cover Plate	Sh. Steel	2	12 swg
"	13	late	C.I.	1	Casting
"	14	Pin	Sh. Steel	1	12 swg
"	15	Cover	"	1	"
"	16	Plat Form	C.I.	1	Casting
"	17	Pin	M.S.	1	3/8" D. x 5 3/8"
"	18	Plate	Sh. Steel	1	12 swg.
"	19	Plate	Brass Sh	1	See B.O. Parts
"	20	Location Chart	"	1	"
"	21	Working Speed Chart	Metal Cal	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Arrt.

DATE

10.3.67

TITLE: 12" D.E. Cabinet Grinding M/c

TDS II

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt</u>			
		Ref: M $3/8"$ x 40° x 5'	—		Brunner
		<u>Circlips</u>			
		Ref: 1400 / $3/8"$ External	—	2	Andertons
		<u>Motor</u>			
		<u>HOOPER</u>			
		1 1/2 h.p. 3 phase ref: 2534 HAF 1633		1	Hoover
		<u>Starter Motor</u>			
		3 phase ref: AT3 - 3C1	—	1	Brooke
		<u>Starter Station</u>			
		Ref: F5	—	1	"
		<u>Drain Plugs</u>			
		1/4 B.S.P ref: 1448 B.	—	2	Enots.
		<u>Bearings</u>			
		Deep Groove ref: 6304ZZ	—	2	D. K. Brgs.
		<u>Grinding Wheels</u>			
		12" Dia ref: A30	—	1	Mitchell
		12" Dia ref: A60	—	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. General Arrt

DATE

10.3.67

TITLE: 12" D.E. Cabinet Grinding M/c

TDS II

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Grubs</u>			
		5/16" wh. x 1/4" long dog pt	—	3	Unbrako
		" x " kn cup pt	—	3	"
		" x 1/2" " " " "	—	2	"
		<u>Skt hd shoulder screws</u>			
		1/2" dia x 3/8" whit x 2 1/4" long	—	4	Unbrako
		<u>Scr. slotted c'sk screws</u>			
		1/4" whit x 5/8" long	—	6	
		<u>Ch. hd. Screws</u>			
		2 B.A. x 1/2" long	—	4	
		<u>Self tapping screws</u>			
		No 8 x 1/2" long	—	13	
		<u>Set Screws</u>			
		1/4" whit x 1/2" long	—	4	
		" x 3 1/2" "	—	2	
		5/16" " x 1" "	—	4	
		3/8" " x 1/2" "	—	4	
		3/8" " x 1 1/4" "	—	4	
		<u>Dowel</u>			
		1/8" D. x 1/2" long	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. General Arrt.

DATE

10.3.67

TITLE: 12" D.E. Cabinet Grinding M/c

TDS 11

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Nuts</u>			
		3/8" std. whit	—	8	
		5/16" " "	—	4	
		1/4" " "	—	2	
		5/8" " "	—	2	
		3/4" " " L.H. & R.H.	—	1 each.	
		<u>Washers.</u>			
		1/4" std washer	—	2	
		3/8" " "	—	12	
		5/8" " "	—	2	
		<u>Charts</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 swg	Brass Sh.	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"
		CH135 : 2 3/16" x 3/4"	—	1	Metal Cal.
		<u>Rivets Hdn. Brass</u>			
		Type 'U' x 3/16" long	—	8	
		<u>Rd. hd. Screws</u>			
		1/4" whit x 1/2" long	—	4	
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box. ref C6103	—	1	GEC.
		Cover ref. CA 4501	—	1	Oriental Tube Co.
		Male Insert 3/4" dia. 16 T.P.I. Conduit thrd.	Brass	1	
		Locknut " " "	Steel	1	

SHEET No.

1

DATE _____

6. 7. 72.

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

ASSY. DRG. No. General Assembly. T.D.S. II.C.P.

TITLE: 12" D.E. Cabinet Grinder M/c with coolant.

SHEET No.

1A.

DATE _____

6. 7. 72.

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. General Assembly

DATE

10.3.67

TITLE: 12" D.E. Cabinet Grinding M/c with Coolant TDS11CP

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF
		<u>Ch. hd. screw</u>			
		2 B.A. x 1/2" long	—	2	
		<u>Set screws</u>			
		5/16" whit x 1" long - now 1 1/4"	—	2	
		<u>Nuts & Washers</u>			
		5/16" whit nut & std washer		2 each.	
		5/16" Dubo rings	Nylon	4	—
		<u>C'sk scr. slotted screws</u>			
		5/16" whit x 1" long	—	2	
		Cable clip single way	—	1	
		<u>Tubing clips</u>		2	Ends.
		<u>Self-tapping screw</u>			
		Nº 8 x 3/8" long	—	1	
		<u>Hdn brass rivets</u>			
		Type 'U' x 3/16" long	—	4	
		<u>Grinding Wheels</u>			
		12" x 1" x 3/4" recessed : ref: A30	—	1	Mitchell
		" x " x " " : ref: A60	—	1	"
		These grinding wheels are used in place of the std. wheels.			

SHEET No.

ASSY. DRG. No. Diamond Dressing Tool Holder B.O.Parts.

TITLE: 12" Viceroy Grinder G M 101

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrt. GM103

DATE

1.7.66

TITLE: 10" Double Ended Pedestal Grinder TDS 7/10".

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM102	1	R.H. wheel Guard.	C.I.	1	Casting
"	2	L.H. " "	"	1	"
"	4	Toolrest bracket	"	2	"
"	5	Outer End Cover	"	2	"
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	9	Toolrest	"	2	"
"	10	Moving Spork Guard	Alum	2	"
"	13	Outer Disc	Mall. Iron	4	"
"	15	Pivot Pin	M.S.	2	3/4" D. x 3 5/16"
"	16	Spindle	"	1	1 1/4" D. x 15 1/8"
"	17	Locking bolt	"	2	5/8" D. x 2 1/2"
"	18	" Pin	"	2	1/2" D. x 2 5/8"
"	23	Distance Piece	"	2	1 1/4" D. x 7/8"
"	31	Headstock Cover	Sh. Steel.	1	16 swg.
"	33	Extractor Hole Cover Plate	"	2	"
"	68	LOCKING BOLT NUT	ENB	2	1 3/8" x 7/8"
GM103	1	Baseplate	C.I.	1	Casting.
"	9	Crank Bolt	M.S.	1	3/8" D. x 8"
"	15	Cabinet (with GM103/14 - Door attached)	Sh. Steel	1	12 swg.
"	19	Extension Stud. (Std. Set screw)	M.S.	1	5/16" x 1/2" long
"	20	WHEEL VISOR	Sh. Steel.	2.	12 swg.
SP	109	Micro-switch bracket	Sh. Steel.	1	12 swg.
"	114	Motor Platform	C.I.	1.	Casting.
"	124	Pivot Pin	M.S.	1	3/8" D. x 5 3/8"
CH	100	Nameplate	Brass Sh.	1	See B.O. Parts.
"	101	Lubrication chart	"	1	"
"	134	Safe Working Speed Chart	Metal Cal	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Att. GM103 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Ended Pedestal Grinder TDS 7/10"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt.</u>			
		Ref: M $3\frac{1}{8}$ " x 40° x 5'	—	1	Brammer.
		<u>Circlips</u>			
		Ref: 1400 $3\frac{1}{8}$ " External.	—	2	Andertons.
		<u>Motor.</u>			
		$\frac{3}{4}$ h.p. single phase ref: 2310 HAF 1633A	—	1	Hoover
		OR.			
		$\frac{3}{4}$ h.p. 3 phase ref: 2543 HAF 1633B	—	1	"
		<u>Starter Motor.</u>			
		Single phase ref: ATF - 2 D1.	—	1	Brook
		OR.			
		3 phase ref: ATF - 3 B1.	—	1	"
		<u>Bearings.</u>			
		Deep Groove ref: 6304ZZ	—	2	D.K. Brgs.
		<u>Grinding Wheels.</u>			
		10" x 1" x $\frac{3}{4}$ " ref A60	—	1	Mitchells
		10" x 1" x $\frac{3}{4}$ " ref A30	—	1	"
		<u>Grubs.</u>			
		$\frac{5}{16}$ " wh. x $\frac{1}{4}$ " long - dog pt.	—	3	Unbrako
		" x " - kn. cup pt.	—	3	"
		" x $\frac{1}{2}$ " long - " " "	—	2	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18

ASSY. DRG. No. General Arrt. G.M.103 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Ended Pedestal Grinder TDS 7/10"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt. hd. Shoulder Screws.</u>			
		1/2" dia x 3/8" whit x 2" long	—	4	Unbrako.
		<u>Rd hd Screws.</u>			
		1/4" whit x 1/2" long	—	4	
		<u>Scr Slotted C'sk Screws.</u>			
		1/4" wh. x 5/8" long	—	6	
		<u>Ch. hd. Screws.</u>			
		2 BA x 1/2" long	—	5	
		<u>Self-Tapping Screws.</u>			
		N° 8 x 1/2" long	—	4	
		N° 6 x 3/8" long	—	3	
		N° 6 x 5/16" long c'sk	—	2	
		<u>Set Screws.</u>			
		1/4" wh. x 3 1/4" long	—	2	
		3/8" wh x 1/2" long	—	4	
		5/16" wh. x 1" long	—	4	
		3/8" whit x 1 1/4" long	—	4	
		<u>Nuts.</u>			
		1/4" std whit	—	2	
		5/16" " "	—	4	
		3/8" " "	—	8	
		3/4" " " L.H.	—	1	
		3/4" " " R.H.	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. General Art. GM103 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Ended Pedestal Grinder TDS 7/10"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Washers.</u>			
		1/4" std washer	—	2	
		3/8" " "	—	12	
		<u>Dowel.</u>			
		1/8" D. x 1/2" long	—	1	
		<u>Charts.</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 swg	Brass Sh	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"
		CH134 : 2 3/16" x 3/4"	—	1	Metal Cal.
		<u>Rivets Hdn. Brass.</u>			
		Type U x 3/16" long	—	8	
		Single cable clip.	—	1	
		<u>Micro Switch.</u>			
		Ref: DS3 - 521	—	1	Burgess.
		<u>Plastic knob.</u>			
		1 1/4" Dia x 5/16" whit.	Plastic	1	Mc millan.
		<u>Stud & Latch.</u>			
		Stud ref: SBV/1698/17/0	—	1	Stenor
		Latch " : SRV/1637/17/0	—	1	"

1 D

12.7.67.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box. ref C 6103	—	1	Gr. E.C.
		Cover ref CA 4501	—	1	Oriental Tube Co.
		Male insert 3/4" dia. 16 T.P.I. Conduit thrd.	Brass	1	
		Lock nut " " "	Steel	1	
24.103	3	Motor Pulley.	Aluminium	1	Coles.

SHEET No

ASSY. DRG. No. G.M.102/A.

TITLE: Drill Grinding Machine.

3.1.68.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
G.M. 102	1A	L. H. Guard.	C. I.	1	Casting.
"	2A	R. H. Guard.	C. I.	1	"
"	34	Headstock tray.	Sheet steel	1	12 SWG.
"	35	Drill setting plate. (from Reliance.)	Alum. sheet	1	20 SWG.
"	36	Guard cover plate.	Sheet steel	1	12 SWG.
All other parts as for G.M. 103 - 10" Double ended Ped. Grinder TDS. 7/10". excluding G.M. 102/1 & 2.					

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

ASSY. DRG. No. CM.102 / A. B.O. parts.

TITLE: Drill Grinding Machine.

SHEET No.

1A

DATE

3.1.68.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		See parts lists for 10"			
		Double ended Ped. Grinder			
		T.D.S. 7/10" - but replace			
		10" x 1" x 3/4" ref. A60			
		8 " " " " A30 wheels			
		with. 10" x 2" x 3/4" - recessed			
		7" dia x 15/16" deep - A.80.			
		8 10" x 1 1/2" x 3/4" - A.80 wheels.			
		from Abrafract.			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrt.

DATE

TITLE: 10" Pedestal Grinding / Polishing M/c

TDS8/10"

9.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM102	1 or 2	R.H. or L.H. Wheel Guard	C.I.	1	Casting.
"	4	Toolrest Bracket	"	1	"
"	5	Outer end cover	"	2	"
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	9	Toolrest	"	1	"
"	10	Moving Spark Guard	Alum.	1	"
"	13	Outer Disc	Mall. Iron	2	"
"	15	Pivot Pin	M.S.	1	3/4" dia x 3 5/16"
"	16	Spindle	"	1	1 1/4" dia x 15 1/8"
"	17	Locking Bolt	"	1	5/8" dia x 2 1/2"
"	18	" Pin	"	1	1/2" dia x 2 5/8"
"	23	Distance Piece	"	2	1 1/4" dia x 7/8"
"	31	Headstock Cover	Sh. Steel	1	16 swg
"	33	Extractor Hole Cover Plate	"	1	"
"	68	LOCKING BOLT NUT.	EN8	1	1 3/8" DIA. x 7/8"
GM103	1	Baseplate	C.I.	1	Casting
"	9	Crank Bolt	M.S.	1	3/8" D. x 8"
"	15	Cabinet (with GM103/14 - Door attached)	Sh. Steel	1	12 swg
"	19	Extension Stud (Std. set screw)	M.S.	1	5/16" wh. x 1/2" long
"	20	WHEEL VISOR	Sh. Steel	1	12 SWG.
SP	109	Micro-Switch Bracket	Sh. Steel	1	12 swg.
"	114	Motor Platform	C.I.	1	Casting
"	124	Pivot Pin	M.S.	1	3/8" D. x 5 3/8"
CH	100	Nameplate	Brass Sh.	1	See Bo. Ports
"	101	Lubrication Chart	"	1	"
"	134	Safe Working Speed Chart	Metal Cal	1	"
These Parts Lists are to be used in conjunction with GM118 Sheet 1 or 2 Parts Lists (Polishing Guards)					

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Arrt.

B.O. Parts

DATE

9.3.67

TITLE: 10" Pedestal Grinding/Polishing M/c

TDS8/10"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt</u>			
		Ref: M $3\frac{3}{8}$ " x 40° x 5'	—	1	Brammer
		<u>Circlips</u>			
		Ref: 1400 $3\frac{3}{8}$ " External	—	2	Andertons
		<u>Motor</u>			
		$\frac{3}{4}$ h.p. single phase ref: 2310 HAF 1633A	—	1	Hoover
		OR			
		$\frac{3}{4}$ h.p. 3 phase ref: 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Single Phase ref: ATF - 2DI	—	1	Brook
		OR			
		3 phase ref: ATF - 3BI	—	1	"
		<u>Bearings</u>			
		Deep groove ref: 6304 ZZ	—	2	D.K. Brgs.
		<u>Grinding Wheel</u>			
		10" x 1" x $\frac{3}{4}$ " ref A	—	1	Mitchells
		<u>Grubs</u>			
		$5\frac{1}{16}$ " whit x $\frac{1}{4}$ " long dog pt.	—	3	Unbrako
		" " " kn. ovpt pt.	—	3	"
		" x $\frac{1}{2}$ " long " " "	—	2	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. General Arrt.

B.O. Parts.

DATE

TITLE: 10" Pedestal Grinding / Polishing M/c

TDS8/10"

9.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt hd shoulder screws</u>			
		1/2" dia x 3/8" whit x 2" long	—	2	Unbrako
		<u>Rd. hd Screws</u>			
		1/4" whit x 1/2" long	—	2	
		<u>Scr. slotted c'sk screw</u>			
		1/4" whit x 5/8" long	—	6	
		<u>Ch. hd screws</u>			
		2 B.A. x 1/2" long	—	5	
		<u>Self Tapping Screws</u>			
		N° 8 x 1/2" long	—	4	
		N° 6 x 3/8" "	—	3	
		N° 6 x 5/16" " c'sk	—	2	
		<u>Set Screws</u>			
		1/4" whit x 3 1/4" long	—	1	
		5/16" whit x 1 " "	—	4	
		3/8" " x 1/2" "	—	4	
		3/8" " x 1 1/4" "	—	4	
		<u>Dowel</u>			
		1/8" Dia x 1/2" long	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 C

ASSY. DRG. No. General Ant.

B.O. Parts

DATE

9.3.67

TITLE: 10" Grinder/Polisher Pedestal M/c.

TDS8/10"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Nuts</u>			
		1/4" std whit	—	1	
		5/16" " "	—	4	
		3/8" " "	—	7	
		3/4" " " L.H. or R.H.	—	1	
		2 BA. " nut.	—	1	
		<u>Washers</u>			
		1/4" std washer	—	1	
		3/8" " "	—	11	
		<u>Charts</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 swg	Brass. Sh.	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"
		CH134 : 2 3/16" x 3/4"	—	1	Metal Cal.
		<u>Rivets Hdn brass</u>			
		Type 'U' x 3/16" long	—	8	
		Single cable clip.	—	1	
		<u>Micro-switch</u>			
		Ref: DS3-521	—	1	Burgess
		<u>Plastic knob</u>			
		1 1/4" Dia x 5/16" whit	Plastic	1	Mc millan

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrt.

DATE

TITLE: Double Ended Pedestal Polishing M/c

TDS9.

6.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
G-M102	5	Outer End Cover	C.I.	2	Casting.
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	16	Spindle	M.S.	1	1 1/4" D. x 15 1/8"
"	23	Distance Piece	"	2	1 1/4" D. x 7/8"
"	31	Headstock Cover	Sh. Steel.	1	16 sug.
G-M103	1	Baseplate	C.I.	1	Casting
"	9	Crank Bolt	M.S.	1	3/8" D. x 8"
"	15	Cabinet (with G-M103/14 - Door attached)	Sh. Steel.	1	12 sug.
"	19	Extension Stud. (Std. set screw)	M.S.	1	5/16" Whit x 1 1/2"
SP10					
SP	109	Micro - Switch Bracket	Sh. Steel	1	12 sug.
"	114	Motor Platform	C.I.	1	Casting
"	124	Pivot Pin	M.S.	1	3/8" D. x 5 3/8"
CH	100	Nameplate	Brass. Sh.	1	See B.O. Parts.
"	101	Lubrication Chart	"	1	"
		These Parts Lists are to be used in conjunction with Parts Lists G-M118 sheets 1 & 2 (Polishing Guards).			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Arrt.

B.O. Parts.

DATE

9.3.67

TITLE: Double Ended Pedestal Polishing M/c

TDS9

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt</u>			
		Ref: M $3\frac{1}{8}$ " x 40° x 5'	—	1	Brammer
		<u>Circlips</u>			
		Ref 1400 / $3\frac{1}{8}$ " External	—	2	Andertons
		<u>Motor</u>			
		$\frac{3}{4}$ h.p. single phase ref: 2310 HAF 1633A	—	1	Hoover
		OR			
		$\frac{3}{4}$ h.p. 3 phase ref: 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Single phase ref: ATF - 2DI	—	1	Brook
		OR			
		3 phase ref: ATF - 3BI	—	1	"
		<u>Bearings</u>			
		Deep groove ref: 6304ZZ	—	2	D. K. Brgs.
		<u>Grubs</u>			
		$\frac{5}{16}$ " whit x $\frac{1}{4}$ " long - dog pt	—	3	Unbrako
		" x " - kn cup pt	—	3	"
		" x $\frac{1}{2}$ " — " " "	—	2	"
		<u>Scr slotted c'sk screws</u>			
		$\frac{1}{4}$ " whit x $\frac{5}{8}$ " long	—	6	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. General Arrt.

B.O. Parts

DATE

9.3.67

TITLE: Double Ended Pedestal Polishing M/c

TDS9

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Ch. hd screws</u>			
		2 BA. x 1/2" long	—	5	
		<u>Self Tapping Screws</u>			
		N° 8 x 1/2" long	—	4	
		N° 6 x 5/16" c'sk	—	2	
		N° 6 x 3/8 long	—	3	
		<u>Set Screws</u>			
		5/16" whit x 1" long	—	4	
		3/8" " x 1/2" "	—	4	
		3/8" whit x 1/4" "	—	4	
		<u>Nuts</u>			
		3/8" std whit	—	6	
		5/16" " "	—	4	
		2 BA " nut	—	1	
		<u>Washers</u>			
		3/8" std washer	—	10	
		<u>Dowel</u>			
		1/8" dia x 1/2" long	—	1	
		<u>Charts</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 swg	Brass Sh.	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. General Arrt.

B.O. Parts.

DATE

9.3.67

TITLE: Double Ended Polishing Pedestal M/c

TDS9

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Rivets Hdn Brass</u>			
		Type 'U' x 3/16" long	—	8	
		Single Cable Clip	—	1	
		<u>Micro-Switch</u>			
		Ref: DS3 - 521	—	1	Burgess
		<u>Plastic knob</u>			
		1 1/4" dia x 5/16" whit	Plastic	1	Mcmillan
		<u>Stud & Latch</u>			
		Stud ref: SBV/1698/17/0	—	1	Stenor
		Latch " : SRV/1637/17/0	—	1	"
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box. ref C6103	—	1	G.E.C.
		Cover ref: CA 4501	—	1	Oriental Tube Co.
		Male Insert 3/4" dia . 16T.P1 Conduit thrd,	Brass	1	
		Locknut " " " "	Steel	1	
G.M.103	4	Motor Pulley.	Aluminium	1	Coles.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrt. GM107.

DATE

1.7.66.

TITLE: 10" Double Ended Cabinet Grinder TDS10.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM102	1	R.H. Wheel Guard	CI	1	Casting
"	2	L.H. " "	"	1	"
"	4	Toolrest Bracket	"	2	"
"	5	Outer End Cover	"	2	"
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	9	Toolrest	"	2	"
"	10	Moving Spark Guard.	Alum	2	"
"	13	Outer Disc.	Mall. Iron	4	"
"	15	Pivot Pin	M.S.	2	3/4" Dia x 3 5/16"
"	16	Spindle	"	1	1 1/4" D. x 15 1/8"
"	17	Locking Bolt	"	2	5/8" D. x 2 1/2"
"	18	" Pin	"	2	1/2" D. x 2 5/8"
"	23	Distance Piece	"	2	1 1/4" D x 7/8"
"	31	Headstock Cover	Sh. Steel	1	16 swg
"	33	Extractor Hole Cover Plate	"	2	"
"	54	Wheel Safety Guard.	Sh Steel	1	"
"	68	LOCKING BOLT NUT.	EN8	2	1 3/8" DIA. x 7/8"
"	50	A Full wheel COVER.	SH STEEL	1	16 SW.G.
GM103	1	Baseplate	CI	1	Casting
"	9	Crank Bolt	M.S.	1	3/8" D. x 8"
GM107	1	Cover Plate	Sh. Steel	1	16 swg.
"	2	Cabinet	"	1	12 swg.
"	3	Tray	"	1	"
SP	114	Motor Platform	CI.	1	Casting
"	124	Pivot Pin	M.S.	1	3/8" D. x 5 3/8"
"	146	Cover Plate	Sh. Steel.	1	12 swg.
CH	100	Nameplate	Brass Sh.	1	See B.O. Parts
"	101	Lubrication Chart	"	1	"
"	134	Safe Working Speed Chart	Metal Cal	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Ant G4107 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Endend Cabinet Grinder TDS10.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt.</u>			
		Ref: M $3\frac{1}{8}$ " x 40° x 5'	—	—	Brammer.
		<u>Cirelips.</u>			
		Ref: 1400 $3\frac{1}{8}$ " External	—	2	Andertons.
		<u>Motor</u>			
		$\frac{3}{4}$ h.p. single phase ref: 2310 HAF1633A	—	1	Hoover
		or			
		$\frac{3}{4}$ h.p. 3 phase ref: 2543 HAF1633B	—	1	"
		<u>Starter Motor.</u>			
		Single phase ref: AT3-2D1	—	1	Brook
		or			
		3 phase ref: AT3-3B1	—	1	"
		<u>Starter Station.</u>			
		Ref: F5	—	1	"
		<u>Drain Plug.</u>			
		$\frac{1}{4}$ " B.S.P. ref 1448B.	—	2	Enots.
		<u>Bearings.</u>			
		Deep groove ref: 6304 ZZ	—	2	D. K. Brgs.
		<u>Grinding Wheels.</u>			
		10" x 1" x $\frac{3}{4}$ " ref A60	—	1	Mitchells
		10" x 1" x $\frac{3}{4}$ " ref A30	—	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18

ASSY. DRG. No. General Arrt. G M107 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Ended Cabinet Grinder. T.D.S.10.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Grubs.</u>			
		5/16" whit x 1/4" long dog pt.	—	3	Unbrako
		" x " kn. cup pt.	—	3	"
		" x 1/2" " " " "	—	2	"
		<u>Sket hd Shoulder Screws.</u>			
		1/2" dia x 3/8" whit x 2" long	—	4	"
		<u>Rd. hd. Screws.</u>			
		1/4" whit x 1/2" long	—	4	
		<u>Scr. Slotted C'sk Screws.</u>			
		1/4" whit x 5/8" long	—	6	
		<u>Ch. hd. Screws.</u>			
		2 B.A. x 1/2" long	—	4	
		<u>Self tapping Screws.</u>			
		No 8 x 1/2" long	—	13	
		<u>Set Screws.</u>			
		1/4" whit x 3 1/4" long	—	2	
		5/16" whit x 1/2" long	—	4	
		3/8" whit x 1/2" long	—	4	
		3/8" whit x 1 1/4" long	—	4	
		1/4" whit x 1/2" long	—	4	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. General Arrt. G M107 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Ended Cabinet Grinder

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Nuts.</u>			
		3/8" std whit	—	12	
		1/4" " "	—	2	
		3/4" " " L.H.	—	1	
		" " " R.H.	—	1	
		<u>Washers.</u>			
		1/4" std washer	—	2	
		5/16" " "	—	4	
		3/8" " "	—	8	
		<u>Dowel.</u>			
		1/8" D. x 1/2" long	—	1	
		<u>Charts.</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 swg	Brass Sh.	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"
		CH134 : 2 3/16" x 3/4"	—	1	Metal Cal.
		<u>Rivets Hot Brass.</u>			
		Type U x 3/16" long	—	8	
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box. ref C 6103	—	1	G.E.C.
		Cover ref. CA4501	—	1	Oriental Tube Co.
		Male insert 3/4" dia 16 T.P.I. Conduit thrd.	Brass	1	
		Locknut " " " "	Steel	1	
G.M.103	3	Motor Pulley.	Aluminium	1	Coles.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Assembly

DATE

10.3.67

TITLE: 10" D.F. Cabinet Grinding M/c with Coolant. TDS10C.P.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM114	1	2 Inlet Top Handle Extension	M.S.	1	3" x 2 1/2"
GM114	6	Splash Guard	"	1	"
GM114	6	Splash Guard	"	1	"
SP162		Eccentric	M.S.	1	1" ϕ x 1 9/16"
GM125	1	Pump Bracket	C.I.	1	Casting
GM114	2	Distance Piece.	M.S.	2	2" dia x 5/8"
"	9	Coolant Pipe Connector.	M.S. hex bar	1	1.100 A/F x 2 3/4"
CH	119	Water Chart	Brass Sh.	1	See B.O. Parts
"	134	Safe Working Speed Chart	Metal Eal	1	"
These parts lists are to be used in conjunction with the 10" Cabinet Grinder parts lists.					

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18

ASSY. DRG. No. General Assembly

DATE

10.3.67

TITLE: 10" D.E. Cabinet Grinding M/c with Coolant TDS 10 C.P.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Ch. hd screw</u>			
		2 B.A. x 1/2" long	—	2	
		<u>Set screws</u>			
		5/16" whit x 1" long	—	2	
		<u>Nuts & Washers</u>			
		5/16" whit nut & std. washer	—	2 each	
		<u>C'sk scr. slotted screws</u>			
		5/16" whit x 1" long	—	2	
		Cable clip single way	—	1	
		<u>Self-tapping screw</u>			
		No 8 x 3/8" long	—	1	
		<u>Hdn. Brass Rivets</u>			
		Type U x 3/16" long	—	4	
		<u>Grinding Wheels</u>			
		10" x 1" x 3/4" bore recessed ref A60	—	1	Mitchell
		10" x 1" x 3/4" " " ref A30	—	1	"
		These wheels are used instead of the std. wheels.			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Double Grinder/Polishing M/c G M127

DATE

TITLE: 10" Viceroy Double Grinder/Polishing M/c Pedestal

3.1.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
G M127	1	Centre Cover Plate	Sh. Steel.	1	12 swg.
"	2	Outer " "	"	1	"
"	3	" " Shroud	"	1	"
"	4	Inner Cover Plate	"	1	"
"	5	Distance Piece	M.S.	1	2" D. x 1 3/4"
"	6	Spindle	M.S.	1	1 1/4" D. x 18 1/2"
"	7A & B	L.H. & R.H. Moving Spark guard (Casting G M102/10)	Alum	1 each	Casting.
"	8	Nut Cover	Sh. Steel	1	12 swg.
"	9	Pivot Pin	M.S.	1	3/4" dia x 7 1/4"
"	10A & B	L.H. & R.H. Toolrest (Casting G M102/9)	C.I.	1 each	Casting
"	11	Swing Protecting Strip	M.S.	1	3 1/16" x 3/4" x 8"
"	12	Pivot	M.S.	1	1/4" sq x 3 3/8"
<u>Additional Parts Req.</u>					
G M100	28	Toolrest Bracket R.H.	C I	1	Casting
G M102	4	" " L.H.	"	1	"
"	5	Outer End Cover	"	2	"
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	13	Outer disc	Mall Iron	4	"
"	17	Locking Bolt	M.S.	2	5/8" D x 2 1/2"
"	18	" Pin	"	2	1/2" D. x 2 5/8"
"	23	Distance Piece	"	2	1 1/4" Dia x 7/8"
"	31	Headstock Cover	Sh. Steel	1	16 swg.
"	49	10" Crocodile	"	2	12 swg
"	51	Crocodile Hinge	B.O. Part	2	1 1/2" x 2 7/8"
G M103	1	Baseplate	Alum	1	"
"	9	Crank Bolt	M.S.	1	3/8" D x 8"
"	15	Cabinet	Sh. Steel	1	12 swg
"	19	Extension Stud (Std set screw)	M.S.	1	5/16" whit x 1/2" long

TITLE: 10" Viceroy Double Grinder/Polishing M/c Pedestal

2

DATE _____

3.1.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Additional Parts Req.</u>			
SP	109	Micro-switch bracket	Sh. Steel	1	12 swg.
"	114	Motor Platform	Cl.	1	Casting
"	124	Pivot Pin	M.S.	1	3/8" D. x 5 3/8"
CM	100	Nameplate	Brass Sh.	1	See B.O. Part
"	101	Lubrication Chart	"	1	" "
"	134	Safe Working Speed Chart	Metal Cal	1	" "
		For list of parts used on polishing spindle & guard see G-M 118 Parts Lists sheets 1 or 2.			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. B.O. Parts G M 127

DATE

TITLE: 10" Viceroy Double Grinder / Polishing M/c Pedestal

3.1.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt</u>			
		Ref : M $3\frac{3}{8}$ " x 40° x 5'	—	1	Brammer
		<u>Circlips</u>			
		Ref : 1400 / $3\frac{3}{8}$ " External	—	2	Andertons
		<u>Motor</u>			
		$\frac{3}{4}$ h.p. Single phase ref: 2310 HAF 1633A	—	1	Hoover
		OR			
		$\frac{3}{4}$ h.p. 3 phase ref: 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Single phase ref: ATF - 2D1	—	1	Brook
		OR			
		3 phase ref: ATF - 3B1	—	1	"
		<u>Bearings.</u>			
		Deep groove ref: 6304ZZ	—	2	D.K. Brgs.
		<u>Grinding Wheels.</u>			
		10" x 1" x $\frac{3}{4}$ " ref: A60	—	1	Mitchells
		10" x 1" x $\frac{3}{4}$ " ref: A30	—	1	"
		<u>Grubs.</u>			
		$\frac{5}{16}$ " whit x $\frac{1}{4}$ " long	—	3	Unbrako
		" x "	—	3	"
		" x $\frac{1}{2}$ " "	—	2	"
		2 BA x $\frac{1}{4}$ " "	—	2	"
		dog pt	—		
		kn cup pt	—		
		" " "	—		
		" " "	—		

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. B.O. Parts G M 127

DATE

3.1.67

TITLE: 10" Double Grinder/Polishing M/c Pedestal

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt hd Shoulder Screws.</u>			
		1/2" dia x 3/8" whit x 2" long	—	2	Unbrako
		<u>Scr. Slotted C'sk Screws.</u>			
		1/4" whit x 5/8" long	—	6	
		<u>Cheese hd screws.</u>			
		2 B.A. x 1/2" long	—	5	
		<u>Self Tapping Screws.</u>			
		N° 6 x 5/16" long c'sk	—	2	
		" x 3/8" "	—	3	
		N° 8 x 1/2" long	—	4	
		<u>Set Screws.</u>			
		5/16" whit x 1" " long	—	4	
		3/8" " x 1/2" "	—	4	
		3/8" " x 1 1/4" "	—	4	
		<u>Nuts & Washers.</u>			
		1/4" std whit & washers	—	3	
		3/8" " " "	—	12	
		5/8" " " "	—	2	
		3/4" " " L.H. Form	—	1	
		2 BA "	—	1	
		<u>Dowel</u>			
		1/8" Dia x 1/2" long	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No

1C

ASSY. DRG. No. B.O. Parts G M 127

DATE

3.1.67

TITLE: 10" Viceroy Double Grinder / Polishing M/c Pedestal.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Charts.</u>			
		CH100 : $4\frac{3}{8}" \times 3\frac{1}{8}" \times 24$ swg	Brass Sh.	1	Brig Engr.
		CH101 : $2\frac{3}{4}" \times 1\frac{3}{4}" \times$ "	"	1	" "
		CH134 : $2\frac{3}{16}" \times \frac{3}{4}"$	—	1	Metal Cal.
		<u>Rivets Hdn Brass.</u>			
		Type U x $\frac{3}{16}"$ long	—	8	
		Rd hd steel $\frac{3}{32}"$ dia x $\frac{3}{8}"$ long	—	6	
		<u>Micro - Switch</u>			
		Ref: DS3 - 521	—	1	Burgess
		<u>Plastic Knob</u>			
		$1\frac{1}{4}"$ dia with $\frac{5}{16}"$ whit brass insert	Plastic	1	Mc millan
		<u>Stud & Latch</u>			
		Stud ref: SBV / 1698 / 17 / 0	—	1	Stenor
		Latch ref: SRV / 1637 / 17 / 0	—	1	"
		Single cable clip	—	1	
		<u>Skt hd c'sk screws.</u>			
		2 BA x $\frac{1}{2}"$ long	—	6	Unbrako
		<u>Clear Tube</u>			
		$\frac{3}{4}"$ O.D. x $\frac{1}{2}"$ I.D. x $\frac{1}{2}"$ long	—	1	
		<u>Hinge.</u>			
		G M 102 / 51 $1\frac{1}{2}"$ wide x $2\frac{7}{8}"$ long	Piano hinge	2	

SHEET No
1 D.

B.O. Parts.

DATE
12.7.67

TITLE: 10" Viceroy Double Grinder / Polishing M/c Pedestal.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box. ref C 6103	—	1	G.E.C.
		Cover ref CA 4501	—	1	Oriental Tube Co.
		Male insert $\frac{3}{4}$ " dia 16 T.P.I. Conduit thrd.	Brass	1	
		Locknut " " " "	Steel	1	
G.M.103	3	Motor Pulley.	Aluminium	1	Coles.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Double Grinder / Polishing M/c GM127

DATE

TITLE: 10" Viceroy Double Grinder / Polishing M/c Cabinet.

3.1.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM127	1	Centre Cover Plate	Sh. Steel	1	12 swg
"	2	Outer " "	"	1	"
"	3	" " Shroud	"	1	"
"	4	Inner Cover Plate	"	1	"
"	5	Distance Piece	M.S.	1	2" dia x 1 3/4"
"	6	Spindle	"	1	1 1/4" D. x 18 1/2"
"	7A & B	L.H. & R.H. Moving Spark Guard (Casting GM102/10)	Alum	1 each	Casting.
"	8	Nut Cover	Sh. Steel	1	12 swg
"	9	Pivot Pin	M.S.	1	3/4" dia x 7 1/4"
"	10A & B	L.H. & R.H. Toolrest (Casting GM102/9)	C.I.	1 each	Casting
"	11	Swing Protecting Strip	M.S.	1	3/16" x 3/4" x 8"
"	12	Pivot	"	1	1/4" sq x 3 3/8"
<u>Additional Parts Req.</u>					
GM100	2B	Toolrest Bracket R.H.	C.I.	1	Casting
GM102	4	" " L.H.	"	1	"
"	5	Outer End Cover	"	2	"
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	13	Outer disc	Mall. Iron	4	"
"	17	Locking Bolt	M.S.	2	5/8" D. x 2 1/2"
"	18	" Pin	"	2	1/2" D. x 2 5/8"
"	23	Distance Piece	"	2	1 1/4" D. x 7/8"
"	31	Headstock Cover	Sh. Steel.	1	16 swg.
"	49	10" Crocodile	"	2	12 swg
"	51	Crocodile Hinge	B.O. Part	2	1 1/2" x 2 7/8"
GM103	1	Baseplate	C.I.	1	Casting
"	9	Crank Bolt	M.S.	1	3/8" D x 8"
GM107	1	Cover Plate	Sh. Steel	1	16 swg
"	2	Cabinet	"	1	12 swg

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. B.O. Parts G M127

DATE

3.1.67

TITLE: 10" Viceroy Double Grinder / Polishing M/c Cabinet

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt</u>			
		Ref: M $\frac{3}{8}$ " x 40" x 5'	—		Brammer
		<u>Circlips.</u>			
		Ref: 1400/ $\frac{3}{8}$ " External	—	2	Andertons
		<u>Motor</u>			
		$\frac{3}{4}$ h.p. single phase ref: 2310 HAF 1633A OR	—	1	Hoover
		$\frac{3}{4}$ h.p. 3 phase ref: 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Single phase ref: AT3-2D1 OR	—	1	Brook
		3 phase ref: AT3-3B1	—	1	"
		<u>Starter Station</u>			
		Ref: F5	—	1	"
		<u>Drain Plug.</u>			
		$\frac{1}{4}$ " BSP ref: 1448 B	—	2	Enots
		<u>Bearings</u>			
		Deep groove ref: 6304 ZZ	—	2	D. K. Brgs.
		<u>Grinding Wheels</u>			
		10" x 1" x $\frac{3}{4}$ " x A60 ref	—	1	Mitchells
		10" x 1" x $\frac{3}{4}$ " x A30 ref	—	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. B.O. Parts GM127

DATE

3.1.67

TITLE: 10" Viceroy Double Grinder/Polishing M/c Cabinet

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Grubs</u>			
		5/16" whit x 1/4" long dog pt	—	3	Unbrako
		" x " kn cup pt	—	3	"
		" x 1/2" " " " "	—	2	"
		2 BA x 1/4" " " " "	—	2	"
		<u>Sk't hd shoulder screws.</u>			
		1/2" dia x 3/8" whit x 2" long	—	2	Unbrako
		<u>Scr. slotted c'sk screws.</u>			
		1/4" whit x 5/8" long	—	6	
		<u>Cheese hd screws</u>			
		2 B.A. x 1/2" long	—	4	
		<u>Self Topping screws</u>			
		No 8 x 1/2" long	—	13	
		<u>Set Screws</u>			
		5/16" whit x 1" long	—	4	
		3/8" " x 1/2" "	—	4	
		3/8" whit x 1 1/4" "	—	4	
		<u>Nuts & Washers.</u>			
		1/4" std whit & washers	—	3	
		3/8" " " "	—	12	
		3/4 " " L.H. Form	—	1	
		5/8" " " & washers	—	2	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Assembly

DATE

10.3.67

TITLE: 12" D.E. Cabinet Grinding M/c

TDS II.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM102	5	Outer End Cover	C.I.	2	Casting
"	7	Spindle Pulley	"	1	"
"	13	Outer Disc	Mall. Iron	4	"
"	15	Pivot Pin	M.S.	2	3/4" D. x 3 3/4"
"	17	Locking bolt	"	2	5/8" D. x 2 1/2"
"	18	" pin	"	2	1/2" D. x 2 7/8"
"	23	Distance Piece	"	2	1 1/4" D. x 7/8"
"	31	Headstock Cover	Sh. Steel	1	16 swg.
GM103	9	Crank Bolt	M.S.	1	3/8" D. x 8"
GM107	1	Cover Plate	Sh. Steel	1	12 swg.
GM110	1	R.H. Wheel Guard	C.I.	1	Casting
"	2	L.H. " "	"	1	"
"	3	Toolrest Bracket	"	1	"
"	4	Toolrest	"	1	"
"	5	Motor Pulley	Alum	1	"
"	6	Spindle	M.S.	1	1 1/4" D. x 19 3/4"
"	10	Moving Spark Guard	Alum.	1	Casting
"	11	Headstock	C.I.	1	"
"	12	Cover Plate	Sh. Steel	2	12 swg.
GM111	1	Base plate	C.I.	1	Casting
"	5	Tray	Sh. Steel	1	12 swg.
"	6	Cabinet	"	1	"
SP	114	Motor Platform	C.I.	1	Casting
"	124	Pivot pin	M.S.	1	3/8" D. x 5 3/8"
"	146	Cover Plate	Sh. Steel	1	12 swg.
CH	100	Nameplate	Brass Sh	1	See B.O. Parts
"	101	Lubrication Chart	"	1	"
"	135	Safe Working Speed Chart	Metal Cal	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Arrt.

DATE

10.3.67

TITLE: 12" D.E. Cabinet Grinding M/c

TDS II

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt</u>			
		Ref: M $3/8"$ x 40° x 5'	—		Brunner
		<u>Circlips</u>			
		Ref: 1400 / $3/8"$ External	—	2	Andertons
		<u>Motor</u>			
		1 1/2 h.p. 3 phase ref: 2534 HAF 1633		1	Hoover
		<u>Starter Motor</u>			
		3 phase ref: AT3 - 3C1	—	1	Brooke
		<u>Starter Station</u>			
		Ref: F5	—	1	"
		<u>Drain Plugs</u>			
		1/4 B.S.P ref: 1448 B.	—	2	Enots.
		<u>Bearings</u>			
		Deep Groove ref: 6304ZZ	—	2	D. K. Brys.
		<u>Grinding Wheels</u>			
		12" Dia ref: A30	—	1	Mitchell
		12" Dia ref: A60	—	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18

ASSY. DRG. No. General Arnt

DATE

10.3.67

TITLE: 12" D.E. Cabinet Grinding M/c

TDS II

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Grubs</u>			
		5/16" wh. x 1/4" long dog pt	—	3	Unbrako
		" x " kn cup pt	—	3	"
		" x 1/2" " " "	—	2	"
		<u>Skt hd shoulder screws</u>			
		1/2" dia x 3/8" whit x 2 1/4" long	—	4	Unbrako
		<u>Scr. slotted c'sk screws</u>			
		1/4" whit x 5/8" long	—	6	
		<u>Ch. hd. Screws</u>			
		2 B.A. x 1/2" long	—	4	
		<u>Self tapping screws</u>			
		No 8 x 1/2" long	—	13	
		<u>Set Screws</u>			
		1/4" whit x 1/2" long	—	4	
		" x 3 1/2" "	—	2	
		5/16" " x 1" "	—	4	
		3/8" " x 1/2" "	—	4	
		3/8" " x 1 1/4" "	—	4	
		<u>Dowel</u>			
		1/8" D. x 1/2" long	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. General Amt.

DATE

TITLE: 12" D.E. Cabinet Grinding M/c

TDS II

10.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Nuts</u>			
		3/8" std. whit	—	8	
		5/16" " "	—	4	
		1/4" " "	—	2	
		5/8" " "	—	2	
		3/4" " " L.H. & R.H.	—	leach.	
		<u>Washers.</u>			
		1/4" std washer	—	2	
		3/8" " "	—	12	
		5/8" " "	—	2	
		<u>Charts</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 swg	Brass Sh.	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"
		CH135 : 2 3/16" x 3/4"	—	1	Metal Cal.
		<u>Rivets Hdn. Brass</u>			
		Type 'U' x 3/16" long	—	8	
		<u>Rd. hd. Screws</u>			
		1/4" whit x 1/2" long	—	4	
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box. ref C6103	—	1	GEC.
		Cover ref. CA 4501	—	1	Oriental Tube Co.
		Male Insert 3/4" dia. 16 T.P.I. Conduit thrd.	Brass	1	
		Locknut " " "	Steel	1	

SHEET No.

1

DATE _____

TDS II C.P.

10. 3. 67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM114	1	3 Way Tap Handle Extension	M.S.	1	3/4" d. x 3 1/2"
"	2	Distance piece	"	2	2" d. x 5/8"
"	8	Splash Guard	Sh. Steel	1	12swg
GM116	1	3 Way Tap Bracket	Sh. Steel	1	12swg
GM125	1	Pump Bracket	C.I.	1	Casting
SP	103A	Locking Handle	Mall. Iron	1	Casting
"	"B	" Stud	M.S.	1	3/8" d. x 1 3/4"
"	"C	Pad.	Brass	1	1/4" d. x 1/2"
CH	119	Water Chart	Brass Sh.	1	See B.O. Parts
CH	135	Safe Working Speed Chart	Metal Cal	1	"
These parts lists are to be used in conjunction with the 12" Cabinet Grinder parts lists.					

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Assembly

DATE

10.3.67

TITLE: 12" D.E. Cabinet Grinding M/c with Coolant TDS 11 C.P.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Enots Fittings</u>			
		Fuel cocks ref: T 1	—	2	Rotherhams
		Tailpiece connectors " : Z 371-1	—	3	Enots
		Male Elbow adaptors " : Y105	—	2	"
		3 Way Cock valve " : 44	—	1	Rotherhams
		Female adaptor " : Z181	—	1	Enots
		Sleeve " : Z4	—	1	"
		Tubing Nut " : Z18	—	1	"
		Brass Flanged Plug " : 1385C	—	1	"
		Bulkhead Adaptor " : Z86	—	1	"
		Locknut " : T57	—	1	"
		Tailpiece Adaptor " : Z380-1	—	1	"
		<u>Tubing</u>			
		3/8" o.d. x 5/16" i.d. x 33" long	Clear	1	Gripflex
		3/16" o.d. x 1/16" i.d. x 16" "	Copper	1	
		5/16" o.d. x 22 swg x 4 "	Bundy tube	1	
		<u>Pump</u>			
		ref: E50 - 426	—	1	A.C. Delco.
		<u>Bearing</u>			
		ref: 6200 - 2Z	—	1	- Fag.
		<u>Charts</u>			
		CH119 : 2 1/2" x 1 13/16" x 24 swg	Brass Sh.	1	Brig. Engr.
		CH135 : 2 3/16" x 3/4"	—	1	Metal Cal.

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DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

13

ASSY. DRG. No. General Assembly

DATE

TITLE: 12" D.E. Cabinet Grinding M/c with Coolant TDS11CP

10.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Ch. hd. screw</u>			
		2 B.A. x 1/2" long	—	2	
		<u>Set screws</u>			
		5/16" whit x 1" long	—	2	
		<u>Nuts & Washers</u>			
		5/16" whit nut & std washer		2 each.	
		<u>C'sk scr. slotted screws</u>			
		5/16" whit x 1" long	—	2	
		Cable clip single way	—	1	
		<u>Self-tapping screw</u>			
		No 8 x 3/8" long	—	1	
		<u>Hdn brass rivets</u>			
		Type 'U' x 3/16" long	—	4	
		<u>Grinding wheels</u>			
		12" x 1" x 3/4" recessed : ref: A30	—	1	Mitchell
		" x " x " " : ref: A60	—	1	"
		These grinding wheels are used in place of the std. wheels.			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. SM 101.

DATE

3. 9. 74.

TITLE: VICEROY DISC & BELT SANDER. - BELT SANDER ARR^I.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>B.O. PARTS REQUIRED.</u>			
		<u>BEARINGS.</u>			
		FAG. REF: 6004 2RS.	———	2	FAG
		" " 160 03	———	2	"
		<u>CIRCLIPS.</u>			
		ANDERTON REF: 1400 - 20M	———	2	ANDERTON.
		<u>HAND WHEEL</u>			
		REF: No 141 x $\frac{3}{16}$ "	———	1	RENCOL
		<u>ADJUSTING SCREW.</u>			
		REF 605-03. $\frac{5}{16}$ " B.S.F. x 2" LG.	———	2	W.D.S.
		<u>COUPLING (SPIDER).</u>			
		REF: 644 404.	———	1	REYNOLDS.
		<u>SKT. HD. CAP SCREWS.</u>			
		$\frac{3}{8}$ " WHIT. x $1\frac{1}{2}$ " LONG.	———	2	
		" x $1\frac{1}{8}$ " "	———	5	
		2 B.A. x $\frac{3}{4}$ " "	———	4	
		" x $\frac{1}{2}$ " "	———	2	
		<u>C'SK. SKT. SCREWS.</u>			
		$\frac{1}{4}$ " WHIT. x $\frac{1}{2}$ " LONG.	———	4	
		2 B.A. x $\frac{1}{2}$ " "	———	8	
		<u>BUTTON HD. SKT. SCREWS.</u>			
		2 B.A. x $\frac{3}{8}$ " LONG.	———	8	
		<u>SKT. SET SCREWS.</u>			
		$\frac{1}{4}$ " WHIT. x $\frac{1}{4}$ " LONG. CONE PT.	———	2	
		$\frac{1}{4}$ " " x $\frac{1}{4}$ " " CUP PT.	———	2	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

3

ASSY. DRG. No. SM 101

DATE _____

3. 9. 74.

TITLE: VICEROY DISC & BELT SANDER - BELT SANDER ARR^T.

DRG.	No.	B.O. CONT.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
			<u>NUTS.</u>			
			1/2" WHIT STD.	—	4	
			5/16" B.S.F. LOCKNUT.	—	2	
			1/4" WHIT STD.	—	1	
			<u>WASHERS.</u>			
			1/2" STD.	—	4	
			5/16" STD.	—	1	RENCOL H'WHEEL
			<u>PINS.</u>			
			1/8" DIA. x 3/4" LONG.	—	2	
			<u>RD. HD. SCREWS.</u>			
			4 BA. x 1/4" LONG.	—	12	
			<u>THUMBSCREW.</u>			
			1/4" WHIT. x 1/4" LONG	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. SM102

1.

DATE

TITLE: VICEROY BELT SANDER ARRT. FOR R.J.H. BANDFACER

12. 11. 74.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SM102	1	MAIN SPINDLE.	M.S.	1	1 1/4" DIA x 13 3/16"
"	2	MALE SWIVEL PLATE. (SM100/4).	C.I.	1	CASTING
"	3	FEMALE SWIVEL PLATE.	C.I.	1	"
"	4	PULLEY (USE GM110/5).	ALUM.	1	"
"	5	BACKPLATE SUPPORT.	M.S.	1	1/2" x 1 1/4" x 2 3/8"
"	6	RETAINING TAB.	SH. STEEL	1	13 S.W.G. x 1" x 1 1/2"
"	7	BELT GUARD.	"	1	20 S.W.G.
"	10	TOP GUARD.	"	1	20 S.W.G.
"	11	MODS. TO R.J.H. CHANNEL SECTION		1	B.O.
<u>OTHER PARTS REQUIRED.</u>					
SM100	7	BELT BACK PLATE.	ALUMINIUM	1	CASTING
"	8	SWIVEL BRACKET.	M.S. PLATE	1	12 S.W.G. x 4" x 7 1/2"
"	9	BRACKET.	C.I.	1	CASTING.
"	12	DUST NOZZLE ADAPTER.	M.S. TUBE.	1	1 1/2" DIA. x 1 5/16" ID. x 1 3/4"
"	31	HEADSTOCK (USE GM102/8 CASTING).	C.I.	1	CASTING.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2.

ASSY. DRG. No. SM102

DATE

12.11.74.

TITLE: VICEROY BELT SANDER ARRT. FOR R.J.H. BANDFACER.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>B.O. PARTS REQUIRED.</u>			
		<u>SKT. HD. CAP SCREWS.</u>			
		3/8" WHIT. x 1 1/2" LONG	—	1	
		3/8" " x 1 1/8" "	—	2	
		1/4" " x 1 1/8" "	—	1	
		2 BA. x 1/2" "	—	2	
		<u>C'SK. SKT. SCREWS.</u>			
		1/4" WHIT. x 1/2" LONG	—	2	
		<u>SKT. SET SCREWS.</u>			
		1/4" WHIT x 3/8" LONG. CONE PT.	—	1	
		1/4" " x 1/4" " " "	—	1	
		2 BA. x 3/8" " CUP PT.	—	2/1	
		<u>BUTTON HD. SKT. SCREWS.</u>			
		2 BA. x 3/8" LONG.	—	4	
		<u>NUTS.</u>			
		1/4" WHIT. STD.	—	1	
		<u>THUMBSCREW.</u>			
		1/4" WHIT x 1/4" LONG.	—	1	
		<u>WASHER.</u>			
		5/16" STD.	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

ASSY. DRG. No. General Arrangement SH5003

TITLE: T.D.S. 12/16" 16" Sharpedge.

SHEET

1

DATE

2-7-6

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SH5003	1	Table	Aluminium	1	Casting
"	2	Swivel Block	C.I.	1	"
"	3	Plane Blade & Chisel Plate	"	1	"
"	4	Swivel Arm	"	1	"
"	5	Clamp Screw end	M.S.	1	7/8"D. x 1/2"
"	7	Main spindle	M.S. (F.C)	1	1 3/4"D. x 5 1/4"
"	9	Lock nut	Mall Iron	1	Casting
"	10	Clamp screw	M.S.	1	1"D. x 3 1/8"
"	11	Bush	Cent. C.I.	1	1 1/4"D. x 5 5/8"
"	12	Plane Clamp Sliding tenon	M.S.	1	1/2"D. x 1/2"
"	13	Adrain	M.S.	1	20 EX. 2 1/8 L
"	14	Lever Arm	M.S.	1	5/8"D. x 20"
"	21	Swivel Block shaft	"	1	3/4"D. x 6 5/16"
"	22	Cabinet Door	Sheet Steel	1	16 SWG
"	23	Cabinet	"	1	12 SWG.
"	33	Lever arm pivot pin	M.S.	1	3/4"D. x 2 3/8"
"	35	Plane Iron & Chisel Clamp	C.I.	1	Casting
"	36	Oil pipe stopper	M.S.	1	5/16"D. x 5/8"
"	37	Oil pipe (See B.O. Parts.)	Bundy Tubing	1	5" O.D. x 22 SWG x 7 1/8"
"	38	Inner Disc	Mall Iron	1	Casting
SP162		Eccentric	M.S.	1	1"D. x 1 1/2"
SH5003	41	Lever locating Pin	"	1	1/4"D. x 1 3/8"
"	43	Base plate	C.I.	1	Casting
"	42	Stud.	M.S.	1	1/2" dia x 3 1/2" long.
"	44	Thrust Washer	"	1	1 3/4" dia x 1/2" long.
S.P.	110	Extension Stud	M.S.	1	5/16" whit x 1 1/4"

2

12-8-66

CUT OFF SIZE

100 58

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY: DRG. No. General Arrangement SH5003.

DATE

2-7-65

TITLE: T.D.S. 12/16" 16 Sharpedge.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Micro - Switch</u>			
		Type D.S.3. 521	—	1	Burgess.
		<u>Oil Pump</u>			
		Type E50-426	—	1	A.C. Pumps.
		<u>Starter Motor</u>			
		Type ATF 2 C.I. (Single Phase) OR.	—	1	Brook
		Type ATF 3 B.I. (3 Phase)	—	1	Brook
		<u>Motor</u>			
		Type 9019 H.A.F. 2541 (Single Phase) OR.	—	1	Hoover
		Type 9306 H.A.F. 2541 (3 Phase)	—	1	"
		<u>Bearing.</u>			
		Type 6200 254	—	1	Fag.
		<u>Circlips</u>			
		Type 1400 / 10mm	—	1	Anderton
		" 1400 / 6mm. ✓	—	1	"
		" 1400 / 1 1/4" ✓	—	2	"
		<u>Split Pin</u>			
		3/32" dia x 1/2" long.	—	1	
		<u>Knobs.</u>			
		1 1/4" o.d. x 5/8" whit. Red. Plastic	—	2	Mcmillan.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. General Arrangement SH5003

DATE

2-7-65

TITLE: T.D.S. 12/16" 16" Sharpedge.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>'V' belt.</u>			
		Type A 14 1/2" x 40" x 3" X	—	1	Brammer
		<u>Tubing.</u>			
		GriFlex clear : 3" o.d. x 5" o.d.	—		GriFlex.
		" " : 1/2" i.d. x 3/4" o.d.	—		"
		<u>GEAR BOX</u>			
		Type : 341503 X	—	1	Holroyd.
		<u>Grinding Wheel.</u>			
		Type A80JV - JA613 ✓	—	1	Mitchell.
		<u>Bushs.</u>			
		Oilite bush type C.I.F. 369 x 1 1/2" —	—	1	Lubbrook.
		<u>C lips</u> ✓			
		3/8" dia type 1439	—	6	Terry.
		<u>Door Catch Spring & Stud.</u>			
		Spring type SRV 1637/17/0. X	—	1	Stenor.
		Stud " SBV 1698/17/0 X			
		<u>Dowels</u>			
		1/4" dia x 2" long X	—	1	taper pin
		3/16" dia x 1 1/2" long ✓	—	1	
		" " x 2 1/4" " ✓	—	1	
		1/8" dia x 1/2" "	—	2	Sel-lok pins
		<u>Locknuts</u>			
		Std. 1/4" whit.	—	2	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 C

ASSY. DRG. No. General Arrangement SH5003

DATE

2-7-65

TITLE: T.D.S. 12/16" 16" Sharpedge.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Grubs.</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long dog pt	—	4	Unbrako
		$\frac{1}{4}$ " " x $\frac{1}{4}$ " "	—	2	"
		$\frac{5}{16}$ " " x $\frac{5}{16}$ " "	—	1	"
		<u>Set screws.</u>			
		$\frac{1}{4}$" U.N.F. x $\frac{1}{2}$" long	—	2	
		$\frac{5}{16}$ " whit x 1" long	—	2	
		" " x 2" "	—	4	
		" " x $2\frac{1}{4}$ " "	—	4	
		$\frac{3}{8}$ " " x $1\frac{1}{2}$ " "	—	1	
		<u>Nuts & Washers</u>			
		Std $\frac{3}{8}$ " whit wedge lock nut	—	1	GKN
		Std $\frac{5}{16}$ " nuts & washers	—	4 each	
		" $\frac{3}{16}$ " spring washer	—	2	
		4 B.A. nuts	—	2	
		Std $\frac{3}{8}$ " washers locknuts 2 off washer & 2 off nuts	—	2	
		<u>C'sk screws</u>			
		4 B.A x $\frac{1}{2}$ " long	—	2	
		$\frac{1}{4}$ " whit x $\frac{5}{8}$ " long	—	1	
		<u>Self-Tapping screws.</u>			
		Nº 6 c'sk	—	2	
		Nº 8	—	3	
		<u>Thumbscrews</u>			
		$\frac{1}{4}$ " whit x $1\frac{1}{4}$ " long	—	2	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

10

ASSY. DRG. No. General Arr^t. SH5003

DATE

31-8-65

TITLE: T.D.S. 12/16" 16" Sharpedge

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Charts.</u>			
		CH 115 24 sug x 4" x 7 1/2"	Brass	1	Big Eage.
		CH 117 28 " x 1 1/2" dia	"	1	" "
		<u>Oilfeed System Parts.</u>			
		Tubing ref: Z18	—	1	Ends
		" Sleeve " : Z4	—	1	"
		Nippled Adaptor " : Z370-1	—	1	"
		Male Elbow " " : Y105	—	1	"
		Bulk head Connector " : Z86	—	1	"
		Lock nut ref: T57	—	1	"
		Tailpiece Connector " : Z371-1	—	2	"
		3/8" B.S.P. Washer " : 1386 C (Alum)	—	1	"
		Universal Stem Tee " : Y1003-3	—	1	"
SH5003	37	Bundy Tubing 5/16" O.D. x 7/8" x 22 sug	—	1	"
		<u>Oil Seal</u>			
		Ref: H Ring PP 180-19.	—	1	Dowty.
		O'Ring R 4100			Ameyland
		<u>Rivets</u>			
		Hdn brass rivets Type 'U' x 3/16"	—	7	
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box. ref C 6103	—	1	GEC
		Cover ref CA 4501	—	1	Oriental Tube Co.
		Male Insert 3/4" dia. 16 T.P.I. Conduit thrd.	Brass	1	
		Locknut " " " "	Steel	1	
SH5003	6	Gear box pulley	Aluminium	1	Coles.
"	29.	Motor pulley.	"	1	Coles.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1.

ASSY. DRG. No. General Assembly S.H.100 A.

DATE

13.3.70.

TITLE: 10" Junior Sharpedge. With Workarm.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SH100	A	Arrangement	—	—	—
"	1A	Worktable.	Alum.	1.	Casting
"	11	Motor Coupling	B.O. Parts	1	See B.O. Lists.
"	17	Cutout Cover Plate	Sh. Steel	1	14 SWG.
"	18	Cabinet.	"	1	12 SWG
"	29	Grinding Wheel.	B.O. Part	1	See B.O. Lists.
"	31	Honing Oil Tank.	Sh Steel	1	16 S.W.G.
"	32	Eccentric.	M.S.	1	1" D x 1 1/2"
"	33	Oil Pipe.	Bundy Tubing	1	5 1/8" D. x 22 S.W.G. x 4"
"	34	Bush.	M.S.	1	1 1/4" D x 5 1/2"
"	35	Swivel Block Shaft.	"	1	3 1/4" D x 6 5/16"
"	36	Boss.	CI	1	2 5/8" D x 2"
"	37	Inspection. Cover Plate.	Sh. Steel.	1	6" x 6" x 14 SWG.
		Other Parts Required.			
5003	2	Swivel Block.	C.I.	1	Casting.
"	3	Plane Blade & Chisel Plate.	"	1	"
"	4	Swivel Arm.	"	1	"
"	5	Clamp Screw End.	M.S.	1	7/8" D x 1/2"
"	7	Main Spindle.	"	1	1 3/4" D x 5 5/16"
"	9	Locknut.	Hall Iron	1	Casting.
"	10	Clamp Screw.	M.S.	1	1" D x 3 1/8"
"	12	Plane Clamp Sliding Teehan.	"	1	1 1/2" Sq. x 1/2"
"	35	Plane Iron & Chisel Clamp.	C.I.	1	Casting.
"	36	Oil Pipe Stopper.	M.S.	1	5 1/8" D x 5/8"
"	38	Inner Disc.	Hall Iron	1	Casting.
"	42	Stud.	M.S.	1	1/2" D x 3 1/2"
"	44	Thrust Washer.	"	1	1 3/4" D x 1/2"
SP103	D	Locking Handle	"	1	3/4" D x 2 13/16"
"	B	" Stud.	M.S.	1	3/8" D x 1 3/4"
"	C	Pad.	Brass	1	1/4" D x 1/2"
C.H.	116	Nameplate.	Brass Sh	1	24 S.W.G.
"	118	Lubrication Chart.	"	1	" "
SK.	314	Foot.	B.O. Part	2	See B.O. List

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. General Assembly. SH.100A.

1A.

TITLE: 10" Junior Sharpege With Workarm B.O. Parts.

DATE

13.3.70.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Hex Hd. Set Screws.</u>			
	X	5/16" whit x 2 1/2" long	—	4	
(13)	X	" " x 1 1/2" "	—	9	
	X	1/4" " x 1" "	—	4	
	X	2 B.A. x 1/2" "	—	2	
	X	3/8" whit x 1 1/2" "	—	1	
		<u>Motor.</u>			
		1/4h.P. Single Phase ref: 9019. HAF 2541	—	1	Hoover.
		or			
		1/4h.P. 3phase ref. 9306 HAF: 2541	—	1	"
		<u>Starter Motor.</u>			
		Single Phase type ATF 2C1	—	1	Brook.
		or			
		3 Phase type ATF 3B1	—	1	"
		<u>Radican Unit.</u>			
		Type 341503.	—	1	Holroyd.
		<u>Flexible Coupling.</u>			
SH100	11	5/8" & 7/16" bores x 2 1/2" long type F10.	—	1	Metaltick Ltd.
		<u>Clips.</u>			
		Tube Clip : 3/4" dia ref: 1234	—	1	Terry.
		" " : 3/8" dia ref: 1439	—	4	"
		Cable Clip: Single	—	1	West Yorks Electric
		<u>Grommet.</u>			
		3/4 dia	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B.

ASSY. DRG. No. General Assembly. SH100A.

DATE

16.3.70.

TITLE: 10" Junior Sharpedge with Workarm B.O. Parts.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Clear Tube.</u>			
		3/4" O.D. x 1/2" I.D. x 4" long.	—	1	Griflex.
		3/8" O.D. x 5/16" I.D. x 6" long.	—	1	"
		" " x " " x 30" long.	—	1	"
		<u>Washers.</u>			
		Std 5/16" washer.	—	21	
		" 1/4" "	—	4.	
		" 3/8" Spring washer	—	1	
		<u>Rivets.</u>			
		Hdn. brass type 'U' x 3/16" long.	—	7	
		<u>Self Tapping Screws.</u>			
		Rd. Hd. N°8 x 1/2" long	—	8	
		<u>Grubs.</u>			
		1/4" whit x 1/2" long dog pt.	—	4	Unbrako
		<u>Locknuts.</u>			
		Std 1/4" whit.	—	6	
		<u>Oilite Bush.</u>			
		Type C.T.F. 369 x 1 1/2"	—	1	Bound Brook.
		<u>Cinclip.</u>			
		Type 1400/G M/M.	—	1	Andertons
		" 1400/1 1/4"	—	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. General Assembly SH.100A.

1 C.

TITLE: 10" Junior Sharpedge with Workarm. B.O. Parts.

DATE

16.3.70.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Circlips Cont.</u>			
		Type 1400/10 ^{1/4} "	—	1	Andertons.
		" 1400/3 ^{1/4} "	—	1	"
		<u>Grinding Wheel</u>			
SH100	20	Ref BAA 80LSV 10" x 1 ^{1/4} " x 1 ^{1/4} " bore.	—	1	AbraFact.
		<u>Cable</u>			
		Single phase P.V.C. covered 2 core; 2 lengths 1-2'-6" & 1-2'-8"			
3	"	" " 3 " : " " " "			
		<u>Thumbscrews</u>			
		1/4" whit x 1 1/4" long.	—	2	
		<u>Oil Seal</u>			
		O'Ring R4100 PS.	—	1	Angus.
		<u>Charts</u>			
		C.H.116 : 24 Swg. x 2 3/4" x 1 3/4"	Brass, Sh.	1	Brig. Engr.
		C.H.118 : " " x 8 1/4" x 2 1/2"	"	1	"
		<u>Oil Feed System. Parts.</u>			
		Tubing nut ref : Z18.	—	1	Enots.
		" Sleeve " : Z4	—	1	"
		Nippled Adaptor " : Z370-1	—	1	"
		Male Elbow " : Y105	—	1	"
		Bulkhead Connector " : Z86	—	1	"
		Locknut " : T57	—	1	"
		Tailpiece Connector " : Z371-1	—	1	"
		3/8" B.S.P. Washer " : 1386C (Alum).	—	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 D.

ASSY. DRG. No. General Assembly SH.100A.

DATE

16.3.70.

TITLE: 10" Junior Sharpedge with Workarm. B.O. Parts.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Oil Feed System Parts Cont.</u>			
		Stem Elbow Connector. Ref: Y958-5	—	1	Enots.
		Adaptor " : Z369	—	1	"
SH100	33	Bundy Tubing 5/16" O.D. x 4" x 22 Swg.	—	1	"
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box. ref C6103.	—	1	G.E.C.
		Cover ref CA 4501.	—	1	Oriental Tube Co
		Male Insert 3/4" dia 16 T.P. 1. Conduit Thr	Brass	1	
		Locknut " " " "	Steel	1	
		<u>Pin.</u>			
		Split Pin 3/32" O.D. x 1/2" long	—	1	
		<u>Dowels.</u>			
		3/16" O.D. x 2 1/4" long.	—	1	
		<u>Cap Hd. Screws.</u>			
		2 B.A. x 3/4" long.	—	3.	
		<u>Nylon Pad.</u>			
		Nylon 101 Type 66	—	1	Polypenco.
		<u>Screwed Bar</u>			
		5/16" whit x 4" long.	—	2	
		<u>Nuts</u>			
		Std 5/16" whit.	—	8	
		Std 1/4" whit.	—	4	

TITLE: 10th Junior Sharpedge with workarm. B.O. Parts.

SHEET No.

1E

DATE _____

16,370

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No

1

ASSY. DRG. No. Gouge Attachment Arrt. SH101

DATE

6.3.67

TITLE: 16" Sharpedge.

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SH101				
" 6	Drive Shaft	"	1	1" dia x 9 1/2"
" 7	Locknut	"	1	1 3/4" dia x 1/16"
" 8	Cone Wheel Oil Pipe	Bundy Tube	1	22swg x 5/16" O.D. x 3 1/2"
" 12	Trough	M.S. Plate	1	12swg.
" 16	Trough Return Pipe	Bundy Tube	1	22swg x 5/16" O.D. x 2 5/8"
" 14	Top Wheel Oil Pipe *	"	1	" " x 4 1/2"
" 18	Gouge Support Block	M.S.	1	1 1/4" sq. x 1 1/4"
" 19	" " Arm	"	1	3/8" dia x 5 1/16"
SP 103	D Locking Handle	M.S.	1	3/4" dia x 2 13/16"
" "	B Locking Stud	M.S.	1	3/8" dia x 1 3/4"
" "	C Pad	Brass	1	1/4" dia x 1/2"
SH5003 36	Oil Pipe Stopper	M.S.	1	5/16" d. x 5/8"
" 40	Re-inforcement Plate.	Sh. St.	1	7" x 6" x 14swg.
* This part SH101/14 is used instead of item SH5003/37.				

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. Grouge Attachment Arrt. SH101

DATE

6.3.67

TITLE: 16" Sharpedge

B.O. Parts.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Bearing.</u>			
		Flangette brg $\frac{3}{4}$ " dia ref: 47-MS.-CI.	—	1	Fafrir.
		<u>Skt hd. cap screws.</u>			
		2 B.A. x $\frac{3}{4}$ " long	—	2	Unbrako.
		<u>Nuts</u>			
		Std: $\frac{1}{4}$ " whit nuts	—	3	
		Std: $\frac{1}{4}$ " whit locknuts	—	3	
		Std: 2 B.A. wingnuts	—	2	
		<u>Grubs</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long kn. cup pt.	—	4	Unbrako
		" x " dog pt	—	2	"
		<u>Hex hd set screws</u>			
		$\frac{1}{4}$ " whit x 1" long	—	3	
		<u>Washers</u>			
		$\frac{1}{4}$ " washers std.	—	6	
		<u>Grinding Wheel</u>			
		Cone grinding wheel ref: WABD - HV.	—	1	Mitchell's.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18

ASSY. DRG. No. Grouge Attachment Arrt. SH101

DATE

6.3.67

TITLE: 16" Sharpedge

B.O. Parts.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Perspex</u>			
		$3\frac{1}{16}" \times 3\frac{1}{2}" \times 6\frac{3}{4}"$	—	1	Walker's.
		<u>Tubing.</u>			
		Clear tubing : $3\frac{1}{8}"$ O.D. $\times$ $5\frac{1}{16}"$ I.D. $\times$ 2'-6"			Griflex.
		<u>Enots Tube Fittings</u>			
		Stem Tee : ref : Y1000-3	—	1	Enots
		Tubing Nut : " : Z18	—	1	"
		Sleeve : " : Z4	—	1	"
		Locknut : " : T57	—	1	"
		Bulkhead Connector : " : Z86	—	1	"
		Nipplea Adaptor : " : Z370-1	—	2	"
		Tap : " : T9	—	2	Rotherhams.
S.H.101	1	Gear box pulley.	Aluminium	1	Coles.

SHEET No.

ASSY. DRG. No. Planer knife Attachment SH102

TITLE: 16" Sharpedge Grinding M/c.

DATE _____

[illegible]

SHEET No.

DATE _____

19.10.67.

H K L 5 6

1

3.9.68.

CUT OFF SIZE

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SK 281	A.	Blower Coupling.	M.S.	1	1 3/4" dia bar
	B.	Spacer Bush.	M.S.	2	7/8" dia bar.
	C.	Screwed Rod.	M.S.	2	5/16 whit.
	D.	Motor Guard.	M.S.S.	1	10 1/8 x 5 1/8 x 22 swg
		<u>Motor.</u>			
		Type B 24.		1	Hoover.
		<u>Pump.</u>			
		A/c Delco Pump.			A/c Delco.
		<u>Filter.</u>			
		1 Filter Ref: 6422732.		1	"
		" " " 55979.		1	"
		<u>Terry clips.</u>			
		1 5/8 dia Ref: N° H20.		2	Terry.
		<u>Nuts & Washers.</u>			
		Nuts 5/16 whit hex type.		4	REN Sutcliffe
		5/16 Washers.		4	" "

TITLE: Layout of Twin Foot Safety Knock Off.

SHEET No.

1

DATE _____

6. 4. 70.

[illegible]

TITLE: Layout of Twin Foot Safety Knock Off.

1

30.12.70

WMR LTD. S/P 8791

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A.

ASSY. DRG. No. SK 329 A, B.O. Parts (10" wet Grinder)

DATE _____

30,12.70.

TITLE: Layout of Twin Foot Knock off.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Micro Switch.</u>			
		✓ Ref DS3521	—	1	Burgess.
		<u>Tapping Screws.</u>			
		✓ N° 6 x 3/8" long.	—	4	—
		✓ " x 1/2" "	—	5	—
		<u>Grubs.</u>			
		1/4" whit x 1/4" long Cone At.	—	3	—
		" " x " " Dog At.	—	2	—
		<u>Nuts.</u>			
		✓ Std 5/16" whit	—	1	—
		✓ Std 4 BA.	—	1	—
		✓ " 2 BA.	—	2	—
		<u>Thumb Screws.</u>			
		✓ 5/16" whit x 1 1/4" long.	—	1	—
		<u>Screws.</u>			
		SK Hd Cap 2BA x 1" Long	—	2	—
		<u>Notes.</u>			

TITLE: 3 cwt Workshop Portable Crane

1

16.12.70

H.M. LTD. S/P 8791

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. SK 348.

DATE _____

23.6.71.

TITLE: Adjusta-Vice TDS 24.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SK 348		Arrangement.			
"	A	Column Arrangement.			
"	1	"	M.S. Tube	2	3 3/8" O.D. x 2 1/2" I.D. x 1/2"
"	2	" Support Bracket.	C. I.	2	Casting.
"	3	Vice Plate.	M.S.	2	6 1/2" dia x 1"
"	4	Bracket Support	"	2	7 1/2" x 6 1/2" x 1/2"
"	5	" Spigot.	"	2	4 3/8" dia x 7/8"
"	6	R.H. & L.H. Bracket Support Plinth	"	2	6 1/2" x 6" x 1/2"
"	7	Rack.	"	2	15 1/4" x 3 1/4" x 3/8"
"	8	Pinion Gear.	"	2	15 1/8" dia x 1 3/8"
"	9	" Stud.	B.M.S.	2	3/8" dia x 2"
"	10	Worm Shaft.	M.S.	2	1" dia x 2 3/8"
"	11	Drawbolt.	"	2	1/2" dia x 17 1/16"
"	12	" Head.	"	2	15 1/16" dia x 9 1/16"
"	13	Retaining Plate.	"	2	3 3/8" dia x 1 1/16"
"	14	Rack Retaining Ring.	"	2	3 7/8" O.D. x 3" I.D. x 1"
"	15	Column Raise & Lower Lever.	C. I.	2	Casting.
"	16	" " " " Handle	M.S. & Chrome	2	1/2" dia x 4"
"	17	" Locking Handle.	"	2	1" dia x 6 5/8"
"	18	A. TABLE.	Plywood	1	See Drg.
"	19	Bracket Support Spacer.	M.S. Tube	2	1" O.D. x 3/4" I.D. x 1 3/8"
"	21	TABLE SUPPORT.	CHIPBOARD	1	1/2" x 3/4"
"	22	PEDESTAL.	SH. STEEL.	1	12 S.W.G.
		<u>Other Parts Required.</u>			
GM103	14	Cabinet Door.	Sh. Steel	1	12 S.W.G.
"	19	Stud.	—	1	See B.O. parts
CH100		Nameplate.	—	1	" " "

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. SK 348 B.O. Parts.

1A

TITLE: Adjusta-Vice. T.D.S. 24.

DATE

23. 6. 71.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vices.</u>			
		N ^o 2 Record Vice.	—	1	—
		N ^o 3 " "	—	1	—
		<u>Bolts.</u>			
		3/8" whit x 1 1/4" long	—	2	—
		1/2" whit x 2 1/4" "	—	3	—
		<u>Set Screws.</u>			
		5/8" whit x 2" long.	—	2	—
		5/16" whit x 2 1/4" "	—	2	—
		<u>Nuts.</u>			
		Std. 1/2" whit	—	5	—
		" 5/16" "	—	2	—
		<u>Washers.</u>			
		Std. 1/2"	—	8	—
		" 5/8"	—	2	—
		" 5/16"	—	2	—
		Spherical Washer 3/8" I.D. x 3/4" O.D. ref 901	—	2	W.D.S.
		<u>Grubs.</u>			
		1/4" whit x 1/4" long Dog Pt.	—	2	—
		" " " " K.ND Cup Pt.	—	10	—
		<u>Rivets.</u>			
		H'ON Brass type 'U' x 3/16" long.	—	4	—

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B.

ASSY. DRG. No. SK 348 B.O. Parts.

DATE

23.6.71.

TITLE: Adjusta-Vice TDS 24.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>50. CUP. HEX. BOLTS.</u>			
		M10 x 75 mm. LONG + STD			
		M10 NUTS & WASHERS	—	4000	EACH.
		<u>Mills Pins.</u>			
		1/8" dia x 3/4" long	—	2	—
		" " x 1" "	—	2	—
		3/16" " x 3/8" "	—	2	—
		<u>Grease Nipple.</u>			
		Ref :- H4123	—	2	Kingfisher
		<u>Plastic Knob.</u>			
		1 1/4" dia x 5/16" wht.	—	1	McMillan
		<u>Stud & latch.</u>			
		Stud ref: SBV/1698/17/0	—	1	Stenor
		Latch " : SBV/1637/17/0	—	1	"
		<u>Self Tapping Screws</u>			
		N°6 CSK. x 5/16" long	—	2	—
CH100		Nameplate.	Brass Sheet	1	Brig. Eng.
GN103	19	Extension Stud 5/16" wht x 1/2" long			
		Set Screw	M.S.	1	—

5.

13.5.71

13.5.71

H.H. LTD. S/P 8791

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A.

ASSY. DRG. No. Mortising table - SK 351

DATE

14.5.71

TITLE: Viceroy Mortising table Att^t B.O. Parts.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>SET SCREWS</u>			
		5/16" whit x 1" long	-	9	Unbrako
		1/4" " x 3/4" "	-	2	"
		<u>SOCKET HEAD CAP SCREWS</u>			
		1/4" whit x 3/4" long	-	4	Unbrako
		5/16" " x 1 1/2" "	-	2	"
		2 BA x 1/2" "	-	4	"
		<u>ROUND HD SCREWS</u>			
		2 BA x 1/2" long.	-	1	Unbrako
		<u>COUNTERSUNK SCREWS</u>			
		1/4" whit x 5/8" long.	-	4	Unbrako
		1/4" " x 3/8" "	-	1	"
		<u>GRUB SCREWS</u>			
		2 BA x 7/16" long.	-	12	Unbrako
		2 BA x 3/16" "	-	2	"
		<u>HANDWHEEL</u>			
		Pattern No 601	Plastic	1	RENCOL
		<u>Chipboard</u>			
		1/2" x 15" x 6 1/2"	chipboard	1	As shown
		<u>PLASTIC BALL</u>			
		Black 3/4" ϕ tapped 1/4" whit	Plastic	2	-
		<u>Clamps</u>			
		Speetog. type T.C. 50.	-	2	Brauer.
		<u>OILER</u>			
		REF 1/4 L.D.	-	1	KING FISHER

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1.

ASSY. DRG. No. Belt tensioner Assembly SK357

DATE

29.7.71

TITLE: Viceroy Drill Bench & Pedestal.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SK357	1	Belt tensioner- SPIGOT	MS	1	$\phi 2\frac{1}{4}" \times 1\frac{1}{8}"$
"	2	" " - BUSH	Ph. bronze	1	$\phi 1\frac{7}{8}" \times 1\frac{1}{4}"$
"	3	" " - ARM	C.I.	1	Casting.
"	4	" " - CAP	M.S.	1	$\phi 1\frac{3}{8}" \times 3\frac{1}{2}"$
"	5	" " - SPINDLE	"	1	$\phi 1\frac{1}{4}" \times 3\frac{7}{8}"$
"	6	" " - ROLLER	"	1	$\phi 1\frac{5}{8}" \times 3\frac{1}{8}"$
"	7	MOTOR PLATE	st Plate	1	$6" \times 7" \times \frac{1}{4}"$

On 8 speed drill to be
used with SK338/1.

B.O. Parts.

Spring.

Special SK357/8

-

1

Screws.

Allon cap c/sunk $1\frac{1}{4}"$ whit x $\frac{1}{2}"$

-

4

Unbrako

" " " $5\frac{1}{6}"$ whit x $\frac{3}{8}"$

-

1

"

Set Screw $1\frac{1}{4}"$ whit x $\frac{5}{8}"$

-

4

"

" " $5\frac{1}{6}"$ whit x $\frac{3}{8}"$

-

4

"

Bearings.

ref:- LS5Z

-

2

FAG

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. SK 368.

1.

TITLE: Parts for Spiral Milling Att⁺.

DATE

29.11.71.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SK368		Layout.			
"	1	Handwheel Bush.	M.S.	1	1 1/4" dia x 3 1/2"
"	2	" " Spacer.	"	1	1 1/2" dia x 1 3/4"
"	3	Self centering Washer.	"	1	1 1/4" dia x 3/8"
"	4	Key.	Key Steel	1	3/16" SQ x 3 1/4"
"	5A	Guard.	Sh. Steel.	1	16. S.W.G.
"	5B	Inner Plate.	" "	1	" "
		<u>B.O. Parts.</u>			
		<u>Button Screws.</u>			
		2 B.A. x 1/2" long.	—	3	
		<u>Set Screws.</u>			
		5/16" whit x 1 3/4" long.	—	1	
		1/4" " x 1/2" "	—	2	
		<u>Wing Nuts.</u>			
		Std. 2 B.A.	—	3	
		<u>Washers</u>			
		Std. 1/4"	—	2	
		<u>Mills Pin.</u>			
		3/16" dia x 1" long.	—	1	

Parts List

Description R.H. Turning Tool

Drawing N° T.H. 100

Part N. O.R.H.

Component List

Dwg N°	Description	Qty
100,11	Body	1
	Tool bit $\frac{1}{4}"$ sq x $1\frac{3}{4}"$	1
	Sq. Hd. screw $\frac{3}{8}"$ whit x $\frac{3}{4}"$	1
	long : dog pt.	1
136	Key K.2.	1
	Corrugated sheet $5\frac{1}{2}"$ sq.	1
	Waxed paper $6" \times 7"$	1
	Box Complete	1

Drawn

Checked

TH-100

M. H. Souder

Date 25.5.65

Parts List

Description L.H. Turning Tool

Drawing N° TH101

Part No. O.L.H.

Component List

Dry N°	Description	Qty
101/1	Body	1
	Tool bit $\frac{1}{4}$ " sq x $1\frac{3}{4}$ "	1
	Sq. Hd. screw $\frac{3}{8}$ " whit x $\frac{3}{4}$ "	
	long : dog pt	1
136	Key k.2.	1
	Corrugated sheet $5\frac{1}{2}$ " sq	1
	Waxed paper 6" x 7"	1
	Box complete	1

Drawn

Checked

TH 101

M. M. Sordien

Date 25.5.65

Parts List

Description	Boring Bar
Drawing N°	TH104
Part N°	104

Component List

Dwg N°	Description	Qty
104/1	Boiling Bar	1
104/2	Holder	1
	Toolbit $\frac{3}{16}$ " 64 x 1" long	2
	Set. Setscrew 2BA x $\frac{3}{16}$ " long	2
Wrench	Hex. $\frac{3}{32}$ " A/F.	1
	Corrugated card $5\frac{1}{4}$ " x 4"	1
	Waxed paper 7" x 6"	1
	Box complete	1

Drawn

M. M. Souden

Checked

Date 26.5.65

TH 104

Parts List

Description: Boing Bar

Drawing N^o. THIO 6

Part N° 106

Component List

Qty	Description	Unit
1	Bar	
1	Holder	
1	Toolbit $5/16"$ sq x $1\frac{1}{2}"$	
2	Hollow setscrew $5/16"$ B.S.F. x $5/16"$	
1	Wrench Hex. $5/32"$ A/F.	
1	Corrugated card $9" \times 8"$	
1	Waxed paper $10" \times 8"$	
1	Box complete	

Dratun

Checked

TH. 106

M. M. Souden

Date 26.5.65

Parts List

Description

Boing Bar

Drawing N°

TH108

Part No.

108

Component List

Qty	Description	Dwg No
1	Bar	108/1
1	Holder	108/2
2	Toolbit $\frac{1}{2}$ " sq x $2\frac{1}{4}$ "	
2	Set screw $\frac{1}{2}$ " B.S.F. x $\frac{1}{2}$ "	
1	Hex. $\frac{1}{4}$ A/F.	Wrench
1	Corrugated card $15\frac{1}{2}$ " x $8\frac{1}{2}$ "	
1	Waxed paper 20" x 10"	
1	Box complete.	

Drawn

Checked

M. M. Souden

Date 26.5.65

TH 108

Parts List

Description: Turning Tool

Drawing N^o. TH III

Part No. 1.5.

Component List

Dr. N°	Description	Qty
116/1	Body	1
	Tool bit $5/16"$ sq x 2"	1
	Se. Hd. screw $7/16"$ whit x 1" long	
	dog pt.	1
137	Key k.3.	1
	Corrugated sheet 9" x 6 1/2"	1
	Waxed paper 10" x 8"	1
	Box Complete	1

Drawn

Checked

TH. 64

M. H. Loomis

Date 25.5.05

Parts List

Description R.H. Turning Tool.

Drawing N° TH.112

Part N. 2.R.H.

Component List

Dry N°	Description	Qty
112/1	Body	1
	Tool bit $3/8"$ sq x $2 1/4"$	1
	Self hd screw $7/16"$ whit x 1" long	1
	dog pt.	1
137	Key K.3.	1
	Corrugated sheet $9" \times 7 1/2"$	1
	Waxed paper $10"$ sq	1
	Box complete	1

Drawn

Checked

M. M. Sovetsky

Date 26.5.65

T.H. 112

Parts List

Description L.H. Turning Tool.

Drawing N° TH113

Part 2 2 L.H.

Component List

Dwg N°	Description	Qty
113/1	Body	1
	Toolbit $\frac{3}{8}$ " sq x $2\frac{1}{4}$ "	1
	Sq Hd screw $\frac{7}{16}$ " whit x 1" long	
	dog pt.	1
137	Key K.3.	1
	Corrugated sheet 9" x $7\frac{1}{2}$ "	1
	Waxed paper 10" sq.	1
	Box Complete	1

Drawn

Checked

TH 113

M. H. Soudan

Date 26-5-65

Parts List

Description: Turning Tool

Drawing No. TH. 117

Part N^o 3.5.

Component List

Drq N°	Description	Qty
117/11	Body	1
	Toolbit $\frac{7}{16}$ " sq x $2\frac{1}{4}$ "	1
	Sq hd. screw $\frac{1}{2}$ " whit x 1" long	
	dog pt.	1
	Corrugated card $8\frac{1}{4}$ " sq	1
138	Key K.4.	1
	Waxed paper 10" sq	1
	Box complete	1

Drawn

Checked

M. M. Souden

Date 26.5.65

TH. 087

Parts List

Description Tuning Tool.

Drawing N° TH120

Part N. 4.5.

Component List

Qty	Description	Dwg No
1	Body	120/1
1	Toolbit $\frac{1}{2}$ " sq x 3"	
1	Sq hd. screw $\frac{5}{8}$ " whit x $1\frac{1}{4}$ " long	
1	dog pt	
1	Key K.5.	139
2	Corrugated card $9\frac{1}{2}$ " sq	
1	Waxed paper 12" sq	
1	Box complete	

Drawn

Checked

K. M. Gordon

Date 26.5.65

T.H. 120

Parts List

Description: R.H. Turning Tool.
 Drawing N^o. T.H. 121
 Part N^o 00 R.H.

Component List

Qty N ^o	Description	Qty
121/1	Body	1
	Toolbit $\frac{3}{16}$ " sq x $1\frac{1}{2}$	1
	Sq hd. screw $\frac{5}{16}$ " whit x $\frac{5}{8}$ " long	
	deg pt.	1
135	Key k. l.	1
	Corrugated cord $4\frac{3}{4}$ " sq	1
	Waxed paper 6" x 7"	1
	Box complete	1

Drawn

M. M. Souden

Checked

Date 26.5.65

T.H. 121

Parts List

Description L.H. Turning Tool.
 Drawing N° TH 122
 Part N° 00 L.H.

Component List

Qty N°	Description	Qty
122/1	Body	1
	Toolbit 3/16" sq x 1 1/2"	1
	Sq hd screw 5/16" whit x 5/8" long	
	dog pt.	1
135	Key k.l.	1
	Corrugated card 4 3/4" sq	1
	Waxed paper 6" x 7"	1
	Box complete	1

Drawn

Checked

TH. 122

M. M. Souden

Date 26.5.65

Parts List

Description: Turning Tool

Drawing N^o. TH123

Part No. 005.

Component List

Dr. N°	Description	Qty
123/1	Body	1
	Toolbit $3/16"$ sq x $1\frac{1}{2}"$	1
	Sq. H.d. screw $5/16"$ whit x $5/8"$	
	long : dog pt.	1
135	Key k.l.	1
	Corrugated sheet $4\frac{3}{4}"$ sq.	1
	Waxed paper $6" \times 7"$	1
	Box Complete	1

Drawn

Checked

TH. 123

M. M. Souden

Date 25.5.65

Parts List

Description L.H. Parting off Tool.
 Drawing N° T.H. 125
 Part N° N. 30. L.H.

Component List

Dwg N°	Description	Qty
125/1	Body	1
126/2	Locking screw	1
126/3	" nut	1
	Parting off Blade $5/8" \times 3/32" \times 4"$	1
136	Key K.2.	1
	Corrugated card $5\frac{1}{4}" \times 7"$	1
	Waxed paper $7" \times 6"$	1
	Box complete	1

Drawn

M.M. Gordon

Checked

Date 26.5.65

T.H. 125

Parts List

Description Knurling Toolholder
 Drawing N° TH 127.
 Part N° O.K.H.

Component List

Dwg N°	Description	Qty
127/1	Body	1
127/2	Knurl mounting plate	1
127/3	Pin $\frac{1}{8}$ " dia x $\frac{5}{8}$ "	1
127/4	Screw	2
127/5	Knurl. (See below) * 3 & 4	2
	Corrugated card $5\frac{1}{4}$ " ss	1
	Waxed paper 6" x 7"	1
	Box complete.	1

* Knurl : Cast Steel or High Speed Steel.

Type	Part N°	Type	Part N°
Spiral Coarse R.H.	KN1	Straight Coarse	KN37
" " L.H.	KN2	" Medium	KN38
* " Medium R.H.	KN3	" Fine	KN39
* " " L.H.	KN4	Checkered Coarse	KN73
" Fine R.H.	KN5	" Medium	KN74
" " L.H.	KN6	" Fine	KN75

Drawn

Checked

M.M. Sorchi

Date 26.5.65.

TH.127

Parts List

Description Threading Tool.
 Drawing N° T.H. 128
 Part N° C. 50 R.

Component List

Qty	Description	Dwg N°
1	Body	128/1
1	Cutter	128/2
1	Csk hd. screw 5/16" B.S.F. x 3/4" screwdriver slotted.	
1	Locking nut	126/3
1	Cheese hd. screw 1/4" B.S.F. x 3/4" long. screwdriver slotted	
1	Key K2.	136
1	Corrugated cord 5 1/2" dia	
1	Waxed paper 6" x 7"	
	Box.	

Drawn

M. M. Gordon.

Checked

Date 26.5.65

T.H. 128

Parts List

Description: Universal Knurling Toolholder.

Drawing N° TH 129

Part N° UKH1.

Component List

Qty N°	Description	Qty
129/1	Body	1
129/2	Knurl Housing	1
129/3	Screw	6
KN7	Knurl R.H. Coarse 36 teeth	1
KN8	" L.H. " " "	1
KN9	" R.H. Medium 66 teeth	1
KN10	" L.H. " " "	1
KN11	" R.H. Fine 92 teeth	1
KN12	" L.H. " " "	1
129/14	Pivot pin	1
	Corrugated card 9" x 7 1/4"	1
	Waxed paper 10" sq	1
	Box.	1
Cast steel knurls standard, but High speed steel knurls supplied at the customers request.		

Drawn

M. M. Souden

Checked

Date 26.5.65

TH. 129.

Parts List

Description American Type Boing Tool.

Drawing N° TH 134

Part N° N° 80

Component List

Qty	Description	Dwg N°
1	Body	134/1
1	Clamp	134/2
2	Clamping screw $\frac{3}{8}$ " whit x $1\frac{9}{16}$ "	134/3
1	Boing Bar $\frac{9}{16}$ " x $6\frac{3}{4}$ "	105/1
	$\frac{1}{8}$ " Wrench.	
1	Socket screw $\frac{1}{4}$ " B.S.F. x $\frac{1}{2}$ " long	
1	Key K.2.	13 6
2	Toolbit $\frac{1}{4}$ " x $1\frac{1}{4}$ " long	
1	Corrugated card $7\frac{1}{4}$ " x 9"	
1	Waxed paper 10" x 15"	
1	Box.	

Drawn

Checked

T.H. 134

M. M. Gordon

Date 26.5.65

Parts List

Description R.H. Porting off Tool.

Drawing N° TH. 143.

Part N. N 34 RH.

Component List

Qty	Description	Dr. No.
1	Body	143/1
1	Locking screw	145/2
1	" nut	145/3
1	Parting off blade $1\frac{1}{8}" \times \frac{3}{16}" \times \frac{3}{64}" \times 5"$	
1	Key K.5.	139
2	Corrugated card $7\frac{3}{4}" \times 9"$	
1	Waxed paper $10" \text{sq}$	
1	Box.	

Drawn

M. M. Loeche

Checked

Date 26.5.65

T.H. 143

Parts List

Description	L.H. Parting off Tool.
Drawing N°	TH. 144
Part N°	N34 L.H.

Component List

Qty	Description	Unit
1	Body	
1	Locking screw	
1	" nut	
1	Parting off blade $1\frac{1}{8}" \times \frac{3}{16}" \times \frac{3}{64}" \times 6"$	
1	Key K.5	
2	Corrugated card $7\frac{3}{4}" \times 9"$	
1	Waxed paper $10"$ sq.	
1	Box.	

Drawn

M. M. Soobz

Checked

Date 26.5.65

TH 144

Parts List

Description Parting off Tool
 Drawing N° T.H. 145.
 Part N° N.24 R.

Component List

Dwg N°	Description	Qty
145/1	Body	1
145/2	Locking screw	1
145/3	" nut	
	Parting off Blade $1\frac{1}{8}" \times \frac{3}{16}" \times \frac{3}{64}" \times 9"$	1
139	Key k 5.	1
	Corrugated card	1
	Waxed paper 10" sq.	1
	Box complete	1

Drawn

M. M. Souden

Checked

Date 26.5.65

T.H. 145

Parts List

Description : Drop Head Tool.

Drawing N°. TH 150 / S

Part N^o 2.5.

Component List

Drq N°	Description	Qty
150/5	Body	1
	Tool bit $\frac{3}{8}$ " sq. x $2\frac{1}{4}$ " long	1
	So hd. screw $\frac{7}{16}$ " whit x 1" long	
	dog pt	1
137	Key K.3.	1
	Corrugated card 9" x $7\frac{1}{2}$ "	1
	Waxed paper 10" sq.	1
	Box.	1

Drawn 

Checked

TH. 150/s

M. M. Sander

Date 26-5-65

Parts List

Description R.H. Porting off Tool.
 Drawing N° T.H. 152
 Part N° N.31.RH.

Component List

Qty	Description	Dwg N°
1	Body	152/1
1	Locking screw	133/2
1	" nut	133/3
1	Porting off blade $3\frac{1}{4}" \times \frac{1}{8}" \times 4\frac{1}{2}"$	
1	Key K.3.	137
1	Corrugated cord $6\frac{3}{4}" \times 8\frac{1}{2}"$	
1	Waxed paper 8" sq.	
1	Box complete.	

Drawn

M.M. Gordon

Checked

Date 26.5.65

T.H. 152.

Parts List

Description: L.H. Porting off Tool.
Drawing N°. TH 153
Part N°. N. 31 L.H.

Component List

Qty	Description	Drawn	Checked	Date
1	Body	M. M. Loebe	TH. 153	26.5.65
1	Locking Screw			
1	" nut			
1	Parting off Blade $3\frac{1}{4}" \times \frac{1}{8}" \times 4\frac{1}{2}"$			
1	Key K. 3			
1	Corrugated card $6\frac{3}{4}" \times 8\frac{1}{2}"$			
1	Waxed paper 8" sa			
1	Box.			

Parts List

Description

Drawing N°

Part N°

Component List

Dwg N°

Description

Qty

Drawn

Checked

Date

T.H.

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DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No.

ONE.

TITLE:

TOOL HOLDERS

DATE

25-7-78

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
TH.100	1 SIZE 0 : R.H. TOOLHOLDER			
TH.101	1 SIZE 0 : L.H. TOOLHOLDER			
TH.102	1 SIZE 0 : STRAIGHT TOOLHOLDER			
TH.103	1 3/8" BORING BAR			
TH.103	2 3/8" BORING BAR HOLDER			
TH.103	3 TOOLBIT (1/8" DIA)			
TH.104	1 7/16" BORING BAR			
TH.104	2 7/16" BORING BAR HOLDER			
TH.105	1 9/16" BORING BAR			
TH.105	2 9/16" BORING BAR HOLDER			
TH.106	1 3/4" BORING BAR			
TH.106	2 3/4" BORING BAR HOLDER			
TH.107	1 15/16" BORING BAR			
TH.107	2 15/16" BORING BAR HOLDER			
TH.108	1 1 5/16" BORING BAR			
TH.108	2 1 5/16" BORING BAR HOLDER			
TH.109	1 SIZE 1 : R.H. TOOLHOLDER			
TH.110	1 SIZE 1 : L.H. TOOLHOLDER			
TH.111	1 SIZE 1 : STRAIGHT TOOLHOLDER			
TH.112	1 SIZE 2 : R.H. TOOLHOLDER			
TH.113	1 SIZE 2 : L.H. TOOLHOLDER			
TH.114	1 SIZE 2 : STRAIGHT TOOLHOLDER			
TH.115	1 SIZE 3 : R.H. TOOLHOLDER			
TH.116	1 SIZE 3 : L.H. TOOLHOLDER			
TH.117	1 SIZE 3 : STRAIGHT TOOLHOLDER			
TH.118	1 SIZE 4 : R.H. TOOLHOLDER			
TH.119	1 SIZE 4 : L.H. TOOLHOLDER			
TH.120	1 SIZE 4 : STRAIGHT TOOLHOLDER			
TH.121	1 SIZE 00 : R.H. TOOLHOLDER			
TH.122	1 SIZE 00 : L.H. TOOLHOLDER			
TH.123	1 SIZE 00 : STRAIGHT TOOLHOLDER			
TH.124	1 N°30 : R.H. PARTING OFF TOOLHOLDER			
TH.125	1 N°30 : L.H. PARTING OFF TOOLHOLDER			
TH.126	1 N°20R : STRAIGHT PARTING OFF TOOLHOLDER			

SHEET No.

1

DATE _____

19-5-65

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 A

ASSY. DRG. No. B.O. Parts. WL100/100

DATE

19.5.65

TITLE: 5" Viceroy Wood Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Cap Screws.</u>			
		$\frac{1}{4}$ " whit x $\frac{3}{4}$ " long.	—	3	Unbrako
		$\frac{1}{4}$ " " x $\frac{1}{2}$ " "	—	3	"
		<u>Round Hd Screws.</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long	—	4	
		<u>Grubscrews.</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long kn cup pt	—	2	Unbrako
		<u>Keys.</u>			
		$\frac{1}{4}$ " sq x $1\frac{3}{16}$ " long	—	1	
		<u>Bearings</u>			
		Ref. 6208 Z.Z.	—	2	D.K. Brgs.
		<u>Vee Belt</u>			
		$\frac{1}{2}$ " 40° 'A' Section x 5'-6"	—	—	Brammer
		<u>Charts</u>			
		CH100 24 swg x $4\frac{3}{8}$ " x $3\frac{1}{8}$ "	Brass	1	Brig. Eng.
		CH131 " x 2" x 1"	"	1	" "
		Red Fibre rod : $\frac{3}{16}$ " dia x $\frac{1}{4}$ " long	Fibre	1	—
		<u>Rivets.</u>			
		Hdn. Brass. Type 'U' x $\frac{3}{16}$ " long	—	8	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18

ASSY. DRG. No. B.O. Parts WL100/100

DATE

9.5.66

TITLE: 5" Viceroy Wood Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Dowel.</u>			
		1/4" dia x 3/4" long.	—	1	
		<u>Knob.</u>			
		1" dia x 5/16" whit	—	1	Mc millen.
		<u>Washers.</u>			
		1/2" std spring washer	—	1	
		2 B.A. washer.	—	1	
		<u>Ch. hd. Screws</u>			
		2 B.A. x 1/2" long	—	1	
		<u>Nuts</u>			
		2 B.A.	—	2	
		<u>Chain</u>			
		2 links to the 1", x 5/16" wide x 18" long x 15 swg. —	—	1	
SP150		Front Nose Cap	Aluminium	1	Hirst.
WL100	113A	Front & Rear Cover. Ref: A1466 & A652	Polythene	1	Robert Moss.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Cabinet Assembly WL 100/200

DATE

19-5-65

TITLE: 5" Viceroy Wood Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL100	201	Motor Pulley	Alum.	1	Casting
"	202	" Cabinet	Sheet Stee	1	12 swg
"	203	Cabinet Foot	"	1	"
"	204	Tray	"	1	"
"	205	Tool cabinet Extra Equipment	"	1	10 swg
"	206	" " Door " "	"	1	16 "
"	210	Cabinet Door	"	1	16 swg.
ML100	221	CONNECTING PIN SUPPORT	MS.	1	
"	222	PIVOT PIN SUPPORT	MS.	2	
"	223	MOTOR ADJUSTMENT STOP	MS.	1	
		Additional Parts Required.			
SP	113	Base plate	C.I.	1	Casting
"	114	Motor platform	"	1	"
"	115	Connecting Pin	M.S.	1	3/4" D x 2 3/16"
"	116	Washer	"	1	3/4" D x 5/8"
"	117	Swing Bolt	"	1	5/8" D x 4"
"	118	Swivel screw	"	1	1/2" D x 1 1/8"
"	119	Handle	"	1	5/16" D x 4 1/2"
"	120	Link	"	1	3/8" x 3/4" x 2"
"					
"	124	Pivot pin	M.S.	1	3/8" D x 5 3/8"
"	106	Hinge Bush	"	2	1/2" dia x 1"
"	107A	DOOR HINGE		2	
"	109	Micro-switch bracket	Sheet St.	1	12 swg.
"	108	Link Pin	M.S.	1	5/16" D. x 1 1/4"
"	110	Extension Stud.	B.M.S.	1	3/8" dia x 1 1/4"
"	183	DOOR PLUNGER	MS.	1	
"	185	KNOCK OFF CAM	MS.	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. B.O. Parts. WL 100/200

DATE

19.5.65

TITLE: 5" Viceroy Wood Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Hex Hd. Set Screw.</u>			
		3/8" whit x 1/2" long	—	4	
		5/16" " x 1" long	—	4	
		1/4" whit x 3/4" long	—	3	
		<u>Grubscrews.</u>			
		1/4" whit x 1/4" long kn. cup pt	—	2	
		3/8" whit x 1/2" long kn cup pt	—	1	
		<u>Nuts</u>			
		std 5/16" whit	—	4	
		std 4 B.A.	—	2	
		std 1/4" whit	—	4	
		<u>Washers</u>			
		std 3/8" whit	—	4	
		std 5/16" whit	—	4	
		std 1/4" whit	—	3	
		<u>Self Tapping Screws.</u>			
		" x 5/16" long csk.	—	2	
		N° 8 x 1/2" long	—	4	
		<u>Micro-Switch</u>			
		Type D.S.3. 521	—	1	Burgess.
		<u>Starter</u>			
		Starter & Control Panel	—	1	ELMIC. Greenhat.
		EFIE 1 PHASE OR			
		EFIE 3 PHASE			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. B.O. Parts WL 100/200

DATE

19-5-65

TITLE: 5" Viceroy Wood Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Motor</u>			
		Single Phase $\frac{3}{4}$ h.p. Ref 2310 HAF 1633 A	—	1	Hoover
OR		3 Phase $\frac{3}{4}$ H.P. Ref 2543 HAF 1633 B	—	1	Hoover.
		<u>Knobs.</u>			
		REF: 1032 - $\frac{5}{16}$ " WHIT - BLACK	—	2	RENCOL
		<u>Pins</u>			
		$\frac{3}{32}$ " D. x $\frac{3}{4}$ " long	—	2	Spilt pin
		<u>Vee Belt</u>			
		$\frac{1}{2}$ " x 40° A Section x 4' - 6"	—	1	Bronner
		<u>Grommets.</u>			
		N° 7	—	1	
		<u>Cable</u>			
		P.V.C. 3-029" x 5' - 0"	—	1	
		<u>Springs</u>			
		$\frac{9}{32}$ " O.D. x $\frac{3}{4}$ " F.L. x 17 SWG x 8 C.P.I	—	1	
		<u>Stenor Latch</u>			
		SRV/1637/17/0	—	1	Stenor
		<u>Stenor Stud.</u>			
		SBV/1698/17/0	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. B.O. Parts. WL 100/200

DATE

19-5-65

TITLE: 5" Viceroy Wood Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Circlips</u>			
		Type 1400 - 3/8"	—	2	Anderton's
		<u>Ball</u>			
		5/16" dia	—	1	
		<u>C'sk Screws.</u>			
		4 B.A. x 1/2" long	—	2	
		<u>Fused Isolator.</u>			
		REF: MEM 310 K.A.		1	Wholesale electro.
		<u>Isolator.</u>			
		REF: MEM. 310 AX.		1	"
		<u>Extra Equipment For Isolators.</u>			
		2 BA CH:HD: screws 1/2" long.		3	Gregory Sutcliffe.
		3/4 conduit Hex locknut.	steel.	1	Wholesale electro.
		3/4 conduit Male insert - L.P. bush.	Brass.	1	"
		1/4 R.H.HEAD screws 3/4" long. (Fused Isolator only.)		4	Gregory Sutcliffe
		<u>Starter Box & Cover REF: 499/A</u>	—	1	Greenbat.

SHEET No.

1

DATE _____

19-5-65

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL100	401	Bed.	C.I.	1	Casting
"	402	Large Foot	"	1	"
"	403	Small Foot	"	1	"
"	405	Large Foot Key	M.S.	1	5 1/4" x 3/4" x 3/8"
"	404	Small Key	"	1	1 3/16" x 3/4" x 3/8"
CH	114	Spindle Speed Chart	Brass	1	See B.O.
CH	101	Lubrication Chart	"	1	" "
SP	121	Stud	M.S.	6	5/16" whit rod x 1 3/8"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 A

ASSY. DRG. No. B.O. Parts WL 100 / 400

DATE

19-5-65

TITLE: 5" Viceroy Wood Lathe.

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
	<u>Cap Screws</u>			
	$\frac{3}{8}$ " whit x $\frac{1}{2}$ " long	—	4	Unbrako
	$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long	—	2	"
	$\frac{5}{16}$ " " x 1" long	—	3	"
	<u>Hex Hd. Screws.</u>			
	$\frac{3}{8}$ " whit x $1\frac{1}{2}$ " long	—	4	
	<u>Chairs</u>			
	CH114 24 swg x 4" x 1"	Brass	1	Brig Eng.
	CH 101 " " x $2\frac{3}{4}$ " x $1\frac{3}{4}$ "	"	1	" "
	<u>Rivets</u>			
	Type 'U' x $\frac{3}{16}$ " long Hdn. brass	—	6	
	<u>Spring Washers</u>			
	$\frac{5}{16}$ " dia	—	3	
	<u>Nuts & Washers</u>			
	$\frac{5}{16}$ " whit nuts & washers.	—	6 each	
	$\frac{3}{8}$ " std washers	—	4	

SHEET No.

ASSY. DRG. No. **B.O. Parts** WL100/500

DATE _____

19-5-65

TITLE: 5" Viceroy Wood Lathe.

[illegible]

TITLE: 5" Viceroy Wood Lathe

SHEET No.

1

DATE _____

19-5-65

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. B.O. Parts WL100/600

DATE

19.5.65

TITLE: 5" Viceroy Wood Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt hd. C'sk Screws.</u>			
		$\frac{3}{8}$ " whit x $\frac{3}{4}$ " long	—	4	Unbrok.
		<u>Bearings</u>			
		Ref 6205 ZZ (Deep groove journal)		2	Fag.
		<u>Circlips</u>			
		Type 1300 Internal 52 ^m /m	—	2	
		Type 1400 External 25 ^m /m	—	2	
		<u>NUTS.</u>			
		STD $\frac{5}{16}$ " WHIT.	—	4	
		<u>Washers.</u>			
		STD $\frac{5}{16}$ "	—	4	
		<u>PINS.</u>			
		$\frac{1}{8}$ " DIA. x $\frac{7}{8}$ " LONG. SEL-LOK.	—	2	

SHEET No.

ASSY. DRG. No. **B.O. Parts** **WL 100 / 700**

DATE _____

TITLE: 5" Viceroy Wood Lathe

19-5-65

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		Skt Cap Screws.			
		1/4" wh x 1/2 long	—	3	Unbroko
		Grubscrews.			
		2 B.A. x 1/4" long kn pt	—	1	Unbrako
		1/4" wh x 1/2" long Dog pt	—	1	"
		Set Screws			
		5/16" whit x 3/4" long	—	2	
		Std Hex Nuts.			
		3/8" whit (Wedgelock)	—	1	G.K.N.
		Knobs.			
		1 1/4" D x 5/16" whit Pott 30. Cream	—	1	McMillan
		Circlips			
		Ref 5108/156	—	1	Salter
		REF: 1400 - 19/16		1	ANDERTON

SHEET No.

ASSY. DRG. No. Outrigger Assembly WL 100 / 800

DATE _____

19-5-65

TITLE: 5" Viceroy Wood Lathe.

[illegible]

SHEET No.

ASSY. DRG. No. B.O. Parts WL100 / 800

TITLE: 5" Viceroy Wood Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Hex Set Screws.</u>			
		1/2" whit x 1 1/4" long	—	2	
		<u>Washers.</u>			
		1/2" dia	—	3	
		<u>Pins</u>			
		3/16" dia x 5/8" long.	—	1	Mills
		<u>Screwed Rod.</u>			
		3/8" wh x 1 1/4" long	—	1	
		<u>Nuts</u>			
		3/8" no whit nut (wedgelock)	—	1	G.K.N.
		<u>Knobs.</u>			
		1 1/4" D. x 5/16" whit. Pat. 30	—	2	McMillan

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. *General Arr^t* WL 105

DATE

TITLE: T.D.S. 6.B.T. Single Ended Bowl Turning Lathe

16.7.65

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL100	101	Headstock	C.I.	1	Casting
"	102	Spindle Pulley	"	1	"
"	103	5" Face plate	Aluminium	1	"
"					
"					
"	107	Main spindle	M.S.	1	1 3/4" d. x 12 5/8"
"	108	Fork Centre	"	1	1" d x 4 5/8"
"	109	Headstock Cover	Sheet Steel	1	12 swg
"	110	Locknut	M.S.	1	2 1/2" d x 5/8"
"					
"	113	A Front & Rear Cover	M.S.	1	See B.O.
"	201	Motor Pulley	Aluminium	1	Casting
"	202	B Motor Cabinet	Sheet Steel	1	12 swg
"					
"					
"	210	Cabinet Door	Sheet Steel	1	16 swg.
"	211	DOOR HINGE	M.S.	2	BAR & PLATE
"	402	Large Foot	C.I.	1	Casting
"	404	Small Key	M.S.	1	3/4" x 3/8" x 1 3/16"
"	405	Large Key	"	1	3/4" x 3/8" x 5 1/4"
"					
"	504 A	6" Toolrest	C.I.	1	Casting
"	" B	12" Toolrest	"	1	"
"	506	Tommy Bar	M.S.	1	3/8" d. x 6"
"					
"	601	Countershaft Pulley	Aluminium	1	Casting
"					
"	802	Outrigger Clamp arm	C.I.	1	Casting
"	802A	Reduced Toolrest support	"	1	"
"	806	Fulcrum Pin	M.S.	1	1 1/4" d. x 1 3/8"
"			Screwed Rod	1	3/8" wht x 1 3/8"
"	807	Clamp	M.S.	1	1" d. x 5 1/8"
		Oil Blue			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. General Arr^t. WL105

DATE

16.7.65

TITLE: T.D.S. 6.B.T. Single Ended Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL100	808	Bearing Washer	M.S.	1	1 1/4" D. x 1/2"
WL123	A1	R.H. Outrigger Platform	C.I.	1	Casting
SP	103	Locking Handle	M.S.	1	3/4" D x 2 13/16"
"	103	E " Stud	M.S.	2	3/8" D. x 1 3/4"
"	103	Pad.	Brass	1	1/4" D. x 1/4"
"	106	Hinge Bush	M.S.	2	1/2" D. x 1"
"	109	Micro - switch bracket ?	Sheet Steel	1	12swg.
"	112	Soft centre	M.S.	1	1" D. x 4 5/8"
"	113	Base plate	C.I.	1	Casting
"	114	Motor Platform	"	1	"
"	115	Connecting Pin	M.S.	1	3/4" D x 2 3/16"
"	116	Washer	"	1	3/4" D x 5/8"
"	117	Swing bolt	"	1	5/8" D x 4"
"	118	Swivel Screw	"	1	1/2" D x 1 1/8"
"	119	Handle	"	1	5/16" D x 4 1/2"
"	120	Link	"	1	3/4" x 3/8" x 2"
"	121	Stud.	"	5	5/16" x 1 5/8"
"					
"					
"	124	Pivot pin	M.S.	1	3/8" D. x 5 3/8"
"	128	A Countershaft bracket	C.I.	2	Casting
"	129	A " spindle	M.S.	1	1 1/4" D. x 6 1/2"
"	108	Link Pin	"	1	5/16" D. x 1 1/4"
CH100		Nameplate	Brass	1	See B.O.
CH	114	Spindle speed chart	"	1	" "
CH	101	Lubrication "	"	1	" "
"	130	Spindle Lock Plate	"	1	" "
SP	143	Rear Nose Cap	Alum	1	Casting
"	144	Spindle Lock Handle - Body	M.S.	1	1/2" x 1" x 2 1/4"
"	145	" " Collar	"	1	3/4" D. x 1 1/8"

SEE SHEET

No. 3

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. B.O. Parts WL105

DATE

16-7-65

TITLE: T.D.S. 6 B.T. Single Ended Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Bearings</u>			
		6208ZZ	—	2	D.K. Brgs
		6205ZZ	—	2	Fag.
		<u>Circlips</u>			
		Internal ref 1300/52 ^m / _m	—	2	Anderton
		External " 1400/25 ^m / _m	—	2	"
		" " 1400/3 ¹ / ₈ "	—	2	"
		<u>Motor</u>			
		Single Phase 3/4 h.p. ref. 2310 HAF 1633A	—	1	Hoover
OR		3 Phase 3/4 h.p. ref. 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Starter & Control Panel.	—	1	Greenbat.
		<u>Micro - Switch</u>			
		Ref D.S.3. 521.	—	1	Burgess.
		<u>Knobs.</u>			
		1 1/4" D. x 5/16" Whit Plastic	—	4	McMillan.
		1" D x " " "	—	1	"
		<u>'Vee' Belt</u>			
		'A' 1/2" x 40" x 4' 6"	—	1	Brammer
		'A' 1/2" x 40" x 5' 6"	—	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. B.O. Parts. WL 105

DATE

16-7-65

TITLE: T.D.S. 6.B.T. Single Ended Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Spring Latch & Stud.</u>			
		Latch ref: SRV/1637/17/00	—	1	Stenor
		Stud ref SBV/1698/17/00	—	1	"
		<u>Pins.</u>			
		$\frac{3}{16}$ " D. x $\frac{3}{4}$ " long	—	1	Mills pin
		$\frac{3}{32}$ " D x $\frac{3}{4}$ " long	—	2	Split pins.
		$\frac{1}{4}$ " D x $\frac{3}{4}$ " " Dowel	—	1	
		<u>Skt. hd. Cap. screws.</u>			
		$\frac{1}{4}$ " whit x $\frac{3}{4}$ " long	—	3	Unbrako
		$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long	—	5	"
		$\frac{3}{8}$ " whit x $\frac{3}{4}$ " long	—	4	"
		<u>Set Screws</u>			
		$\frac{1}{4}$ " whit x $1\frac{1}{4}$ " long	—	2	
		$\frac{5}{16}$ " whit x 1" long	—	4	
		$\frac{3}{8}$ " whit x $\frac{1}{2}$ " long	—	4	
		$\frac{3}{8}$ " whit x $1\frac{3}{4}$ " long	—	2	
		<u>Nuts</u>			
		4 B.A.	—	2	
		$\frac{1}{4}$ " whit	—	2	
		$\frac{5}{16}$ " whit	—	8	
		$\frac{3}{8}$ " whit (wedge lock)	—	1	
		2 B.A.	—	2	
		<u>Washers</u>			
		$\frac{1}{4}$ " whit	—	2	
		$\frac{5}{16}$ " whit	—	8	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. B.O. Parts. WL 105

DATE

16-7-65

TITLE: T.D.S. 6.B.T. Single Ended Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Washers.</u>			
		1/2" Split.	—	1	
		3/8" whit	—	8	
		1/2" whit	—	1	
		2 B.A.	—	1	
		<u>Grubs.</u>			
		1/4" whit x 1/4" long kn. cup pt	—	3	Unbroke
		" x "	—	1	"
		3/8" whit x 1/2" long kn. cup. pt.	—	1	"
		<u>C'sk screws.</u>			
		4 B.A. x 1/2" long	—	2	"
		3/8" whit x 3/4" long Skt hd.	—	4	"
		<u>Self Tapping Screws.</u>			
		N° 8 x 1/2" long	—	4	
		N° 6 x 5/16" " c'sk	—	2	
		<u>Rd. Hd. screws.</u>			
		1/4" whit x 1/2" long	—	4	
		<u>Spring.</u>			
		3/4" F.L., 9/32" O.D. 17 swg 8 C.P.I.	—	1	Airedale
		<u>Bolt.</u>			
		5/16" Dia	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1D

ASSY. DRG. No. B.O. Parts WL105

DATE

31-8-65

TITLE: T.D.S. 6.B.T. Single Ended Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Charts</u>			
		CH100 2A swg x 4³/₈" x 3¹/₈"	Brass	1	Brig. Engr.
		CH114 " " x 4" x 1"	"	1	" "
		CH101 " " x 2³/₄" x 1³/₄"	"	1	" "
		CH131 " " x 2" x 1"	"	1	" "
		SGG SHEET No 3			
		<u>Rivets</u>			
		Hdn brass type 'U' x 3/16" long	—	14	
		<u>Ch. hd. Screws</u>			
		2 B.A. x 1/2" long	—	1	
		<u>Chain</u>			
		2 links to the 1", x 5/16" wide x 18" long x 15 swg.	—	1	
SP150		Front Nose Cap	Aluminium	1	Hirst
WL100	113A	Front & Rear Cover Ref: A1466 & A662.	Polythene	1	Robert Moss.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrangement WL 110

DATE

15.7.65

TITLE: T.D.S. 6 B.T. Double Ended Bowl turning lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL100	101	A Headstock	C.I.	1	Casting
"	102	Spindle Pulley	"	1	"
"	103	5" Faceplate R.H.	Aluminium	1	"
"					
"					
"	107	Main Spindle	M.S.	1	1 3/4" d. x 12 5/8"
"	108	Fork Centre	"	1	1" d x 4 5/8"
"	109	Headstock Cover	Sheet Steel	1	12 s.w.g.
"	110	Locknut	M.S.	1	2 1/2" d. x 5/8"
"					
"	113	A Front & Rear Cover	M.S.	1	See B.O.
"	201	Motor Pulley	Aluminium	1	Casting
"	202	B Motor Cabinet	Sheet Steel	1	12 s.w.g.
"	210	CABINET DOOR	" "	1	16 "
"					
"					
"	402	Large Foot	C.I.	1	Casting
"	404	Small Key	M.S.	1	3/4" x 3/8" x 1 3/16"
"	405	Large Key	"	1	3/4" x 3/8" x 5/4"
"					
"	506	Tommy Bar	M.S.	2	3/8" d. x 6"
"	504	A 6" Toolrest	C.I.	1	Casting
"	"	B 12" Toolrest	"	1	"
"					
"	601	Countershaft Pulley	Aluminium	1	Casting
"	801	Outrigger Platform L.H.	C.I.	1	Casting
"	802	Outrigger Clamp arm	C.I.	2	Casting
"	803	B Toolrest support	"	1	"
"	"	A Reduced Toolrest support	"	1	"
"	804	12" Faceplate L.H.	Aluminium	1	"
"	806	Fulcrum Pin	MS.	2	1 1/4" d. x 1 3/8"
			Screwed Rod	2	3/8" Whit x 1 3/8"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. General Arr^t WL 110

DATE

16-7-65

TITLE: T.D.S. 6 B.T. Double Ended Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL100	807	Clamp Oil Blue	M.S.	2	1" D. x 5 1/8"
"	808	Bearing Washer	"	2	1 1/4" D. x 1/2"
WL123	X1	Outtrigger Platform R.H.	C.I.	1	Casting
SP	1030	Locking Handle	M.S.	2	3/4" D x 2 13/16"
"	1038	" Stud.	M.S.	2	3/8" D. x 1 3/4"
"	1035	Pad.	Brass.	2	1/4" D. x 1/4"
"	106	Hinge Bush	M.S.	2	1/2" D x 1"
"	107A	DOOR HINGE		2	
"	112	Soft Centre	"	1	1" D. x 4 5/8"
"	109	Micro-Switch bracket	Sheet Steel	1	12 Swg.
"	113	Base Plate	C.I.	1	Casting
"	114	Motor Platform	"	1	"
"	115	Connecting Pin	M.S.	1	3/4" D. x 2 3/16"
"	116	Washer	"	1	3/4" D x 5/8"
"	117	Swing Bolt	"	1	5/8" D. x 4"
"	118	Swivel Screw	"	1	1/2" D x 1 1/8"
"	119	Handle	"	1	5/16" D. x 4 1/2"
"	120	Link	"	1	3/4" x 3/8" x 2"
"	121	Stud	"	5	5/16" x 1 5/8"
"					
"					
"	124	Pivot pin	M.S.	1	3/8" D x 5 3/8"
"	128	Countershaft bracket	C.I.	2	Casting
"	129	A " spindle	M.S.	1	1 1/4" D. x 6 1/2"
"	108	Link Pin	"	1	5/16" D. x 1 1/4"
"	143	Rear Nose Cap	Alum	1	Casting
CH	100	Nameplate	Brass	1	See B.O.
CH	114	Spindle speed chart	"	1	" "
CH	101	Lubrication "	"	1	" "
"	131	Spindle lock Plate	"	1	" "
SP	144	" " Handle - Body	M.S.	1	1/2" x 1" x 2 1/4"
"	145	" " Collar	"	1	3/4" D x 7/8"

SEE SHEET

No 3

SHEET No.

ASSY. DRG. No. General Arrt. WL110

TITLE: TDS 6 BT. Double Ended Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
S.P.	110	Extension Stud.	B.M.S.	1	3/8" dia x 1 1/4
"	150	Front Nose Cap.	Alum	1	Casting.
"	151	Spindle Lock - Retaining Screw.	M.S.	1	597 A/F x 2 3/8
CH	131	SPINDLE LOCK PLATE	ALUM	1	
CH	267B	SPECIFICATION PLATE	ALUM	1	
CH	373	SPINDLE R.P.M. PLATE	POCY CARBONATE	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. B.O. Parts.

WL 110

DATE

16-7-65

TITLE: T.D.S. 6 B.T. Double Ended Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Bearings</u>			
		6208ZZ	—	2	D.K. Brgs.
		6205ZZ	—	2	Fag.
		<u>Circlips</u>			
		Internal. ref 1300/52 ^m / _m	—	2	Andertons
		External ref 1400/25 ^m / _m	—	2	"
		" " 1400/3 ^m / ₈ "	—	2	"
		<u>Motor</u>			
OR		Single Phase 3/4" h.p. ref: 2310 HAF 1633A	—	1	Hoover
		3 Phase 3/4 h.p. ref: 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Starter & Control Panel.	—	1	Greenbat.
		<u>Micro - Switch</u>			
		Ref D.53-521	—	1	Burgess.
		<u>Knobs</u>			
		1 1/4" d. x 5/16" whit	Plastic	6	Mc millan.
		1" d x "	"	1	"
		<u>'Vee' Belt</u>			
		'A' 1/2" x 40" x 5' 6"	—	1	Brommer
		" 'A' 1/2" x 40" x 4' 6"	—	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. B.O. Parts.

WL. 110

DATE

16-7-65

TITLE: T.D.S. 6.B.T. Double Ended Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Spring Latch & Stud</u>			
		Latch ref: SRV/1637/17/00	—	1	Stenor
		Stud ref: SBV/1698/17/00	—	1	"
		<u>Pins</u>			
		$\frac{3}{16}$ " dia x $\frac{3}{4}$ " long	—	2	Mills
		$\frac{3}{32}$ " dia x $\frac{3}{4}$ " long	—	2	Split pins.
		$\frac{1}{4}$ " dia x " " Dowel	—	1	
		<u>Sk t hd Cap screws.</u>			
		$\frac{3}{8}$ " whit x $\frac{3}{4}$ " long	—	4	Unbrako
		$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long	—	5	"
		" x $\frac{3}{4}$ " long	—	3	"
		<u>Set Screws.</u>			
		$\frac{1}{4}$ " whit x $1\frac{1}{4}$ " long	—	2	
		$\frac{5}{16}$ " whit x 1" long	—	4	
		$\frac{3}{8}$ " whit x $\frac{1}{2}$ " long	—	4	
		$\frac{1}{2}$ " whit x $1\frac{1}{4}$ " long	—	2	
		$\frac{3}{8}$ " whit x $1\frac{3}{4}$ " long	—	2	
		<u>Nuts.</u>			
		4 B.A.	—	2	
		$\frac{1}{4}$ " whit	—	2	
		$\frac{5}{16}$ " whit	—	8	
		$\frac{3}{8}$ " whit wedge lock	—	2	
		<u>Washers</u>			
		$\frac{1}{4}$ " whit	—	2	
		$\frac{5}{16}$ " whit	—	8	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. B.O. Parts WL 110

DATE

16-7-65

TITLE: T.D.S. L.B.T. Double Ended Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Washers</u>			
		$\frac{3}{8}$ " whit	—	8	
		$\frac{1}{2}$ " whit	—	4	
		2 B.A.	—	1	
		$\frac{1}{2}$ " split.	—	1	
		<u>Grubs</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long kn cup pt	—	3	Unbrako
		" x " "	—	1	"
		$\frac{3}{8}$ " whit x $\frac{1}{2}$ " long " " "	—	1	"
		<u>C'sk screws</u>			
		4 B.A x $\frac{1}{2}$ " long	—	2	"
		$\frac{3}{8}$ " whit x $\frac{3}{4}$ " long skt hd	—	4	"
		<u>Self topping screws</u>			
		N° 8 x $\frac{1}{2}$ " long	—	4	
		N° 6 x $\frac{5}{16}$ " long c'sk	—	2	
		<u>Rd. Hd. screws</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long	—	4	
		<u>Thumbscrew</u>			
		$\frac{1}{4}$ " whit x $1\frac{1}{4}$ " long	—	2	
		<u>Spring. + Ball</u>			
		$\frac{3}{16}$ " F.L. $\frac{9}{32}$ " O.D. 17 SWG, 8 C.P.I.	S.S.	1	Airedale
		$\frac{5}{16}$ " dia ball	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 D

ASSY. DRG. No. B.O. Parts WL110

DATE

31-8-65

TITLE: T.D.S. 6BT Double Ended Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Charts</u>			
		CH100 24 swg x 4 ³ / ₈ " x 3 ¹ / ₈ "	Brass	1	Brig. Engr.
		CH114 " " x 4" x 1"	"	1	" "
		CH101 " " x 2 ³ / ₄ " x 1 ³ / ₄ "	"	1	" "
		CH131 " " x 2" x 1"	"	1	" "
		SEE PAGE No 3			
		<u>Rivets</u>			
		Hdn. brass type 'U' x 3/16" long	—	14	
		<u>Nuts.</u>			
		Std 2 B.A.	—	2	
		<u>Ch. hd. screws</u>			
		2 B.A. x 1/2" long	—	1	
		<u>Chain.</u>			
		2 links to the 1" x 5/16" wide x 18" long x 15 swg	—	1	
SP150		Front Nose Cap	Aluminium	1	Hirst.
WL100	113A	" & Rear cover. Ref: A1466 & A652	Polythene	1	Robert Mass.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrt'

WL115

DATE

21.8.67.

TITLE: TDS 6 SB. Short Bed Bowl Turning Lathe. (D.E)

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL115	1	R.H. Outrigger & Foot	C.I.	1	Casting
"	2A	Toolrest Support	"	1	"
"	3	Locking Strip	M.S.	1	$3\frac{3}{4}" \times 1\frac{1}{4}" \times 4\frac{15}{16}"$
"	4	Key	M.S. Plate	2	$3\frac{1}{8}" \times 7\frac{7}{8}" \times 3\frac{3}{8}"$
"	5				
"	6	Centre Pillar	C.I.	1	Casting.
"	7	Barrel	M.S.	1	$15\frac{1}{16}" \text{ dia} \times 5\frac{1}{2}"$
"	8	Locking Stud Make from SP103B.	"	1	$3\frac{1}{8}" \times 17\frac{1}{16}"$
		<u>Other parts required.</u>			
WL100	101A	Headstock	C.I.	1	Casting
"	102	Spindle Pulley	"	1	"
"	103	5" Faceplate R.H.	Alumin.	1	"
"	107	Main Spindle	M.S.	1	$13\frac{3}{4}" \text{ Dia} \times 12\frac{5}{8}"$
"	108	Fork Centre	"	1	$1" \text{ Dia} \times 4\frac{5}{8}"$
"	109	Headstock Cover	Sheet Steel	1	12 swg.
"	110	Locknut	M.S.	1	$2\frac{1}{2}" \text{ dia} \times 5\frac{1}{8}"$
"	113A	Front & Rear Cover	M.S.	1	See B O
"	201	Motor Pulley	Alumin.	1	Casting.
"	202 B.	" Cabinet	Sheet Steel	1	12 swg.
"	210	Cabinet Door	" "	1	16 swg.
"					
"	504A	6" Toolrest	C.I.	1	Casting
"	"	B 12" Toolrest	"	1	"
"	506	TOMMY Bar	M.S.	3	$3\frac{3}{8}" \text{ dia} \times 6"$

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. WL115 General Arr^t.

DATE

TITLE: T.D.S. 6 S.B. D.E. Viceroy Short Bed Bowl Turning Lathe 21.8.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL100	601	Countershaft Pulley	Alumin.	1	Casting.
"	801	Outrigger Platform L.H.	C.I.	1	Casting.
"	802	Outrigger Clamp Arm	"	2	"
"	803	Toolrest Support	"	2	"
"	804	12" Faceplate L.H.	Alumin.	1	"
"	806	Fulcrum Pin.	M.S.	2	1 1/4" dia x 1 3/8"
		\$	Screwed Rod	2	3/8" wh. x 1 3/8"
"	807	Clamp Oil Blue	M.S.	3	1" dia x 5 1/8"
"	808	Bearing Washer	"	2	1 1/4" dia x 1/2"
SP	103	D Locking Handle	M.S.	3	3/4" D x 2 13/16"
"	"	B Locking Stud	M.S.	3	3/8" dia x 1 3/4"
"	"	C Pad.	Brass	2	1/4" dia x 1/4"
"	106	Hinge Bush	M.S.	2	1/2" sq. x 1"
"	107	A DOOR HINGE		2	
"	112	Soft Centre	"	1	1" dia x 4 5/8"
"	109	Micro - Switch Bracket	Sheet Steel	1	12 swg
"	113	Baseplate	C.I.	1	Casting
"	114	Motor Platform	"	1	"
"	115	Connecting Pin	M.S.	1	3/4" dia x 2 3/16"
"	116	Washer	"	1	3/4" dia x 5/8"
"	117	Swing Bolt	"	1	5/8" dia x 4"
"	118	Swivel Screw	"	1	1/2" dia x 1 1/8"
"	119	Handle	"	1	5/16" dia x 4 1/2"
"	120	Link	"	1	3/4" x 3/8" x 2"
"	121	Stud	"	5	5/16" x 1 5/8"
"	124	Pivot Pin	"	1	3/8" dia x 5 3/8"
"	128	A Countershaft Bracket	C.I.	2	Casting
"	129	A " Spindle	M.S.	1	1 1/4" dia x 6 1/2"
"	108	Link Pin	"	1	5/16" dia x 1 1/4"
"	143	Rear Nose Cap	Alumin.	1	Casting.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. B.O. Parts.

WL115

DATE

21.8.67.

TITLE: TDS 6SB D.E. Short Bed Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Bearings</u>			
		Ref 6208 ZZ	—	2	D.K. Brgs
		" 6205 ZZ	—	2	Fag.
		<u>Circlips</u>			
		Internal ref 1300/52 ^M / _M	—	2	Anderton
		External " 1400/25 ^M / _M	—	2	"
		" " 1400/3 ⁸ / ₈ "	—	2	"
		" " 5108/156	—	1	Salter.
		<u>Motor</u>			
		Single Phase $\frac{3}{4}$ h.p. ref 2310 HAF 1633A	—	1	Hoover
		OR			
		3 Phase $\frac{3}{4}$ h.p. ref 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Starter & Control Panel.	—	1	Greenbat.
		<u>Starter Station ref F5</u>	—	1	"
		<u>Micro - Switch</u>			
		Ref D.S3-521 KBS QBR.	—	1	Burgess
		<u>Knobs</u>			
		1 ¹ / ₄ " dia x 5 ¹ / ₁₆ " whit insert	Plastic	8	Mc Millan
		1" dia x " " "	"	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 B

ASSY. DRG. No. B.O. Parts

WL 115

DATE

21-8-67.

TITLE: TDS 6 S.B. Viceroy D.E. Short Bed Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>'V' Belt</u>			
		'A' 1/2" x 40° x 5' 6"	—	1	Brammer
		'A' 1/2" x 40° x 4' 6"	—	1	"
		<u>Spring Latch & Stud.</u>			
		Latch ref SRV/1637/17/00.	—	1	Stenor
		Stud ref SRV/1638/17/00	—	1	"
		<u>Pins</u>			
		3/16" dia x 3/4" long	—	2	Mills
		3/32" dia x " "	—	2	Split pins
		1/4" dia x " "	—	1	Dowel
		1/4" dia x 2" "	—	1	Taper Pin.
		<u>Skt hd Cap screws</u>			
		2 BA. x 3/4" long	—	2	Unbrako
		1/4" whit x 1/2" "	—	6	"
		" x 3/4" "	—	5	"
		3/8" " x 1 1/2" "	—	4	"
		<u>Set Screws</u>			
		1/4" whit x 1 1/4" long	—	2	
		5/16" " x 1" "	—	4	
		3/8" " x 1/2" "	—	4	
		1/2" " x 1 1/4" "	—	2	
		<u>Nuts</u>			
		Std. 4 B.A.	—	2	
		" 2 B.A.	—	2	
		Std 1/4" whit	—	1	
		" 5/16" "	—	8	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. B.O. Parts

WL115

DATE

21.8.67

TITLE: TDS6SB Viceroy D.E. Short Bed Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Nuts</u>			
		Std 3/8" whit wedgelock	—	2	
		<u>Washers</u>			
		1/4" whit	—	2	
		5/8" "	—	8	
		3/8" "	—	4	
		1/2" "	—	5	
		2 BA.	—	1	
		1/2" Split.	—	1	
		<u>Grubs</u>			
		1/4" whit x 1/4" long kn cup pt	—	5	
		3/8" " x 1/2" " " " "	—	2	
		<u>C'sk Screws</u>			
		4 B.A. x 1/2" long	—	2	
		3/8" whit x 3/4" " s'kt. hd.	—	4	
		<u>Self Tapping Screws</u>			
		Nº 8 x 1/2" long	—	6	
		Nº 6 x 5/16" c'sk	—	2	
		<u>Rd. hd. Screws</u>			
		1/4" whit x 1/2" long	—	4	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 D.

ASSY. DRG. No. B.O. Parts

WL 115

DATE

21.8.67

TITLE: TDS 6 SB Viceroy D.E. Short Bed Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Spring & Ball</u>			
		$\frac{3}{4}$ " F.L. x $\frac{9}{32}$ " O.D. x 17 swg x 8 c.p.i.	S.S.	1	
		5/16" dia ball	—	1	
		<u>Charts</u>			
		CH100 24 swg x $4\frac{3}{8}$ " x $3\frac{1}{8}$ "	Brass	1	Brig. Engr.
		CH101 " x $2\frac{3}{4}$ " x $1\frac{3}{4}$ "	"	1	" "
		CH114 " x 4" x 1"	"	1	" "
		CH131 " x 2" x 1"	"	1	" "
		SEE SHEET No 3			
		<u>Rivets</u>			
		Hdn. brass type 'U' x $\frac{3}{16}$ " long	—	14	
		<u>Ch. Hd. Screws</u>			
		2 B.A. x $\frac{1}{2}$ " long	—	1	
		<u>Chain.</u>			
		2 links to the 1" x $\frac{5}{16}$ " wide x 18" long x 15 swg	—	1	
		<u>Nylon Slug</u>			
		$\frac{1}{2}$ " dia x $\frac{1}{8}$ " long	—	1	
SP150		Front Nose Cap	Aluminium	1	Hirst.
WL100	113A	Front & Rear Cover. Ref: A1466 & A652.	Polythene	1	Robert Moss.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrangement.

DATE

22.8.67

TITLE: TDS 6SB S.E. Viceroy Bowl Turning Lathe - Short Bed.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL115	1	R.H. Outrigger & Foot.	C.I.	1	Casting.
"	2A	Toolrest Support.	"	1	"
"	3	Locking Strip.	M.S.	1	$3\frac{3}{4}" \times 1\frac{1}{4}" \times 4\frac{15}{16}"$
"	4	Key	M.S. Plate	2	$3\frac{3}{8}" \times 7\frac{7}{8}" \times 3\frac{3}{8}"$
"	5				
"	6	Centre Pillar.	C.I.	1	Casting
"	7	Barrel.	M.S.	1	$1\frac{5}{16}" \text{ dia} \times 5\frac{1}{2}"$
"	8	Locking Stud. Make From SP103B.	"	1	$3\frac{1}{8}" \text{ dia} \times 1\frac{7}{16}"$
		<u>Other Parts Required.</u>			
WL100	101A	Headstock	C.I.	1	Casting.
"	102	Spindle Pulley	"	1	"
"	103	5" Faceplate R.H.	Alumin.	1	"
"	107	Main Spindle	M.S.	1	$1\frac{3}{4}" \text{ dia} \times 12\frac{5}{8}"$
"	108	Fork Centre	"	1	$1" \text{ dia} \times 4\frac{5}{8}"$
"	109	Headstock Cover	Sheet Steel	1	12 swg
"	110	Locknut	M.S.	1	$2\frac{1}{2}" \text{ dia} \times 5\frac{5}{8}"$
"	113A	Front & Rear Cover	M.S.	1	See B.O.
"	201	Motor Pulley	Alumin.	1	Casting
"	202	B. " Cabinet	Sheet Steel	1	12 swg
"	210	Cabinet Door	"	1	16 swg.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2

ASSY. DRG. No. General Arrangement.

DATE

22.8.67.

TITLE: TDS65B. S.E. Short Bed Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL100	504	A 6" Toolrest	C.I.	1	Casting
"	"	B 12" Toolrest	"	1	"
"	506	Tommy Bar	M.S.	2	3/8" dia x 6"
"					
"	601	Countershaft Pulley	Alumn.	1	Casting.
"					
"	802	Outrigger Clamp Arm	CI	1	Casting
"	806	Fulcrum Pin	M.S.	1	1/4" dia x 3/8"
"			Screwed Rod	1	3/8" whit x 13/8"
"	807	Clamp Oil Blue	M.S.	2	1" dia x 5/8"
"	808	Bearing Washer	"	1	1/4" dia x 1/2"
"					
"					
SP	103	D Locking Handle	M.S.	2	3/4" dia x 2 13/16"
"	"	BE " Stud	M.S.	2	3/8" dia x 1 3/4"
"	"	C Pad.	Brass	1	1/4" dia x 1/4"
"	106	Hinge Bush	M.S.	2	1/4" sq. x 1"
"	107	A DOOR HINGE	"	2	
"	108	Link Pin	"	1	5/16" dia x 1/4"
"	109	Micro-Switch Bracket	Sheet Steel	1	12 swg
"	112	Soft Centre	M.S.	1	1" dia x 4 5/8"
"	113	Base plate	C.I.	1	Casting
"	114	Motor Platform	"	1	"
"	115	Connecting Pin	M.S.	1	3/4" dia x 2 3/16"
"	116	Washer	"	1	3/4" dia x 5/8"
"	117	Swing Bolt	"	1	5/8" dia x 4"
"	118	Swivel Screw	"	1	1/2" dia x 1 1/8"
"	119	Handle	"	1	5/16" dia x 4 1/2"
"	120	Link	"	1	3/4" x 3/8" x 2"
"	121	Stud	"	5	5/16" dia x 1 5/8"
"	124	Pivot Pin.	"	1	3/8" dia x 5 3/8"

SHEET No.

3

DATE _____

22-8-67.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
6P	128	Countershaft Bracket	C.I.	2	Casting.
"	129	A " Spindle	M.S.	1	1 1/4" dia x 6 1/2"
"	143	Rear Nose Cap	Alumin.	1	Casting.
"	144	Spindle Lock Handle - Body	M.S.	1	1/2" x 1" x 2 1/4"
"	145	" " Collar	"	1	3/4" dia x 7/8"
"	131	Tailstock Handwheel	C.I.	1	Casting
"	132	" Bush	Chrome Plate.	1	"
"	138	Tee Key.	M.S.	1	1/4" DIA. x 5/8"
"	150	Front Nose Cap.	Alum	1	Casting.
"	151	Spindle Lock - Retaining Screw.	M.S.	1	5/16" A/F x 2 3/8"
CH	100	Nameplate	Brass	1	See B.O. Parts
"	101	Lubrication Chart	"	1	"
"	114	Spindle Speed Chart	"	1	"
"	131	" Lock Plate	"	1	"
CH	131	SPINDLE LOCK PLATE	ALUM	1	
CH	267B	SPECIFICATION PLATE	ALUM	1	
CH	373	SPINDLE R.P.M. PLATE	ALUM CARBONATE	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. B.O. Parts.

DATE

22.8.67.

TITLE: TDS 6SB. S.E. Short Bed Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Bearings</u>			
		Ref 6208ZZ	—	2	D.K. Brgs
		" 6205ZZ	—	2	FAG.
		<u>Circlips</u>			
		Internal ref 1300/52 M/m	—	2	Anderton
		External ref 1400/25 M/m	—	2	"
		" " 1400/3/8"	—	2	"
		" " 5108/156	—	1	Salter.
		<u>Motor</u>			
		Single Phase $\frac{3}{4}$ h.p. ref 2310 HAF 1633A	—	1	Hoover
		OR			
		3 Phase $\frac{3}{4}$ h.p. ref 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Starter & Control Panel.	—	1	Greenbat.
		<u>Micro-Switch</u>			
		Ref DS3. 521	—	1	Burgess
		<u>Knobs</u>			
		1 1/4" dia x 5/16" whit insert	Plastic	6	Mc Millan.
		1" " x " " "	"	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18

ASSY. DRG. No. B.O. Parts.

DATE

22. 8. 67.

TITLE: TDS6S.B. - S.E. Short Bed Bowl Turning Lathe

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>'V' Belt</u>			
		'A' 1/2" x 40° x 4' 6"	—	1	Brammer
		'A' 1/2" x 40° x 5' 6"	—	1	"
		<u>Spring Latch & Stud</u>			
		Latch ref : SRV/1637/17/00	—	1	Stenor
		Stud ref : SBV/1638/17/00	—	1	"
		<u>Pins</u>			
		3/32" dia x 3/4" long	—	2	Split pins
		3/16" dia x 3/4" "	—	1	Mills pin
		1/4" dia x 3/4" "	—	1	Dowel
		1/4" dia x 2" "	—	1	Taper Pin.
		<u>Skf hd. Cap Screws</u>			
		2 B.A. x 3/4" long	—	2	Unbrako
		1/4" whit x 3/4" "	—	5	"
		" x 1/2" "	—	6	"
		3/8" whit x 1 1/2" "	—	4	"
		<u>Set Screws</u>			
		1/4" whit x 1 1/4" long	—	2	
		5/16" " x 1" "	—	4	
		3/8" " x 1/2" "	—	4	
		<u>Nuts</u>			
		4 B.A. std.	—	2	
		2 B.A. std	—	2	
		1/4" whit std	—	1	
		5/16" " std	—	8	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. B.O. Parts.

DATE

22.8.67

TITLE: TDS 65B. S.E. Short Bed Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Nuts</u>			
		$\frac{3}{8}$ " whit std. wedgelock.	—	1	
		<u>Washers</u>			
		2 B.A.	—	1	
		$\frac{1}{4}$ " whit	—	2	
		$\frac{5}{16}$ " "	—	8	
		$\frac{3}{8}$ " whit	—	4	
		$\frac{1}{2}$ " whit	—	2	
		$\frac{1}{2}$ " Split.	—	1	
		<u>Grubs</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long kn. cup. pt.	—	5	Unbrako.
		$\frac{3}{8}$ " " x $\frac{1}{2}$ " " " " "	—	2	"
		<u>C'sk screws</u>			
		4 B.A. x $\frac{1}{2}$ " long	—	2	
		$\frac{3}{8}$ " whit x $\frac{3}{4}$ " " skt. hd.	—	4	
		<u>Self Tapping Screws</u>			
		No 8 x $\frac{1}{2}$ " long	—	4	
		No 6 x $\frac{5}{16}$ " " c'sk	—	2	
		<u>Rd. Hd. Screws</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{2}$ " long	—	4	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1D

ASSY. DRG. No. B.O. Parts.

DATE

22.8.67

TITLE: TDS 6 S.B. S.E. Short Bed Bowl Turning Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Spring & Ball</u>			
		$\frac{3}{4}$ " F.L. x $\frac{9}{32}$ " O.D. x 17swg. x 8 C.P.I.	S.S.	1	Airdale
		$\frac{5}{16}$ " dia ball	—	1	
		<u>Charts</u>			
		CH100 24swg. x $4\frac{3}{8}$ " x $3\frac{1}{8}$ "	Brass	1	Brig. Engr.
		CH 101 " x $2\frac{3}{4}$ " x $1\frac{3}{4}$ "	"	1	"
		CH 114 " x 4" x 1"	"	1	"
		CH 131 " x 2" x 1"	"	1	"
		SEE SHEET N.3			
		<u>Rivets</u>			
		Hdn. brass type 'U' x $\frac{3}{16}$ " long	—	14	
		<u>Ch. hd. Screws</u>			
		2 B.A. x $\frac{1}{2}$ " long	—	1	
		<u>Chain</u>			
		2 links to the 1", x $\frac{5}{16}$ " wide x 18" long x	15swg —	1	
SP150		Front Nose Cap	Aluminium	1	Hirst.
WL100	113A	" & Rear Cover. Ref: A1466 & A652	Polythene	1	Robert Moss.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Extra Equipment

DATE

27.1.67

TITLE: 5" Viceroy Wood & Bowl Turning Lathes.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL	101	Heavy Duty Revolving Centre			
"	102	Screw Chuck			
"	103	3" Dia Faceplate R.H.			
"	103A	" " L.H.			
"	104	Sanding Table			
"	106	Drill Pad			
"	107	Dowel Collet			
"	108	Deep Hole Boring Tool.			
"	109	Vee Centre Pad			
"	111	Cup Centre			
"	112				
"	113	A Bowl Turning Rest R.H.			
"	113 B	" " " L.H.			
"	114	Polishing Spindle L.H.			
"	116	12" Dia Sanding Disc. L.H.			
"	117	1 3/4" Dia Bell Chuck			
"	118	8" Dia Faceplate Light Type R.H.			
"	118A	" " " " L.H.			
"	119	Boring Centre			
"	121				
"	122				
"	123	Outtrigger Platform R.H.			
"	124				
"	125	Turning between crs att ⁺			
"	126	Metal Spinning Att ⁺			
"	127	Dust Extractor Unit.			
/					

SHEET No.

DATE _____

TITLE: 5" Viceroy Wood Lathe

[illegible]

SHEET No.

ASSY. DRG. No. Screw Chuck WL102

TITLE: 5" Viceroy Wood Lathe

[illegible]

SHEET No

1

DATE

18-5-65

[illegible]

SHEET No.

ASSY. DRG. No. Sanding Table WL104

TITLE: 5" Viceroy Wood Lathe

[illegible]

SHEET No.

1 A

DATE
23.2.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Ball.</u>			
		1 1/4" dia x 5/16" whit	—	1	M ^c millan.
		<u>Washers</u>			
		5/8" std washer	—	1	
		1/4" " "	—	1	
		<u>Pins.</u>			
		3/16" dia x 1 1/2" long	—	1	Mills Pins.
		<u>Protractor</u>			
		Casting ref Fig. 110	—	1	Picador
		Slider Bar " " 1245.	—	1	"
		Thumbscrew " " 121	—	1	"

SHEET No.

DATE _____

23.2.67

[illegible]

SHEET No.

ASSY. DRG. No. Vee Centre Pad. WL 109

DATE _____

18-5-65

TITLE: 5" Viceroy Wood Lathe

[illegible]

SHEET No.

ASSY. DRG. No. Bowl Turning Rest R.H. WL 113A

TITLE: 5th Viceroy Wood Lathe

DATE
19-5-65

[illegible]

SHEET No.

ASSY. DRG. No. Polishing Spindle WL 114 L.H.

DATE

14-5-65

TITLE: 5" Viceroy Wood Lotte

[illegible]

TITLE: 5" Viceroy Wood Lathe

SHEET No.

1

DATE

19-5-65

[illegible]

SHEET No.

1

ASSY. DRG. No. 8"b. Faceplate - Light Type R.H. WL 118

DATE _____

19-5-65

TITLE: 5" Viceroy Wood Lathe.

[illegible]

SHEET No.

1

DATE

19-5-65

[illegible]

SHEET No.

ASSY. DRG. No. Outrigger Platform R.H. WL123/A

DATE _____

TITLE: 5" Viceroy Wood Lathe

19-5-65

[illegible]

SHEET No.

ASSY. DRG. No. Metal Spinning All-^t WL126

DATE _____

19-5-65

TITLE: 5" Viceroy Wood Lathe

[illegible]

ASSY. DRG. No.

DATE

25.7.78

TITLE: TOOL HOLDERS

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
TH.100	1	SIZE 0 : R.H. TOOLHOLDER			
TH.101	1	SIZE 0 : L.H. TOOLHOLDER			
TH.102	1	SIZE 0 : STRAIGHT TOOLHOLDER			
TH.103	1	3/8" BORING BAR			
TH.103	2	3/8" BORING BAR HOLDER			
TH.103	3	TOOLBIT (1/8" DIA)			
TH.104	1	7/16" BORING BAR			
TH.104	2	7/16" BORING BAR HOLDER			
TH.105	1	9/16" BORING BAR			
TH.105	2	9/16" BORING BAR HOLDER			
TH.106	1	3/4" BORING BAR			
TH.106	2	3/4" BORING BAR HOLDER			
TH.107	1	1 5/16" BORING BAR			
TH.107	2	1 5/16" BORING BAR HOLDER			
TH.108	1	1 5/16" BORING BAR			
TH.108	2	1 5/16" BORING BAR HOLDER			
TH.109	1	SIZE 1 : R.H. TOOLHOLDER			
TH.110	1	SIZE 1 : L.H. TOOLHOLDER			
TH.111	1	SIZE 1 : STRAIGHT TOOLHOLDER			
TH.112	1	SIZE 2 : R.H. TOOLHOLDER			
TH.113	1	SIZE 2 : L.H. TOOLHOLDER			
TH.114	1	SIZE 2 : STRAIGHT TOOLHOLDER			
TH.115	1	SIZE 3 : R.H. TOOLHOLDER			
TH.116	1	SIZE 3 : L.H. TOOLHOLDER			
TH.117	1	SIZE 3 : STRAIGHT TOOLHOLDER			
TH.118	1	SIZE 4 : R.H. TOOLHOLDER			
TH.119	1	SIZE 4 : L.H. TOOLHOLDER			
TH.120	1	SIZE 4 : STRAIGHT TOOLHOLDER			
TH.121	1	SIZE 00 : R.H. TOOLHOLDER			
TH.122	1	SIZE 00 : L.H. TOOLHOLDER			
TH.123	1	SIZE 00 : STRAIGHT TOOLHOLDER			
TH.124	1	Nº 30 : R.H. PARTING OFF TOOLHOLDER			
TH.125	1	Nº 30 : L.H. PARTING OFF TOOLHOLDER			
TH.126	1	Nº 202 : STRAIGHT PARTING OFF TOOLHOLDER			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

Two

ASSY. DRG. No.

DATE

25.7.78

TITLE:

TOOLHOLDERS

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
TH.127	1				
TH.127	2	KNURL MOUNTING PLATE			
TH.127	3	DOWEL			
TH.127	4	O.K.H. SCREW			
TH.127	5	KNURL.			
TH.128	1	THREADING TOOLHOLDER			
TH.128	2	TOOL BIT			
TH.128	3				
TH.128	4	ADJUSTING SCREW			
TH.128	5	LOCATING SCREW			
TH.129	1	UNIVERSAL KNURLING TOOLHOLDER BODY			
TH.129	2	KNURL HOUSING.			
TH.129	3	SCREW			
TH.129	4	PIVOT PIN			
TH.130	1	BORING BAR HOLDER BODY			
TH.130	2	STIRRUP			
TH.130	3	DOWEL			
TH.130	4				
TH.130	5	3/16" BORING BAR			
TH.130	6	1/4" BORING BAR			
TH.131	1	N°32: R.H. PARTING OFF TOOLHOLDER			
TH.132	1	N°32: L.H. PARTING OFF TOOLHOLDER			
TH.133	1	N°22R: STRAIGHT PARTING OFF TOOLHOLDER			
TH.133	2	LOCKING SCREW			
TH.133	3	LOCKING NUT			
TH.134	1	N°80: AMERICAN TYPE BORING TOOLHOLDER			
TH.134	2	N°80: AMERICAN TYPE - CLAMP			
TH.135		K1. 5/16" SQ KEY			
TH.136		K2. 3/8" SQ KEY			
TH.137		K3. 7/16" SQ KEY			
TH.138		K4. 1/2" SQ KEY			
TH.139		K5. 5/8" SQ KEY			
TH.143	1	N°34: RH. PARTING OFF TOOLHOLDER			
TH.144	1	N°34: LH. PARTING OFF TOOLHOLDER			
TH.145	1	N 24R: STRAIGHT PARTING OFF TOOLHOLDER			

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrt. G M103

DATE

1.7.66

TITLE: 10" Double Ended Pedestal Grinder TDS 7/10".

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM102	1	R.H. wheel Guard.	C.I.	1	Casting
"	2	L.H. " "	"	1	"
"	4	Toolrest bracket	"	2	"
"	5	Outer End Cover	"	2	"
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	9	Toolrest	"	2	"
"	10	Moving Spark Guard	Alum	2	"
"	13	Outer Disc	Mall. Iron	4	"
"	15	Pivot Pin	M.S.	2	3/4" D. x 3 5/16"
"	16	Spindle	"	1	1 1/4" D. x 15 1/8"
"	17	Locking bolt	"	2	5/8" D. x 2 1/2"
"	18	" Pin	"	2	1/2" D. x 2 5/8"
"	23	Distance Piece	"	2	1 1/4" D. x 7/8"
"	31	Headstock Cover	Sh. Steel.	1	16 swg.
"	33	Extractor Hole Cover Plate	"	2	"
GM103	1	Baseplate	C.I.	1	Casting.
"	3	Motor Pulley	Alum	1	"
"	9	Crank Bolt	M.S.	1	3/8" D. x 8"
"	15	Cabinet	Sh. Steel	1	12 swg.
"	19	Extension Stud. (Std. Set screw)	M.S.	1	5/16" x 1/2" long
SP	109	Micro-switch bracket	Sh. Steel.	1	12 swg.
"	114	Motor Platform	C.I.	1	Casting.
"	124	Pivot Pin	M.S.	1	3/8" D. x 5 3/8"
"					
CH	100	Nameplate	Brass Sh.	1	See B.O. Parts.
"	101	Lubrication Chart	"	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Arrt. GM103 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Ended Pedestal Grinder TDS 7/10"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt.</u>			
		Ref: M $3\frac{1}{8}$ " x 40° x 5'	—	1	Brommer.
		<u>Circlips</u>			
		Ref: 1400/ $3\frac{1}{8}$ " External.	—	2	Andertons.
		<u>Motor.</u>			
		$\frac{3}{4}$ h.p. single phase ref: 2310 HAF 1633A	—	1	Hoover
		OR			
		$\frac{3}{4}$ h.p. 3 phase ref: 2543 HAF 1633B	—	1	"
		<u>Starter Motor.</u>			
		Single phase ref: ATF-2BI.	—	1	Brook
		OR.			
		3 phase ref: ATF-3BI.	—	1	Brook.
		<u>Bearings.</u>			
		Deep Groove ref: 6304ZZ	—	2	Fag.
		<u>Grinding Wheels.</u>			
		10" x 1" x $\frac{3}{4}$ " ref A60	—	1	Mitchells
		10" x 1" x $\frac{3}{4}$ " ref A30	—	1	"
		<u>Grubs.</u>			
		$\frac{5}{16}$ " wh. x $\frac{1}{4}$ " long - dog pt.	—	3	Unbrako
		" x " - kn. cup pt.	—	3	"
		" x $\frac{1}{2}$ " long - " " "	—	2	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

18

ASSY. DRG. No. General Arrt. G.M.103 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Ended Pedestal Grinder TDS 7/10"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt. hd. Shoulder Screws.</u>			
		1/2" dia x 3/8" whit x 2" long	—	4	Unbrako.
		<u>Rd hd Screws.</u>			
		1/4" whit x 1/2" long	—	4	
		<u>Scr Slotted C'sk Screws.</u>			
		1/4" wh. x 5/8" long	—	6	
		<u>Ch. hd. Screws.</u>			
		2 BA x 1/2" long	—	5	
		<u>Self-Tapping Screws.</u>			
		N° 8 x 1/2" long	—	4	
		N° 6 x 3/8" long	—	3	
		N° 6 x 5/16" long c'sk	—	2	
		<u>Set Screws.</u>			
		1/4" wh. x 3 1/4" long	—	2	
		5/16" wh x 1/2" long	—	4	
		5/16" wh. x 1" long	—	4	
		3/8" whit x 1 1/4" long	—	4	
		<u>Nuts.</u>			
		1/4" std whit	—	2	
		5/16" " "	—	4	
		3/8" " "	—	8	
		5/8" " "	—	2	
		3/4" " " L.H.	—	1	
		3/4" " " R.H.	—	1	

2 DEC 1966

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. General Arrt. GM103 B.O. Parts.

DATE

1.7.66

TITLE: 10" Double Ended Pedestal Grinder TDS 7/10"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Washers.</u>			
		1/4" std washer	—	2	
		5/16" " "	—	4	
		3/8" " "	—	8	
		5/8" " "	—	2	
		<u>Dowel.</u>			
		1/8" D. x 1/2" long	—	1	
		<u>Charts.</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 sug	Brass Sh	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"
		<u>Rivets Hdn. Brass.</u>			
		Type U x 3/16" long	—	8	
		Single cable clip.	—	1	
		<u>Micro Switch.</u>			
		Ref: DS3 - 521	—	1	Burgess.
		<u>Plastic knob.</u>			
		1 1/4" dia x 5/16" w hit.	Plastic	1	McMillan.
		<u>Stud & Latch.</u>			
		Stud ref: SBV/1698/17/0	—	1	Stenor
		Latch " : SRV/1637/17/0	—	1	"

SHEET No.

1 D.

DATE

30.11.66

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Extra parts required.</u>			
		<u>Motor</u>			
		1 1/2 H.P. 380/3/50. Totally Enclosed, Ball Bearing.	—	1	Brook
		<u>Station</u>			
		Single stop station Ref F.4.	—	1	Brook
		<u>Set screws, nuts & washers.</u>			
		1/4" whit x 3/4" long set screws	—	4	
		1/4" whit nuts	—	8	
		1/4" std washers	—	12	
GM112	2	Spark Guard Frame	Alumin.	2	Casting.
"	5	" " Retainer	M.S.	2	1/4" dia x 7 1/8"
"	9	Safety " Screen ref L.55V	Triplex Aero	2	6" x 4" x 7/32"
GM113	1	Hinge bracket	Alumin	2	Casting.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1.

ASSY. DRG. No. W.M. 100/100 (See M100/100B Form 4372)

DATE

25.10.69

TITLE: Headstock Assembly. (With New WH100/102B)

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
W.M.100	101	Headstock	C.I.	1	Casting.
"	102	Main Spindle.	M.S.	1	12 $\frac{1}{2}$ " long X 1 $\frac{1}{2}$ " dia
"	103	Locknut.	M.S.	2.	2" dia x 1 $\frac{1}{2}$ " long
"	104	Thrust collar.	"	1.	1 $\frac{1}{8}$ " dia x 3" long.
"	105	Limit collar.	"	1.	2" dia x 1 $\frac{1}{2}$ " long.
"	106	38T Driving Gear	C.I.	1.	Casting.

All other part required are
as standard metal lathe but
deleting:-

M.L.100/101

" /107

" /108

" /111

" /122.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

ASSY. DRG. No. Dust Extractor Unit. WL127.

TITLE: 5" Viceroy Wood Lathes.

SHEET No.

1.

DATE _____

30. 8. 72.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WLI27	1B	Guard.	Sh. Steel	2	16 S.W. G.
"	2A	Support Bracket.	M.S.	1	1" Sq x 4" long
"	3A	Headstock Cover.	Sh. Steel	1	7" x 4 1/4" x 12 S.W. G.
"	4	Boss.	M.S.	4	1" dia x 1" long
"	5	Guard Support.	"	2	1 1/2" dia. x 12" "
		<u>B.O. Parts.</u>			
		Dust Extraction Unit.			
		Hose & Fittings	—	1	Unicraft.
		<u>Set Screws.</u>			
		1/4" whit x 3/4" long.	—	7	
		<u>Nuts.</u>			
		Std 1/4" whit	—	4	
		<u>Washers.</u>			
		Spot washer 5/16" dia. bore	—	4	Dowty.
		Std 1/4"	—	4	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. Countershaft Assembly ML100 B.O. Parts

DATE

5-8-65

TITLE: 5" Viceroy Metal Lathe.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Bearings</u>			
		Deep groove ref 6205 ZZ	—	2	Fag.
		<u>Circlips</u>			
		External ref 1400/25 ^{mm}	—	2	Anderton
		Internal ref 1300/52 ^{mm}	—	2	"
		<u>C'sk 5kt. Hd. Screws</u>			
		$\frac{3}{8}$ " whit x $\frac{3}{4}$ " long	—	4	Unbrako
		<u>Hex Set Screws</u>			
		$\frac{1}{4}$ " whit x $\frac{1}{4}$ " long	—	2	
		<u>Washers</u>			
		Std $\frac{1}{4}$ " whit	—	2	
		<u>Vee Belt.</u>			
		'A' x $\frac{1}{2}$ " x 40° x 4' - 2 $\frac{1}{2}$ " long	—	1	Brammer.

SHEET No.

DATE _____

22-1-73

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. SH5005

DATE

TITLE: TDS 12/16. 16" SHARPEDGE

DRG.	No.	DESCRIPTION	MATL.	No. OFF	GUT OFF SIZE
SH5005	1	TABLE	ALUMINIUM	1	CASTING
"	2	CABINET	SHEET STEEL	1	16 S.W.G.
"	3	CABINET COVER	" "	1	16 S.W.G.
"	4	PUMP BRKT	" "	1	10 S.W.G.
"	5	MAIN SPINDLE	M.S.	1	1 3/4" ϕ x 5"
"	6	WASHER	M.S.	1	1 7/8" ϕ x 3/8"
SH5003	2	SWIVEL BLOCK	C.I.	1	CASTING
"	3	PLANE BLADE & CHISEL PLATE	"	1	"
"	4	SWIVEL ARM	"	1	"
"	5	CLAMP SCREW END	M.S.	1	7/8" ϕ x 1/2"
"	9	LOCK NUT	MALL IRON	1	CASTING
"	10	CLAMP SCREW	M.S.	1	1" ϕ x 3 1/8"
"	11	BUSH	CENT C.I.	1	1 1/4" ϕ x 5 5/8"
"	12	PLAIN CLAMP SLIDING TENON	M.S.	1	1/2" ϕ x 1/2"
"	14	LEVER ARM	M.S.	1	5/8" ϕ x 20"
"	21	SWIVEL BLOCK SHAFT	"	1	3/4" ϕ x 6 5/16"
"	33	LEVER ARM PIVOT PIN	M.S.	1	3/4" ϕ x 2 3/8"
"	35	PLAIN IRON & CHISEL CLAMP	C.I.	1	CASTING
"	36	OIL PIPE STOPPER	M.S.	1	5/16" ϕ x 5/8"
"	37	OIL PIPE	BUNDY TUBING	1	5/16" OD x 22 S.W.G.
"	41	LEVER LOCATING PIN	M.S.	1	1/4" ϕ x 1 3/8"
"	42	STUD	M.S.	1	1/2" ϕ x 3 1/2" LONG
"	47	MULTI-PURPOSE ADAPTOR	M.S.	1	1" ϕ x 3 3/8"
"	38	INNER DISC	M.S.	1	CASTING
SP	103B	LOCKING STUD	M.S.	1	3/8" ϕ x 1 3/4"
"	103C	PAD	BRASS	1	1/4" ϕ x 1/2"
"	103D	LOCKING HANDLE	M.S.	1	3/4" ϕ x 2 1/16"
CH	115	NAME PLATE	BRASS	1	B.O. PART
"	117	DIAL	"	1	" " "

SHEET No.

S. H 5005

DATE _____

TITLE: TDS 12/16/6" SHARP EDGE

DRG. No.

DESCRIPTION

MATL.

No.
OFF

CUT OFF SIZE

645004

WORM BOX ASSY

SUR ASSY

EXTRA EQUIPMENT

SH500 32

32

CHISEL BUSH

M.S.

7

1 1/8" Ø x 2 3/4"

11

34

ROTARY LINER BUSH

1

1 1/2" Ø x 2 3/4"

11

31

Gauge Radius Block

61.

7

CASTING

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. SH 5005

DATE

TITLE: TDS 12/16 16" SHARP EDGE.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>B. O. PARTS.</u>			
		<u>OIL PUMP</u>			
		TYPE E5Q-426	-	1	A.C. PUMPS
		<u>STARTER MOTOR</u>			
		TYPE ATF 2C1 (SINGLE PHASE)		1	GREEN BAY
		OR.			
		" ATF 3B1A (3 PHASE)		1	" "
		<u>MOTOR</u>			
		9019 HAF 2541 (SINGLE PHASE)		1	HOOVER
		9306 HAF 2541 (3 PHASE)		1	"
		<u>CIRCLIPS</u>			
		TYPE 1400-1 1/4"		1	ANDERTON
		" 1400 6mm		1	"
		<u>SPLIT PIN</u>			
		3/32" Ø x 1/2" LONG		1	
		<u>KNOBS</u>			
		1 1/4" Ø x 5/16" WHIT RED PLASTIC		1	NE MILLAR
		<u>GRINDING WHEEL</u>			
		TYPE A80 JV-JA613		1	NUTCHEL

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

ASSY. DRG. No. SH 50051B

DATE

TITLE: TDS 12/16 16" SHARPEDGE

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>BUSHES</u>			
		TYPE C.T.F. 369x2"		1	LUBROOK
		<u>CLIPS</u>			
		3/8" ϕ TYPE 1439		4	TERRY
		<u>DOWELS & PINS</u>			
		3/16" ϕ x 1 1/2" LONG DOWEL		1	
		3/16" ϕ x 2 1/4" " "		1	
		1/4" ϕ x 2" " TAPER PIN		1	
		<u>GRUB SCRS</u>			
		1/4" WHIT x 1/2" LONG DOG PT		2	UNBRAKO
		<u>SET SCRS</u>			
		1/4" B.S.F. x 1" LONG		3	G.K.N
		3/8" WHIT x 1 1/2" LONG		1	" " " "
		5/16" WHIT x 1" LONG		2	" " " "
		1/4" WHIT x 1/2" LONG		2	" " " "
		<u>LAP SLRS</u>			
		1/4" WHIT x 1 1/4" LONG		4	G.K.N
		<u>C'SK SCRS</u>			
		1/4" WHIT x 5/8" LONG		1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1G

ASSY. DRG. No.

SH 5005

DATE

TITLE:

TDS 12/16 16" SHARPEGE.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>SELF TAPPING SCREWS</u>			
		N ^o 8 C'SK.		3	
		<u>THUMB SCREWS</u>			
		1/4" WHIT x 1/4" LONG		2	
		<u>NUTS & WASHERS</u>			
		STD 3/8" WHIT WEDGE LOK NUT		1	G.K.N
		STD 3/8" SPRING WASHER		2	--
		1/4" WASHER		3	
		5/16" WASHER & LOCKNUT		2	EACH
		<u>CHARTS</u>			
		CH115 24 S.W.G. x 4" x 7 1/2"	BRASS	1	BRIG. ENG
		CH117 28 S.W.G. x 1 1/2" Ø	"	1	" "
		<u>OIL SYSTEM</u>			
		SH5003/13A DRAIN.	PLASTIC	1	BARKSTON RUBBER
		SH5003/37 BUNDY TUBING			
		TUBING 3/8" O/D x 3/16" I/D			
		<u>RIVETS</u>			
		HDN BRASS RIVETS TYPE 'U' x 3/16"		7	
		<u>TERMINAL JUNCTION BOX</u>			
		TERMINAL EXT. BOX REF C6103		1	GEC.
		COVER REF CA 4501		1	
		MALE INSERT 3/4" Ø 16T.P.I. CONDUIT.	BRASS	1	
		LOCKNUT " " " " " "	STEEL	1	

SHEET No.

ASSY. DRG. No. Backgear Assembly SK. 338

DATE _____

10.9.70.

TITLE: Viceroy Bench & Pedestal Drill

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A.

ASSY. DRG. No. Backgear Assembly SK,338 B.O. Parts.

DATE

10.9.70

TITLE: Viceroy Bench & Pedestal Drill

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Oilite Bushes.</u>			
		1 1/4 O/D x 1" I/D x 2 7/8 long	Ph. Brom	1	
		3/4 O/D x 1 1/2 I/D x 1 1/2 long with flange 1" O/D x 1/8	"	1	
		1 3/4 O/D x 1" I/D x 1/8 thick washer.	"	1	
		<u>Bearings.</u>			
		6205 2Z. 25mm	-	1	Koyo
		<u>Screws.</u>			
		Allen cap scr 1/4 whit x 3/4 long	-	4	Unbrako.
		Cheese hd. 2 B.A x 7/16 "	-	1	"
		<u>Grub Screws.</u>			
		2 B.A x 3/8 long knurl cup	-	1	Unbrako
		1/4 whit x 1/4 " Dog point.	-	1	"
		" x " " Knurl cup	-	1	"
		<u>Pins</u>			
		1/4 Dia x 1 1/2 long groove's pin	-	2	
		" x 1" " " "	-	2	"
		<u>Vee Belt.</u>			
		3/8 Vee, 40" long, endless	-	1	Flexicon.
		<u>Spring.</u>			
		Type 1100 Circlip ref: 1100-28	-	1	Anderton.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1.

ASSY. DRG. No. S.K. 355.

DATE

6.7.71.

TITLE: Auto - Knock Off Assembly.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
SK355		Arrangement.	—		—
"	1	Striker Plate.	Stelvetite	1	12 5/8" x 4 1/8" x 18S.W.
"	2	Shoulder Screw.	M.S.	2	3/4" dia x 1 5/8"
"	3	Spacer Bush.	"	2	5/8" dia x 3/4"
SP.109		Micro - Switch Bracket	Sh. Steel.	1	2 3/4" x 2" x 12S.W.
		<u>B.O. Parts.</u>			
		Bellows ref: 6439	—	1	Herga.
		Air Switch " : 6401	—	1	"
		Plastic tube.	—	1	" 2 Ft.
		<u>Micro Switch.</u>			
		ref D.S3.- 521.	—	1	Burgess.
		<u>Natural Nylon Fasteners.</u>			
		ref: 272 ED 962 - 00.	—	1	I.T.W.
		<u>Self Tapping Screws.</u>			
		N° 6 x 3/8" Long.	—	2	—
		<u>C/SK. Screws.</u>			
		4BA x 3/8" long.	—	2	—
		<u>Plastic Washers.</u>			
		5/16" Dado Rings.	—	2	—

SHEET No.

ASSY. DRG. No. Dust Extractor Unit WL127

DATE _____

TITLE: 5" Viceroy Wood Lathe.

23.2.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
WL127	1	Guard (R.H.)	Sh. Steel	1	18 x 12 swg.
"	2	Guard Bracket	M.S.	1	3/4" x 1/4" x 14 3/8"
"	3	Headstock Cover	M.S. bars	1	1/4" x 3/4" x 4 1/4"
			Sh. Steel.	1	4 1/4" x 7" x 12 swg.
SP44	1	Motor housing & Dust Bag Compartment	S.h Steel	1	See drg.
"	2	Top Cover	Sh. Steel.	1	21 swg.
"	3	Base Cover	"	1	"
"	4	Dust Bag Baffle Plate	"	1	20 swg.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

14

ASSY. DRG. No. Dust Extractor Unit WL127 B.O. Parts.

DATE

23.2.67

TITLE: 5" Viceroy Wood Lathe

DRG. No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
	<u>Cheese hd screws</u>			
	2 B.A. x 1/2" long	—	2	
	<u>Wing Nuts</u>			
	Std 2 B.A.	—	2	
	<u>Washers</u>			
	Std. 3/16" washers	—	2	
	" 1/4" "	—	4	
	<u>Set screws</u>			
	1/4" whit x 3/4" long	—	4	
	<u>'Dowty' Washers</u>			
	5/16" dia "spat" dowty washers	—	4	
	<u>Dust Bag.</u>			
	5 1/2" dia	—	1	Heath Filtration.
	<u>Nuts</u>			
	1/4" whit std nuts	—	4	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. B.O. Parts GM127

DATE

3.1.67

TITLE: 10" Viceroy Grinder / Polishing M/c

Cabinet

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Dowel</u>			
		1/8" dia x 1/2" long	—	1	
		<u>Charts</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 swg	Brass Sh.	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	" "
		CH134 : 2 3/16" x 3/4"	—	1	Metal Cal.
		<u>Rivets</u>			
		H'dn. brass type 'U' x 3/16" long	—	8	
		Rd. hd. steel 3/32" dia x 3/8" "	—	6	
		<u>Skt hd c'sk screws</u>			
		2 B.A. x 1/2" long	—	6	Unbrako
		<u>Clear Tube</u>			
		3/4" O.D. x 1/2" I.D. x 1/2" long	—	1	
		<u>Hinge</u>			
		GM102/51 : 1 1/2" wide x 2 7/8" long	Piano hinge	2	
		<u>Terminal Junction Box.</u>			
		Terminal Ext. Box ref: C6103	—	1	G.E.C.
		Cover ref CA4501	—	1	Oriental Tube Co.
		Male insert 3/4" dia, 16 T.P.I. Conduit thrd.	Brass	1	
		Locknut " " " "	Steel.	1	
GM.103	3	Motor Pulley.	Aluminium	1	Coles.

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Arrt.

DATE

TITLE: 8" Double Ended Pedestal Grinder T.D.S. 7/8"

6.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM102	3	Toolrest	C.I.	2	Casting
"	4	" bracket	"	2	"
"	5	Outer End Cover	"	2	"
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	10	Moving Spindle Guard	Alum.	2	"
"	13	Outer Disc	Mall. Iron	4	"
"	15	Pivot Pin	M.S.	2	3/4" D. x 3 5/16"
"	16	Spindle	"	1	1 1/4" D. x 15 1/8"
"	17	Locking bolt	"	2	5/8" D. x 2 1/2"
"	18	" pin	"	2	1/2" D. x 2 5/8"
"	23	Distance Piece	"	2	1 1/4" D. x 7/8"
"	31	Headstock Cover	Sh. Steel.	1	16 swg.
"	33	Extractor Hole Cover Plate	"	2	"
"	56	Full wheel cover.	"	1	"
"	68	LOCKING BOLT NUT.	EN8.	2	1 3/4" DIA. x 7/8"
"	69	WHEEL VISE	Sh Steel.	2	12 SWG.
GM103	1	Baseplate	C.I.	1	Casting
"	9	Crank Bolt	M.S.	1	3/8" D. x 8"
"	15	Cabinet (with GM103/14 - Door attached)	Sh. Steel.	1	12 swg.
"	19	Extension Stud (Std. set screw)	M.S.	1	5/16" wh. x 1/2" long.
GM104	1A	R.H. Wheel Guard	C.I.	1	Casting
"	2A	L.H. " "	"	1	"
SP	109	Micro - Switch Bracket	Sh. Steel.	1	12 swg.
"	114	Motor Platform	C.I.	1	Casting
"	124	Pivot Pin.	M.S.	1	3/8" D. x 5 3/8"
CH	100	Nameplate	Brass. Sh.	1	See B.O. Ports
"	101	Lubrication Chart	"	1	"
"	133	Safe Working Speed Chart	Metal Cal	1	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Arrt.

B.O. Parts.

DATE

6.3.67

TITLE: 8" Double Ended Pedestal Grinder

T.D.S. 7/8"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt</u>			
		Ref: M 3/8" x 40° x 5'	—	1	Brammer
		<u>Circlips</u>			
		Ref: 1400/3/8" External	—	2	Andertons.
		<u>Motor</u>			
		3/4 h.p. single phase ref: 2310 HAF 1633A	—	1	Hoover
		OR.			
		3/4 h.p. 3 phase ref: 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Single phase ref: ATF - 2D1	—	1	Brook
		OR			
		3 phase ref: ATF - 3B1	—	1	"
		<u>Bearings</u>			
		Deep Groove ref: 6304 ZZ	—	2	D.K. Brgs.
		<u>Grinding Wheels</u>			
		8" x 1" x 3/4" ref: A60	—	1	Mitchells
		8" x 1" x 3/4" ref: A30	—	1	"
		<u>Grubs</u>			
		5/16" wh. x 1/4" long	—	3	Unbrako
		" x "	—	3	"
		" x 1/2" "	—	2	"
		dog pt.	—		
		kn. cup pt.	—		
		" " "	—		

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1B

ASSY. DRG. No. General Arrt.

B.O. Parts.

DATE

6.3.67

TITLE: 8" Double Ended Pedestal Grinder.

TDS 7/8"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Skt. hd. Cap Screws</u>			
		1/2" dia x 3/8" whit x 2" long	—	4	Unbrako
		<u>Rd. hd. Screws</u>			
		1/4" wh. x 1/2" long	—	4	
		<u>Scr. Slotted C'sk Screws</u>			
		1/4" wh. x 5/8 long	—	6	
		<u>Ch. hd. screws</u>			
		2 BA. x 1/2" long	—	5	
		<u>Self-Tapping Screws</u>			
		N° 8 x 1/2" long	—	4	
		N° 6 x 3/8" "	—	3	
		N° 6 x 5/16" " c'sk	—	2	
		<u>Set Screws</u>			
		1/4" wh. x 3 1/4" long	—	2	
		5/16" wh. x 1 " "	—	4	
		3/8" " x 1/2" "	—	4	
		3/8" wh x 1 1/4" "	—	4	
		<u>Nuts</u>			
		1/4" std nut whit	—	2	
		5/16" " " "	—	4	
		3/8" " " "	—	8	
		3/4" " " " R.H. & L.H.	—	1 each	
		2 BA " "	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. General Arrt.

B.O. Parts.

DATE

6.3.67

TITLE: 8" Double Ended Pedestal Grinder

TDS 7/8"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Washers</u>			
		1/4" std washer	—	2	
		3/8" " "	—	12	
		<u>Dowel</u>			
		1/8" dia x 1/2" long	—	1	
		<u>Charts</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 swg	Brass Sh.	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"
		CH133 : 2 3/16" x 3/4"	—	1	Metal Cal.
		<u>Rivets Hdn. Brass</u>			
		Type 'U' x 3/16" long	—	8	
		<u>Micro - Switch</u>			
		Ref: DS3 - 521	—	1	Burgess.
		<u>Plastic Knob</u>			
		1 1/4" dia x 5/16" whit.	—	1	Mcmillan.
		<u>Stud & Latch</u>			
		Stud ref: SBV / 1698 / 17/0	—	1	Stenor
		Latch ref: SRV / 1637 / 17/0	—	1	Stenor
		<u>Cable Clip</u>			
		Single Wire Clip	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. General Amt.

DATE

9.3.67

TITLE: 8" Pedestal Grinding / Polishing M/c

TDS 8/8"

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
GM102	3	Toolrest	C.I.	1	Casting
"	4	" Bracket	"	1	"
"	5	Outer End Cover	"	2	"
"	7	Spindle Pulley	"	1	"
"	8	Headstock	"	1	"
"	10	Moving Spark Guard	Alum	1	"
"	13	Outer Disc	Mall. Iron	2	"
"	15	Pivot Pin	M.S.	1	3/4" D. x 35/16"
"	17	Locking bolt	"	1	5/8" D. x 2 1/2"
"	16	Spindle	"	1	1 1/4" D. x 15/8"
"	18	Locking pin	"	1	1/2" D. x 25/8"
"	23	Distance piece	"	2	1 1/4" D. x 7/8"
"	31	Headstock Cover	Sh. Steel	1	16 swg.
"	33	Extractor Hole Cover Plate	"	1	"
"	68	LOCKING BOLT NUT.	EN8.	1	1 3/8" DIA. x 7/8"
"	69	WHEEL VISOR	sh. Steel.	1	12 swg
GM103	1	Baseplate	C.I.	1	Casting
"	9	Crank Bolt	M.S.	1	3/8" D. x 8"
"	15	Cabinet (with GM103/14 - Door attached)	Sh. Steel	1	12 swg
"	19	Extension Stud (Std. set screw)	M.S.	1	5/16" wh. x 1/2" long
GM104	1 or 2	R.H. or L.H. Wheel Guard	C.I.	1	Casting.
SP	109	Micro-Switch Bracket	Sh. Steel	1	12 swg
"	114	Motor Platform	C.I.	1	Casting
"	124	Pivot Pin	M.S.	1	3/8" D. x 5 3/8"
CH	100	Nameplate	Brass. Sh.	1	See B.O. Parts
"	101	Lubrication Chart	"	1	"
"	133	Safe Working Speed Chart	Metal Cal	1	"
The Parts Lists are to be used in conjunction with GM118			Sheets 1 or 2		
Parts Lists (Polishing Guards)					

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1A

ASSY. DRG. No. General Arrt.

B.O. Parts

DATE

TITLE: 8" Pedestal Grinding / Polishing M/c

TDS 8/8"

9.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Vee Belt</u>			
		Ref A $3\frac{3}{8}" \times 40^\circ \times 5'$	—	1	Brammer
		<u>Circlips</u>			
		Ref: 1400/ $3\frac{3}{8}"$ External	—	2	Andertons
		<u>Motor</u>			
		$\frac{3}{4}$ h.p. Single Phase ref: 2310 HAF 1633A	—	1	Hoover
		OR			
		$\frac{3}{4}$ h.p. 3 Phase ref 2543 HAF 1633B	—	1	"
		<u>Starter Motor</u>			
		Single Phase ref ATF - 2 D1	—	1	Brook
		OR			
		3 Phase ref ATF - 3 B1	—	1	"
		<u>Bearings</u>			
		Deep groove ref: 6304 ZZ	—	2	D.K. Brgs.
		<u>Grinding Wheel</u>			
		8" x 1" x $3\frac{3}{4}"$ ref A	—	1	Mitchells
		<u>Grubs</u>			
		$5\frac{1}{16}"$ whit x $\frac{1}{4}$ long dog pt	—	3	Unbrako
		" x " kn cup pt	—	3	"
		" x $\frac{1}{2}"$ " " " "	—	2	"

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1 B

ASSY. DRG. No. General Amt.

B.O. Parts

DATE

TITLE: 8" Pedestal Polishing / Grinding M/c

TDS 8/8"

9.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Sk hd shoulder screws</u>			
		1/2" dia x 3/8" whit x 2" long	—	2	Unbrako
		<u>Rd. hd screws</u>			
		1/4" whit x 1/2" long	—	2	
		<u>Scr. slotted c'sk screws</u>			
		1/4" whit x 5/8" long	—	6	
		<u>Ch. hd. screws</u>			
		2 B.A. x 1/2" long	—	5	
		<u>Self tapping screws</u>			
		N° 8 x 1/2" long	—	4	
		N° 6 x 3/8" "	—	3	
		N° 6 x 5/16" " c'sk	—	2	
		<u>Set screws</u>			
		1/4" whit x 3 1/4" long	—	1	
		5/16" " x 1" long	—	4	
		3/8" " x 1/2" "	—	4	
		3/8" " x 1 1/4" "	—	4	
		<u>Nuts</u>			
		1/4" std whit	—	1	
		5/16" " "	—	4	
		3/8" " "	—	7	
		3/4" " " L.H. or RH.	—	1	
		2 B.A. " nut	—	1	

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1C

ASSY. DRG. No. General Arrt.

B.O. Parts

DATE

TITLE: 8" Pedestal Grinding / Polishing M/c

TDS 8/8"

9.3.67

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Washers</u>			
		1/4" std washer	—	1	
		3/8" " "	—	11	
		<u>Dowel</u>			
		1/8" dia x 1/2" long	—	1	
		<u>Charts</u>			
		CH100 : 4 3/8" x 3 1/8" x 24 sug	Brass Sh.	1	Brig. Engr.
		CH101 : 2 3/4" x 1 3/4" x "	"	1	"
		CH133 : 2 3/16" x 3/4	—	1	Metal Cal.
		<u>Rivets Hdn Brass</u>			
		Type 'U' x 3/16" long	—	8	
		Single cable clip.	—	1	
		<u>Micro switch</u>			
		Ref: DS3 - 521	—	1	Burgess
		<u>Plastic knob</u>			
		1 1/4" dia x 5/16" whit	—	1	McMillan.
		<u>Stud & Latch</u>			
		Stud ref: SBV/1698/17/0	—	1	Stenor
		Latch ref: SRV/1637/17/0	—	1	"

1D

12.7.67.

TDS 8/8"

[illegible]

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

1

ASSY. DRG. No. Open Polishing Guard & Polishing Mop Guard

DATE

4.1.67

TITLE: 10" Viceroy D.E. Polisher

GM 118

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>Open Polisher Guard Type A</u>			
GM 118	1A	Sleeve Bush	CI	1	Casting
"	5 or 6	Polishing Spindle L.H. or R.H.	M.S.	1	1 3/8" D x 8 3/16"
"	11A	Sleeve	P.V.C.	1	2" D x 5 3/4"
"	17	Deflector Guard	Sh Steel	1	12SWG
"	18X	Large Ring	M.S. Tube	1	3 3/8" O.D. x 2 7/8" I.D. x 1 1/4"
"	18Y	Small Ring	M.S.	1	1 3/4" O.D. x 1 1/4"
"	18Z	Arm	"	1	3/8" x 1 1/4" x 15 3/4"
"	18B	Open Polisher Guard Sleeve	P.V.C.	1	1 1/4" D x 5 3/4"
		<u>B.O. Parts Req.</u>			
		<u>S'kt h'd cap screws.</u>			
		1/4" whit x 3/4" long	—	2	Unbrako
		<u>Grubs</u>			
		1/4" whit x 1/4" long kn. cup pt	—	4	"
		1/4" " x " " Dog pt.	—	1	"
		<u>Mills Pins.</u>			
		3/16" dia x 1 3/8" long	—	1	
		<u>Thumbscrew.</u>			
		1/4" whit x 1/2" long.	—	1	
		<u>Polishing Mop</u>			
		6" Dia or 8" Dia or 10" Dia x 2 Fold	—	1	Calico.

1A

DATE _____

GMB

18.3.68

H.M. LTD. S/P 8791

DENFORD MACHINE TOOLS. BRIGHOUSE, YORKSHIRE.

SHEET No.

2.

ASSY. DRG. No. POLISHING MOP GUARD

DATE

TITLE: 10" VICEROY D.E. POLISHER.

GM.118.

24.2.77.

DRG.	No.	DESCRIPTION	MATL.	No. OFF	CUT OFF SIZE
		<u>POLISHING MOP GUARD TYPE 'B'</u>			
GM.118	1A	SLEEVE BUSH.	C.I.	1	CASTING.
"	5	POLISHING SPINDLE L.H.	M.S.	1	3/8" x 8 3/16" L
"	6	POLISHING SPINDLE R.H.	M.S.	1	" "
"	11A	SLEEVE.	P.V.C.	1	2" x 5 3/4" L
"	15B	POLISHING MOP GUARD R.H.	12 SWG	1	SEE DRG.
"	15C	POLISHING MOP GUARD L.H.	12 SWG	1	" "
"	18C	GUARD SLEEVE	P.V.C.	1	1 1/4" x 3 1/4" L
"	21A	POLISHING GUARD BRACKET.	M.S.	1	SEE DRG.
SP	103	LOCKING HANDLE	M.S.	1	SEE DRG.
		<u>B.O. PARTS REQUIRED</u>			
		<u>HEX NUTS.</u>			
		STD M8.		1	
		STD 3/8" WHIT		1	
		LOCKNUT 1/4" WHIT		1	
		GRUB SCREW. DOG PT. M5		1	
		" " KNL. CUP 1/4" WHIT		2	
		SKT. HD. CAP SCREWS.			
		1/4" WHIT x 3/4" LONG.		2	
		M5 x 10 LONG.		1	
		THUMBSCREW: 1/4" WHIT x 1/2" LONG		1	
		MILLS PIN: 3/16" DIA x 1 3/8" LONG		1	
		PLASTIC CAP. REF: A1615		1	