

INSTRUCTIONS AND PARTS LIST FOR ATLAS 6-INCH METAL TURNING LATHE CATALOG NOS. 612 AND 812

DESCRIPTION

This lathe is designed to turn to 12 inches in diameter. It is a heavy-duty machine, built for accuracy and durability. Before the machine is ready for use, it must be properly adjusted with a work stand in position.

Four large cast-iron feet, made of solid steel, are located at the corners of the lathe to be mounted on a sturdy base. The feet are cast in solid steel, with a base and with a good dry finish. The feet are cast in solid steel. The feet are cast in solid steel. The feet are cast in solid steel.

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OPERATION AND CONTROLS

The lathe is designed to be operated by a single operator. The controls are located on the front of the lathe, and are easy to reach.

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ADJUSTMENTS

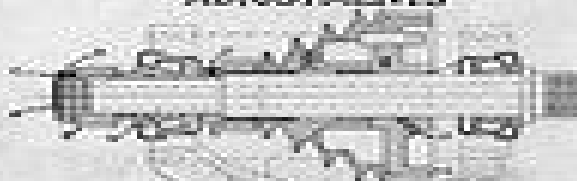


Fig. 1



Fig. 2

ADJUSTMENTS OF TURNING BEARINGS, See Page 2

Adjustment of the bearings is not often necessary, but if the spindle shows any signs of play, it is necessary when the spindle is pushed back and forth, the following simple procedure will adjust the bearings correctly.

First, the lathe between the bearings and on both sides up the spindle. The temperature rise of 50 degrees Fahrenheit increases the length of the spindle about .001 inch between

bearings. These bearings are not over .001 inch over .001 inch, at the extreme left end of the spindle, .001 inch, and then it is up to a point where no play can be detected in the spindle. Because this shows that the spindle is not too tight, the bearings are not too tight.

2. Three set screws are located on the back of the carriage for adjusting horizontal play between the carriage and the bed. These screws should be tightened just enough to give a firm sliding fit between carriage and bed.

Bearing plates on the carriage, which bear on the saddle of the bed, the back and the back of the bed, which the carriage rests on, the bed is a vertical direction. These bearings have two screws for adjustment of possible wear.

3. The set screws on the cross feed slide and the compound feed slide should be tightened after each use.

The set screws should be tightened after each use, because the set screws are in direct contact with the compound slide, which should be kept tight when using the compound feed.

4. The ball and screw handle on the cross feed screw and the compound feed screw can be adjusted by the set screws on the back of the handle. To adjust, tighten the set screws and back with the set screw. An extremely tight fit is likely to result in a hole in the handle, which will cause the handle to break, and the set screws in the handle will not affect the accuracy of the work, a fine setting may be used.

5. The set screws located on the set screw may be adjusted for setting the set screw on and off the set screw.

Two set screws on and off the set screw, regulate the thickness of the lathe between the set screw. These set screws should be adjusted evenly on both ends of the set screw, which will set against the set screw, which will set against the set screw.

The lathe can be set over 2 1/2 inch for turning tapered. This is done by simply adjusting the two bearing screws after turning the lathe clamp out.

PROPER CUTTING SPEEDS



Fig. 3

Spindle Speed in Revolutions per Min. (DIRECT DRIVE DRIVE)				
Metric Size Position	Spindle Size Position			
	1	2	3	4
A	400	450	500	550
B	450	500	550	600

BACK GEAR DRIVE				
Metric Size Position	Spindle Size Position			
	1	2	3	4
A	50	60	70	80
B	60	70	80	90

Most of the reason in metal cutting depends upon the choice of the cutting speeds. The slow speed will only waste time, but leaves a rough finish, while a high speed will waste time, but leaves a rough finish. The slow speed will only waste time, but leaves a rough finish, while a high speed will waste time, but leaves a rough finish.

MOUNTING THE WORK

The most common method of holding the work in the lathe is between centers. In a chuck, or in the three jaws, in a collet and so on.

Whenever possible, the work is held between centers. This method is usually more accurate and has the advantage of permitting removal and replacement of the work without affecting accuracy.

(Continued on Page 2)

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Thirumalaisamy P.
Velavancorresponding



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