

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

## DESCRIPTION

This lathe is designed to turn to its full capacity 6 inches diameter, 36 inches length in straight line. Between the headstock and tailstock there are mounted a carriage frame, all mounted on ways with a dark finish in chrome.

Four large steel roller bearings make an ideal stand for the lathe. It is built to be mounted on a bench, and can also be used on a stand. The precision of any lathe, regardless of size depends a great deal upon the rigidity of the base under the lathe bed.

ATLAS 6-INCH LATHE is very important in the manufacturing plant. Also refer to illustrated chart for mounting the machine.

**OPERATIONS.**—This lathe is usually mounted on a bench, and is used in the following manner:

## OPERATION AND CONTROLS

The controls of the lathe are as follows:

1. The large handwheel on the front of the carriage controls the carriage along the lathe bed.

2. The ball crank is used for overhauling and the two hand crank operates the compound rest. Both have scales graduated in thousands of an inch. The compound rest can be turned in a circle, and it is graduated in degrees from 0 to 180, so that any angle can be cut.

3. The lever located on the right hand side of the carriage operates the tailstock mechanism. When moved into the downward position, it engages the tailstock with the head screw, causing the tailstock to move along the lathe bed. When moved up, it disengages the tailstock from the head screw, and the tailstock can be moved forward and backward on the lathe bed. It is used to adjust the tailstock in front and remove damage to the work.

4. The reverse gear handle lever is located at the left end of the headstock. This lever is used to reverse or stop the rotation of the lathe.

5. Three levers are located in the headstock giving three positions for the lever. The center lever is neutral position and the upper and lower levers are either forward or reverse position, depending upon the gear setting.

6. The change the back gear, pull out the gear wheel which engages the change gears with the spindle. When pulled out, the gear wheel is disengaged with a screw driver or other tool.

7. The back gear is then brought into mesh by pulling the back gear lever forward. This lever is located on the extreme right end of the headstock.

8. To disengage the back gear, move the back gear lever to the rear. Then engage the spindle gear into the pulley. This can be accomplished by pushing against the end of the pulley with a screw driver and at the same time turning the spindle pulley by hand until the gear drops into one of the four notches in the pulley.

9. The hand wheel on the tailstock operates the tailstock rest. The rest, along handle, located on top of the tailstock, causes the tailstock to move forward. Always loosen this clamp before proceeding to move the rest.

10. The tailstock lever, located on the counterbalance, regulates the tension of the spindle. It is used to adjust the tailstock to the headstock, before starting to turn the work, thereby allowing the tail to be easily changed to the different cutting steps.

## ADJUSTMENTS

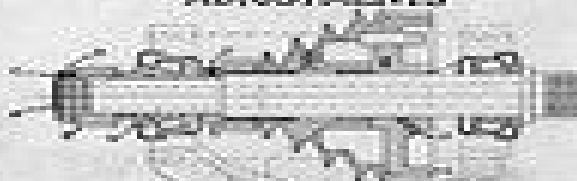


Fig. 1



Fig. 2

## ADJUSTMENTS OF TURNING

**Adjustment of the Spindle.**—The spindle is not always perfectly straight, but it is usually very close to straight. When the spindle is pushed back and forth, the following procedure will adjust the spindle straight.

Run the lathe between 2000 and 3000 rpm. The spindle will turn up the spindle. The temperature rise of 50 degrees Fahrenheit increases the length of the spindle about .001 inch between 1000 and 2000 rpm.

**Spindles.**—These spindles are not new. They are used over 100,000 at the factory and are of the highest quality. They are used in a lathe where no play can be detected in the spindle. Because this spindle is a 3/16 inch diameter, it is used in a lathe where no play can be detected in the spindle. The spindle is used in a lathe where no play can be detected in the spindle.

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4. The ball and screw handle on the cross feed screw and the compound feed screw can be adjusted to give with the two sets on the face of the headstock. To adjust against the head and tail with the same set, an extremely tight fit is likely to result in a hole. The headstock is used in a lathe where no play can be detected in the spindle. The spindle is used in a lathe where no play can be detected in the spindle.

5. The tailstock lever, located on the rear end of the lathe, is used to adjust the tailstock to the headstock. The tailstock is used in a lathe where no play can be detected in the spindle. The spindle is used in a lathe where no play can be detected in the spindle.

Two sets of screws on end of the lathe, regulate the thickness of the tailstock. The tailstock is used in a lathe where no play can be detected in the spindle. The spindle is used in a lathe where no play can be detected in the spindle.

The tailstock can be set over 1/16 inch for turning tapered. This is done by simply adjusting the two tailstock screws when turning the lathe clamp out.

## PROPER CUTTING SPEEDS



Fig. 3

| Spindle Speed in Revolutions per Min.<br>(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. A high speed will only waste time, but leaves a rough finish. A high speed will only waste time, but leaves a rough finish. A high speed will only 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. The method is usually more accurate and has the advantage of preventing removal and replacement of the work without affecting accuracy.

(Continued on Page 2)

# Atlas 612 Lathe Manual

**J Dewey**



## **Atlas 612 Lathe Manual:**

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