

Atlas 6" Backgeared Screwcutting LATHE



- ★ 6" swing, 18" capacity between centers
- ★ Headstock spindle is equipped with Timken tapered roller bearings for accuracy, service and versatility
- ★ Bed ways are massive, precision ground grey-iron for accuracy and rugged strength
- ★ The 16 spindle speeds equip you to handle a wide work range
- ★ Back gears provide extra power for heavy cuts
- ★ Reversible automatic longitudinal power feed cuts operating time
- ★ Complete V-belt drive
- ★ Wide thread cutting range — 8 to 96 Standard, right or left hand — Metric, .5 to 3 mm., Standard.
- ★ Operates from a 1/4 or 1/2 HP motor.

No. 618 6" BACKGEARED SCREW-CUTTING LATHE. Complete as shown, less motor, with equipment listed below. Code YEDUP, shipping weight 100 lbs.

EQUIPMENT FURNISHED

Reversible Automatic Power Longitudinal Feed; Graduated Compound Rest; Tool Post, Ring and Ratchet, 3/8" Tool Bit; Complete Set of Change Gears to cut standard threads between 8 and 96 per inch; Threading Chart, Threading Dial; Quick-Change Countershaft; Complete V-Belt Drive; Motor Pulley furnished is for 3/4" diameter motor shaft — dealer can supply bushings for 1/2" dia. motor shafts; 60-Hole Indexing Mechanism; 3/4" Combination Metal and Wood-working Face Plate; Two 60° Lathe Centers — No. 2 Morse Taper for Headstock, No. 1 Morse Taper for Tailstock; 5 Wrenches; Instruction Manual.

WIDE THREADING RANGE



Atlas 6-inch lathes are equipped with change gears and threading dial for cutting all threads from 8 to 96 per inch, right or left hand, in the following standards: National Coarse (UNC), National Fine (UNF), Acme, Square, and Whitworth. Gear train is completely enclosed — threading chart mounted on inside of guard shows gear train set-ups.

SPECIFICATIONS

CAPACITY

Swing Over Bed.....	6"
Swing Over Carriage.....	3 1/2"
Capacity between Centers.....	18"
Threading Range.....	8 to 96 Standard, Right or Left Hand — Metric, .5 to 3 mm. Standard
Collet Capacity.....	9/32" (see page 14)
Overall Dimensions.....	35 1/2" x 27" x 12" high

SPEEDS AND FEEDS

Sixteen Speeds.....	54, 82, 122, 140, 187, 287, 317, 365, 481, 550, 820, 940, 1250, 1925, 2125, 3225 RPM.
Feeds (Left or Right) per Revolution of Spindle.....	.0078", .0048", .0039" or .0024"
Lead Screw.....	1/2" Diam., 16 Acme Threads per inch

DRIVE UNIT

Motor Recommended.....	1/4 or 1/2 HP, 1725 RPM
Motor Mounting.....	Bench
Countershaft Spindle Bearings.....	Oilite Bronze

HEADSTOCK

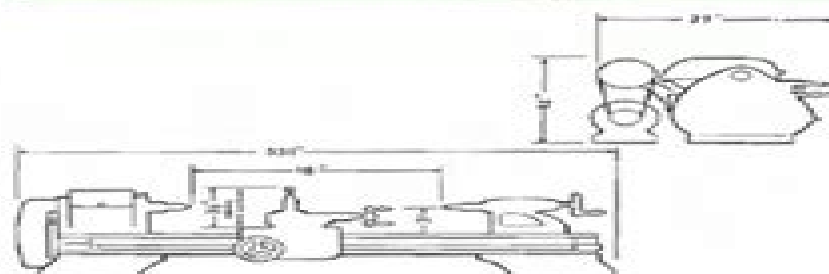
Spindle Bearings.....	Timken Tapered Roller Bearings with Thrust Take-up Collar and Nut
Spindle Nose.....	1" Diameter, 10 Pitch NS Threads
Spindle Nose Taper.....	No. 2 Morse Taper
Hole through Spindle.....	17/32"
Back Gears.....	20 Pitch, 3/8" Wide
Backgear Shaft Bearings.....	Oilite Bronze
Spindle Gear.....	24 Pitch, 32 Teeth, 7/16" Wide

CARRIAGE

Cross Feed Travel.....	4 3/4"
Cross Feed Screw.....	3/8" Diameter, Acme Thread
Tool Post Slide Travel.....	1 3/8"
Tool Post.....	13/32" x 3/4" slot to take 3/8" bits or tool holder for 3/16" bits

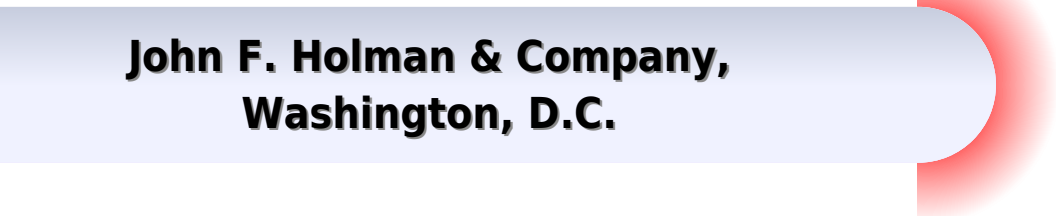
TAILSTOCK

Tailstock Ram.....	3/4" Diam. Bored for No. 1 Morse Taper
Tailstock Ram Travel.....	1 1/4"
Tailstock Set-Over, Forward or Back.....	9/16"



Atlas Lathe Operations Manual

**John F. Holman & Company,
Washington, D.C.**



Atlas Lathe Operations Manual:

Engine Lathe Operations Graham G. Whipple, Anthony C. Baudek, 1942 *Manual of Lathe Operation and Machinists Tables* Atlas Press Company, Kalamazoo, Mich, 1937 **Popular Mechanics**, 1937-03 Popular Mechanics inspires instructs and influences readers to help them master the modern world Whether it s practical DIY home improvement tips gadgets and digital technology information on the newest cars or the latest breakthroughs in science PM is the ultimate guide to our high tech lifestyle *Circular* United States. Office of Education, 1964 **A Small Selected Management and Technical Library** John F. Holman & Company, Washington, D.C., 1962 *Industrial Arts & Vocational Education*, 1966

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Table of Contents Atlas Lathe Operations Manual

1. Understanding the eBook Atlas Lathe Operations Manual
 - The Rise of Digital Reading Atlas Lathe Operations Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Atlas Lathe Operations Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Atlas Lathe Operations Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Atlas Lathe Operations Manual
 - Personalized Recommendations
 - Atlas Lathe Operations Manual User Reviews and Ratings
 - Atlas Lathe Operations Manual and Bestseller Lists
5. Accessing Atlas Lathe Operations Manual Free and Paid eBooks
 - Atlas Lathe Operations Manual Public Domain eBooks
 - Atlas Lathe Operations Manual eBook Subscription Services

- Atlas Lathe Operations Manual Budget-Friendly Options
- 6. Navigating Atlas Lathe Operations Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Atlas Lathe Operations Manual Compatibility with Devices
 - Atlas Lathe Operations Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Atlas Lathe Operations Manual
 - Highlighting and Note-Taking Atlas Lathe Operations Manual
 - Interactive Elements Atlas Lathe Operations Manual
- 8. Staying Engaged with Atlas Lathe Operations Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Atlas Lathe Operations Manual
- 9. Balancing eBooks and Physical Books Atlas Lathe Operations Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Atlas Lathe Operations Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Atlas Lathe Operations Manual
 - Setting Reading Goals Atlas Lathe Operations Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Atlas Lathe Operations Manual
 - Fact-Checking eBook Content of Atlas Lathe Operations Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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