Betriebsanleitung
Operating instructions
Instructions de service

Maschinen-Nr.: 19.9.18
Type: MO

Meuser & Co. G.m.b.H.
Werkzeugmaschinenfabrik
Frankfurt/Main-Mainkur
Sketch 5

Lubrication Diagram

Oil Bath
Oil Level Gauge
Oil Pump for Lubrication of Spindle Bearings

1 - 19 Points for manual lubrication: daily
20 - 21 Lubrication by wick: weekly
22 Ball bearings
Sketch 7

Important Control Elements

A. Lever for standard and coarse pitch threads
B. Intermediate gear lever at the headstock
C. Lever for metric and inch thread
D. Lever for changing the speeds
E. Lever for guide and feed spindle
F. Lever for guide and feed spindle
G. Reserve switch lever for clockwise and anti-clockwise motion of the guid and feed spindle
H. Impulse switch
I. Gear box
J. Back gear switch lever
K. Front gear switch lever
L. Gear box
M. Back gear switch lever
N. Front gear switch lever
O. Lever for longitudinal or cross feed
P. Lever for split nut
Q. Trip worm for switching on and off the longitudinal or transverse motion of the slide
R. Lever for clockwise and anti-clockwise motion of the machine
S. Switch Rod
T. Pump switch for cooling agent pump (special arrangement)
U. Main switch
V. Fixing of the automatic self-release
<table>
<thead>
<tr>
<th>List No.</th>
<th>Designation</th>
<th>Sketch</th>
</tr>
</thead>
<tbody>
<tr>
<td>13015a</td>
<td>front bronze bearing</td>
<td></td>
</tr>
<tr>
<td>13022a</td>
<td>back bronze bearing</td>
<td></td>
</tr>
<tr>
<td>14052a</td>
<td>nut for cross-slide screw</td>
<td></td>
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<tr>
<td>14055</td>
<td>nut for top slide screw</td>
<td></td>
</tr>
<tr>
<td>17043a</td>
<td>worm wheel</td>
<td></td>
</tr>
<tr>
<td>17058a</td>
<td>split-nut</td>
<td></td>
</tr>
<tr>
<td>17x1900</td>
<td>3 Vee-belts</td>
<td></td>
</tr>
<tr>
<td></td>
<td>180 H.-centr. (50~)</td>
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<tr>
<td></td>
<td>180-200H.-centr. (50~)</td>
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<td>17x2000</td>
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<td></td>
<td>200 H.-centr. (50~)</td>
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</tbody>
</table>
Radial play of the front and rear anti-friction bearing will be adjusted as follows:

1) Loosen screws "A"
2) Loosen nuts "B", "C", and "E".
3) Fasten nut "F" until the sliding of the main spindle can be felt by turning the driving plate, transmission disengaged.
4) Fasten and secure nut "E", fasten screws "A"
5) Fasten nut "D" until the sliding of the main spindle can be felt by turning the driving plate, transmission disengaged
6) Secure nut "C", fasten screw "A"
7) Axial play of the main spindle to be eliminated by fastening and securing of nut "B"
Main spindle with roller bearing

Adjustment of the front main bearing:

1.) Remove chuck or face plate, etc.
2.) Loosen the fastening screws of the divided ring "C" and withdraw them out through the bored holes in the cap nut "A". Take off divided ring.
3.) Loosen counter-nuts "B". Screw the other nut until the bearing runs again free from play and the spindle will allow to be turned easily by hand.
4.) Face-grind the divided ring "C" and place it again.
5.) Check nut "B" by securing it.

Radial play of the front and rear anti-friction bearing will be adjusted as follows:

1.) Loosen screws "A".
2.) Loosen nuts "B", "C" and "E".
3.) Fasten nut "F" until the sliding of the main spindle can be felt by turning the driving plate on disengaged transmission.
4.) Fasten and secure nut "E", fasten screws "A".
5.) Fasten nut "D" until the sliding of the main spindle can be felt by turning the driving plate on disengaged transmission.
6.) Secure nut "C", fasten screw "A".
7.) Axial play of the main spindle to be eliminated by fastening and securing of nut "B".
1) Remove nut "A"
2) Clutch "C" to be shifted to the right with back-gear lever "B"
3) Loosen nut "D" and main spindle gear
4) Remove main spindle from the right
5) Lift transmission in the left cabinet foot and remove the belts from the driving gear
6) Remove the 4 hexagonal (inside) screws
7) Remove and exchange V-belt pulley "P" with bearing covers "G" and belts
8) V-belt pulley with belts, "F" to be mounted
9) Apply sealing agent to bearing lid "G", mount and fasten with screws "E"
10) Apply belts to the driving gear and fasten transmission
11) Insert main spindle, mount main spindle gear "H" and fasten nut "D"
12) Fasten nut "A" and secure with counter-nut
Sketch No. 1

Standard Accessories

Driving plate

Fastening ring

Cone

2 dead centres

Releasing dog for 2 directions

Oil gun

Wrenches
Ausführung mit Kegelrollenlagerung