HIGH SPEED LATHES, type REX

Model VF-140

This is their current lathe.
headstock
the standard one-speed motor gives 8 spindle speeds but the machine can also be supplied with a two-speed-motor on request when 16 spindle speeds are obtained.
The drive is transmitted to the spindle by a V-strap — see page 4. All gears run in an oil bath.

quick change gear box
with 49 longitudinal and cross feeds, 49 Whitworth and 31 metric pitches.
Module and Dp-pitches are obtained by extra change gears. All shafts are bored in self lubricating bearings. A safety clutch on the leadscrew prevents damages at overload.

main spindle
of robust design and bored in double taper roller bearings. Spindle-nose of L-type preventing the chuck to run off the spindle when reversing quickly.

apron
of totally enclosed design with all gears running in an oil bath. Automatic longitudinal and cross feed and separate nut for thread cutting.

guide-ways
the new VF-140 has very rigid slides — extended cross slide with T-slots can be furnished on request. The compound slide can of course be delivered with T-slot to take an American tool post. The bed — is made wider.

standard equipment:
Complete electric equipment — Complete coolant system — 6" Ø 3-jaw self-centering chuck with two sets of jaws — 4-way tool holder — Thread indicator — Steady and following rests — Face plate — Driving plate — Two dead centres — Change gears and necessary wrenches.

additional equipment:
for VF-lathes:
Collet chuck with collets — Ball bearing centre — Drill chuck —
Longitudinal feed stop with 4 positions — Micrometer stop —
Quick change tool holder with side holders— cut-off tool holder, drill bar holder, drill bar and sleeve — Taper turning attachment etc.

see page 3:
1. 3-jaw self-centering chuck with two sets of jaws and key
2. 4-jaw independent chuck with key
3. Face plate
4. Chuck flange
5. Quick change tool holder with side holder, cut-off tool holder and key
6. Steady rest
7. Following rest
### Specifikation:

**VF-140**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Inch</th>
<th>Metric</th>
</tr>
</thead>
<tbody>
<tr>
<td>Centre height</td>
<td>5½</td>
<td>140</td>
</tr>
<tr>
<td>Swing over cross slide</td>
<td>6¼</td>
<td>160</td>
</tr>
<tr>
<td>Centre distance</td>
<td>23—40</td>
<td>600—1000</td>
</tr>
<tr>
<td>Width of bed</td>
<td>6¾</td>
<td>170</td>
</tr>
<tr>
<td>Height of bed</td>
<td>6¾</td>
<td>170</td>
</tr>
<tr>
<td>Length of bed</td>
<td>47—63</td>
<td>1190—1590</td>
</tr>
<tr>
<td>Spindle bore</td>
<td>1</td>
<td>26</td>
</tr>
<tr>
<td>Spindle Ø in front bearing</td>
<td>1¼</td>
<td>45</td>
</tr>
<tr>
<td>Spindle nose</td>
<td>L-type</td>
<td></td>
</tr>
<tr>
<td>Taper in spindle, Morse</td>
<td>4</td>
<td></td>
</tr>
<tr>
<td>Spindle speeds, number</td>
<td>8 or 16</td>
<td></td>
</tr>
<tr>
<td>Spindle speeds, 1-speed motor</td>
<td>50—2000</td>
<td></td>
</tr>
<tr>
<td>2-speed motor</td>
<td>30—2500</td>
<td></td>
</tr>
<tr>
<td>Tailstock spindle Ø</td>
<td>1⅛</td>
<td>35</td>
</tr>
<tr>
<td>Tailstock spindle travel</td>
<td>3⅜</td>
<td>85</td>
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<tr>
<td>Tailstock spindle taper, Morse</td>
<td>2</td>
<td></td>
</tr>
<tr>
<td>Cross slide travel</td>
<td>7</td>
<td>180</td>
</tr>
<tr>
<td>Top slide travel</td>
<td>3⅛</td>
<td>80</td>
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<tr>
<td>Leadscrew Ø</td>
<td>¾</td>
<td>20</td>
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<tr>
<td>Leadscrew pitch, t.p.i.</td>
<td>8</td>
<td></td>
</tr>
</tbody>
</table>

**Feeds:**

- **49 sliding**
  - inch/Rev: 0.0039—0.03819
  - mm/Rev: 0.01—0.97
- **49 surfacing**
  - inch/Rev: 0.0039—0.03819
  - mm/Rev: 0.01—0.97

**Threads:**

- Metric threads
  - mm: 0.2—6.0
- Whitworth
  - t.p.i.: 4—224

**Main motor**

- HP: 1 or 0.8/1

**Net weight, approx.**

- lbs/kg: 740/880, 335/400

**Gross weight, approx.**

- lbs/kg: 990/1210, 450/550

**Volume**

- cu.ft/m³: 46/60, 1.3/1.7

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**Rexvalter AB**

S-577 00 Hultsfred, Sweden

S-590 00 Storebro, Telephone 040/31 20 10
When ordering spares, please state number of spare part and the serial number of the lathe.

I. HEADSTOCK. See drawing above.

50. Nut
51. Spacer
52. Seal
53. Conical roller bearing
54. Bearing cup
55. Ferrolite bearing
56. Spacer
57. Gear wheel
58. Backgear shaft
59. Pulley
60. Shifting fork
61. Clutch
62. Circlip (?)
63. Spacer
64. Spacer
65. Circlip (?)
66. Ferrolite bearing
67. Circlip (?)
68. Conical roller bearing
69. Cover
70. Mandrel
71. Centre
72. Centre bush
73. Bearing bush
74. Clutch
75. Gear wheel
76. Lever
77. Shaft
78. Knob
79. Ferrolite bearing
80. Ferrolite bearing
81. Stud
82. Selector banjo
83. Screw
84. Gear wheel
85. Gear wheel
86. Stud
87. Gear wheel
88. Stud
89. Gear wheel
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K. GEARBOX, mandrel speeds. See drawing above.

100. Ball bearing
101. Pulley
102. Spacer
103. Seal
104. Retaining collar
105. Ball bearing
106. Spacer
107. Gear wheel
108. Shaft
109. Cover
110. Gear wheel
111. Gear wheel
112. Spacer
113. Ball bearing
114. Ball bearing
115. Gear wheel
116. Axle journal
117. Gear wheel
118. Spacer
119. Ball bearing
120. Spacer
121. Retaining collar
122. Seal
123. Pulley
124. Cover
125. Ball bearing
126. Gear wheel
127. Shifting fork
128. Shifting arm
129. Shaft
130. Spring
131. Spring housing
132. O-ring
133. Gearbox housing
134. Shifting arm
135. Shifting fork
136. Gear cluster
137. Circlip
138. Shaft
139. Cover
When ordering spares, please state number of spare part and the serial number of the lathe.

L. NORRIS GEARBOX. See drawing above.

150. Spacer  
151. Ferrolite bearing  
152. Shaft  
153. Ferrolite bearing  
154. Selector banjo  
155. Washer  
156. Gear wheel  
157. Gear wheel  
158. Gear wheel  
159. Gear wheel  
160. Ferrolite bearing  
161. Seal  
162. Gear wheel  
163. Gear wheel  
164. Gear wheel  
165. Gear wheel  
166. Gear wheel  
167. Gear wheel  
168. Gear wheel  
169. Washer  
170. Ferrolite bearing  
171. Washer  
172. Shaft journal  
173. Gear wheel  
174. Seal  
175. Ferrolite bearing  
176. Gear wheel  
177. Gear wheel  
178. Ferrolite bearing  
179. Circlip  
180. Washer  
181. Ferrolite bearing  
182. Shaft  
183. Axle journal  
184. Banjo  
185. Key  
186. Gear wheel  
187. Plunger  
188. Spring  
189. Bush  
190. Spacer  
191. Bush  
192. Spring  
193. Plunger  
194. Gear wheel  
195. Banjo  
196. Axle journal  
197. Ferrolite bearing  
198. Washer  
199. Circlip  
200. Ferrolite bearing  
201. Gear wheel  
202. Bush  
203. Casing  
204. Gear wheel
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H. MAIN PARTS. See drawing above.

1. Cover
2. Headstock
3. Cover
4. Saddle
5. Cross slide
6. Intermediate slide
7. Top slide
8. Washer
9. Toolpost
10. Cradle
11. Nut
12. Bearing bush
13. Micrometer collar
14. Ball handle
15. Top slide
16. Centre
17. Tailstock barrel
18. Locking lever
19. Lever
20. Backplate
21. Dial, barrel feed
22. Micrometer Collar
23. Barrel screw
24. Excenter
25. Bottom part
26. Back bearing
27. Set bolt
28. Clamp
29. Cupboard
30. Motor cover
31. Cross slide nut
32. Cross slide feedscrew
33. Bearing bush
34. Micrometer collar
35. Ball handle
36. Lever, speed selector
37. Lever, speed selector
38. Forward/reverse lever
39. Norton gearbox
40. Feedscrew
41. Rack
42. Cover
43. Lever, speed selector
44. Bed
45. Tailstock
46. Apron
47. Lever, screwcutting/auto feed
48. Lever, crossfeed