IF IN DOUBT ASK.

1" Dia std. bar.

13 16 Dia.

221 213"

750" +004" -002"

31 32

5 64

Do not chamfer this corner, break the sharp edge only.

Machine at W

Cyanide Harden

Grind at G

5" Viceroy Metal Lathe: Spacing Bush.

DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN M. M. Soudan
CHECKED
PASSED
DATE 27.1.65

MAT. Mild Steel Cyanide H.d.
MAT SIZE 1" Dia x 1 1/2" long
No. REQD. 2 SCALE 2½ FULL
DRAWING No. ML105/113
CALIPER SETTINGS

<table>
<thead>
<tr>
<th>ADD.</th>
<th>0.056&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>WIDTH</td>
<td>0.084&quot;</td>
</tr>
</tbody>
</table>

No. TEETH 54
PITCH 18 D.P.
PRESS. 20°
P.C.D. 3.000°

Keyway 8 wide
x \( \frac{3}{32} \) deep.

3\( \frac{1}{16} \) at 15° max. Chk.
on both sides

Machine at \( \Omega \)

5" Metal Turning Lathe - 54 T. CHANGE WHEEL.

DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN ASS'T.

CHECKED &

PASSED

DATE 1. 4. 64.

M.L. 105/129
IF IN DOUBT ASK.

Keyway: \( \frac{1}{8} \) in. wide
\( \times \frac{3}{32} \) in. deep

\( \frac{3}{16} \) in. at 15° max. Cham.

on both sides

Machine at W

Caliper Settings

<table>
<thead>
<tr>
<th>Add.</th>
<th>Width</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.056&quot;</td>
<td>0.084&quot;</td>
</tr>
</tbody>
</table>

N° of Teeth 52
Pitch 18 d.p.
Press. Apple 2.000
P.C.D. 2.888

5" Viceroy P.C.S. Lathe : 52 t Change Wheel.

DENFORD MACHINE TOOLS LTD.
(Ino.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN M.M. Souda
CHECKED
PASSED
DATE 11-6-65

MAT. C.I.
MAT SIZE Casting
No. REQD. 1
SCALE Full
DRAWING NO. ML105/128
Keyway: 1/8" wide x 3/32" deep.

3/16" at 15° max chamfer on both sides

Machine at W

Caliper Settings
Add. 0.056"  Width 0.084"

No. of Teeth 48  Pitch 18 d.p.
Press. Angle 20°  P.C.D. 2.666"

5" Viceroy P.C.S. Lathe: 48 T Change Wheel

DENFORD MACHINE TOOLS LTD.  DRAWN M.M. Scadden
(INC) DENFORD SMALL TOOLS (BRIG) LTD.  MAT. C. I.
BRIGHOUSE,  Casting  No. Req'd. 1  SCALE Full
YORKSHIRE  DATE  11.6.65  DRAWING No. ML105/127
Machine Drawn

5VCFL SU METAL LATHE - INTERMEDIATE STOP (TRAVEL CAGE)

IF IN DOUBT ASK.
Key Way 1/25" wide × 3/16" deep

Chamfer 3/16" x 15°
Both Sides.

27778° 6,667° 1,000°
DIA P.C.D.

2 3/32" P.C.D.

48 Teeth 18 D.P.
20° Pressure Angle.
Whole Tooth Depth 1/198"

Machine All Over

Caliper Settings
ADD. 0.056
WIDTH 0.086

5" Viceroy G.B. Lathe - 48T Gear (Transposing Setup)

DENFORD MACHINE TOOLS LTD.
(Inc.) DENFORD SMALL TOOLS (BRIG) LTD.
BRIGHOUSE,
YORKSHIRE.

DRAWN
J.P.

CHECKED

PASSED

DATE 5-4-72

MAT. C.I.

MAT. SIZE CASTING

No. REQD. 1
SCALE F

DRAWING No. ML 114/10

LIMITS ON DIMENSIONS UNLESS OTHERWISE STATED.