

SCHAUBLIN LATHE TYPE 70 ON BASE

1. Concrete foundation and power supply

The SCHAUUBLIN lathe type 70 should preferably be installed on a concrete foundation, the dimensions of which are given in the diagram (see overleaf). The depth of the foundation depends on the nature of the soil; the concreting should be done on firm soil.

Three holes 27 mm (1 1/16") dia. and 90 mm (3 1/2") deep should be provided for the foundation bolts. The position of these three holes can be marked out from the lathe base itself.

The purpose of the foundation is to insulate the lathe from the vibrations of the ground. But if the floor is sufficiently stable and vibration-free, a special foundation may be dispensed with.

The power supply cable should pass through the concrete foundation in a conduit terminating at point 6. For this purpose it is recommended to cast a 26 mm (1") i.d. steel tube into the concrete so that it projects not more than 5 mm (3/16") above floor level. The electric cables themselves should project about 1 m (40").

2. Bolting the machine to the floor and levelling

The lathe base should be fixed to the floor by three flexible foundation bolts (70-80.050), these being provisionally wedged in the 27 mm (1 1/16") dia. holes in the concrete foundation.

The lathe base is provided with five set-screws (70-80.040), which rest on 100 mm (4") dia. support plates.

Levelling should be carried out in the following order, taking the lathe bed as reference :

a) Transverse levelling headstock end :

Provisionally tighten foundation bolts 1 and 2;
level by means of set-screws 1 and 2 and finally tighten foundation bolts 1 and 2.

b) Longitudinal levelling, to be checked over the whole length of the bed :

Provisionally tighten foundation bolt 3; level by means of set-screw 3 and finally tighten foundation bolt 3.

c) Transverse levelling, tailstock end :

Use set-screws 4 and 5.

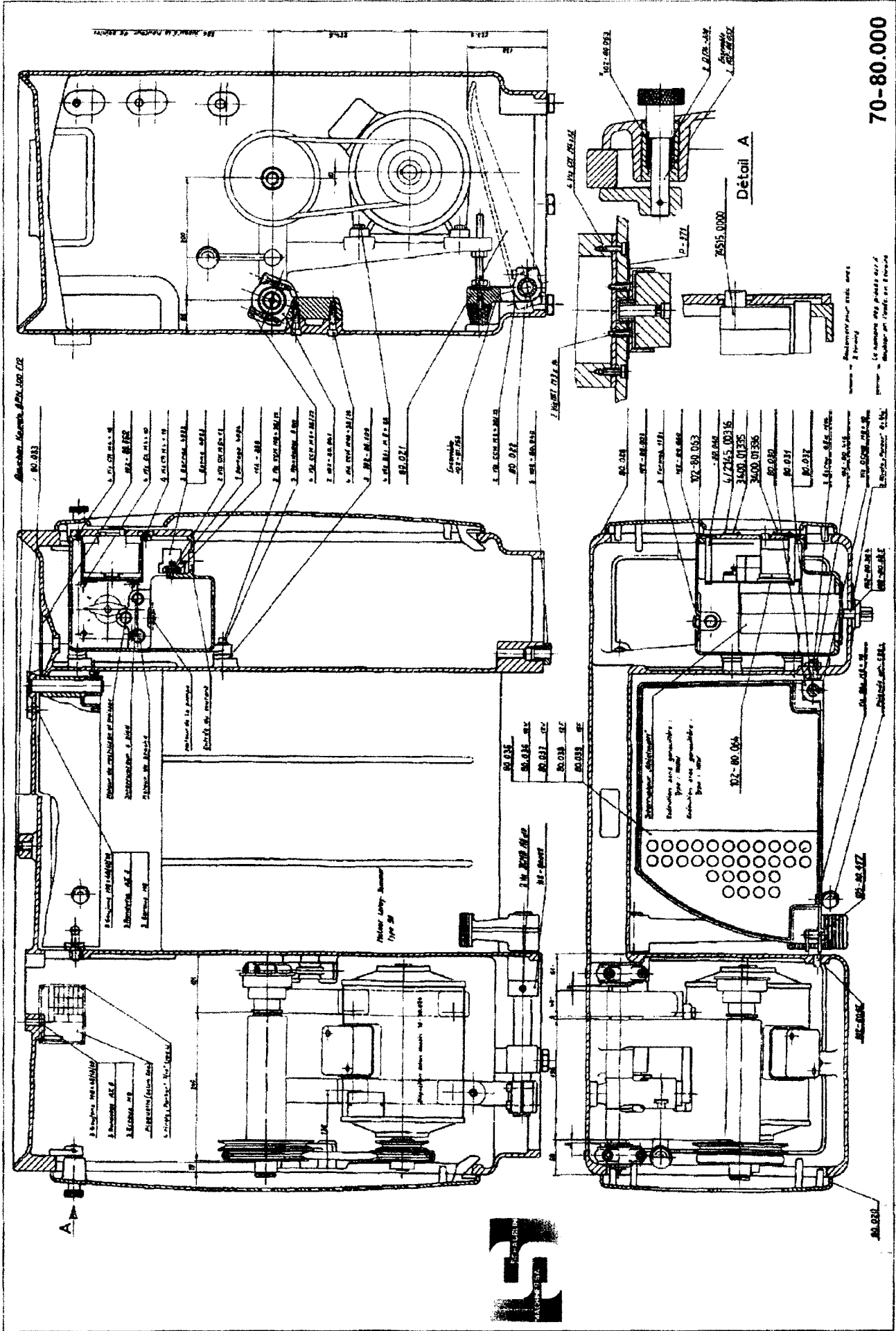
On request we will supply a set of three flexible foundation bolts (70-80.050) with 100 mm (4") dia. support plates. The set-screws (70-80.040) are part of the standard equipment of the base.

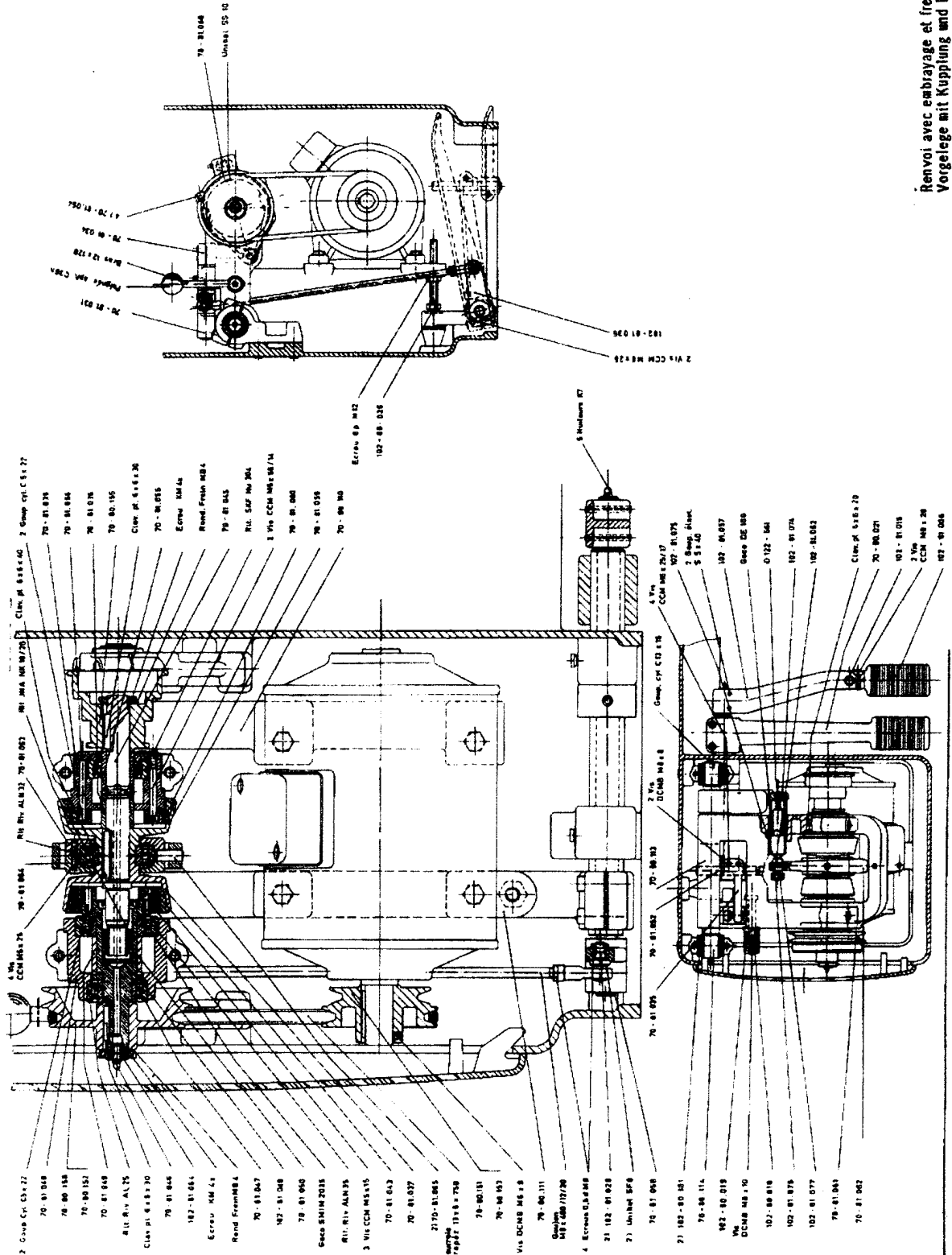
The holes in the base and set-screws are 15 mm (19/32") dia.

Correct levelling is very important for ensuring the accuracy of the lathe.

Use a precision spirit level : one graduation = 0,02 mm (0.001") on a length of 1000 mm (39 3/8"). The importance of correct levelling cannot be over-emphasised, and the work should not be scamped.

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Renvoi avec embrayage et frein
Vorgelege mit Kuppelung und Bremse
Countershaft with clutch and brake

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