

SCREW-OPERATED CARRIAGE 102-45.000

CHARACTERISTICS

Longitudinal stroke	90 mm*
Transverse stroke	100 mm
Height of centre over carriage	20 mm
Diameter allowed over carriage	
- without rear tool holder	120 mm
- with rear tool holder	60 mm
Adjustable dials, reading	1/100 mm
Tool dimensions	12 x 12 mm
Net weight	10.700 kg
*Special design with longitudinal stroke of (screw-operated carriage 102-45.150)	150 mm

MAINTENANCE

For the purpose of despatch all machined faces are given a coat of special anti-rust grease. This has no lubricating properties and must therefore be carefully removed.

Clean the unit with a chemically neutral white rag soaked in paraffin. Then apply a film of lubricating oil to all faces where the metal is bare.

Use one of the oils stipulated in the lubrication chart IN 102N-5.

LUBRICATION

Lubrication of the slideways, nuts, and screws

The screw-operated carriage has two nipples for injection of oil by means of the gun supplied with the lathe.

This system of lubrication is characterized by the cleaning action exerted by the pressure of the oil in the slideways and nuts. Four or five shots twice a week are sufficient.

Lubrication of the screw bearing

This patented bearing contains a ball bearing prepacked with a consistent grease for a period of about 5 years. To renew the charge of grease (a good ball-bearing grease), proceed as follows :

1. Drive out the taper pin 102-45.513.
2. Withdraw the crank handle 102-45.512 and the dial 102-45.506.

3. Unlock the screw of the nut 102-45.503 and unscrew this.
4. Rinse the bearing 102-45.507 thoroughly in petrol. Then pack the new grease between the balls and fill the space marked on the drawing.

ADJUSTMENTS

Adjustment of the screw bearing

Taking up play in the bearing does not require any dismantling.

1. Unlock the screw of the nut 102-45.502.
2. Screw the nut 102-45.502 onto the sleeve 102-45.503 according to the amount of play to be taken up.
3. Securely lock the screw of the nut 102-45.502.

The index mark engraved on the nut 102-45.502 can be reset in the appropriate position by turning the sleeve 102-45.503, which is held in its housing by a locking screw.

Adjustment of play in the slideways

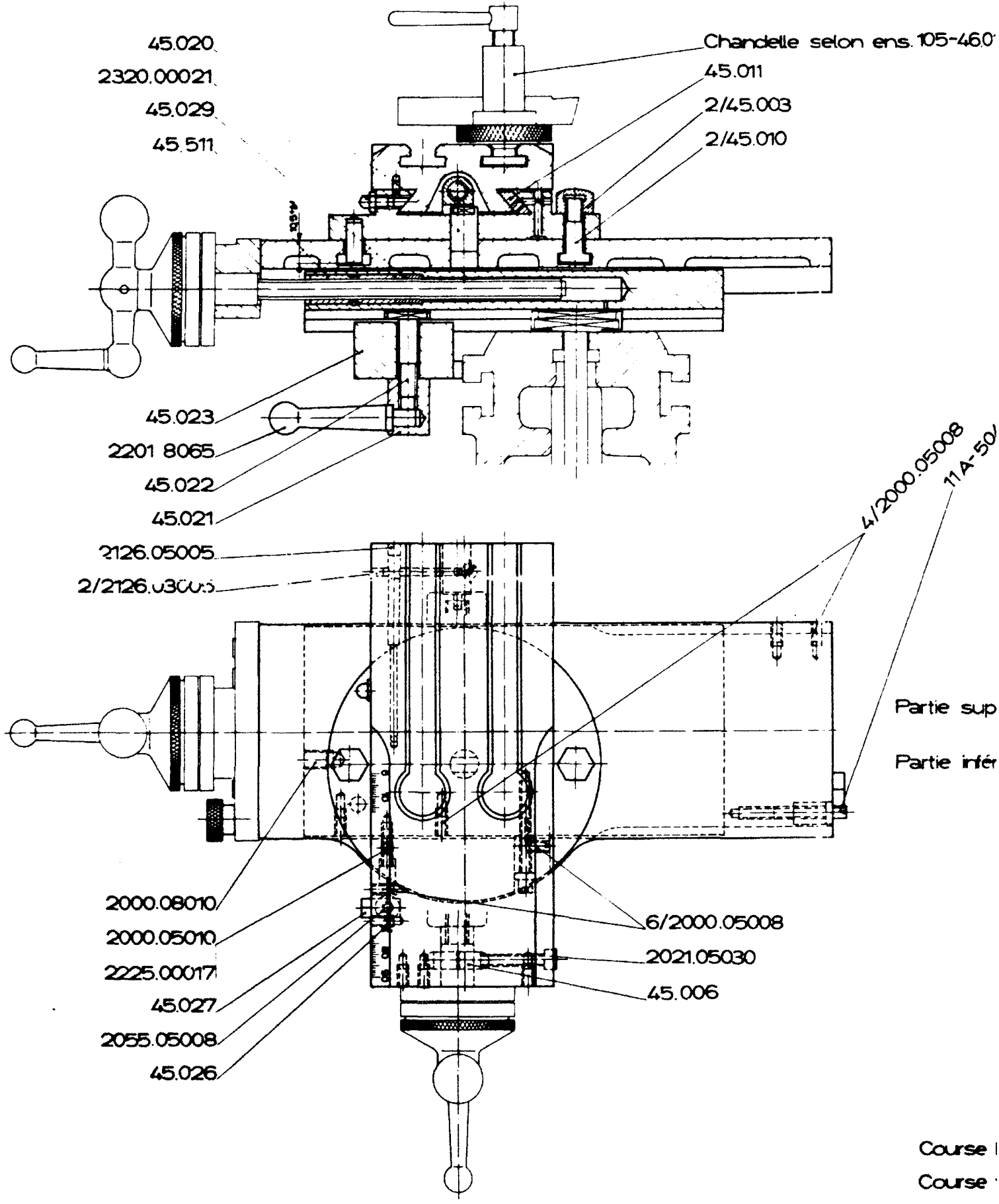
The transverse and longitudinal slides are fitted with taper gibs for taking up wear.

The screw 11A-504 provides simple adjustment.

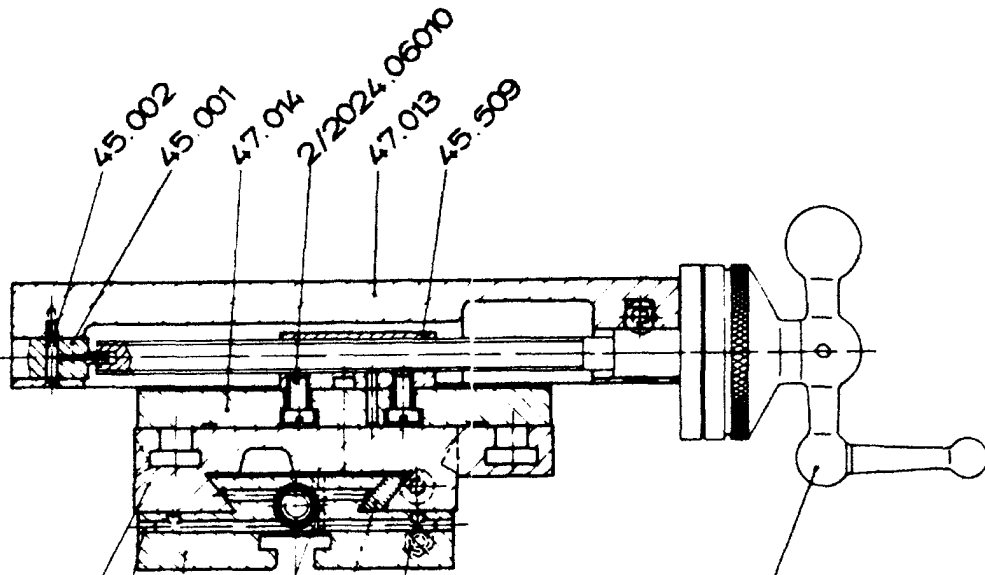
Adjustment of the zero-setting device

The swivelling longitudinal slide is rapidly reset to zero by means of a retractable stop. To adjust the stop, proceed as follows :

1. Slightly undo the screw 2000.05006.
2. Undo the 2 nuts 102-45.003.
3. Locate the longitudinal slide against the piston 102-45.008.
4. Turn the knob 102-45.007 until the top slide is perfectly parallel to the bed.
5. When perfect adjustment has been obtained, securely retighten the screw 2000.05006 and the nuts 102-45.003.



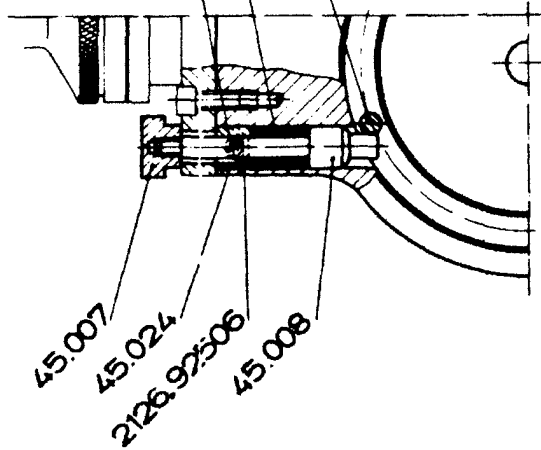
n ens. 105-46010



4/200.05008
11A-504
47.016
2/2126.03005
47.015
2/2126.03016
45.012
2320.00021
200.05006
45.073
2-1140325
102-45.017
Vis sup. vis inf.
selon ens. 10245.500

Partie supérieure Art. 102-45.050

Partie inférieure Art. 102-45.060



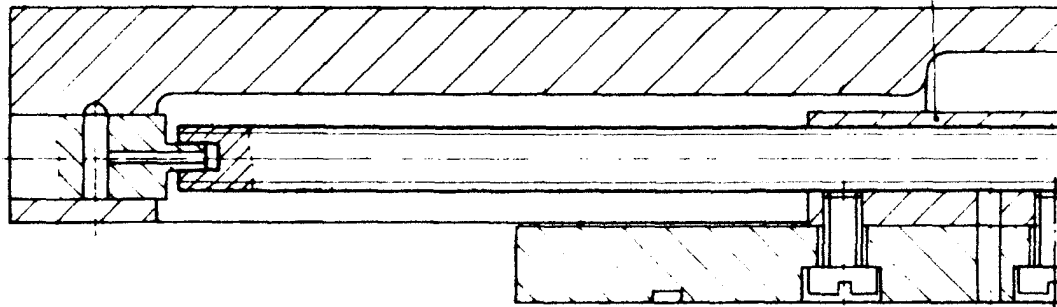
Course longitudinale 90mm
Course transversale 100mm

Emp. par:		Matière:	
Pièces similaires:		Norme: NF A 21.5.84	
Chariot universel		Echelle:	1:1
SCHAUBLIN SA BEVILARD (SUISSE)		Designé par:	102-45000

Vis supérieure

102-45.500

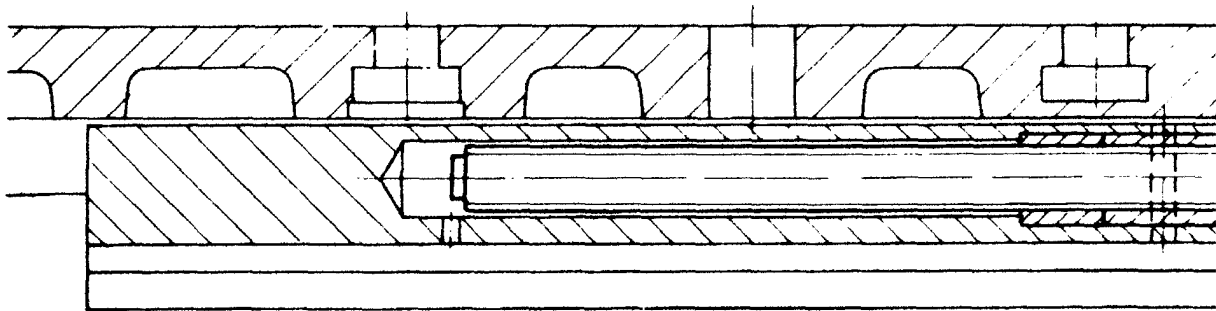
45.500



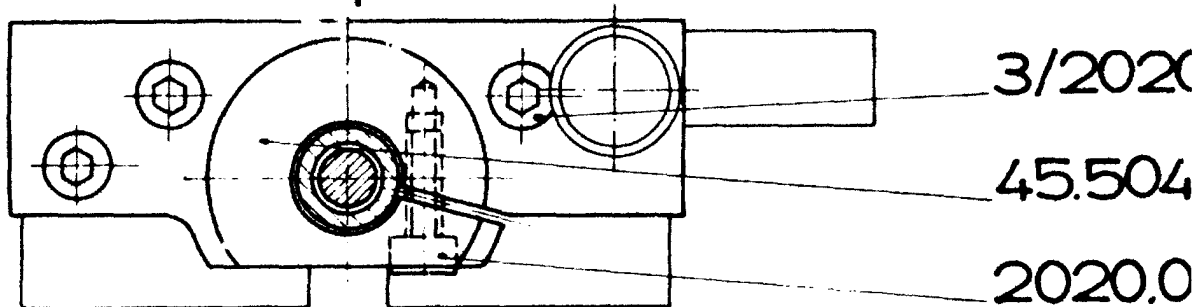
Vis inférieure

102-45.501

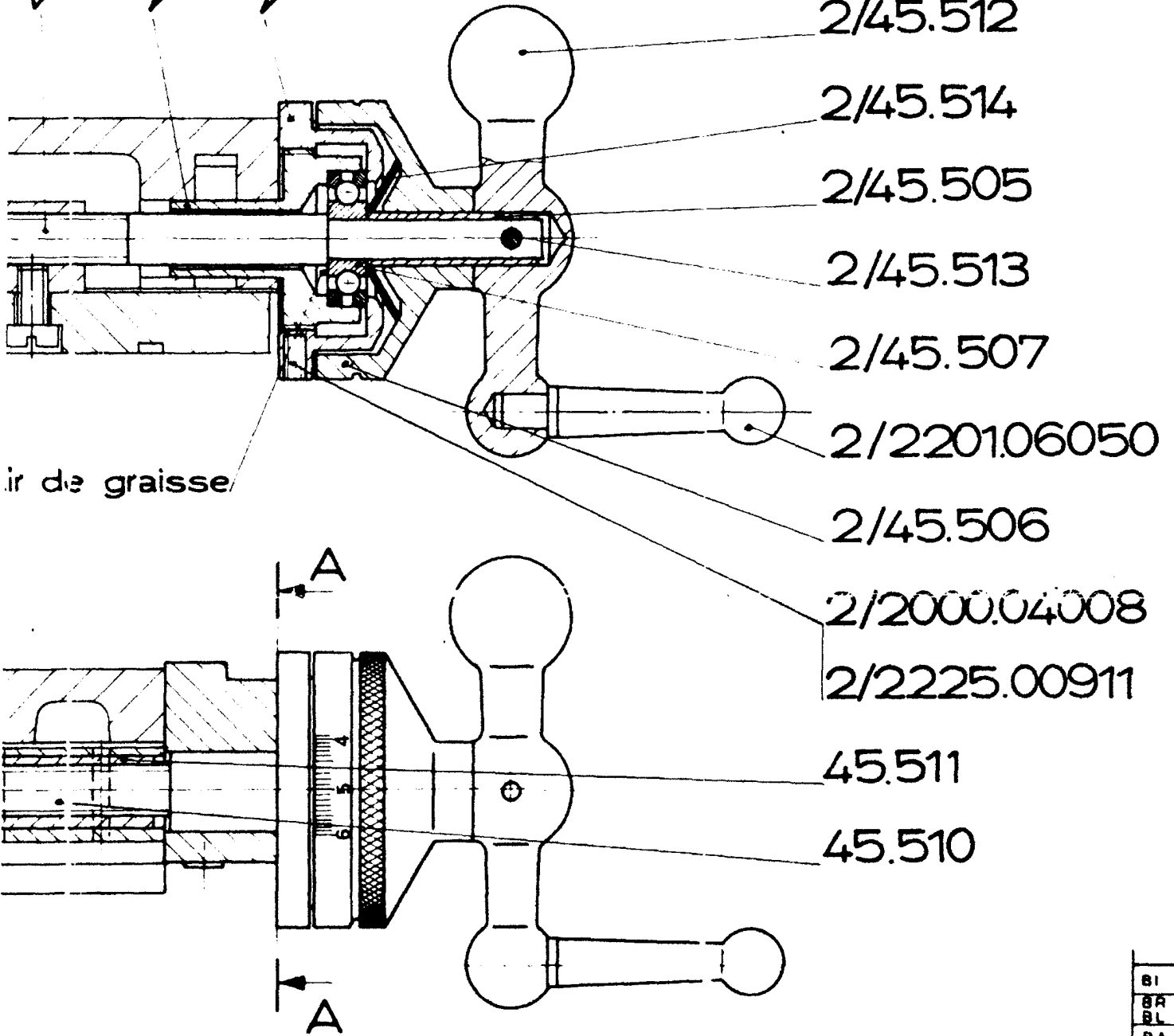
Remplir



Coupe A-A



9
45.508
2/45.503
2/45.502



2/45.512
2/45.514
2/45.505
2/45.513
2/45.507
2/2201.06050
2/45.506
2/2000.04008
2/2225.00911
45.511
45.510

Vis de graisse

20.05015

4

05015



BI
BR
BL
BA
Stock

Empl pour		Modifications	
Pièces semblables		Remplace Même N°1.4.5	
Vis de chariot		Echelle	Dessiné 11.1.75 Dal
		1:1	Contrôle
Matère	Modèle	Normes	Vu
SCHAUBLIN SA BÉVILARD (SUISSE)		102-45.500	