

SHELL TAPPA 30

HOL:7.

HOLBROOK

MODEL "B" No. 13

WITH

RELIEVING EQUIPMENT

OPERATOR'S INSTRUCTIONS.

CONSTRUCTION No. 10052

HOLBROOK

MACHINE TOOL CO. LTD

WORKS
STRATFORD
LONDON

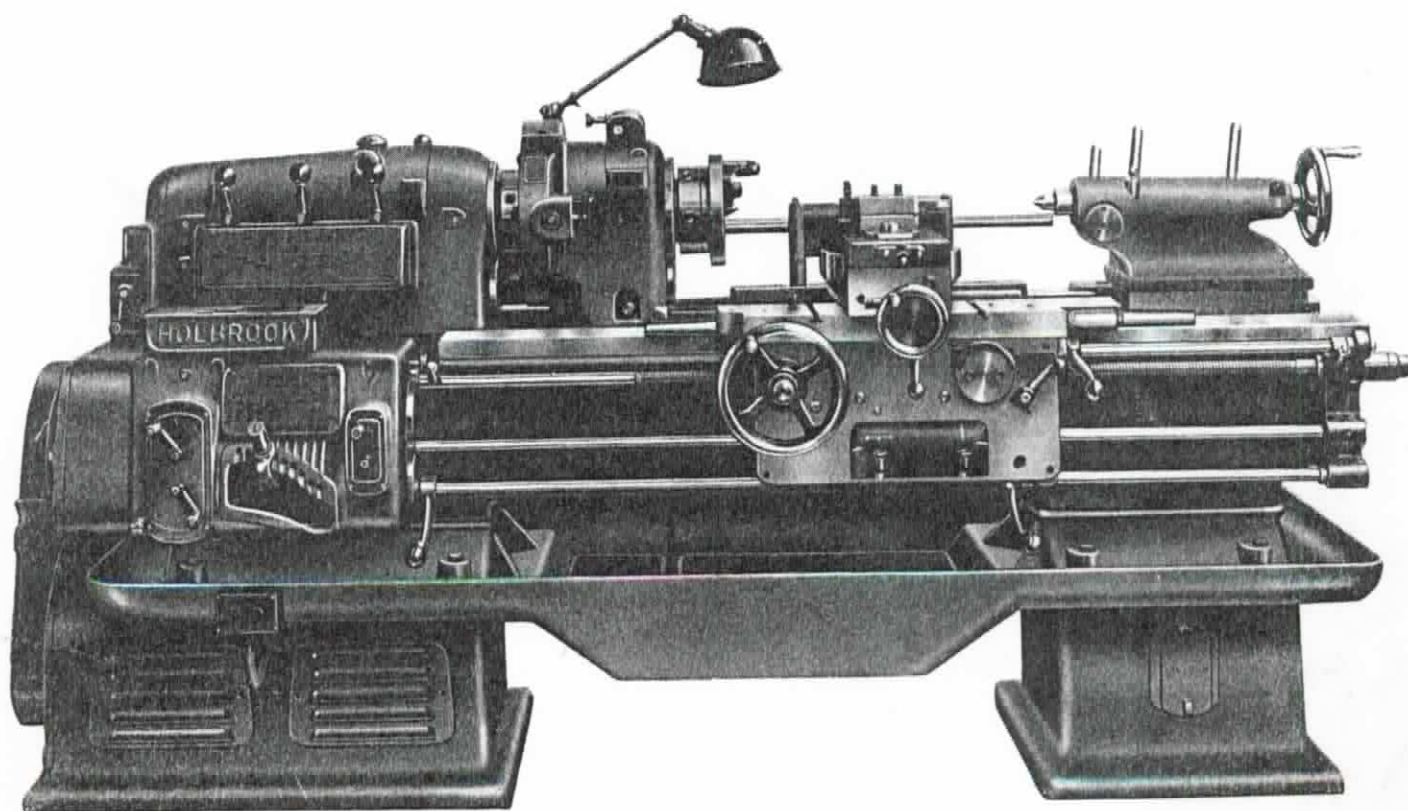
REGISTERED OFFICES

44, MARTIN ST. STRATFORD LONDON
ENGLAND

WORKS
HARLOW
ESSEX

UNIVERSAL RELIEVING EQUIPMENT

MODEL "B" Nos. 13, 17 AND 21



MAIN DIMENSIONS

MODEL "B" WITH SPINDLE REDUCER AND RELIEVING EQUIPMENT

	No. 13	No. 17	No. 21
Length between Centres	24"	27"	32"
Maximum Swing over Relieving Slide ...	5 $\frac{1}{4}$ "	7"	8"
Range of Speeds in r.p.m.	2.5—96.6	1.6—87.5	1.3—68
Range of Threads, Inch Lead	.079—4.8"	.079—4.8"	.107—6"
Range of Feeds	.006—.370"	.009—.549"	.018—1"
Range of Reliefs	2—40	2—40	2—40
Rise of Standard Cams	$\frac{3}{32}$ " , $\frac{5}{32}$ "	$\frac{3}{32}$ " , $\frac{5}{32}$ "	$\frac{1}{8}$ " , $\frac{1}{4}$ "
Rise of Hob "Heeling" Cams	$\frac{5}{16}$ "	$\frac{5}{16}$ "	$\frac{5}{16}$ "
Height of Tool	$\frac{7}{16}$ "	$\frac{3}{4}$ "	$\frac{1}{2}$ "
H.P. of motor	3	5	7 $\frac{1}{2}$
Floor Space	8' 3" × 3' 10"	9' 7" × 4' 4"	11' 1" × 4' 7"
Height	4' 1"	4' 2"	4' 3"
Weight Standard Lathe and Relieving Equipment	5,340 lbs.	7,280 lbs.	10,400 lbs.
Weight Standard Lathe and Relieving Equipment, Boxed	6,680 lbs.	8,750 lbs.	12,300 lbs.
Code Word	THIRE	SEVRE	TWERE

Capacity of Machine is the same for Grinding and Relieving.
Speeds, Pitches, etc., shown above include use of Spindle Speed Reducer.

Holbrook

UNIVERSAL RELIEVING EQUIPMENT

MODEL "B" Nos. 13, 17 AND 21

UNIVERSAL RELIEVING EQUIPMENT

can be furnished as Additional Equipment on each of the Model "B" Lathes providing it is ordered with the machine and "Built-In" at our works. This equipment provides a ready means of producing Straight or Angular Cutters, End Milling Cutters, Hobs, Taps, etc.

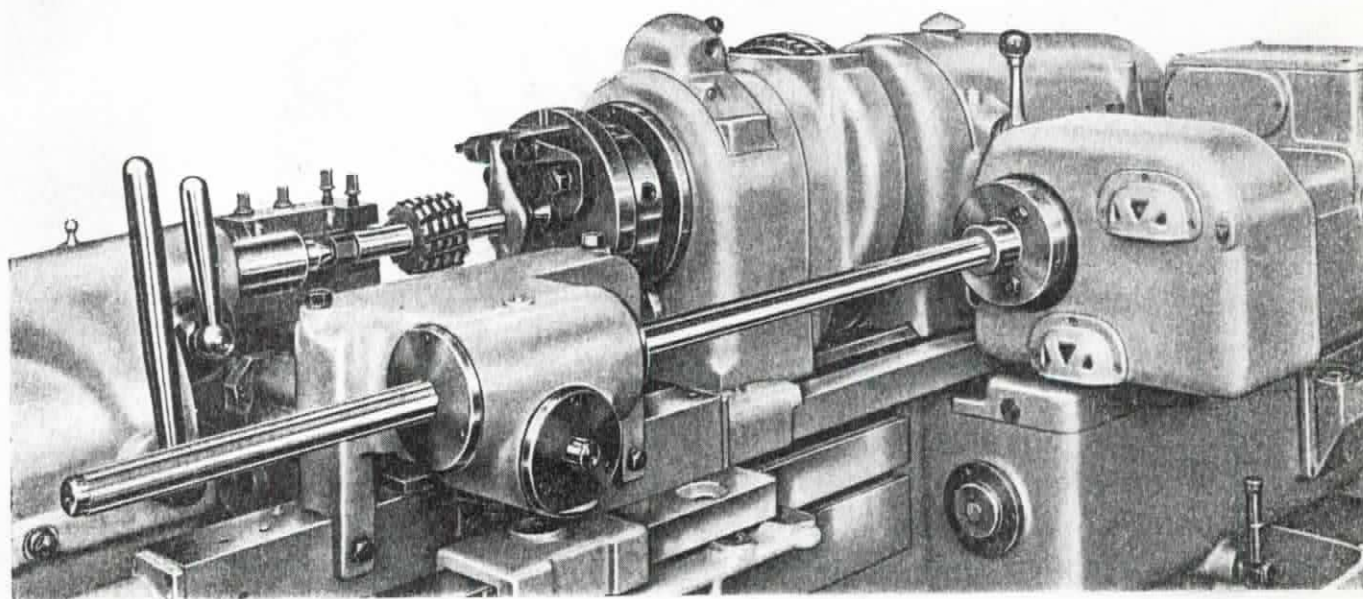
Relief can be obtained around 360° as the operating Cam is centrally mounted in the Relieving Slide. Full provision is made for Grinding Hobs or Cutters, to

remove any distortion due to hardening, thus ensuring a true and accurate cutting face.

This equipment is more versatile than any other yet available, but there are some limitations, such as Spiral Fluted Form Cutters, which, however, can be readily handled by our Model "R" Relieving Lathes.

Spindle Speed Reducer forms part of the equipment and is fully described on Page 18.

This unit is, in addition, useful for Cutting Multi-Start Threads with leads up to six times the range of the normal Quick Change Gearbox.



MODEL "B" No. 17. REAR VIEW OF RELIEVING EQUIPMENT

The above illustration shows the general arrangement of the Relieving Equipment and the Multi-Splined Shaft Drive, without telescopic shafts and universal joints.

(Sub-head Cover removed to show Index Plate.)