

MATERIAL $\frac{9}{16}$ ROUND 12L14

SURFACE FT. PER MIN. 267

SPINDLE R.P.M. 1810

GEARS 35-29

CYCLE 75

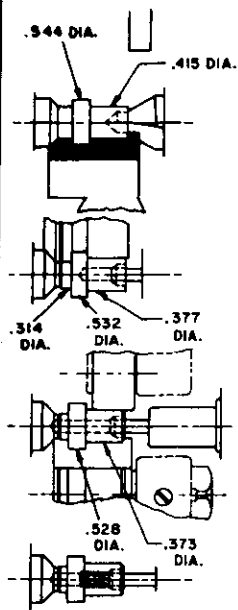
SEC. PER PIECE 2.8

GROSS PER HOUR

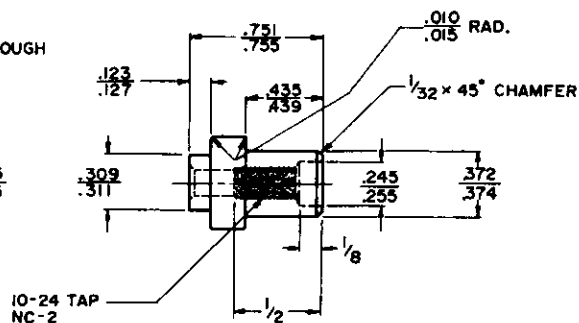
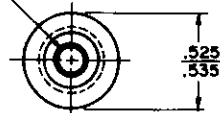
FEED GEAR 50 (60 IDLER)

THREAD GEARS 32-32

MODEL "B" WITH THREADING



25-.1495 DIA. DRILL THROUGH
90° CO'SINK $\frac{1}{32}$ DEEP



OPERATIONS	CAMS USED	FEED OF TOOL PER REV.	FEED PER REV.	EFFECT REVS	BLOCK LOC'N
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STOP STOCK & DRILL .250 DIA.	$\frac{1}{4}$.239	.0034	70	96
FORM	$\frac{3}{32}$	$\frac{3}{32}$.0014	65	1.0

REVOLVE DRILL $\frac{1}{2}$ TO 1 1232-98-70-SA

DRILL 25 .1495 DIAMETER	$\frac{3}{8}$.304	.0028	110	.81
FORM	$\frac{3}{32}$	$\frac{3}{32}$.0014	65	1.0

REVOLVE DRILL $\frac{1}{2}$ TO 1 1232-98-70-SA

DRILL 25 .1495 DIAMETER	SPECIAL C-22552	.304	.0028	110	1.0
SIZE	$\frac{3}{32}$	$\frac{3}{32}$.0014	65	1.0

TAP 10-24 NC-2	#4 STEEL				1.08

CUTOFF	$\frac{5}{32}$	$\frac{5}{32}$.0024	65	1.0
CO'SINK LEFT END	SPECIAL 5-C-1510-1	.045	.005	9	—

STATIONARY HEAD BURRING ATTACHMENT 1263-5-10-SA
CO'SINK ARM ATTACHMENT 1263-119-1-SA
5-C-1488

TOOLS REQUIRED

- 5- $\frac{9}{16}$ ROUND COLLETS
- 5- $\frac{9}{16}$ FEED FINGERS
- 1- 2904-10-SA STOCK STOP
- 1- 2717-SA ADJ. DRILL HOLDER
- 1- SPECIAL 1ST POSITION CENTER DRILL
- 1- 3060-1-1-SA DOVETAIL FORM TOOL HOLDER
- 1- 1ST POSITION DOVETAIL FORM TOOL
- 2- 2714-SA REVOLVING DRILL HOLDER
- 2- #25 (.1495) DIA. DRILL H.S.S.
- 1- 1801 DRILL BUSHING WITH .1495 DIA. HOLE
- 1- 2ND POSITION CIRCULAR FORM TOOL
- 1- 3RD POSITION SPECIAL DRILL BUSHING
- 1- SPECIAL DRILL CAM C-22552
- 1- 2726-O-SA OVERSIZE SIZING TOOL WITH $\frac{3}{4}$ " PLATE
- 1- SIZING TOOL & ROLL
- 1- 2747-C TAP HOLDER
- 1- 10-24-NC TAP
- 1- 1801 TAP BUSHING
- 1- 2768-SA CUTOFF BLADE HOLDER
- 1- SPECIAL CUTOFF BLADE
- 1- 1263-5-10-SA STATIONARY HEAD BURRING ATTACH
- 1- 646-23-1 $\frac{3}{8}$ ROUND BURRING CHUCK
- 1- SPECIAL BURRING CAM 5-C-1510-1
- 1- 1263-119-1-SA COUNTER-SINK ARM & STOP ATTACH.
- 1- SPECIAL LEFT HAND CENTER DRILL
- 1- SPECIAL SWING ARM CAM 5-C-1488

GASH FORM & CUT OFF TOOLS $\frac{1}{4}$ " BELOW CENTER
GASH REING TOOLS $\frac{1}{2}$ " BELOW CENTER

DAVENPORT MACHINE TOOL DIV.
DOUGLAS CORPORATION
ROCHESTER, N.Y., U.S.A.

MARK ALL TOOLS A.J.L.-L0-1

DRAWN BY A.J.L. DATE 6-17-80

NO **6394**

DAVENPORT INSTRUCTION
BOOK LAYOUT