

OPERATION AND MAINTENANCE

of the

Brown & Sharpe 2 and 3 ULTRAMATIC SCREW MACHINES

FOREWORD

This book offers a practical working knowledge of the Brown & Sharpe 2 and 3 Ultramatic Screw Machines. It will enable the machine operator to obtain continuous and accurate production of work that requires close tolerances and good finish.

Chapter 1 on Machine Installation covers connecting to power supply, lubrication and coolant requirements. The floor plans on page 6 should be considered before permanent location for the machine is chosen.

Detailed explanations are presented in Chapter 2 for each set-up adjustment and operating control of the machine.

We strongly urge the reader to note the contents of Chapter 3 on Preventive Maintenance and the schedule of regular inspections.

Chapter 4 on Construction and Maintenance Adjustments will be a valuable aid to the maintenance man.

Chapter 5 will be of help to better understand the use, care, and sharpening, etc. of blades used in screw machine tools, also includes Speed Tables and Production Tables.

Speed Tables and Production Tables will be found on pages 50 to 79 inclusive.

As Brown & Sharpe is constantly improving the design of its machines, there may be some instances where this book differs somewhat from the machine that you are concerned with.

Cam Design and Standard Tools are explained in a separate booklet.

Repair parts are listed and illustrated in a booklet entitled "Repair Parts for the 2 and 3 Ultramatic Screw Machines."

B-339

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