

Atlas 6" Backgeared Screwcutting LATHE



- ★ 6" swing, 18" capacity between centers
- ★ Headstock spindle is equipped with Timken tapered roller bearings for accuracy, service and versatility
- ★ Bed ways are massive, precision ground grey-iron for accuracy and rugged strength
- ★ The 16 spindle speeds equip you to handle a wide work range
- ★ Back gears provide extra power for heavy cuts
- ★ Reversible automatic longitudinal power feed cuts operating time
- ★ Complete V-belt drive
- ★ Wide thread cutting range — 8 to 96 Standard, right or left hand — Metric, .5 to 3 mm., Standard.
- ★ Operates from a 1/4 or 1/2 HP motor.

No. 618 6" BACKGEARED SCREW-CUTTING LATHE. Complete as shown, less motor, with equipment listed below. Code YEDUP, shipping weight 100 lbs.

EQUIPMENT FURNISHED

Reversible Automatic Power Longitudinal Feed; Graduated Compound Rest; Tool Post, Ring and Ratchet, 3/8" Tool Bit; Complete Set of Change Gears to cut standard threads between 8 and 96 per inch; Threading Chart, Threading Dial; Quick-Change Countershaft; Complete V-Belt Drive; Motor Pulley furnished is for 3/4" diameter motor shaft — dealer can supply bushings for 1/2" dia. motor shafts; 60-Hole Indexing Mechanism; 3/4" Combination Metal and Wood-working Face Plate; Two 60° Lathe Centers — No. 2 Morse Taper for Headstock, No. 1 Morse Taper for Tailstock; 5 Wrenches; Instruction Manual.

WIDE THREADING RANGE



Atlas 6-inch lathes are equipped with change gears and threading dial for cutting all threads from 8 to 96 per inch, right or left hand, in the following standards: National Coarse (UNC), National Fine (UNF), Acme, Square, and Whitworth. Gear train is completely enclosed — threading chart mounted on inside of guard shows gear train set-ups.

SPECIFICATIONS

CAPACITY

Swing Over Bed.....	6"
Swing Over Carriage.....	3 1/2"
Capacity between Centers.....	18"
Threading Range.....	8 to 96 Standard, Right or Left Hand — Metric, .5 to 3 mm. Standard
Collet Capacity.....	9/32" (see page 14)
Overall Dimensions.....	35 1/2" x 27" x 12" high

SPEEDS AND FEEDS

Sixteen Speeds.....	54, 82, 122, 140, 187, 287, 317, 365, 481, 550, 820, 940, 1250, 1925, 2125, 3225 RPM.
Feeds (Left or Right) per Revolution of Spindle.....	.0078", .0048", .0039" or .0024"
Lead Screw.....	1/2" Diam., 16 Acme Threads per inch

DRIVE UNIT

Motor Recommended.....	1/4 or 1/2 HP, 1725 RPM
Motor Mounting.....	Bench
Countershaft Spindle Bearings.....	Oilite Bronze

HEADSTOCK

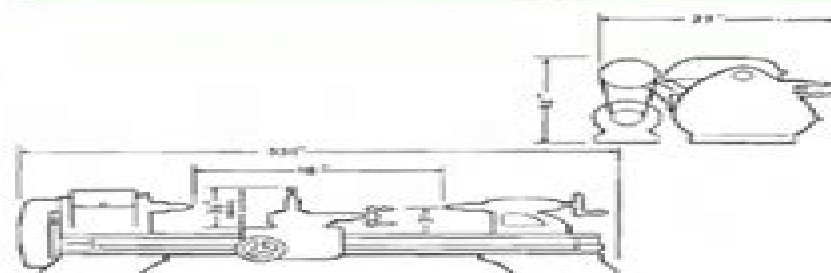
Spindle Bearings.....	Timken Tapered Roller Bearings with Thrust Take-up Collar and Nut
Spindle Nose.....	1" Diameter, 10 Pitch NS Threads
Spindle Nose Taper.....	No. 2 Morse Taper
Hole through Spindle.....	17/32"
Back Gears.....	20 Pitch, 3/8" Wide
Backgear Shaft Bearings.....	Oilite Bronze
Spindle Gear.....	24 Pitch, 32 Teeth, 7/16" Wide

CARRIAGE

Cross Feed Travel.....	4 3/4"
Cross Feed Screw.....	3/8" Diameter, Acme Thread
Tool Post Slide Travel.....	1 3/8"
Tool Post.....	13/32" x 3/4" slot to take 3/8" bits or tool holder for 3/16" bits

TAILSTOCK

Tailstock Ram.....	3/4" Diam. Bored for No. 1 Morse Taper
Tailstock Ram Travel.....	1 1/4"
Tailstock Set-Over, Forward or Back.....	9/16"



Atlas Lathe Operations Manual

Graham G. Whipple, Anthony C. Baudek



Atlas Lathe Operations Manual:

Manual of Lathe Operation and Machinists Tables Atlas Press Company. Engineering Department, 1937 *Manual of Lathe Operation and Machinists Tables* Atlas Press Company, Kalamazoo, Mich, 1937 **Engine Lathe Operations** Graham G. Whipple, Anthony C. Baudek, 1942 **Manual of Lathe Operation and Machinists Tables** Atlas Press Company, 1967

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