#### ATTACHMENT FOR THREADCUTTING BY LEADER AND GEARS

Type 102N-85.200: Attachment for external and internal threadcutting by leader and gears for use with open or closed headstocks, with or without compound slide.

For headstocks equipped with a lever-operated quick-closing attachment, the quickclosing sleeve must be replaced by item 105-85.248 (W20) or item 105-85.249 (W25). Lever and bracket are to be replaced by 105-85.240.

#### CHARACTERISTICS

Maximum diameter of component to be threaded	120	more
Maximum length threaded	100	mm
Maximum pitch cut	3	mm
Minimum pitch cut	0,25	more
Radial stroke of tool slide for adjustment of p	60	mm
Accuracy of adjustment of tool slide	0,02	mem
Axial stroke of toolholder (for fine adjustment against a shoulder or for finishing a thread flank)	1.0	
Maximum inclination of tool slide (for screwcutting with angular feed)	30*	
Rotation of toolholder (inclination of circular tool to helix angle of thread)	- 10*	

#### MAINTENANCE

#### Cleaning on receipt

On despatch all external and internal machined faces are given a coat of special anti-rust grease. This has no lubricating properties, and its presence may cause serious seizures, even several weeks after starting up.

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

#### Lubrication

The attachment for screwcutting by leader requires no particular maintenance except cleaning and lubrication at regular intervals.

The lubrication is carried out 1

- a) under pressure, through three nipples, 2320.00021 with the aid of the gun supplied with the machine;
- with an oil can in the case of the slide (105-35.591) and its operating screw, the pivots, the gears, and the thread of the leader (102-85.300).

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