

ATTACHMENT FOR THREADCUTTING BY LEADER AND GEARS

Type 102N-83.200 : 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 quick-closing sleeve must be replaced by item 105-83.248 (W20) or item 105-83.249 (W25). Lever and bracket are to be replaced by 105-83.240.

CHARACTERISTICS

Maximum diameter of component to be threaded	120	mm
Maximum length threaded	100	mm
Maximum pitch cut	3	mm
Minimum pitch cut	0,25	mm
Radial stroke of tool slide for adjustment of ϕ	60	mm
Accuracy of adjustment of tool slide	0,02	mm
Axial stroke of toolholder (for fine adjustment against a shoulder or for finishing a thread flank)	10	mm
Maximum inclination of tool slide (for screwcutting with angular feed)	30°	
Rotation of toolholder (inclination of circular tool to helix angle of thread)	$\pm 10^\circ$	

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 :

- a) under pressure, through three nipples, 2320.00021 with the aid of the gun supplied with the machine;
- b) with an oil can in the case of the slide (103-35.591) and its operating screw, the pivots, the gears, and the thread of the leader (102-83.300).

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