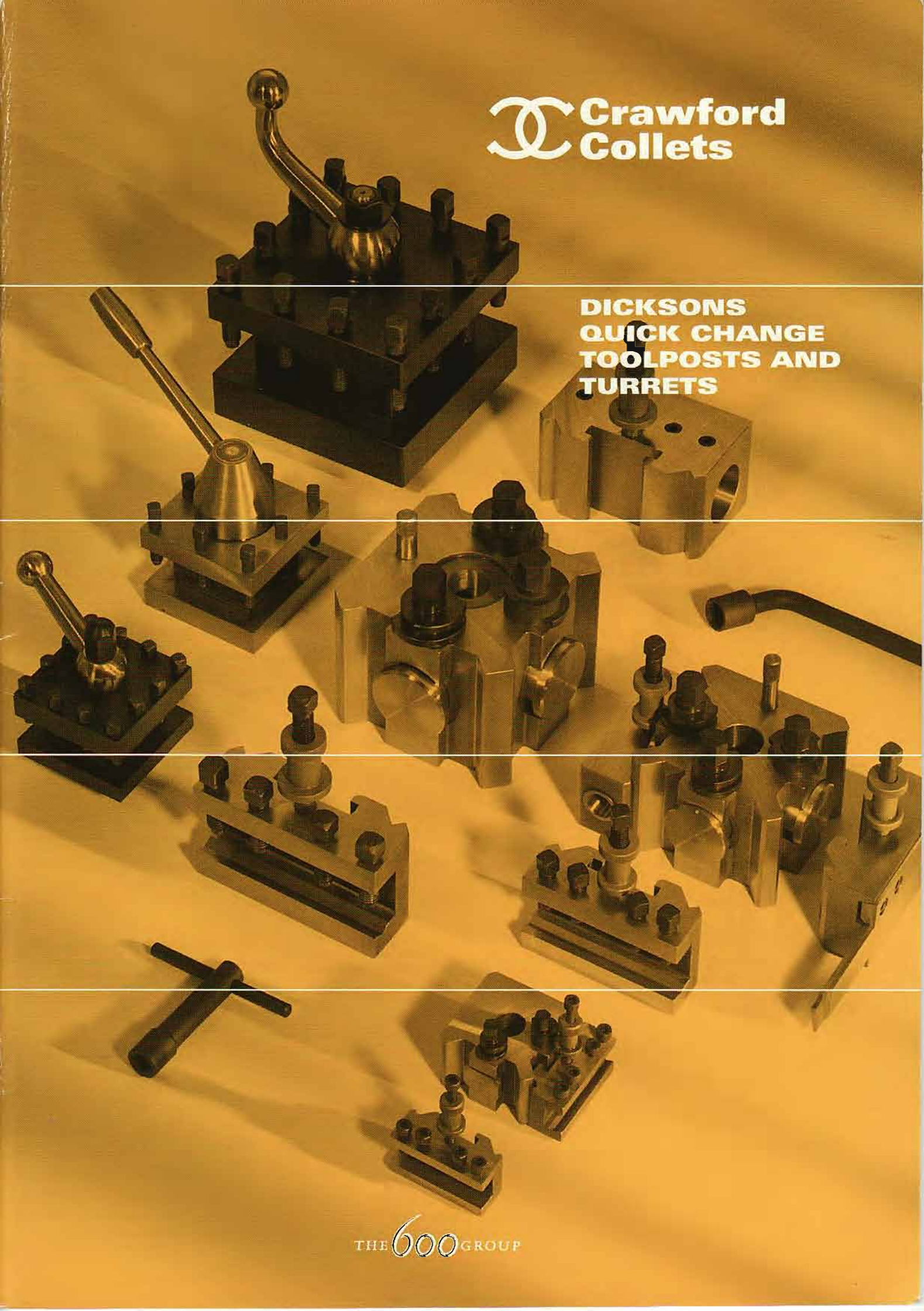




**Crawford
Collets**

**DICKSONS
QUICK CHANGE
TOOLPOSTS AND
TURRETS**

THE **600** GROUP

Crawford Collets

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48 WAY MANUAL TURRETS – VARIABLE HEIGHT

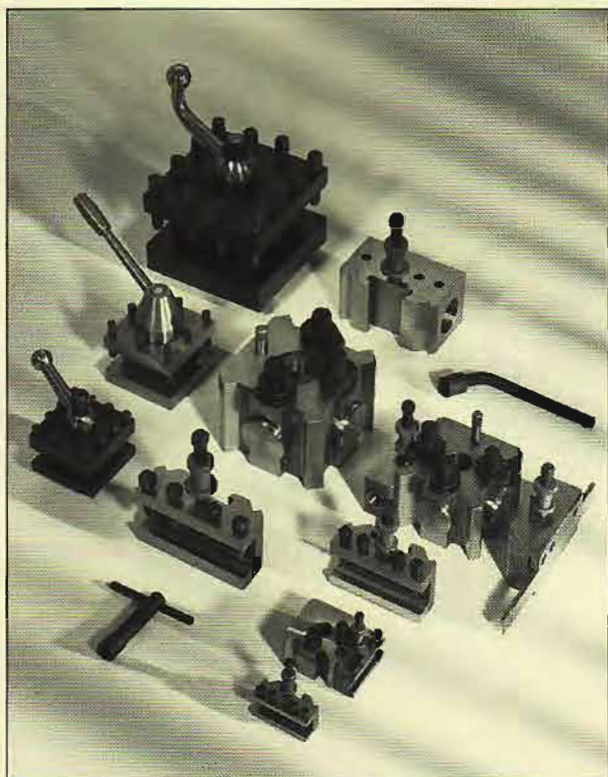
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– STANDARD

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Design Drawing &
Ordering Information

– pull out back cover



Crawford Collets

QUICK CHANGE TOOLPOSTS AND TURRETS

Crawford Collets manufacture the extensive range of Dicksons quick change toolposts and toolholders, as well as semi-automatic and manually indexing turrets.

QUICK CHANGE TOOLPOSTS

The quick change system was developed as a major advance from the conventional four way toolpost. The simple but robust design uses hardened and ground components to give high accuracy and repeatability.

A versatile range of toolholders which can be brought into use in seconds provides a flexible approach to machining and significant savings in set up times.

Change over time can be reduced significantly using preset holders.

Centre height adjustment is achieved by a simple knurled nut which can be adjusted in seconds, eliminating the need for packing pieces.

Additional toolholders can be purchased to compliment the standard sets, which will further increase the savings on down time.

BENEFITS

- Suits Most Lathes
- Large Range of Toolholders
- Case Hardened and Precision Ground Components
- High Degree of Accuracy and Repeatability
- Simple, Robust Design is Easy and Quick to Use
- Reduces Set Up Time

TURRETS

MANUAL TURRETS

This range of hand indexing turrets will suit most lathes. They have been designed to be user friendly incorporating a simple robust mechanism using hardened and ground components. The economical design allows up to 4 tools to be used at one time with a high degree of accuracy. 48 position indexing provided by 2 geared rings giving indexing repeatability and exceptional rigidity.

BENEFITS

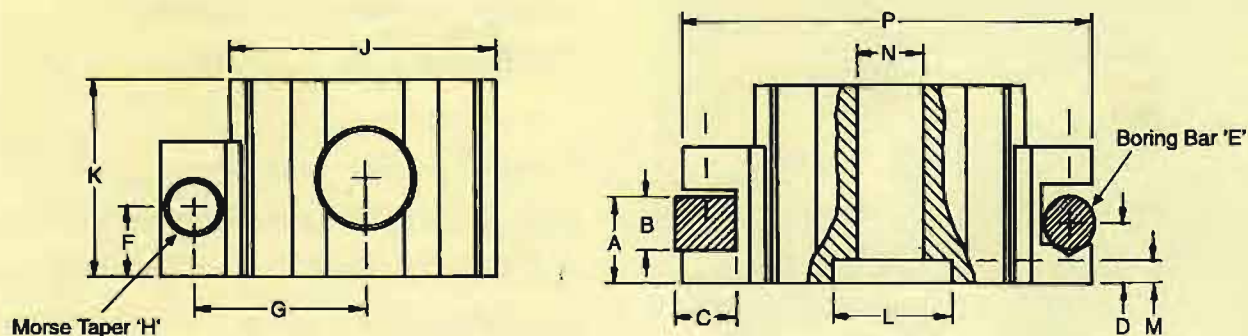
- Suits Most Lathes
- Rigid Construction
- Hardened and Ground Components
- High Degree of Accuracy
- 48 Position Indexing

SEMI-AUTOMATIC TURRETS

This range of semi-automatic indexing turrets will suit most lathes. The mechanism is completely sealed against dirt, coolant and swarf. The turret is positively indexed at 90° positions. Hardened and ground components ensure high accuracy with a smooth positive action.

BENEFITS

- Suits Most Lathes
- Rigid Construction
- Hardened and Ground Components
- Semi-automatic Indexing
- High Degree of Accuracy



QC Ref	A	B	C	D	ØE	F	G	H	J	K	ØL	M	ØN	P
S00	min 19.5 max 35	13	13	min 11.5 max 28	10	-	-	-	57	42	-	-	16	*77.5
S0	min 26.5 max 39	16	16	min 17 max 30	16	min 19 max 32	50	MT1	73	50.8	22.03	11.0	19	*98
S1	min 31 max 53	20	16	min 22.5 max 44	16	min 23 max 42	50	MT1	73	63.5	31.75	6.3	19	123
S1X	min 40.5 max 62.5	20	16	min 32 max 53.5	16	min 32.5 max 51.5	50	MT1	73	73	31.75	6.3	19	123
S2	min 34.5 max 51.5	20	20	min 26 max 47	19	min 28 max 50	65	MT2	97.4	71.4	44.45	7.9	25.4	158
S2T	min 41.5 max 59	25	25	min 24.5 max 42	19	min 32.5 max 52	70	MT2	106	76.2	44.45	7.9	25.4	167
S3	min 52 max 76	32	25	min 29 max 58.5	25	min 36 max 61	85	MT3	125.7	95.2	50.8	9.5	25.4	200
S3X	min 68 max 92	32	25	min 45 max 74.5	25	min 52 max 77	85	MT3	125.7	111	50.8	9.5	25.4	200
S4	min 57.5 max 89	32	32	min 40.5 max 75	25	-	-	-	149	120.5	63.5	12.7	38.1	241

QC Ref	Make/Model	Swing Over Bed	Power kW
S00	Myford		
	254 Plus	280	0.75
	254V Plus	280	1.5
	Boxford		
	160 TCL	160	0.49
	250B	250	2.2
	250F	250	2.2

S0	600 Lathes		
	TSH Trainer	280	1.3
	TSH M250	280	1.3
	TSH V280	280	2.0
	CLC Bantam VS 3500	280	2.0
	CLC Bantam 2000	280	1.3
	Ajax		
	AJ 165E	335	2.4/4.5
	Boxford		
	280 Manual	280	1.1

S1	600 Lathes		
	TSH M300	330	2.2
	TSH V330	330	3.75
	CLC Student 2500	330	2.2
	CLC Student VS 3000	330	3.75
	TSH Alpha 330	330	3.75
	Boxford		
	280 Turnmaster	280	3.75
	Excel		
	XL 320	320	2.2
	XL 1440 GE	360	2.2

S2	600 Lathes		
	TSH V350	350	7.5
	CLC Master VS	350	7.5
	600 Centre		
	*TOS SN32C	400	5.5

S2T	600 Lathes		
	TSH V390	400	7.5
	TSH M390	400	5.5
	CLC Triumph 2000	400	5.5
	CLC Triumph VS 2500	400	7.5
	*TSH Alpha 400	400	7.5
	Excel		
	XL 1640	400	5.5
	XL 1860	450	5.5

QC Ref	Make/Model	Swing Over Bed	Power kW
S2T	Ajax		
	AJ 225	450	7.46
	Bridgeport		
	*EZ Path	419	6.96
	600 Centre		
	*TOS SU 132	320	4.0
	XYZ		
	350	250	6.5
	410	470	6.5
	410 VS	470	8.7
	1400	355	2.6
	1600	406	6.5

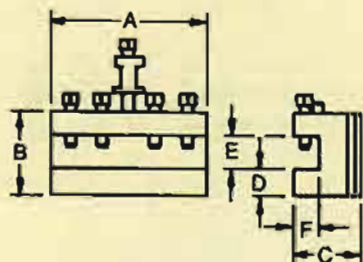
S3	600 Lathes		
	TSH V460	460	11
	TSH M460	460	9.3
	TSH V550	554	11
	TSH M550	554	9.3
	CLC Mascot GH	460	9.3
	CLC Mascot VS 2000	460	11
	CLC Mastiff GH	550	9.3
	CLC Mastiff VS 1800	550	11
	*TSH Alpha 460	460	11
	*TSH Alpha 550	554	11
	Ajax		
	AJ 310	620	8.95
	Excel		
	XL 580	580	11
	XL 500	500	11
	XL 440	440	11
	600 Centre		
	TOS SN40C	400	5.5
	XYZ		
	560	560	11
	2200	559	13

S4	600 Lathes		
	TSH M600	635	15
	TSH M750	760	15
	CLC Magnum	635	15
	CLC Magnum LB	760	15
	Excel		
	XL 640	640	11
	XL 32	800	15
	XL 43	1090	30
	600 Centre		
	*TOS SN63C	630	7.5
	*TOS SN71C	710	7.5

* Sets for these lathes are not shown on page 9 standard sets. Details on request.

Note: This chart shows the Q.C. size for reference only as there are more than one Q.C. set per size reference. When ordering, please state which set you require by set number (see page 9) and state machine to which the Q.C. set is to be fitted. Alternatively, use the design drawing on the fold-out back cover to send us details of your lathe.

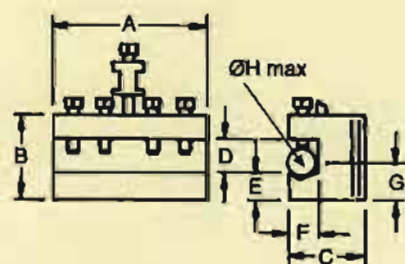
TOOLHOLDERS



Standard Toolholders

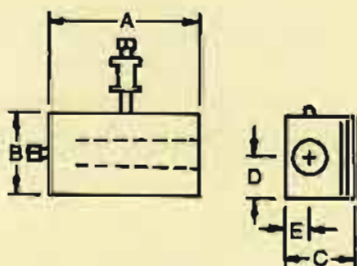
A	B	C	D	E	F	Order Code
57.5	27	27	6.7	13.5	11	S00 141T
73	38	31.5	10.3	17.5	14	S0 143T
73	44.5	31.5	11	22	14	S1 141T
98	49.8	40	12	22.3	19	S2 141T
98	57	40	14.3	28.5	19	S2 143T
124	70	47	17.5	35	22	S3 141T
147	92	60	25.4	41	25.4	S4 143T

Boring Bar Holders



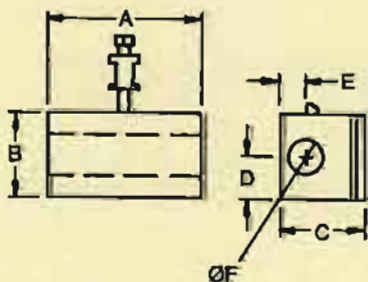
A	B	C	D	E	F	G	H	Order Code
57.5	27	27	8	13.5	11	11.5	10	S00 151T
73	38	31.5	10.3	17.5	14	17	16	S0 153T
73	44.5	31.5	16	17.5	14	23	16	S1 151T
98	49.8	40	15.3	22.4	19	23	19	S2 151T
98	57	40	14.3	28.5	19	22	19	S2 153T
124	70	47	17.5	35	22	29	25	S3 151T
147	79.4	60	19	41	25.4	29	25	S4 151T

Morse Taper Toolholders



A	B	C	D	E	MT	Order Code
73	38	31.5	19	9.4	1	S0 161T
73	44.5	31.5	22.3	9.4	1	S1 161T
95	44.5	41	22.3	15.7	2	S1 167T
98	49.8	40	25	14	2	S2 161T
111	49.8	49.8	25	18	3	S2 167T
124	70	47	35	15.5	3	S3 161T
140	70	67	35	24.3	4	S3 167T

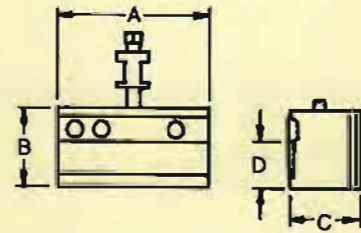
Plain Bore Toolholders



A	B	C	D	E	F	Order Code
73	44.5	47	19	19	25	S1 181T
98	50	60	25	25	32	S2 181T
124	70	76	32	34	40	S3 181T
149	82.5	95	38	39	50	S4 181T

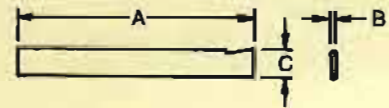
Part Off Toolholders

A	B	C	D	Order Code
57.5	27	27	16	S00 171T
73	38	31.5	25.5	S0 171T
73	44.5	31.5	27	S1 171T
98	49.8	40	33.5	S2 171T
124	70	47	39.5	S3 171T



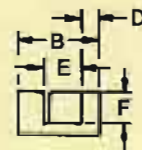
Part Off Blades

A	B	C	Used On	Order Code
127	3	13	S00 171T	B408 00
105	3	16	S0 171T	B408 01
152	3	19	S1 171T	B408 02
203	5	25	S2/3 171T	B408 03



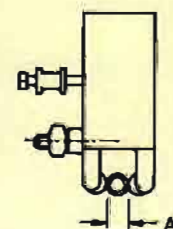
Extended Standard Toolholders

A	B	C	D	E	F	Order Code
95	44.5	31.5	11	22	14	S1 201T
124	49.8	40	12	22.3	19	S2 201T
143	70	47	17.5	35	22	S3 201T

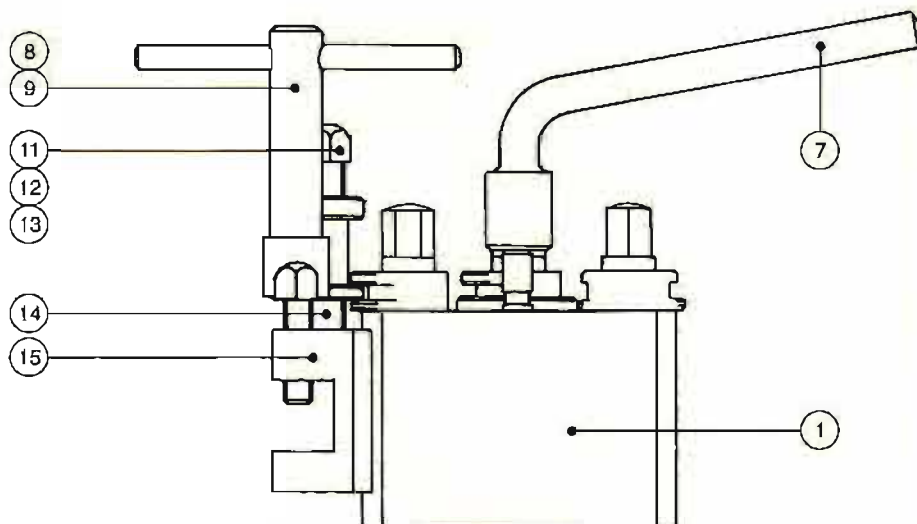
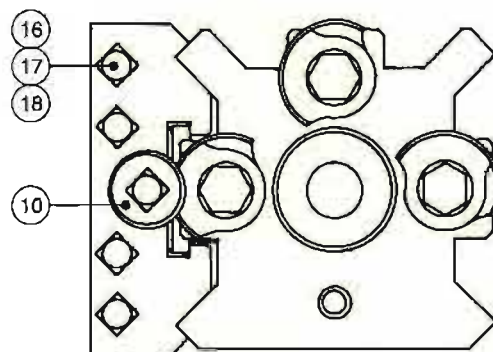
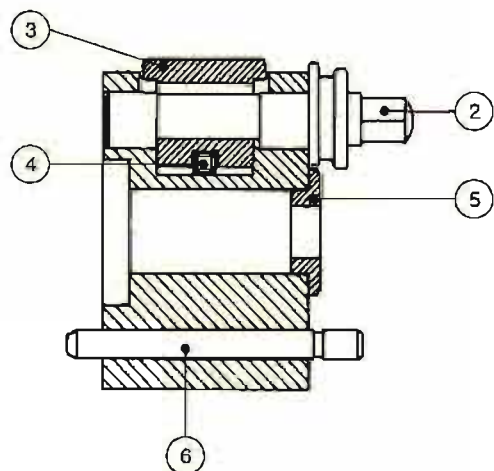


Knurling Toolholders

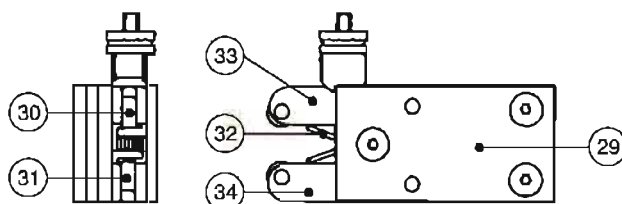
A	Order Code
32	S1 301T
38	S2 301T
44.5	S3 301T



Toolpost Assembly with Standard Toolholder



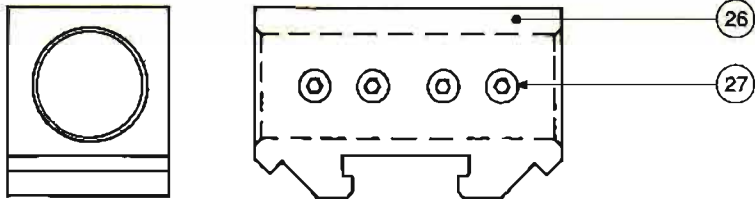
Knurling Holder



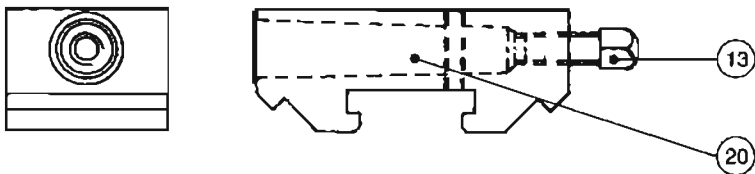
Extended Standard Toolholder



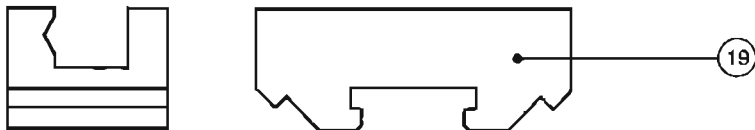
Plain Bore Holder



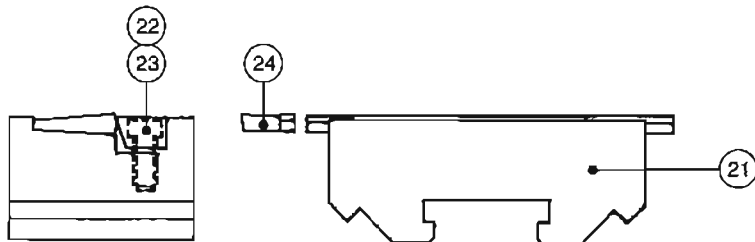
Morse Taper Holder



Boring Bar Holder



Part Off Toolholder



QUICK CHANGE TOOLPOSTS

SPARES - SHORT ORDER CODES

Key	Description	Size								
		S00	S0	S1	S1X	S2	S2T	S3	S3X	S4
1	Toolpost Body	S00 00	S0 07	S1 01	S1 03	S2 00	S2 02	S3 01	S3 19	S4 00
2	Clamp Bolt	S00 10	S1 10	S1 10	S1 10	S2 10	S2 11	S3 10	S3 10	S4 10
3	Clamp Pad	S00 15	S1 15	S1 15	S1 15	S2 15	S2 16	S3 15	S3 15	S4 15
4	Compression Spring	B210 00	B210 01	B210 01	B210 01	B210 02	B210 02	B210 03	B210 03	B210 04
5	Flange Washer	S00 20	S0 20	S1 20	S1 20	S2 20	S2 20	S3 21	S3 21	S4 20
6	Location Pin	-	S1 26	S1 26	S1 28	S2 25	S2 25	S3 26	S3 28	S4 25
7	Hexagon Wrench	S00 30	S1 30	S1 30	S1 30	S2 30	S2 30	S3 30	S3 30	S4 30
8	Square Key	-	-	S1 71	S1 71	S2 71	S2 71	S3 71	S3 71	S4 71
9	Allen Key	B403 1001	B403 1001	-	-	-	-	-	-	-
10	Stop	S00 101	S0 101	S1 101	S1 101	S2 101	S2 101	S3 101	S3 101	S4 101
11	Socket Set Screw (Stop)	-	B162 2051	-	-	-	-	-	-	-
12	Socket Head Cap Screw (Stop)	B163 3002	-	-	-	-	-	-	-	-
13	Square Head Cap Screw (Stop)	-	-	B165 00	B165 00	B165 01	B165 01	B165 02	B165 02	B165 04
14	Stud	B162 2001	B162 2052	B111 111	B111 111	B112 111	B112 111	B113 111	B113 111	B114 111
15	Standard Toolholder	S00 141	S0 143	S1 141	S1 141	S2 141	S2 143	S3 141	S3 141	S4 143
16	Socket Set Screw (Tool Screw)	-	B162 2050	-	-	-	-	-	-	-
17	Socket Head Cap Screw (Tool Screw)	B163 3001	-	-	-	-	-	-	-	-
18	Square Head Screw (Tool Screw)	-	-	B165 00	B165 00	B165 01	B165 01	B165 02	B165 02	B165 04
19	Boring Bar Holder	S00 151	S0 153	S1 151	S1 151	S2 151	S2 153	S3 151	S3 151	S4 151
20	Morse Taper Holder	-	S0 161	S1 161	S1 161	S2 161	S2 161	S3 161	S3 161	S4 161
21	Part Off Tool Holder	S00 171	S0 171	S1 171	S1 171	S2 171	S2 171	S3 171	S3 171	-
22	Clamping Strip (Part-off Blade)	S00 175	S1 174	S1 174	S1 174	S2 174	S2 174	S3 174	S3 174	-
23	Socket Head Cap Screw	B163 3059	B163 3003	B163 3003	B163 3003	B163 3010	B163 3010	B163 3010	B163 3010	-
24	Part Off Blade	B408 00	B408 01	B408 02	B408 02	B408 03	B408 03	B408 03	B408 03	-
25	Extended Morse Taper Holder	-	-	S1 167	S1 167	S2 167	S2 167	S3 167	S3 167	-
26	Plain Bore Holder	-	-	S1 181	S1 181	S2 181	S2 181	S3 181	S3 181	S4 181
27	Socket Screw Set	-	-	B162 2051	B162 2051	B162 2070	B162 2070	B162 2054	B162 2054	B162 2061
28	Extended Standard Toolholder	-	-	S1 201	S1 201	S2 201	S2 203	S3 201	S3 201	-
29	Knurling Holder	-	-	S1 301	S1 301	S2 301	S2 301	S3 301	S3 301	-
30	Knurl (r/h)	-	-	B409 00	B409 00	B409 00	B409 00	B409 00	B409 00	-
31	Knurl (l/h)	-	-	B409 01	B409 01	B409 01	B409 01	B409 01	B409 01	-
32	Torsion Spring	-	-	D111 370	D111 370	D111 370	D111 370	D111 370	D111 370	-
33	Upper Arm	-	-	S1 320	S1 320	S2 320	S2 320	S3 320	S3 320	-
34	Lower Arm	-	-	S1 330	S1 330	S2 330	S2 330	S3 330	S3 330	-

Part Numbers Consisting of the Following

S00 Sets

Part Numbers	S100D0007	S100D0012	
A100D0000	1	1	Body Assembly
D100D0021	1	1	Flange Washer
D100D0030	1	1	Hex Wrench 8mm AF
B403D1001	1	1	Allen Key 4mm AF
T100D0141	2	2	Standard Toolholder
T100D0151	1	-	Boring Bar Holder

S0 Sets

Part Numbers	S110D0015	
A110D0007	1	Body Assembly
D111D0020	1	Flange Washer
D111D0030	1	Hex Wrench 3/8 AF
B403D1001	1	Allen Key 4mm AF
D111D0035	1	Location Ring
T110D0143	2	Standard Toolholder

S1 Sets

Part Numbers	S111D0009	S111D0003	S111D0001	
A111D0001	1	1	1	Body Assembly
A111D0071	1	1	1	Square Key 8mm AF
D111D0020	1	1	1	Flange Washer
D111D0030	1	1	1	Hex Wrench 3/8 AF
T111D0141	4	3	4	Standard Toolholder
T111D0151	-	-	1	Boring Bar Holder
T111D0161	-	-	1	Morse Taper Holder 1MT
T111D0181	1	-	-	Plain Bore Holder Ø25mm

S1X Sets

Part Numbers	S111D0013	S111D0011	
A111D0003	1	1	Body Assembly
A111D0071	1	1	Square Key 8mm AF
D111D0020	1	1	Flange Washer
D111D0030	1	1	Hex Wrench 3/8 AF
T111D0141	4	4	Standard Toolholder
T111D0151	-	1	Boring Bar Holder
T111D0161	-	1	Morse Taper Holder 1MT
T111D0181	1	-	Plain Bore Holder Ø25mm

S2 Sets

Part Numbers	S112D0021	S112D0003	S112D0001	
A112D0000	1	1	1	Body Assembly
A112D0071	1	1	1	Square Key 10mm AF
D112D0020	1	1	1	Flange Washer
D112D0030	1	1	1	Hex Wrench 9/16 AF
T112D0141	4	3	4	Standard Toolholder
T112D0151	-	-	1	Boring Bar Holder
T112D0161	-	-	1	Morse Taper Holder 2MT
T112D0181	1	-	-	Plain Bore Holder Ø32mm

Part Numbers Consisting of the Following

S2T Sets

Part Numbers	S112D0023	S112D0011	S112D0007	
A112D0002	1	1	1	Body Assembly
A112D0071	1	1	1	Square Key 10mm AF
D112D0020	1	1	1	Flange Washer
D112D0030	1	1	1	Hex Wrench 9/16 AF
T112D0143	4	4	3	Standard Toolholder
T112D0153	-	1	-	Boring Bar Holder
T112D0161	-	1	-	Morse Taper Holder 2MT
T112D0181	1	-	-	Plain Bore Holder Ø32mm

S3 Sets

Part Numbers	S113D0031	S113D0009	S113D0001	
A113SK580	1	-	-	Body Assembly
A113D0001	-	1	1	Body Assembly
A113D0071	1	1	1	Square Key 13mm AF
B166D0012	1	-	-	Hex Head Centre Bolt M20
D113D0020	1	-	1	Washer Ø15/16
D113D0021	-	1	-	Washer Ø11/16
D113D0030	1	1	1	Hex Wrench 11/16 AF
T113D0141	4	4	4	Standard Toolholder
T113D0151	-	1	1	Boring Bar Holder
T113D0161	-	1	1	Morse Taper Holder 3MT
T113D0181	1	-	-	Plain Bore Holder Ø40mm

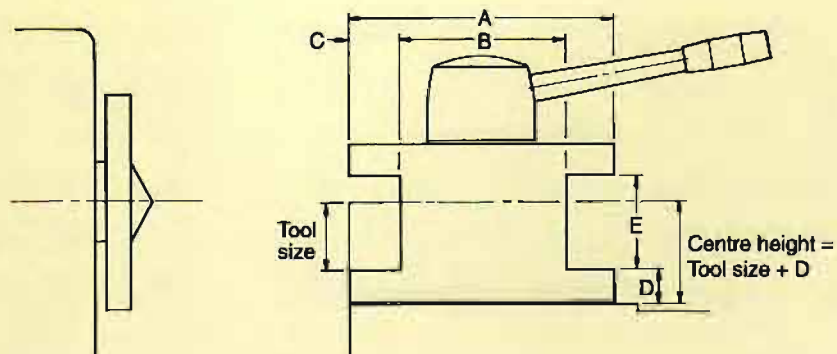
S3X Sets

Part Numbers	S113SK584	S113D0019	S113D0015	
A113D0019	-	1	1	Body assembly
A113SK584	1	-	-	Body Assembly
A113D0071	1	1	1	Square Key 13mm AF
B166D0013	1	-	-	Hex Head Centre Bolt M24
D113D0020	-	1	-	Washer Ø15/16
D113D0021	-	-	1	Washer Ø11/16
D113D0022	1	-	-	Washer Ø24mm
D113D0030	1	1	1	Hex Wrench 11/16 AF
T113D0141	4	4	4	Standard Toolholder
T113D0151	1	1	1	Boring Bar Holder
T113D0161	1	1	1	Morse Taper Holder 3MT

S4 Sets

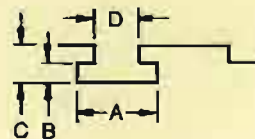
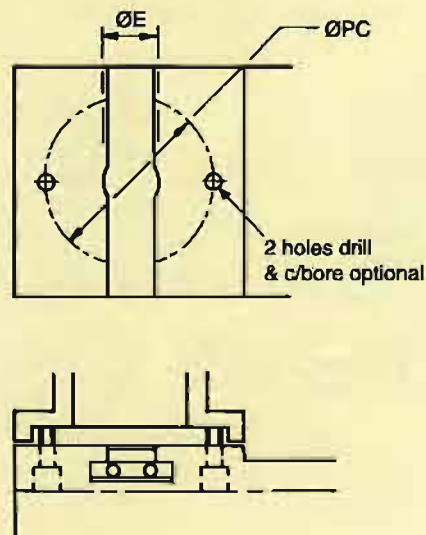
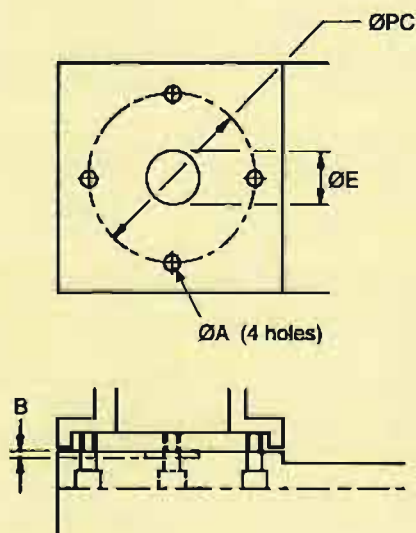
Part Numbers	S114D0013	S114D0009	
A114D0000	1	1	Body Assembly
A114D0071	1	1	Square Key 13mm AF
D114D0020	1	1	Flange Washer
D114D0030	1	1	Hex Wrench 20mm AF
T114D0143	4	4	Standard Toolholder
T114D0151	1	-	Boring Bar Holder
T114D0181	-	1	Plain Bore Holder Ø50mm

CAPACITY DATA



Turret	A	B	C	D	E
T1	96	62	17	22.25	32
T2	114	76	19	20.50	38
T3	125	81	22	21.50	50
T3X	125	81	22	33.00	50
T4	143	98	22.5	24.50	47.6
T4E	176	131	22.5	24.50	47.6
T4X	143	98	22.5	34.85	47.6

FITTING METHODS

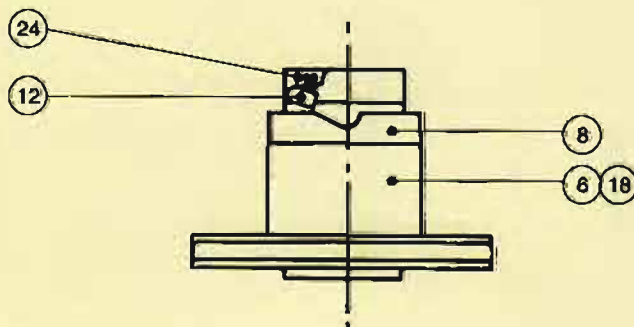
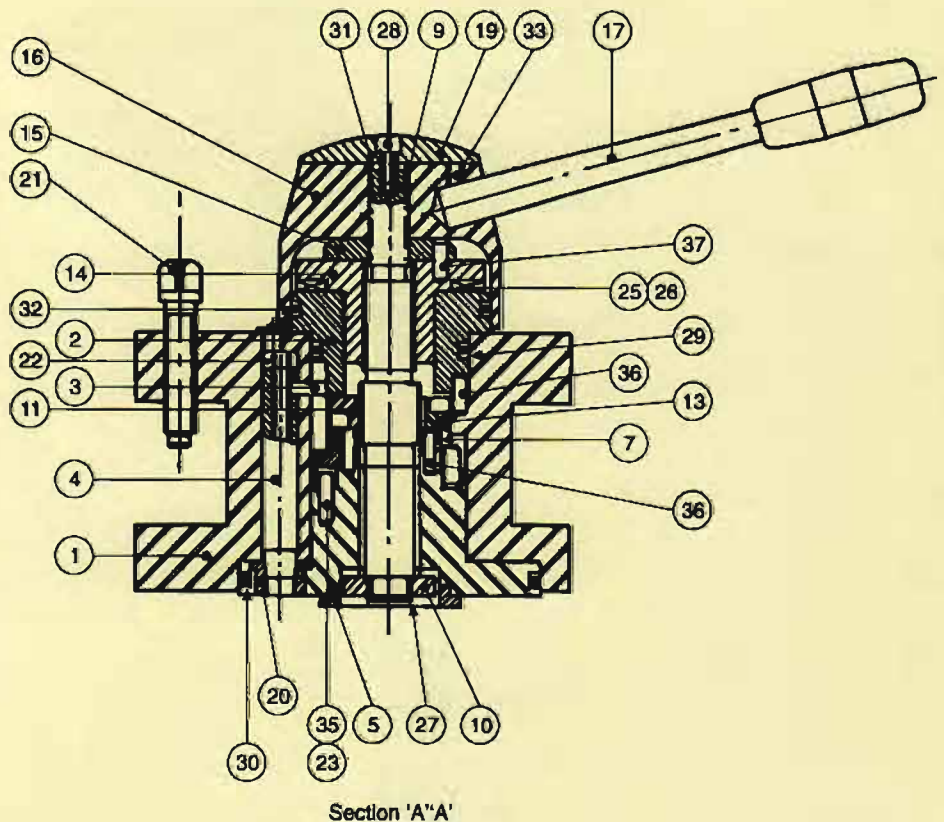
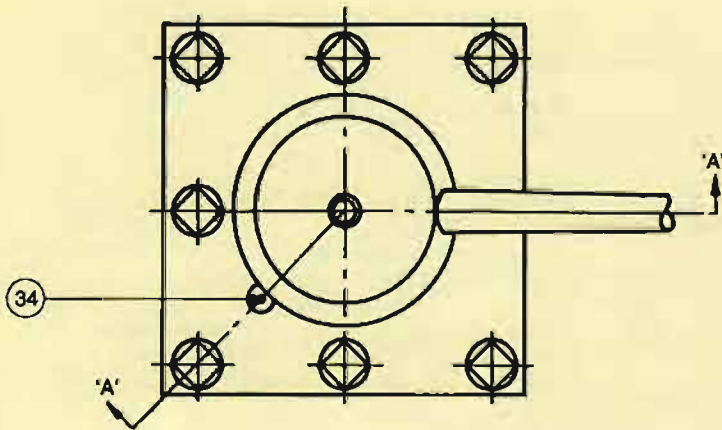


METHOD OF FITTING TO SOLID TOPSIDE

Turret	ØA	B	ØE	ØPC
T1	11/32	3/16	1.750	2.500
T2	11mm	3/16	1.750	3.000
T3	11mm	3/16	1.750	3.000
T4E	11mm	3/16	2.000	3.500

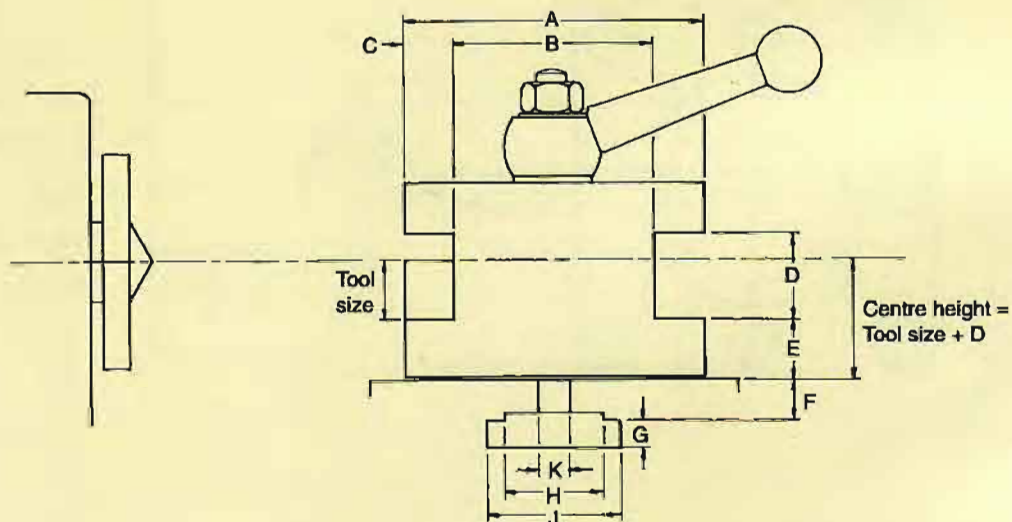
METHOD OF FITTING TO TEE SLOTTED TOPSIDE

Turret	A	B	C	D	ØE	ØPC
T1	1.906	0.406	0.843	1.406	1.750	2.500
T2	1.032	0.406	0.906	1.531	1.750	3.000
T3	2.187	0.406	0.906	1.531	1.695	3.000
T4E	2.312	0.406	1.032	1.781	2.000	3.500



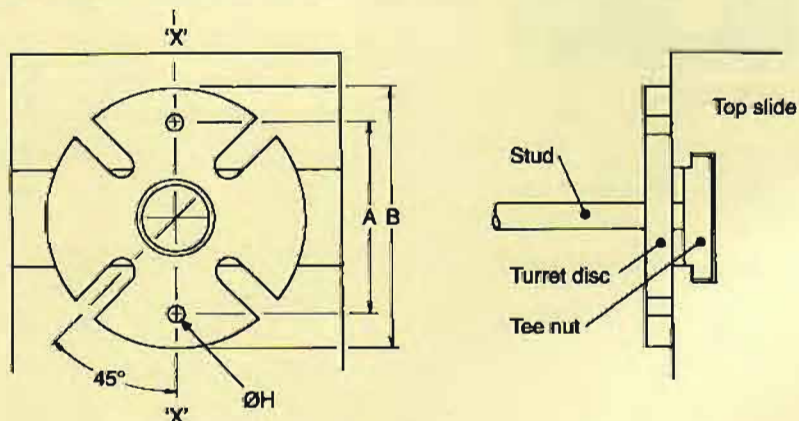
Item	Description	Qty
1	Turret Body	1
2	Index Ring	1
3	Index Release Pin	1
4	Index Location Pin	1
5	Spigot Bush	1
6	Spigot	1
7	Pawl Release Ring	1
8	Cam Ring	1
9	Shaft	1
10	Stop	1
11	Pawl Ring	1
12	Pawl	2
13	Upper Pawl Carrier	1
14	Clamp Bush	1
15	Tension Disc	1
16	Cap	1
17	Handle	1
18	Stop Screw	1
19	Top Disc	1
20	Location Pin Bush	4
21	Tool Clamp Screw	8
22	Spring (Index Pin)	1
23	Spring (Cam Ring)	1
24	Spring (Pawl)	1
25	Needle Thrust Bearing	1
26	Bearing Plate	1
27	Circlip	1
28	Socket Head Cap Screw	1
29	'O' Ring (Index Ring Lower)	1
30	'O' Ring (Spigot)	1
31	'O' Ring (Index Ring)	1
32	'O' Ring (Cap)	1
33	Socket Set Screw	1
34	Springwell Oiler	1
35	Spring Dowel (Spigot)	2
36	Spring Dowel (Index Ring)	4
37	Spring Dowel (Clamp Bush Cam Ring)	2
38	Spring Dowel (Pawl Release Ring)	3

CAPACITY DATA

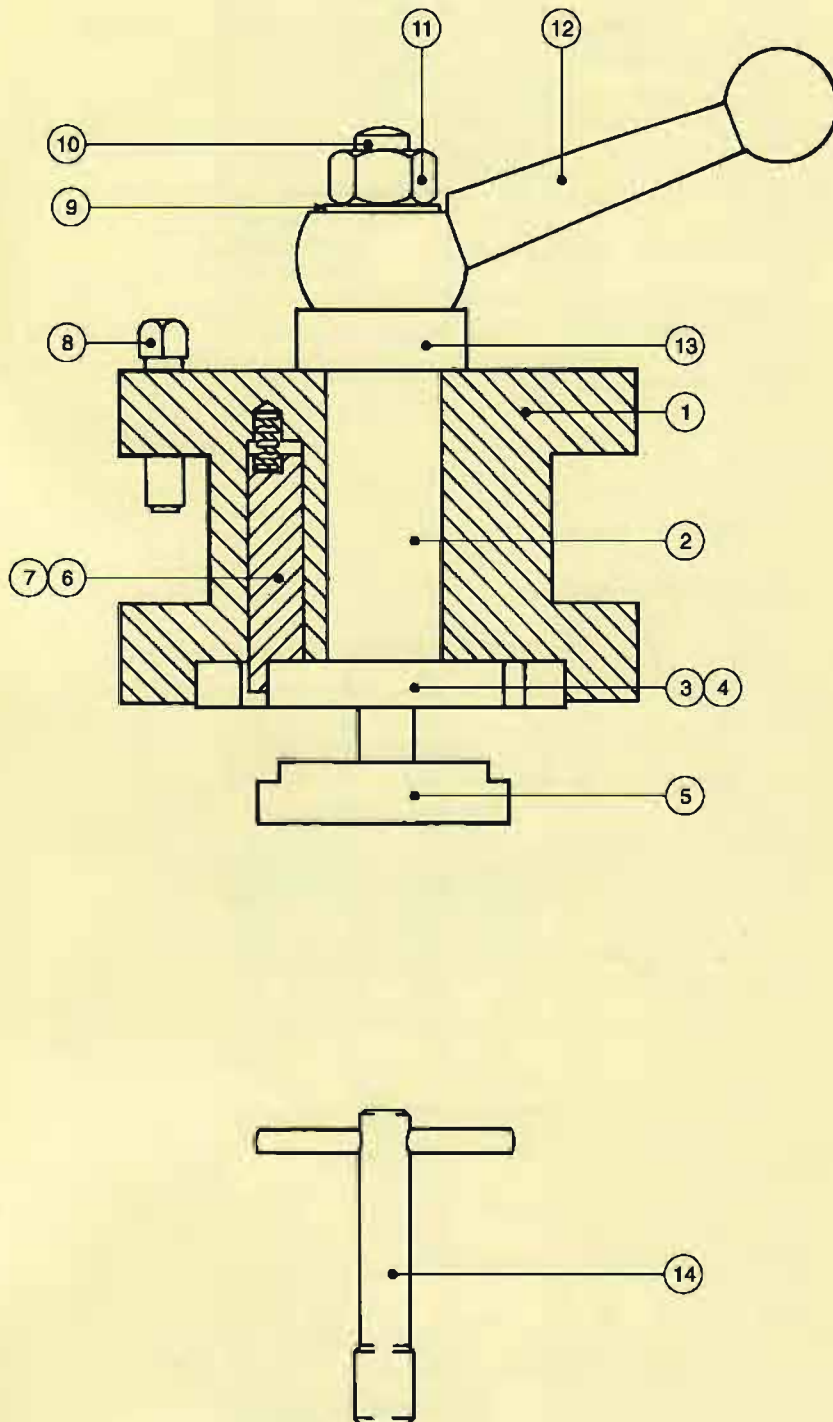


Turret	A	B	C	D	E	F Max	G	H	J	K
*0239	75	50.8	12.1	11.65	20	11.2	7	11.7	18	M10
0450	114	76	19	22	32	16	8	35	48	1/2 UNF
0600	152	108	22	25.5	47.5	20	9.6	44.5	57	5/8 UNF
0675	171	127	22	24.5	47.5	20	9.6	44.5	57	5/8 UNF
1450	114	76	19	20.4	35	16	9.6	38.1	50.8	1/2 UNF
1600	152	108	22	34.9	47.5	20	9.6	44.5	57	5/8 UNF

FITTING METHODS

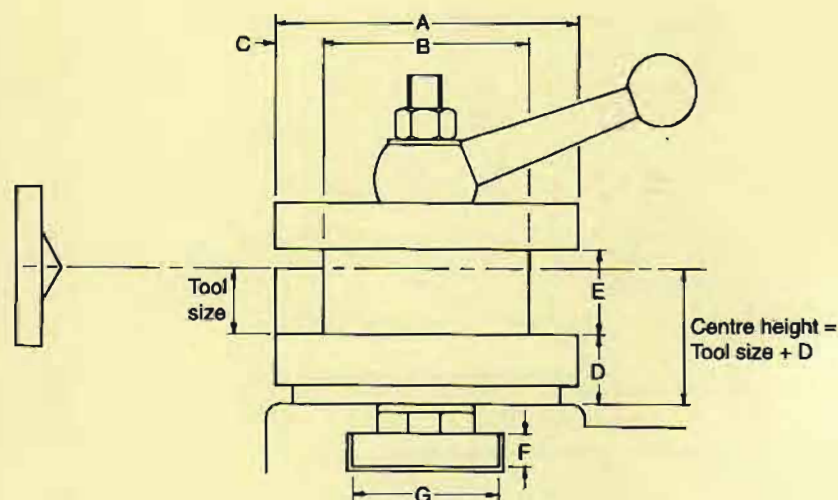


Turret	A	B	ØH
0239	63.5	50.8	6
0450	81	63.5	8
0600	117.5	88.9	8
0675	117.5	88.9	8
1450	95	76.2	8
1600	117.5	88.9	8



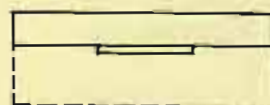
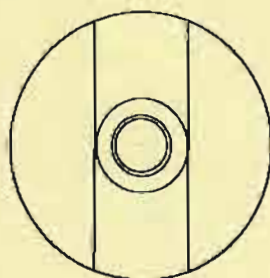
Item	Description	Qty
1	Turret Body	1
2	Spindle	1
3	Turret Disk	1
4	Spring Dowels	2
5	Tee Nut	1
6	Location Pin	1
7	Spring	1
8	Tool Screw	12
9	Washer	1
10	Stud	1
11	Nut	1
12	Handle	1
13	Spacer	1
14	Square Key	1

CAPACITY DATA



Turret	A	B	C	D Min	D Max	E	F	G
250	63.5	44.5	9.5	13	24	11	6.35	38
350	89	66	13	14.5	33.5	16	12.7	51
352	89	66	14	16	32	26	12.7	51
450	114	76	17.5	17.5	36.5	22	12.7	57
452	114	76	17.5	19	35	32.5	12.7	57
454	114	76	18.5	20.5	38	39.5	12.7	57
600	152	114	18	22	38	32.5	16	76
650	165	120.5	22	25.5	43	43	16	76
700	178	127	25.5	28.5	52.5	51.5	16	89
800	203	146	28.5	35	51	58	25.5	95

FITTING METHODS



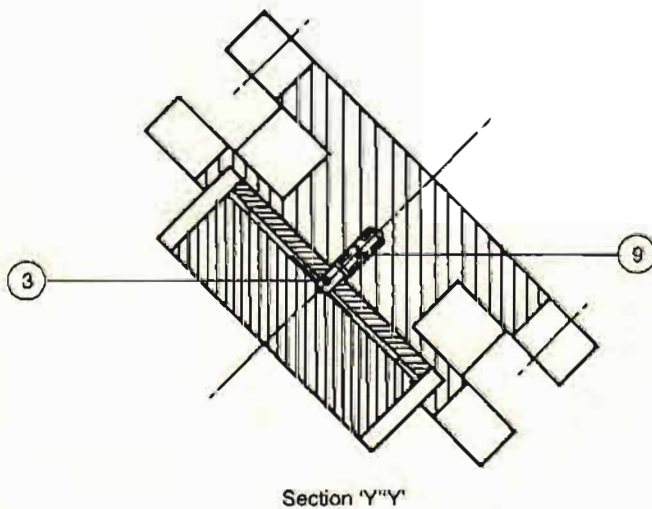
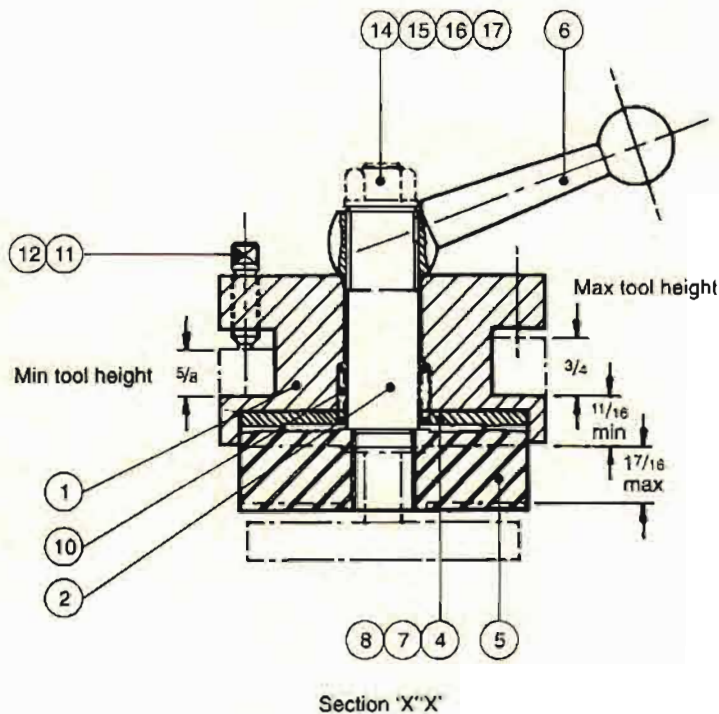
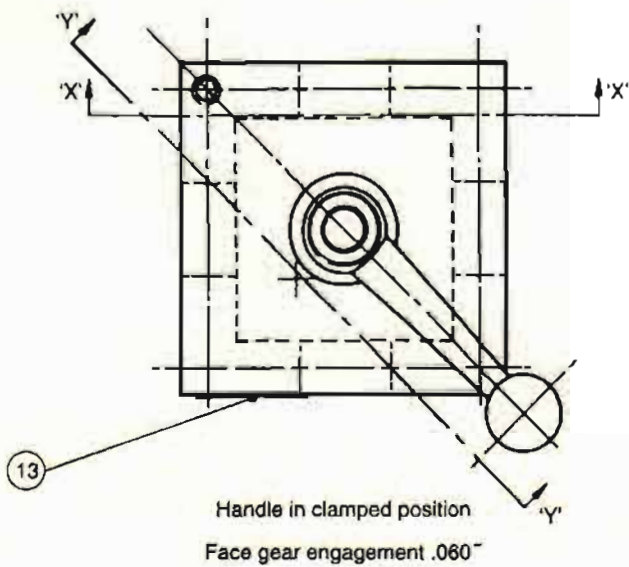
Machine lower ring to suit machine



This range of turrets is supplied ready to be modified to suit your particular lathe.

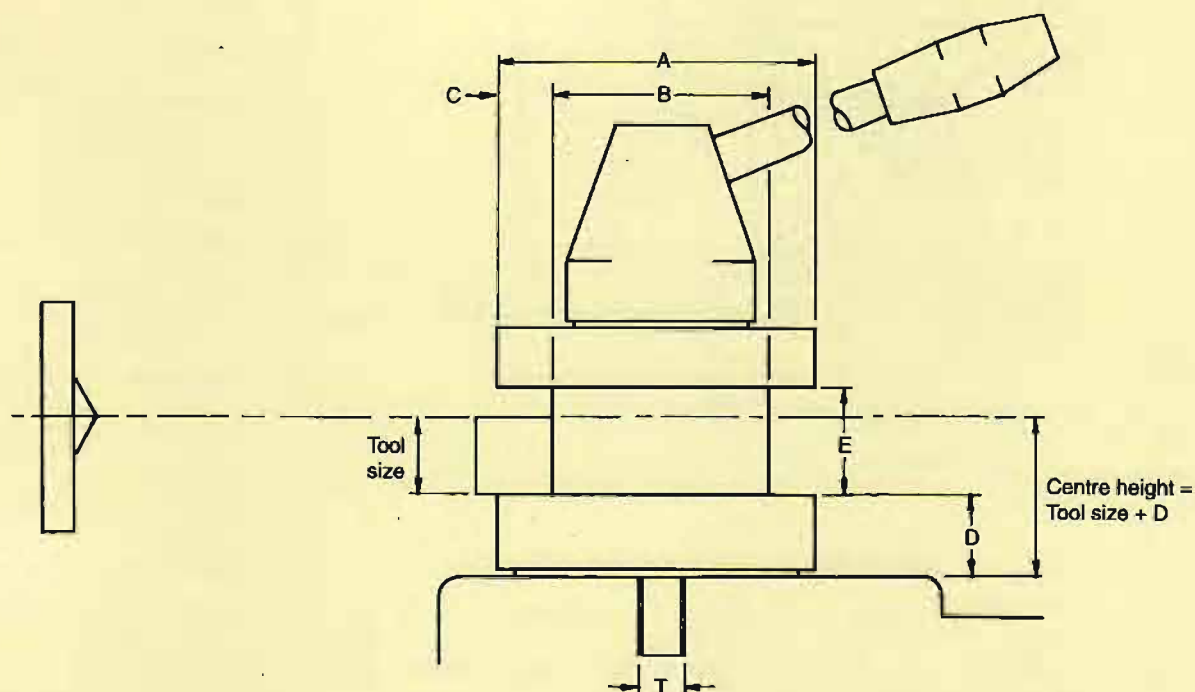
You will need to know the size of toolbit to be used and the centre height of your machine, as measured from the mounting face (see set up arrangement).

The geared face of the lower ring is induction hardened, leaving the remaining part of the ring soft for machining. (See capacity data for machining limits.)



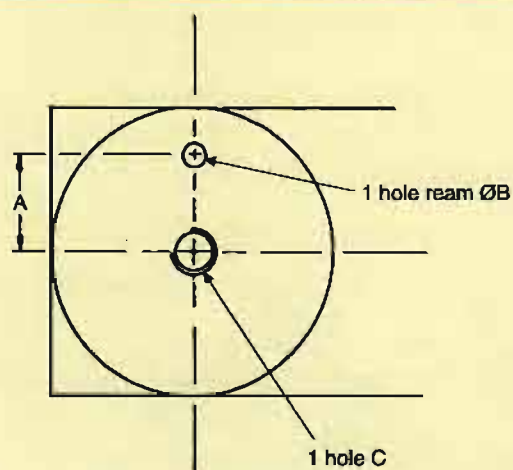
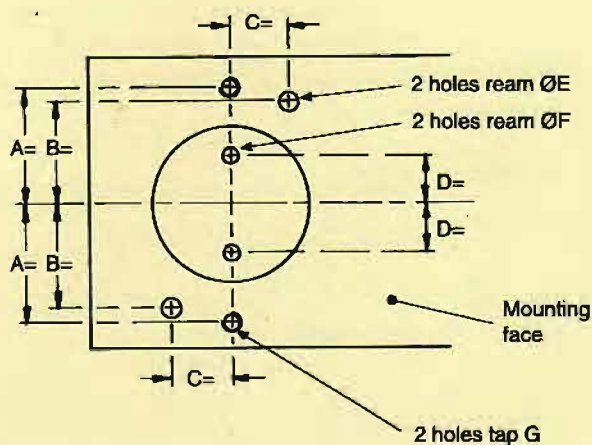
Item	Description	Qty
1	Turret Body	1
2	Spindle	1
3	Index Pin	1
4	Upper Index Ring	1
5	Lower Index Ring	1
6	Handle	1
7	Spring Dowel	2
8	Button Head Screw	3
9	Index Spring	1
10	Main Spring	1
11	Tool Screw	12
12	Square Key	1
13	Label	1
14	Washer	1
15	Nut	1
16	Snid	1
17	Tee Nut	1

CAPACITY DATA



Turret	A	B	C	D	E	T
T.O.H.M.	86	57	14	18.8	30	M12x1.75
T.O.H.X.	86	57	14	27	30	M12x1.75

FITTING METHODS

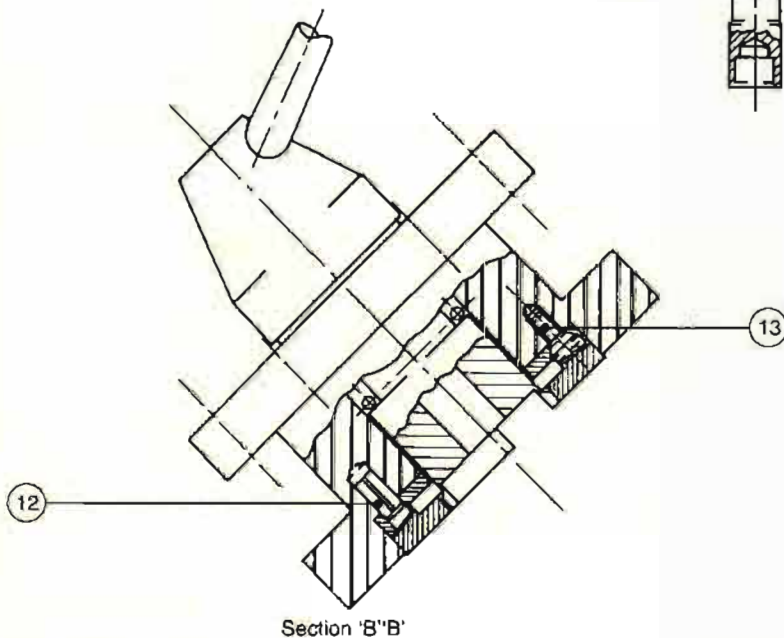
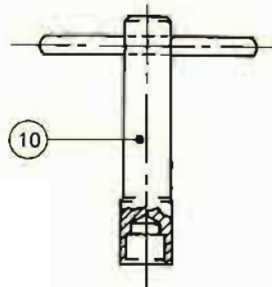
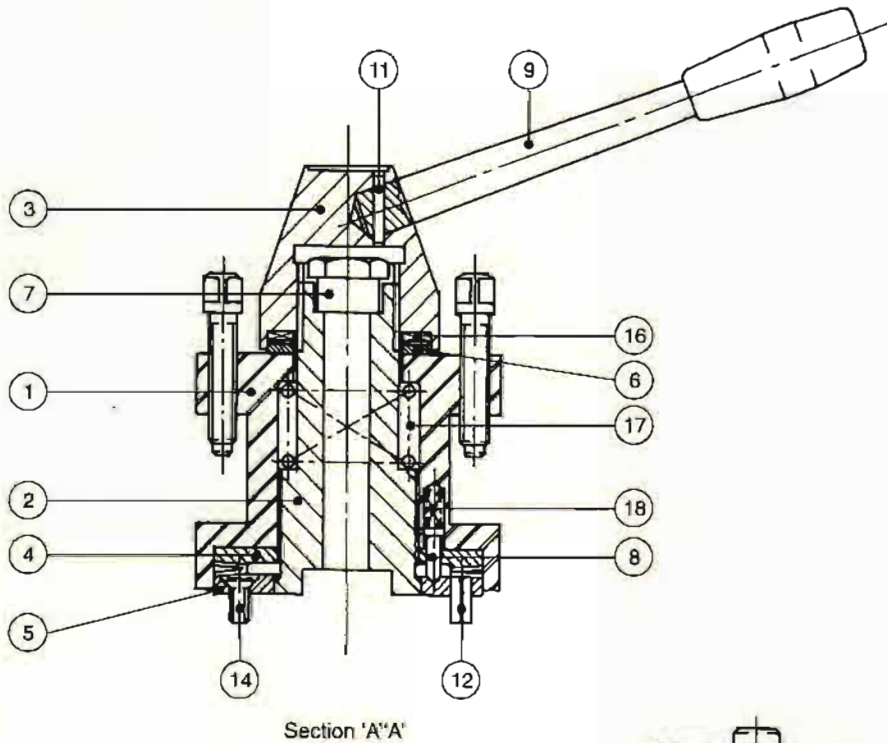
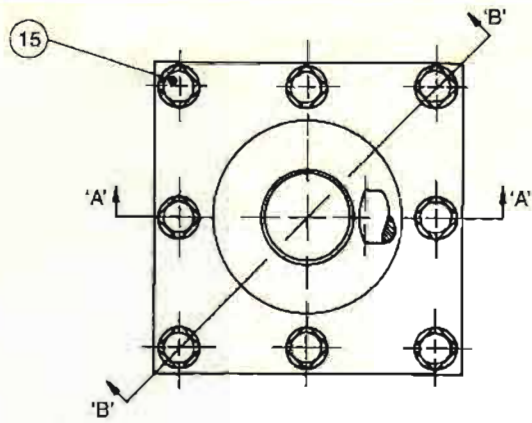


METHOD OF FITTING T.O.H.M. TURRET

Turret	A	B	C	D	$\varnothing E$	$\varnothing F$	G
T.O.H.M.	30.48	27	15.6	12.7	6.35	4.76	10.24 UNC

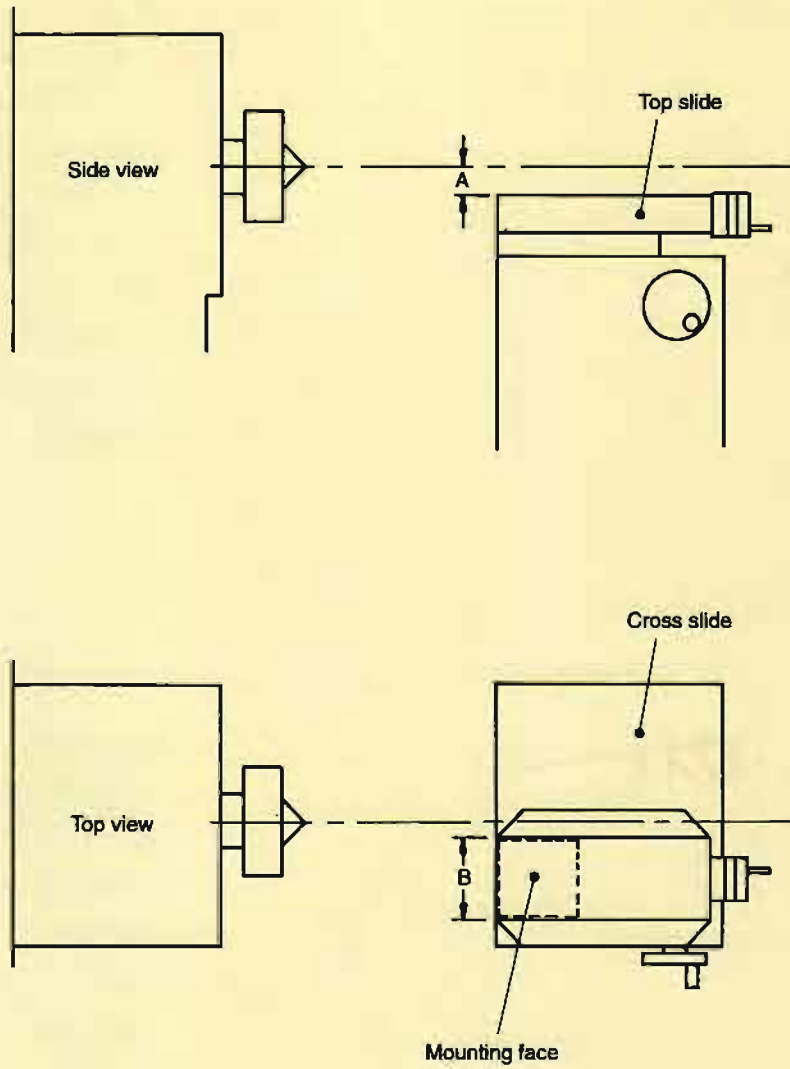
METHOD OF FITTING T.O.H.X. TURRET

Turret	A	$\varnothing B$	C
T.O.H.X.	25.4	6.35	M12



Item	Description	Qty
1	Turret Body	1
2	Spigot	1
3	Cap	1
4	Upper Index Ring	1
5	Lower Index Ring	1
6	Pressure Pad	1
7	Lock Nut	1
8	Index Pin	1
9	Handle	1
10	Square Key	1
11	Spring Dowel	1
12	Spring Dowel	2
13	Socket Head C/Sunk Screw	3
14	Socket Head C/Sunk Screw	2
15	Tool Screw	8
16	Needle Thrust Bearing	1
17	Main Spring	1
18	Index Spring	1

DESIGN DRAWING SK810



DESIGN DATA

Manufacturer:

Model:

Year of Manufacture:

Dimension A:

Dimension B:

Swing-over Bed:

Swing-over Cross Slide:

Centres:

Height:

Motor Power (HP or KW):

Give details of any holes, bosses, recesses, protrusions or tee slots etc on/in mounting face: