

CONVENTIONAL LATHE MERLI MOD.CLOVIS 28 HEIGHT CENTER MM. 450-DISTANCE CENTER MM. 2000



HEADSTOCK

The headstock is provided with variable speed gear whose gears are of hardened and ground Cr-Ni-Mo steel. All teeth are accurately ground and strictly tested for their contour of contour and a perfect coupling of flanks is guaranteed with total noise elimination. The driving gears transmit their movement to the spindle through a pair of helical gears which permits, besides a gradual transmission, absolute reliability for the most heavy duty cutting operations. The 16 spindle speeds are selected by shifting the gears on the splined shafts by means of centralized controls. These splined shafts are also made of hardened and ground Cr- Ni-Mo steel and they are mounted on ball bearings and opposed and adjustable taper roller bearings. Engagement and disengagement of the spindle rotation is performed by a double clutch and electromagnetic brake. All members are force feed lubricated by means of a driven pump. The spindle is made of special hardened and ground steel. Hole through-spindle is 4 1/6" dia mm and the spindle is provided with a Camlock 8" nose (optionally, an ASA A2 8" nose). The spindle is mounted on special Gamet high precision bearings. A special device multiplies the threading and feeding ratio by 8.

SLIDES

The generously dimensioned slides are made of high quality cast iron in order to ensure absolute stability and high working accuracy. The feed screws are mounted on thrust bearings. The nuts of the cross slide and of the tool – holder have external adjustment for compensating backlash which inevitably builds up after a long period of use. Taper gibs are provided for adjusting play between the cross slide and saddle. The compound rest can swivel through 360° and its clear graduation permits accurate setting of any angle with respect to the center line of the lathe or to the perpendicular of this line. The ground cross slide is provided with T - slots for clamping a second tool post for large series production. Large verniers with high precision graduations allow traverses to an accuracy of .00039 inch.

APRON

The apron comprises a single casting to ensure maximum stability. All its members are oil-bath lubricated, guaranteeing long working life and silent operation. A special pump is provided for bed and slide guideways lubrication. Selection of longitudinal and cross feed is performed by a double multi-disk clutch, externally adjustable; this clutch ensures maximum smoothness and reliability of feeds. In this system, automatic stopping of feeds is ensured within an accuracy of .00039 inch. A special device guarantees perfect independence of the lead screw and feed rod engagement.

NORTON BOX

The Norton box is of the very latest universal type. The totally enclosed high strength steel gears and splined shafts run in oil bath and allow the easy selection of Whitworth, Metric, Module or Diametral pitch threads without the necessity of changing gears. The number and value of feeds is rationally stepped.

BED

The bed is provided with double V-ways, the main guideway being of Leblond profile. It is dimensioned for great rigidity and ruggedness and is made of highly alloyed, normalized and aged cast iron. The large size guideways are induction hardened and precision ground.

TECHNICAL CHARACTERISTICS

CAPACITY

• height center	mm.	450
• max turning diameter on the guides of the bed	mm.	900
• max turning diameter over cross slide	mm.	675
• max turning diameter on the gap	mm.	1180
• length in front of the platform	mm.	350
• bed width	mm.	450

SPINDLE

• spindle hole diameter	mm.	105
• front spindle bearing inside diameter	mm.	127
• front spindle bearing outside diameter	mm.	215,9
• spindle taper	C.M.	5
• spindle nose	Cam-Lock	8"
• number of speeds	n°	16
• spindle speed	rpm	14-1010
• spindle motor	HP	15

TAILSTOCK

• quill diameter	mm.	85
• tailstock quill inside taper	C.M.	5
• quill travel	mm.	250

FEEDS

• number of automatic feeds	n°	70
• longitudinal feed range	mm.	0,04÷4,8
• cross feed range	mm.	0,02÷2,4

THREADS

• diameter lead screw	mm.	40
• whitworth threads number	n°	70
• whitworth threads range	fx1"	½÷56
• metric threads number	n°	64
• metric threads range	mm.	0,5÷56

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• diametral pitch threads number	n°	60
• diametral pitch threads range	D.P.	2÷112
• modul threads number	n°	45
• modul threads range	M	0,25÷14

GENERAL DATA

• floor space	mm.	4055x1360
• height machine	mm.	1790
• weight machine	Kg.	6000

STANDARD ACCESSORIES

- Coolant system
- Self-centering chuck with 3 guides
- Steady rest
- Rapid feeds on the longitudinal axis
- Tool turret with tool holder
- Operator and maintenance manuals
- Follow rest
- Digital Readouts 2 axis