SCREW-OPERATED CARRIAGE 70-45

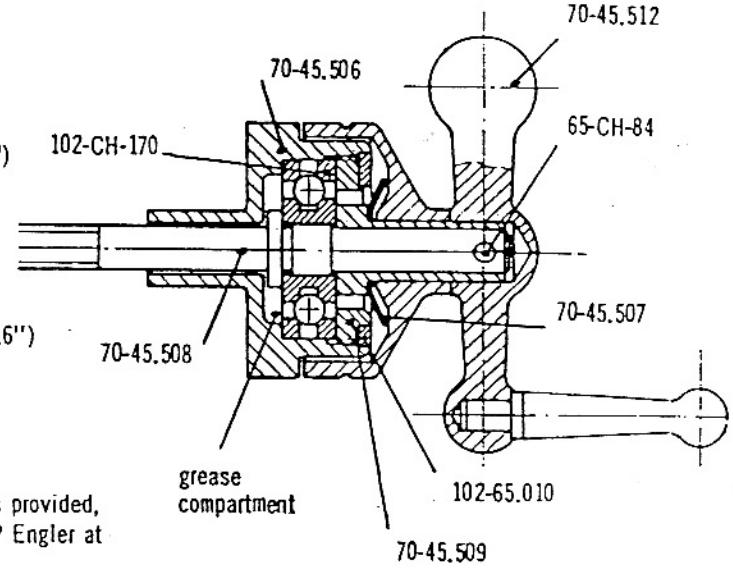
for SCHAUBLIN 70 high-precision lathe
(suitable also for Schaublin 65 lathe with special toolpost)

ADVANTAGES

1. Great rigidity and high precision
2. Fully protected slideways with forced-feed lubrification (cleaning action)
3. Micrometer screws supported at both ends; special patented ball bearing at handle end for taking up axial and radial play
4. Patented device for rapid and accurate resetting of swivel base to zero
5. Dovetail on bottom slide for taking and adjustable rear toolholder
6. Harmonious lines and superior finish

SPECIFICATION

Longitudinal stroke	60 mm (2 3/8")
Transverse stroke	65 mm (2 9/16")
Accuracy of reading of adjustments	1/100 mm (1/1000")
Top slide swivelling	2 x 90°
Height of centre above carriage	16 mm (5/8")
Swing over carriage	
without rear toolholder	85 mm (3 3/8")
with rear toolholder	45 mm (1 3/4")
Size of tools	8 x 8 mm (5/16x5/16")
Net weight	3.4 kg (7.500 lbs.)



LUBRICATION

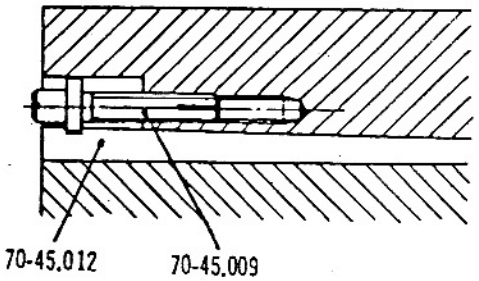
SLIDEWAYS, MICROMETER SCREWS AND NUTS

Give 4 or 5 shots twice a week through the two nipples provided, using a good light mineral oil with a viscosity of 3° Engler at 50° C.

BALL BEARING OF MICROMETER SCREWS

Use a good consistent ball-bearing grease and renew it every 5 years, proceeding as follows :

1. Drive out the taper pin 65-CH-84
2. Withdraw the handle 70-45.512 and the divided drum 70-45.506.
3. Remove the cup spring 70-45.507 and the Seeger clip 102-65.010 and completely unscrew the nut 70-45.509.
4. Remove the ball-bearing ring 102-CH-170 and slightly slacken the screw 70-45.508 in order to be able to fill the compartment with grease. Pack the ball bearing also with grease.



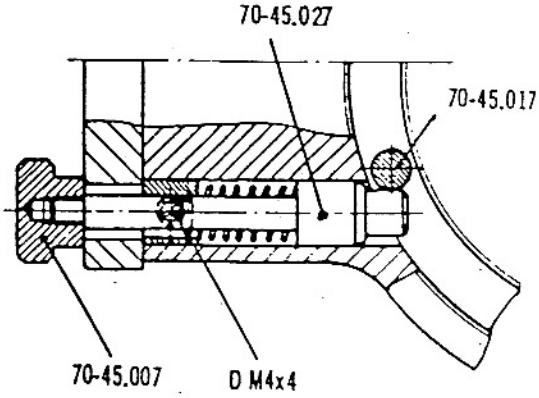
ADJUSTMENTS

BALL BEARING OF MICROMETER SCREWS

1. Drive out the taper pin 65-CH-84.
2. Withdraw the handle 70-45.512 and the divided drum 70-45.506.
3. Remove the Seeger clip 102-65.010 and tighten the nut 70-45.509 according to the amount of play to be taken up.

PLAY IN SLIDES

A taper gib 70-45.012 is fitted to each of the slides. Play caused by wear in the slideways can be taken up by tightening the adjusting screw 70-45.009 as required.



DEVICE FOR RESETTING SWIVEL BASE TO ZERO

1. Fix the carriage securely in correct position on the bed.
2. With the aid of a dial indicator, position the top slide exactly at 90°.
3. Unlock the screw D M4 x 4.
4. Turn the knurled knob 70-45.007 until the end of the rod 70-45.027 is resting against the stop 70-45.017 and then retighten the screw D M4 x 4 securely.