

Quick Change Feed Gearbox

The Feed Gear Box of the COMMADOR combines in one unit the gearing and switching elements for longitudinal and transverse movements and for cutting of threads.

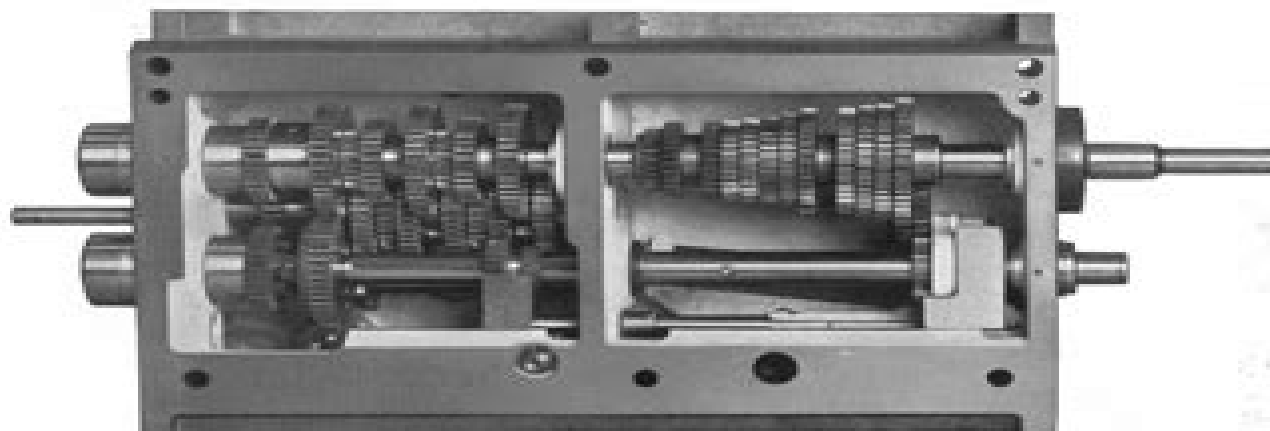
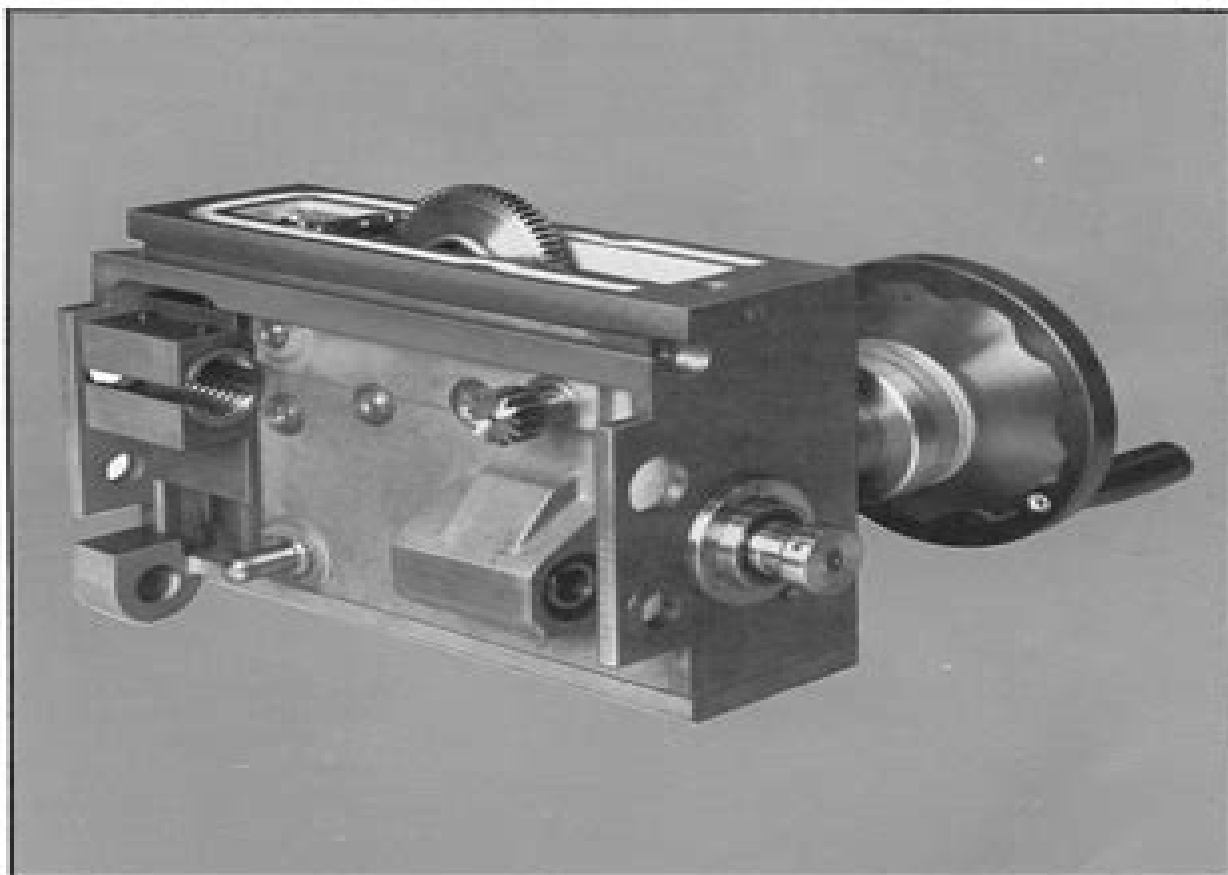
The working process is as follows:
The drive from the feedbox is transmitted via the feed shaft to the apron and transferred to a trip worm. The pressure of the trip worm is adjustable, which allows the turning against the fixed stop in longitudinal or transverse direction. In the case of an overload condition the feed motion is disconnected. The selection of longitudinal and transverse movement is made by means of a push-pull knob. A second lever is used to engage the half nuts onto the leadscrew for screw-cutting. The nuts have a long thread mesh, and are designed as exchangeable bronze shells, automatically lubricated whilst in the engaged position.

The carriage hand-wheel has a large diameter friction grip graduated dial for length travel measurement.

All the shafts and gears are manufactured from heat treated steel, and are lubricated by an oil bath.

All the selection levers are provided with safety inter-locking devices to prevent a double engagement i.e. feeding and screw-cutting.

The drive from the main spindle is transmitted to the totally enclosed feed gear box via fixed gearing in the headstock, and quadrant gearing situated on the left end of the main casing. There are 60 steps in the range from 0.026 to 0.888 mm per revolution, or the imperial equivalent. The Feedbox is built up as follows:
A stepped gear cluster with tumbler gear switching, duplicating block reversing gear spindle; all gearwheels are hardened and ground and mounted on hardened shafts which are supported in roller or plain bearings.



Weiler Commodor Manual

LL Leslie



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 Holden Commodore ,1987 **Holden Commodore V Series Five Speed Manual Transmission** ,1983 **Holden Commodore VC Series** ,1980 **Commodores** Ellery Publications,1994-07-01 **Holden Commodore Automotive Repair Manual** Larry Warren,Jeff Killingsworth,John Harold Haynes,2006-01-01

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