

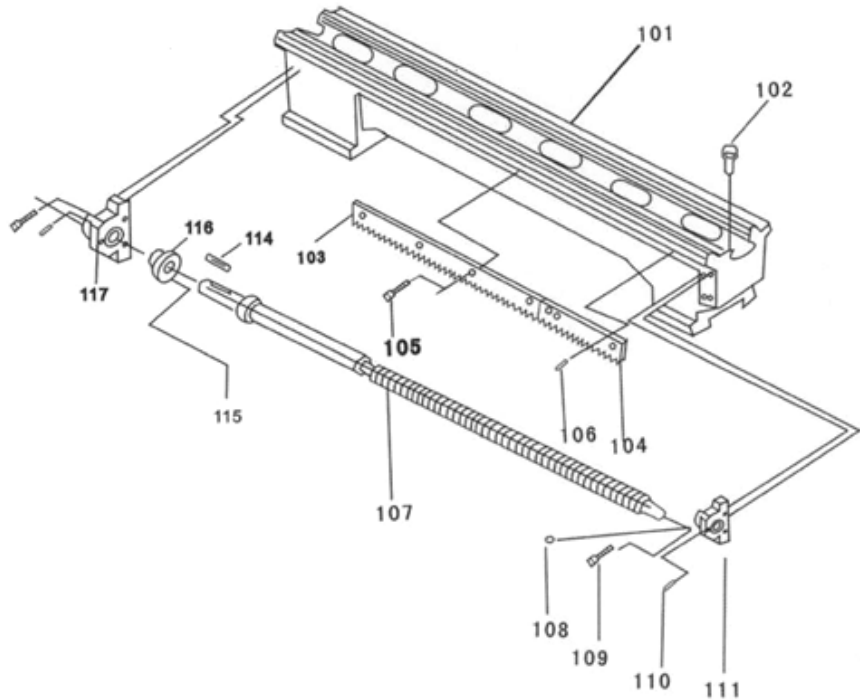


XWS004 METALLISORVI 250X550 / METAL LATHE 250X550

Varaosatunnus / Spare part code XWSV esim. / e.g. XWSV004-12 (-12=pos.no.)

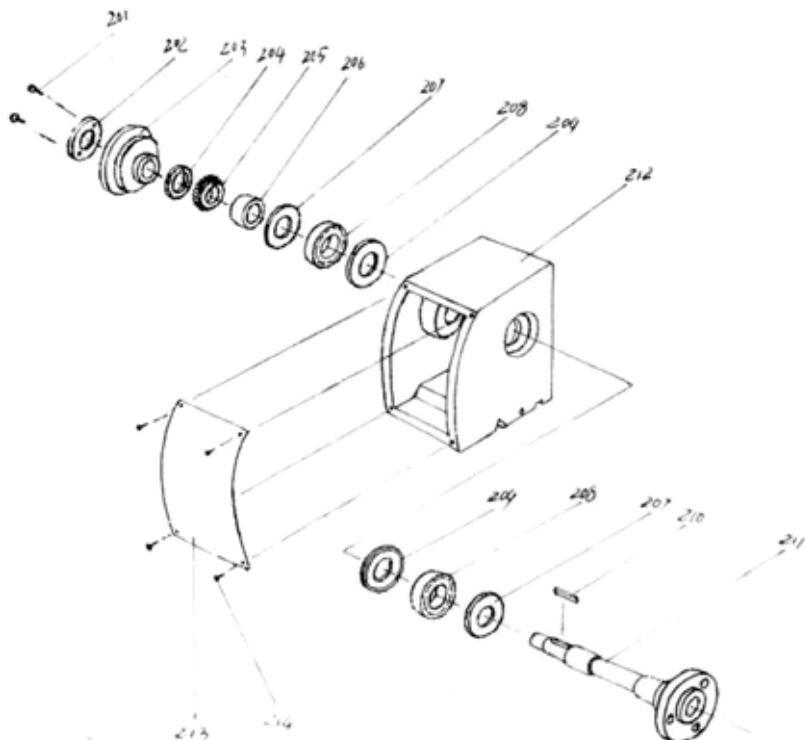
Bed assembly

No.	Description
101	Bed way
102	Screw
103	Gear rack
104	Gear rack
105	Screw
106	Pin
107	Lead screw
108	Oil seal
109	Screw
110	Pin
111	Right backup
114	Key
115	Screw
116	Connection plate
117	Left backup

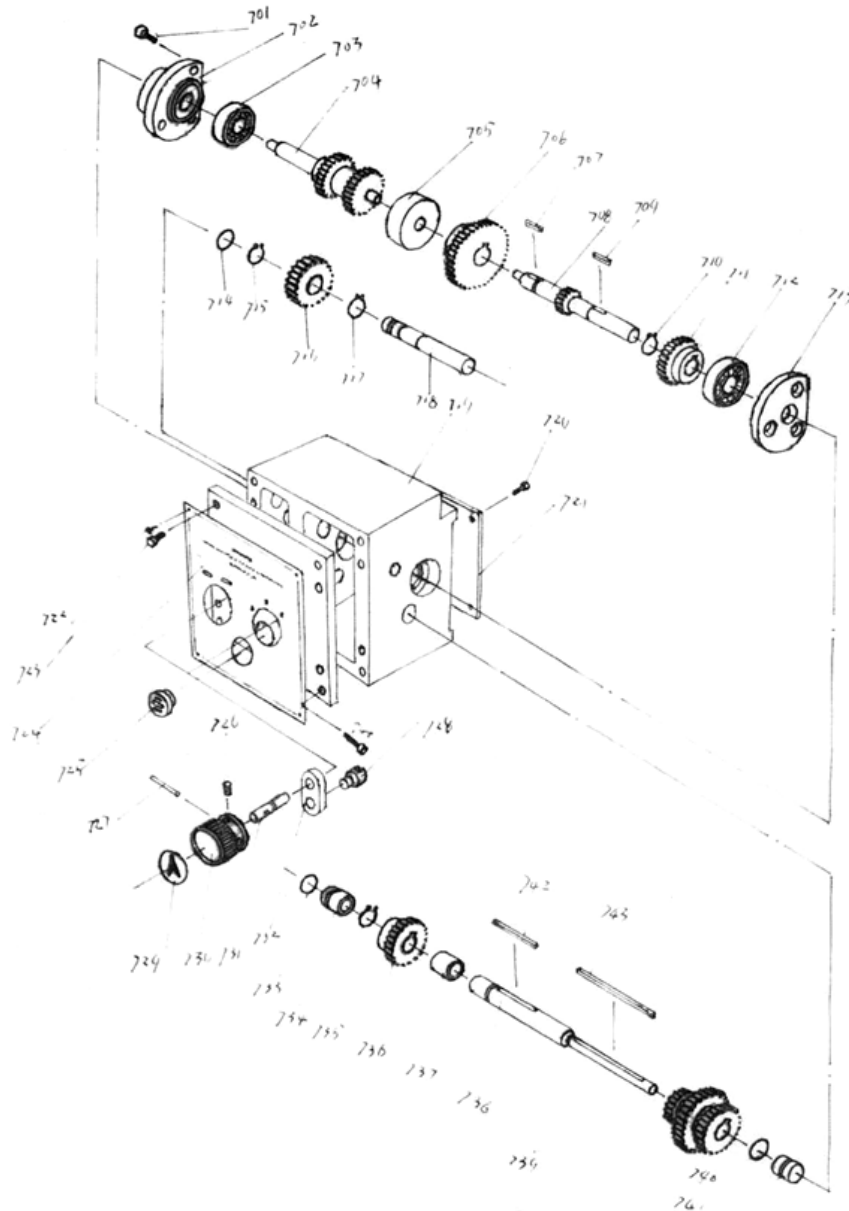


Headstock

No.	Description
201	Screw
202	Washer
203	Pulley
204	Gasket
205	Gear
206	Separator
207	Gasket
208	Bearing
209	Oil seal
210	Key
211	Spindle
212	Headstock
213	Label
214	Screw



Feedbox

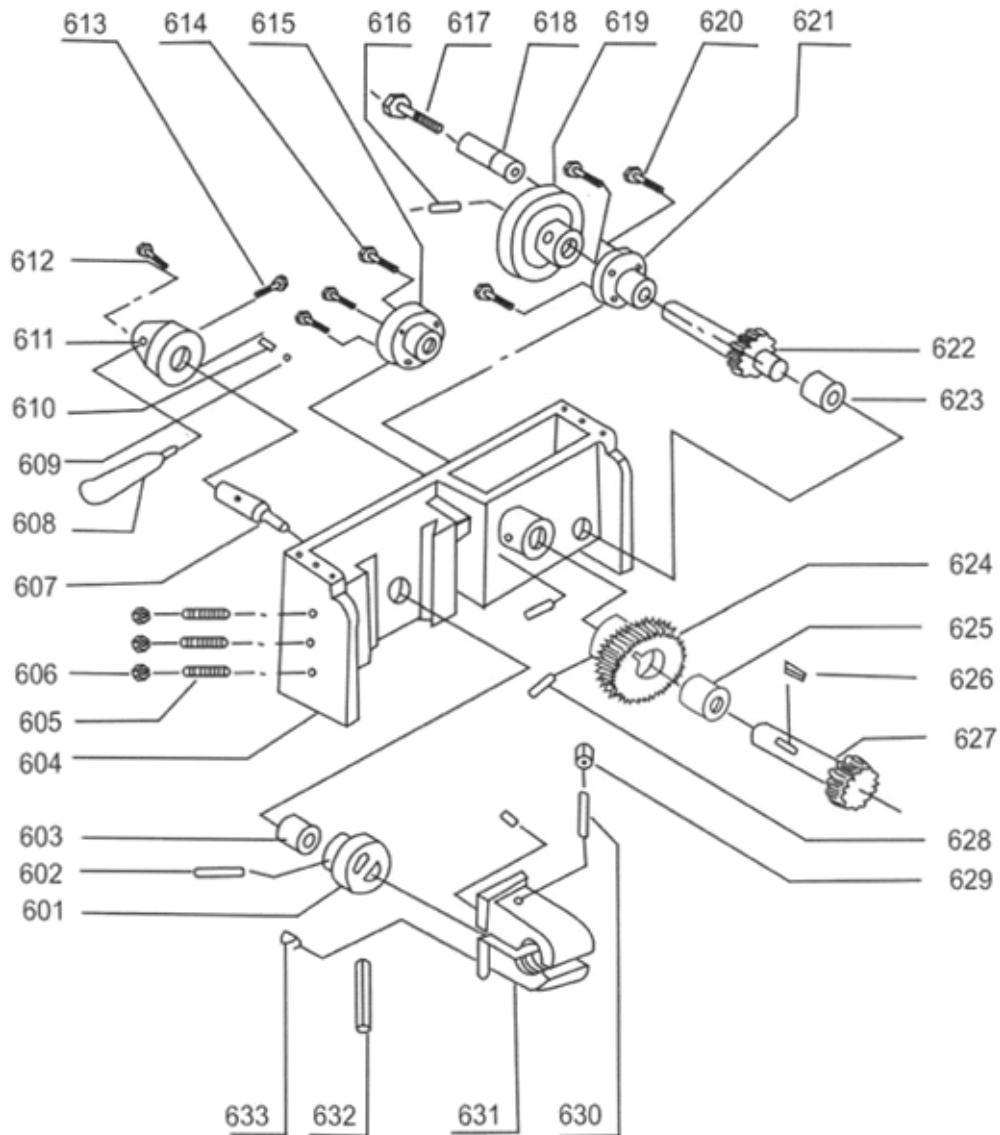


No.	Description
701	Screw
702	Flange OAS17307
703	Bearing
704	Gear shaft
705	Toggle
706	Gear
707	Key
708	Gear shaft
709	Key
710	Snap ring
711	Gear
712	Bearing
713	Flange
714	O-ring
715	Snap ring

No.	Description
716	Gear
717	Snap ring
718	Shaft
719	Feed box
720	Screw
721	Back cover
722	Screw
723	Screw
724	Label
725	Oil window
726	Screw
727	Key
728	Fork
729	Label
730	Knob

No.	Description
731	Shaft
732	Bracket
733	O-ring
734	Gasket
735	Snap ring
736	Gear
737	Shaft sleeve
738	Shaft
739	Gear
740	O-ring
741	Shaft sleeve
742	Key
743	Key
744	Screw

Apron



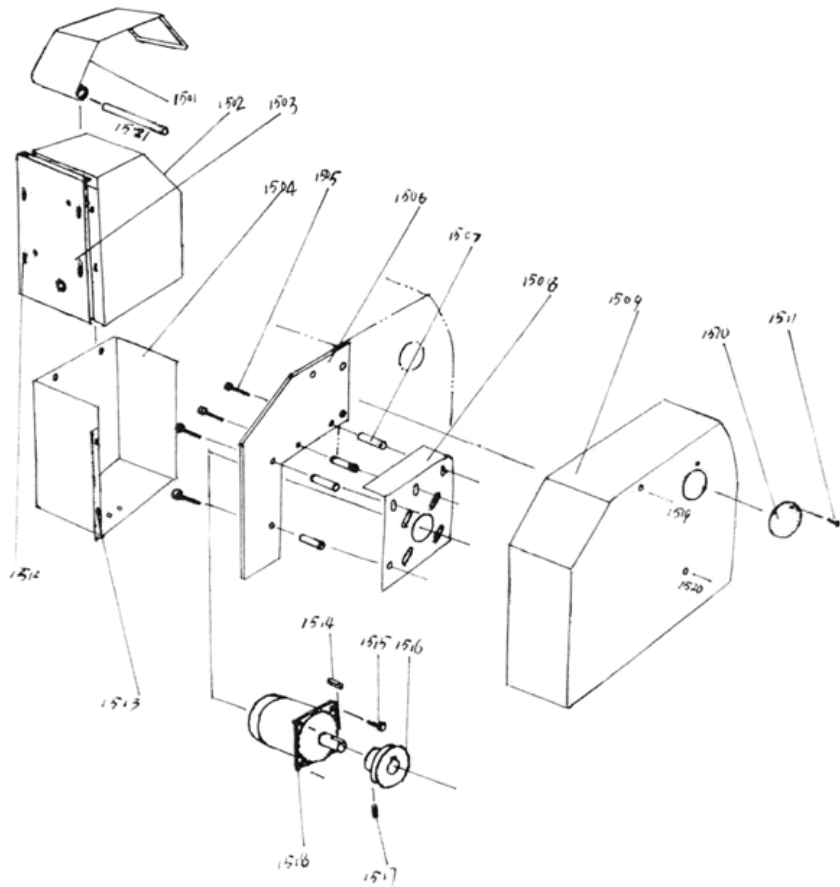
No.	Description
601	Notched joint
602	Pin
603	Shaft sleeve
604	Apron
605	Screw
606	Nut
607	Shaft
608	Handle
609	Ball
610	Spring
611	Handle

No.	Description
612	Screw
613	Screw
614	Screw
615	Flange sleeve
616	Pin
617	Bolt
618	Handle sleeve
619	Hand wheel
620	Screw
621	Flange sleeve
622	Gear shaft

No.	Description
623	Shaft sleeve
624	Gear
625	Shaft sleeve
626	Key
627	Gear shaft
628	Screw
629	Nut
630	Screw
631	Half nut
632	Gib
633	Cylinder pin

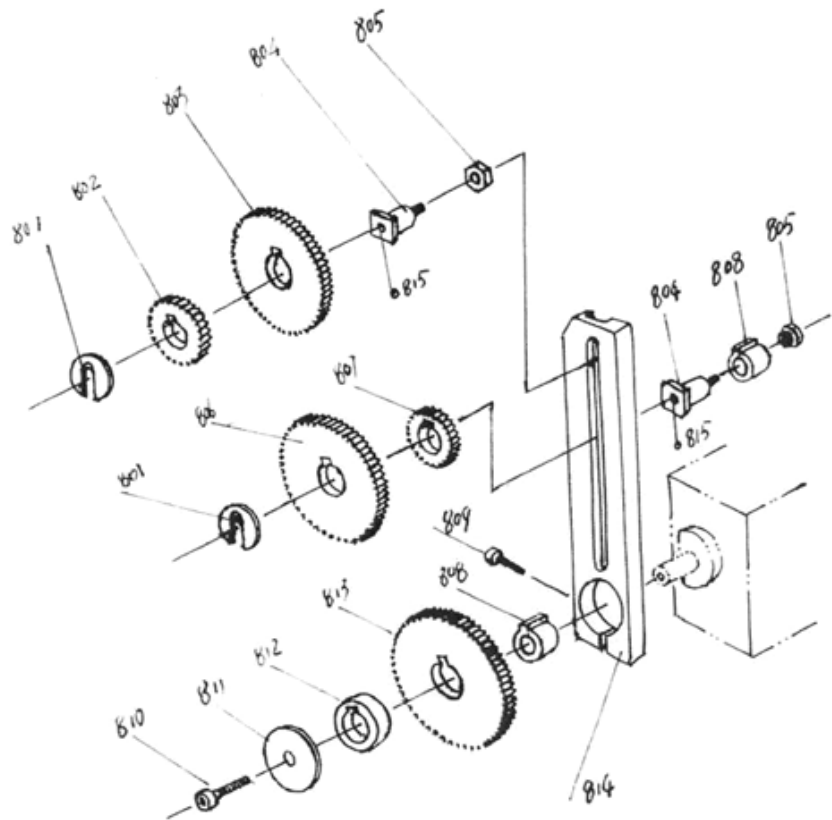
Motor and pulleys

No.	Description
1501	Chuck cover
1502	Electrical box
1503	Cover
1504	Cover
1505	Screw
1506	Bracket
1507	Bolt
1508	Bracket
1509	Cover
1510	Cover
1511	Screw
1512	Screw
1513	Screw
1514	Key
1515	Screw
1516	Motor pulley
1517	Screw
1518	Motor
1519	Bolt
1520	Bolt
1521	Shaft



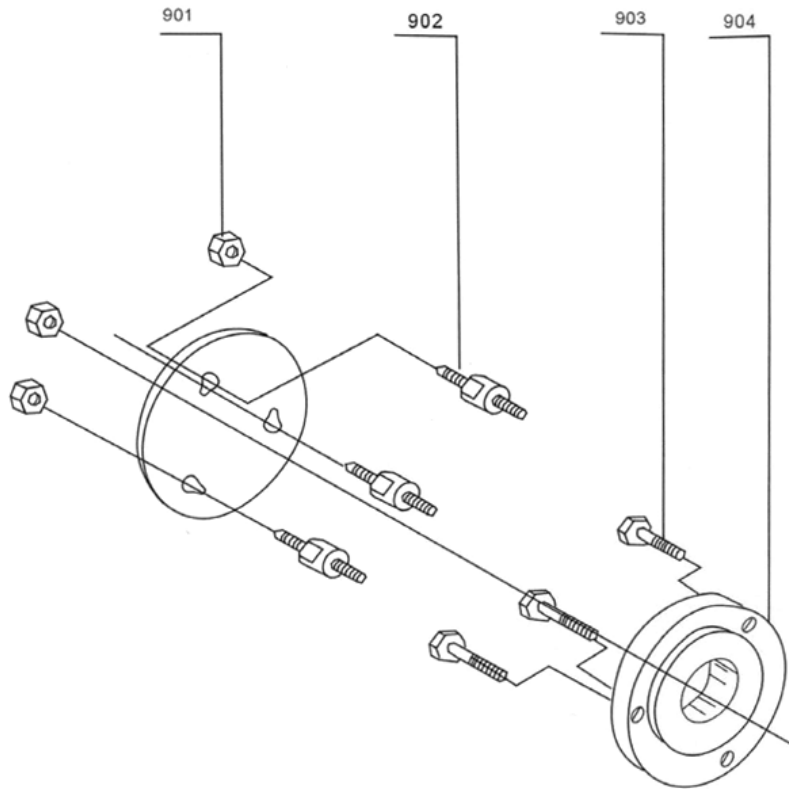
Change gear

No.	Description
801	Washer
802	Change gear
803	Change gear
804	Bolt
805	Nut
806	Change gear
807	Change gear
808	Shaft sleeve
809	Screw
810	Screw
811	Washer
812	Separator
813	Change gear
814	Bracket
815	Oil cup



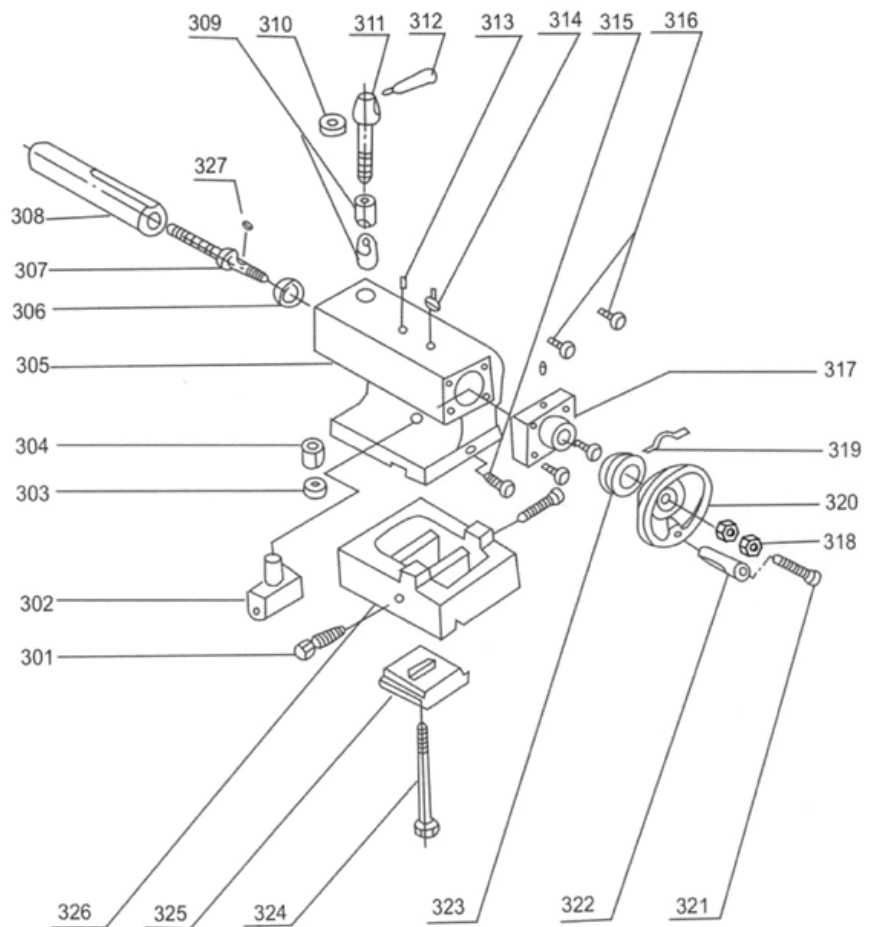
3-jaw chuck base

No.	Description
901	Nut
902	Bolt
903	Bolt
904	Chuck base

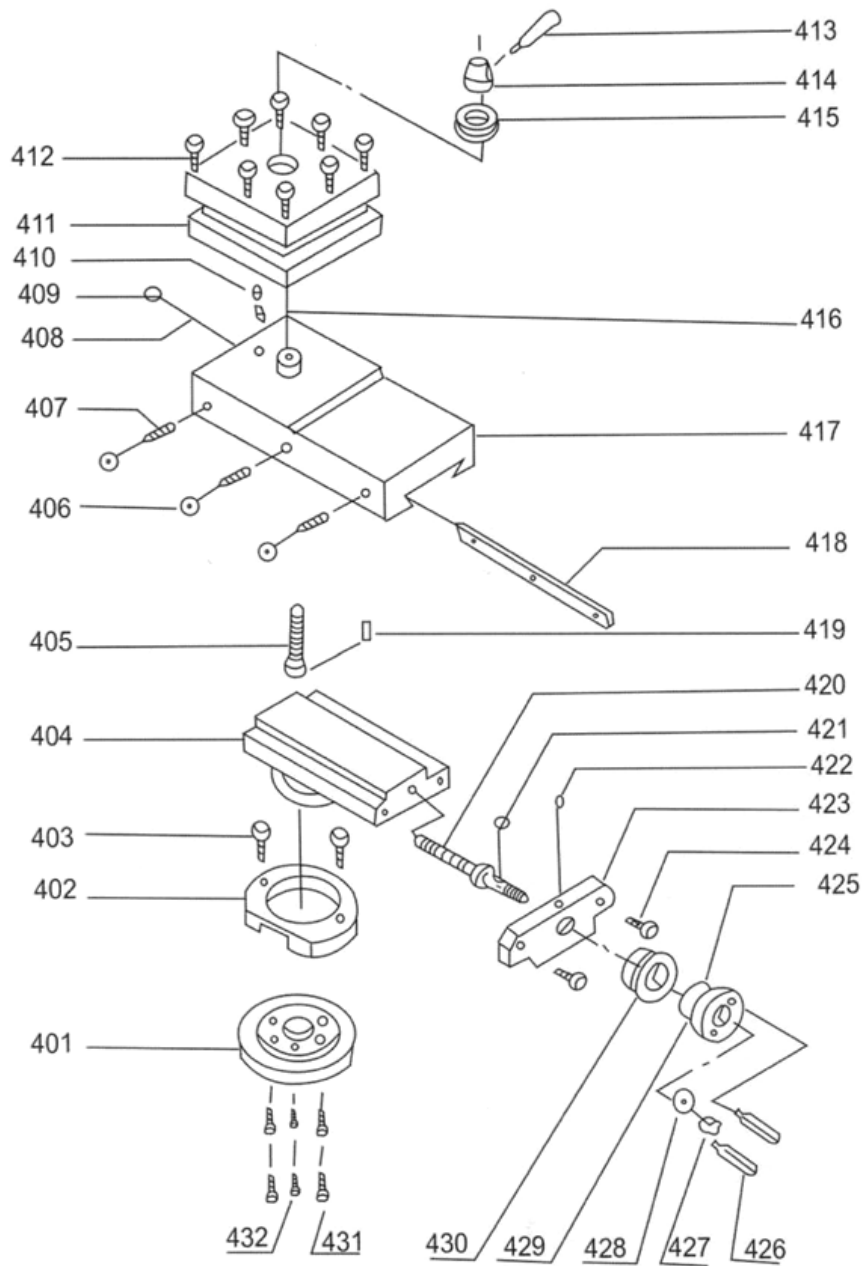


Tailstock

No.	Description
301	Screw
302	Nut
303	Washer
304	Nut
305	Tailstock
306	Bearing
307	Lead screw
308	Sleeve
309	Toggle
310	Washer
311	Bolt
312	Handle
313	Oil cup
314	Key
315	Screw
316	Screw
317	Cover
318	Pin
319	Spring washer
320	Hand wheel
321	Bolt
322	Sleeve
323	Graduated collar
324	Bolt
325	Clamping plate
326	Base



Tool rest

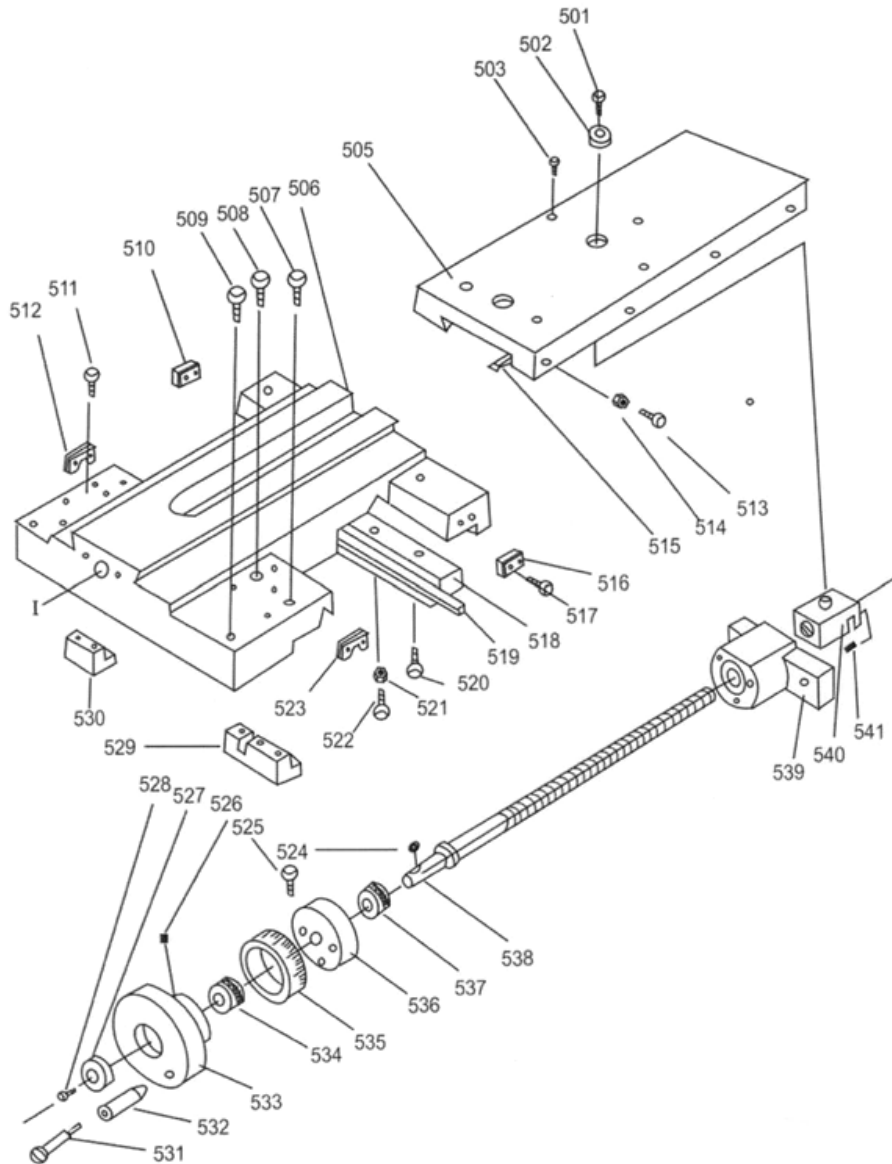


No.	Description
401	Graduated collar
402	Clamping ring
403	Bolt
404	Swivel base
405	Bolt
406	Nut
407	Screw
408	Screw
409	Nut
410	Pin
411	Tool rest

No.	Description
412	Screw
413	Handle
414	Handle base
415	Washer
416	Spring
417	Tool slide
418	Gib
419	Pin
420	Lead screw
421	Key
422	Oil cup

No.	Description
423	Bracket
424	Screw
425	Spring washer
426	Handle
427	Nut
428	Washer
429	Handle wheel
430	Graduated collar
431	Screw
432	Pin

Carriage



No.	Description
501	Screw
502	Washer
503	Oil cup
504	Screw
505	Cross-slide
506	Carriage
507	Screw
508	Screw
509	Screw
510	Wiper
511	Screw
512	Wiper
513	Screw
514	Nut

No.	Description
515	Gib
516	Wiper
517	Screw
518	Brake clip
519	Gib
520	Screw
521	Nut
522	Screw
523	Wiper
524	Key
525	Screw
526	Spring washer
527	Washer
528	Screw

No.	Description
529	Brake clip
530	Brake clip
531	Handle
532	Handle sleeve
533	Handle wheel
534	Bearing
535	Graduated collar
536	Bearing base
537	Bearing
538	Lead screw
539	Screw base
540	Nut

BENCH LATHE INSPECTION RECORD
CQ6125;C210

NO.	INSPECTION ITEM	TOLERANCE	DATA
G1	A Spindle axial runout	A 0.025	
	B Runout on spindle base plane	B 0.04	
G2	Spindle nose runout	0, 03	
G3	Spindle taper runout		
	A At the end of spindle nose	A 0.03	
	B At the end of 300mm test bar	B 0.06	
G4	Parallelism of center line of tailstock spindle to longitudinal motion of carriage		
	A In vertical plane	A 0.025/50	
	B In horizontal plane	B 0.015/50	
G5	Difference in center height between headstock and tailstock (tailstock upward)	0.03-0.08	
G6	Parallelism of spindle center line to longitudinal motion of carriage		
	A In vertical plane (upward)	A 0.06	
	B In horizontal plane(forward)	B 0.04	