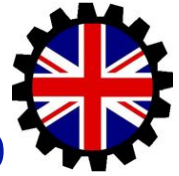




EXETER MACHINE TOOLS LIMITED



The International Pavilion, 10th Street, Stoneleigh Park, Nr Coventry, CV8 2LZ
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Webster & Bennett 48EV Turret Type Conventional Vertical Turret Lathe New machine standard 12 month warranty

In 40 years rebuilding and modernising Webster & Bennett Vertical Lathes this is the best specification conventional machine we have ever processed - the top specification of a new W&B VTL were it built today

The electrical system has been redesigned to a modern updated specification incorporating a new electrical cabinet with PLC and new solenoids and new wiring. From the pendant control the operator is able not only to select the speed range he is able to increase 20% or decrease 50% the table speed while in that range - without stopping to change gears.

The new design pendant provides all operator controls in the most operator friendly way possible with precision joysticks and set in a CNC style enclosure swivelling on the guarding in operator's position. The machine is fitted with an Emergency stop.



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Registered Address : 1 Gainsborough Crescent, Solihull B93 9EX
Registered in England No. 1382020. VAT registration no. 738 6893 71
Bankers : NatWest, Birmingham City Centre, 60 0235 account 67451705

The machine's condition and accuracy will be as new - full new machine standard 12 months warranty

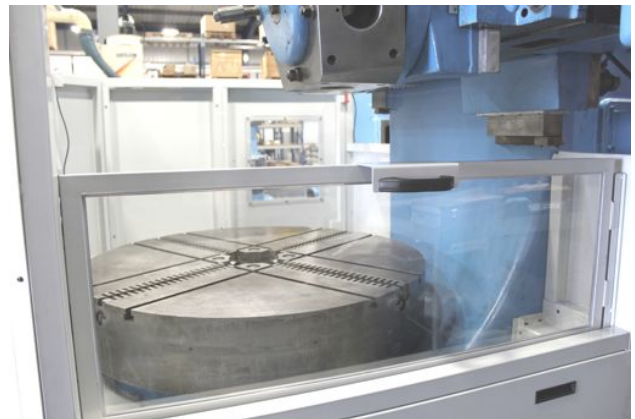
This machine is from one of the last series of conventional machines built by Webster & Bennett. Due to nature of the previous users work it was already in very good, little worn mechanical condition but we have followed our standard practice to completely strip down the machine, regrind operating guideways and fit new low friction material to mating surfaces and gibs, to disassemble the table drive and spindle bearings, clean thoroughly, check, adjust, replace where necessary and to reassemble ensuring a fully functioning lubrication system. This machine's main table spindle bearing is a Timken bearing designed to run at speeds up to 500rpm. The machine specification for the original user is for low speed work so the bearing is barely run in.

The machine has the highest specification for operator control being fitted with three very desirable major options

1. **Creep Feed to the X and Z axes.** A DC servo motor is coupled direct to the electro-magnetic feed transmission unit. This feature is particularly advantageous to user working with digital readout. (This machine will have a new digital readout set fitted). Some users who work with creep feed like to have ball screws instead of trapezoidal screws in X axis for very fine feed work and manual work with reduced stick slip. **(This machine has a ballscrew in the X axis)**
2. **Operator variable speed control of table**
3. **Operators Joy Stick Pendant Control.** This high quality pendant provides very user-friendly control over all operating functions - **start, axis feed and rapid movements including Creep Feed control to X axis, speeds and feeds selection and table variable speed control.** The new 2 axis Digital Readout is incorporated to the pendant panel for optimum operator convenience
4. **New operator safety guarding (see photos) with front doors for easy component loading and side doors for toolbox access and swarf removal access**



Componet loading



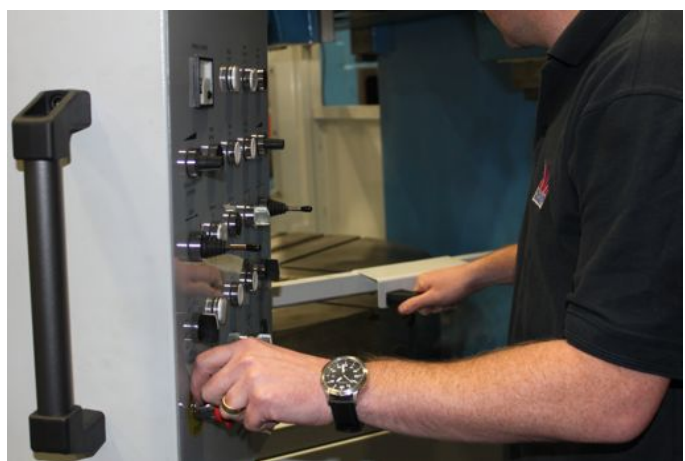
Access to change tools



New electrical cabinet , swarf access door. Excellent swarf collection area



GREAT FOR THE OPERATOR



Easy control for setting up and checking/changing toolholders and cutting tools

MACHINE SPECIFICATION

W&B 4 jaw independent chuck	(54") 1370 mm
Maximum Swing	(59") 1499 mm
12 Table Speeds, operator controlled variation in each range	3.1 – 70rpm ***(-50% to +20%)* **
Vertical travel of turret slide	(38") 965 mm
Horizontal feed of turret from chuck centre out	(36") 914 mm
Max height under the cross rail	(48") 1219 mm
Max height under the turret	(59") 1499 mm
Vertical adjustment of cross slide	(24") 610 mm
12 Feed rates	.005 - .250
Approx weight of the machine	11500 Kgs
Maximum working height required	(163") 4140 mm
Standard transit height	(139") 3531 mm
Minimum transit height	(109") 2769 mm

*****the new electrical design enables the operator to control from the pendant each individual geared speed and to vary each speed from 50% to 120% of the nominal speed in that range**

The machine will be delivered repainted to RAL 5012 light blue and guarding RAL 7035 light grey unless buyer has other requirement

Documentation supplied - machine accuracy and capability certification and operating/maintenance manuals

OPTIONS - Conversion from turret to ram and extra height options

RAM - The machine can be supplied with a forged ram 8" square reengineered to the vertical slide. Toolholding or options are available.

After re-engineering the capacities for boring are

The bottom 280mm of the ram will be 200mm square and will enter a bore 283mm diameter to required size.

The ram slide will enter a bore 706mm diameter.

Tool holding can be modified, possibly at extra cost. Currently the intention is to complete with the Capto C6 quick change system, for productivity and flexibility

EXTRA HEIGHT – The machine operating height capacity can be increased by 12" –



Scope of work

Electrical

- **The electrical system** has been redesigned to a modern updated specification incorporating a new electrical cabinet with **PLC** and new solenoids and new wiring. **The operators pendant** provides all operator controls in the most operator friendly way possible with **precision joysticks** (see illustration). The machine will be fitted with an Emergency stop. The table drive has been re designed **to enable the operator to introduce table speed increase 20% or decrease 50% without stopping to change gears.**

Mechanical work

- The Cross Rail assembly has been totally dismantled to enable the following processes.
- The Cross Rail has been reground to ensure the original geometric tolerances.
- The Saddle has been machined and scraped into position on the Cross Rail.
- The Saddle Slide Clamps have been reconditioned.
- The Swivel Slide has been machined, new low friction material fitted and scraped to within the original geometric tolerances.
- The turret slide has been reground to ensure the original geometric tolerances
- Low friction material fitted to Gib and retaining strips and scraped and bedded into position.
- New Slideway Wipers to all slideway mating surfaces.
- The Rapid Traverse Drive Shafts and Gears have been checked and refurbished where necessary, bearings and new Support Bushes, Thrust Bearings and Seals have been fitted.
- All Lubrication Piping and Meter Valves to both Saddle and Ram Slide have been replaced.
- Table drive assembly has been fully dismantled, checked, reworked where necessary and reassembled
- Repaint machine to RAL 5012 light blue and guarding RAL 7035 light grey
- **Run machine to test all functions. Cut test component. Set alignments to new machine tolerances and certify.**