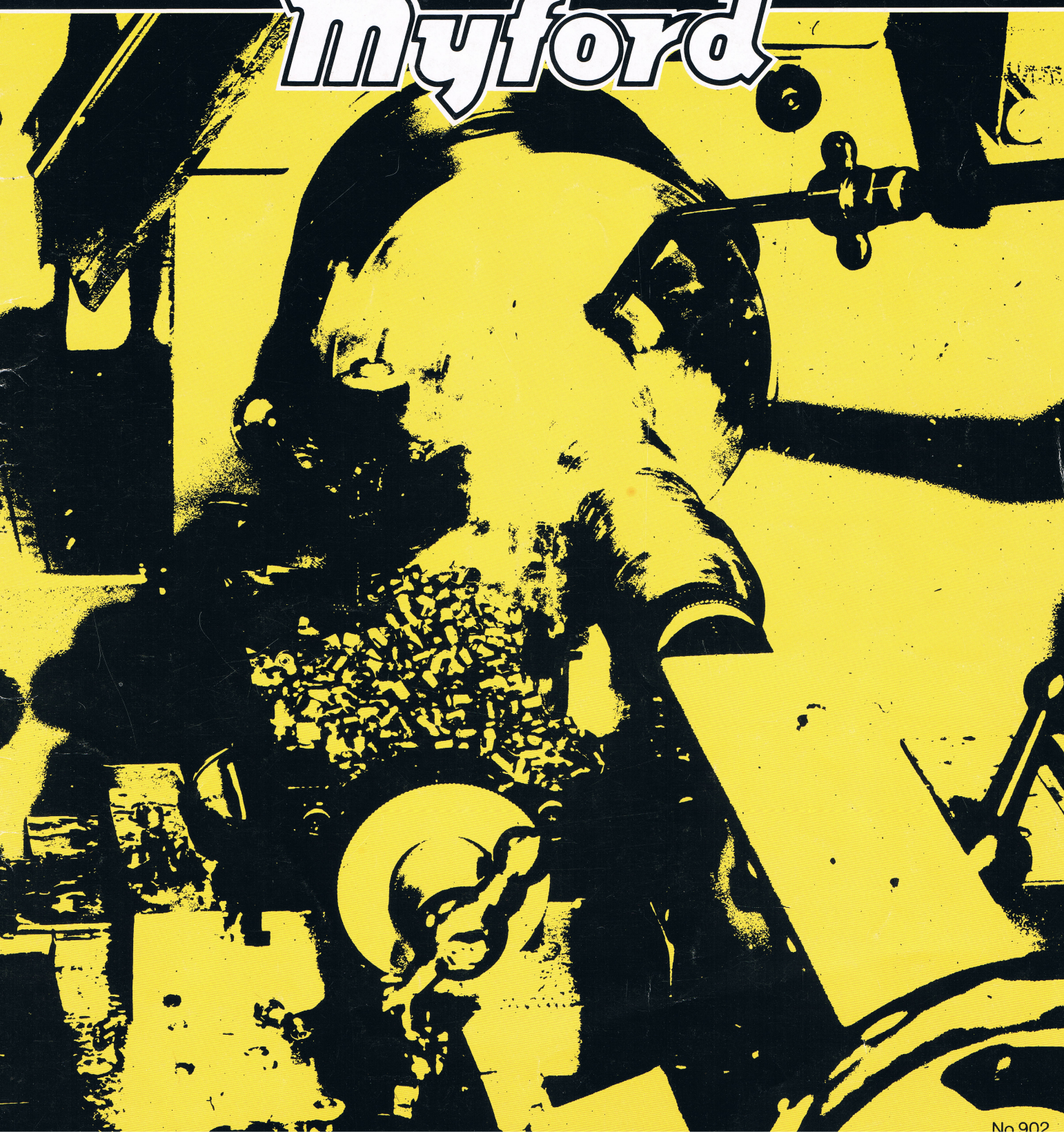
254s

TWO FIVE FOUR

A New Lathe from

myford



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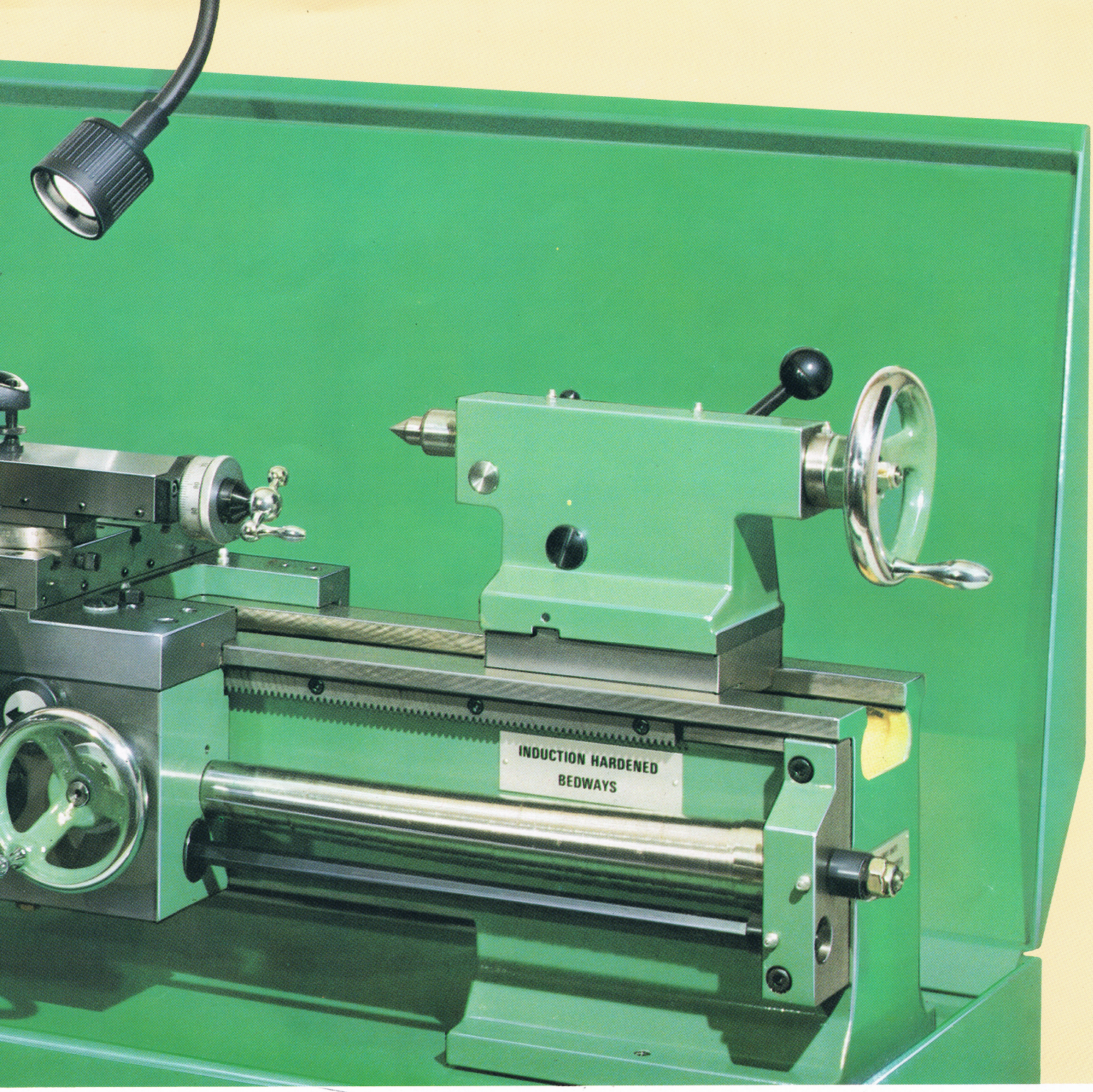
Inheritor of the famous Myford tradition of accuracy and excellence.

From Myford comes a new and worthy extension of their range of high speed centre lathes.

The design of the 254s is based upon the knowledge and experience gained from one of the world's most successful series of small lathes and its introduction marks the Company's 50th Anniversary of specialist small lathe manufacture.

The 254s offers its user greater capacity and capability without a proportional increase in physical size.

Whilst great advances have been made in the areas of enclosure of the mechanisms, durability, self lubrication etc., accuracy and excellence remain the over riding considerations in the manufacture of the 254s and, in its class, it has no rivals.



48·3" × 15·3"

Centre Height	123mm (4¾")
Swing over Bed	254mm∅ (10" ∅)
Bed	Square shears induction hardened.
Maximum distance between centres	500mm (20")
Headstock spindle speeds (10)	53 to 2,000 r.p.m.
Headstock spindle taper	No. 4 M.T.
Headstock spindle bore	26mm ∅ (1" ∅) A3 BS 4442 modified
Swing over saddle	208mm (8 3/16")
Swing over cross-slide	140mm (5½")
Cross-slide travel	162mm (6⅜")
Topslide travel	85mm (3 5/16")
Topslide swivel	360°
Height from topslide to centres	20mm (¾")
Tailstock barrel travel	70mm (2¾")
Tailstock barrel taper	No. 2 M.T.

Leadscrew	3mm or 8 t.p.i.
Screwcutting range via 15 speed gearbox	5.0 to 0.25mm or 4 to 56 t.p.i. — with one change
Longitudinal Feeds per rev.	0.32 to 0.04mm or .026" to .0019" — with one change
Power cross feeds per rev.	Approx. ½ of Longitudinal
Motor	¾ h.p. Single Phase ¾ h.p. Three Phase
Enclosed oil bath lubrication to headstock, gearbox and apron	
Enclosed leadscrew clutch	
Feed shaft fitted overload clutch	
Bench lathe motorised (approx.)	211 kgs (464lbs)
Cabinet stand (approx.)	90 kgs (199lbs)
Cabinet stand with doors and splash back (approx.)	104kgs (230lbs)

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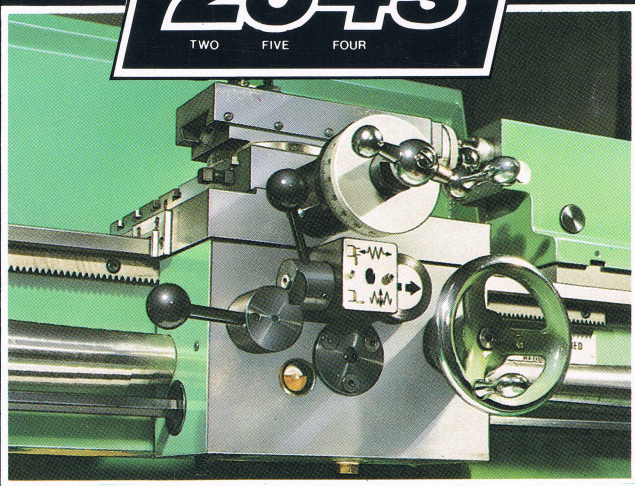

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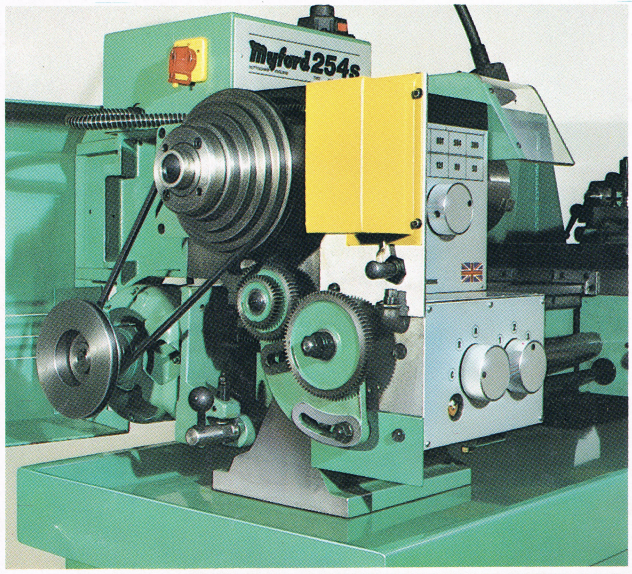

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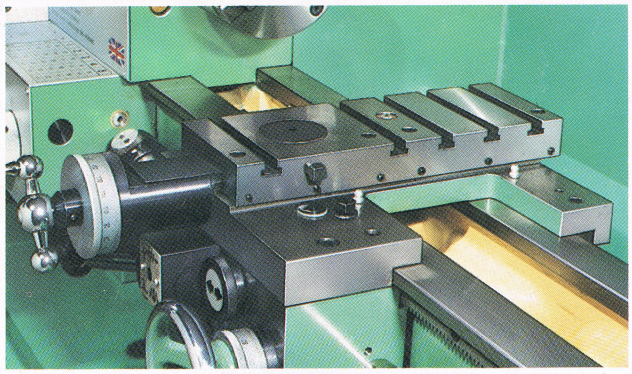

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FEATURES

- Electrical control gear options provide for simple D.O.L. reversing switch or complete safety package with push button operation with thermal overload and no-volt release protection utilising a 110 volt control circuit. A 12 volt tapping for a machine light is incorporated, which avoids the necessity for a separate transformer.
- Interlock switches are incorporated in the safety electrical package and operated by the main drive access door and the chuck guard.
- The headstock comprises a heavy box-structure with No. 4 Morse Taper spindle in precision taper roller-bearings.
- Speed-reduction gears and sliding gearbox and leadscrew drive reverse gears are enclosed within the headstock. The headstock oil bath provides lubrication for the entire headstock including the spindle bearings and spindle-pulley gear bearing.
- The buttress-form of spindle flange with inset chuck securing nuts provides a stiff secure mounting with minimum overhang from the spindle bearings.
- The motor is specially mounted to minimise the transmission of motor vibration to the machine.
- The high efficiency drive, without intermediate shafts, ensures maximum torque at the spindle nose. (Fig. 2).
- The spindle drive coupling effects positive axial and radial clamping to eliminate all play in the directly driven high speed range.
- The robust bed casting with well-spaced induction-hardened flat ways provides the maximum resistance to load and wear in all planes.
- Generous provision in lathe bed casting for the free passage of metal cuttings etc.
- Provision is made within the bed feet for easy levelling either on a bench or special cabinet stand.
- The gearbox is totally enclosed with oil-bath lubrication for the sliding gears.
- 15 pitches are provided up to 4 t.p.i. on Imperial machines and 5 mm pitch on metric machines; also 15 feeds down to .04mm or .002″ respectively. Metric or Imperial conversion change wheel sets are available.
- A leadscrew drive coupling permits total disengagement of the leadscrew, when not in use, as an additional safety feature.
- An adjustable overload clutch on the feed-shaft provides protection from accidental damage to the feed mechanisms.
- The total enclosure of the leadscrew protects it from abrasive contamination and provides a further element of safety.
- The apron is totally enclosed with oil-bath lubrication.
- Both feed motions and screwcutting are fully interlocked against simultaneous engagement of any two.
- There is separate selection of either longitudinal or cross traverse motions.
- Re-settable friction dial on apron handwheel indicates carriage movement at 25mm (1″) per handwheel rev. (Fig. 1).
- The cross-slide is provided with four tee slots, of standard Myford proportions and disposition, to facilitate the mounting of work for boring, milling etc., and also to accommodate the usual range of Myford accessories. (Fig. 3).
- The heavy-gauge rigid all-welded monobloc cabinet stand with integral tray has full-length shelves to make maximum provision for the storage of accessories etc. (Fig. 4).
- Optional sliding doors, specially engineered for free movement without rattles, conserve space and are more convenient in confined areas.

Myford Limited
Beeston, Nottingham NG9 1ER. England.
Telephone: Nottingham (0602) 254222 (4 lines)
Telegrams: Myford Beeston Nottingham
Telex: 37100

Myford

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