

Upper Slide Front (Ram Type)

For 00, 2 and 3 Ultramatic Screw Machines and 2 Ultramatic Chucking Machines.*

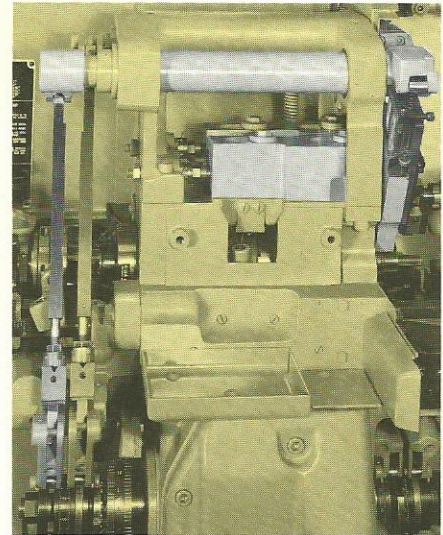
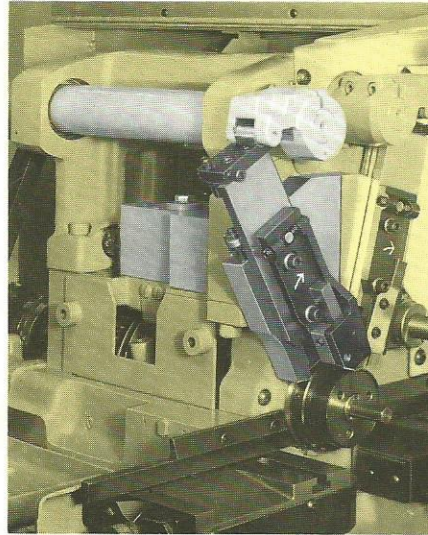
The Upper Slide Front is located just forward of the machine spindle nose at an angle in the vertical plane. Its addition to the machine provides another tool position for such operations as rough forming, finish forming, knurling, marking, rolling, etc. The tool posts furnished can be interchanged with the Upper Rear Slide Cutting Off Tool Posts when it is advantageous to do so, such as when the Transfer Mechanism is to be used or when overlapping of Cross Slides is desirable.

Dual compression springs in the slide assure smooth cam control of the slide movements.

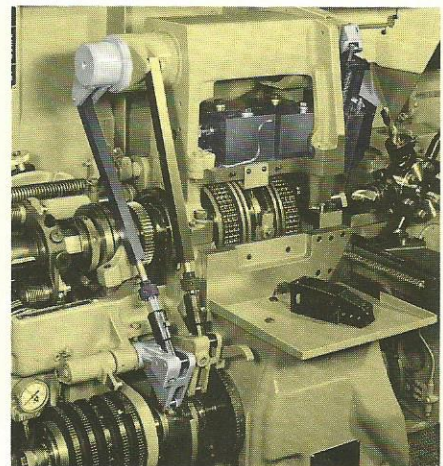
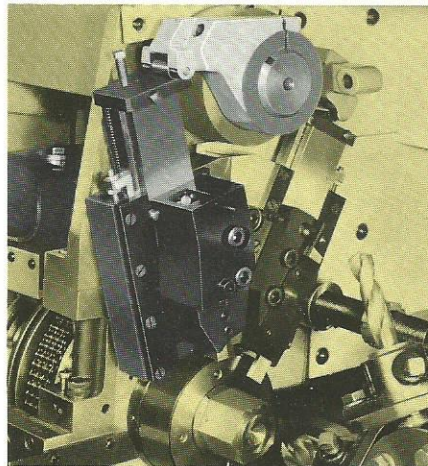
"On center" adjustment for the tool bit is in the Tool Holder rather than the Slide Trunnion for ease of setting. Micrometer adjustment for precise diametral control is located adjacent to the Cam Levers for operator convenience.

Screw type positive stops insure repetitive forming capability.

The heavy duty Ram Slide affords maximum rigidity for heavy plunge forming cuts, even with the Ram fully extended. Two bolts securely anchor the Rams to the machine bed, following longitudinal adjustment.



00 size



2 & 3 size

Specifications

	00	2 AND 3
Forming width With Standard Holder With Optional Holder	1/2" (13mm)	1" (25mm) 1/2" (13mm)
Blade Size	3/8" x 1/2" (9.5 x 13mm)	3/4" x 1" (19 x 25mm)
Longitudinal Adjustment of Ram	1" (25mm)	1 1/2" (38mm)
Distance Face of Collet To Inside Edge of Blade Min. Max.	3/16" (4.8mm) 1 3/16" (30mm)	5/16" (8mm) 1 13/16" (46mm)
Cam Diameter	4 1/2" (114mm)	7" (178mm) or 8" (203mm)
Slide Ratio	1 to 1 & 1 1/3 to 1	1 to 1 & 1 1/3 to 1
Slide Travel at 1 1/3 to 1	1 1/2" (38mm)	3" (76mm)
Wav Construction	Dovetail	Rectangular
Lubrication	Automatic	Automatic

*For Machines Beginning Serial Nos:

#00 542-00-9150

2 542-2-7747

3 542-3-320

All machines must be equipped with upper slide rear to accept this 4th slide.

STANDARD EQUIPMENT

00 machines—forming tool post, right hand; forming tool post, left hand; micrometer longitudinal adjustment for both upper slide front and upper slide rear.

2 and 3 machines—forming tool post for both left and right hand turning; micrometer longitudinal adjustment.

00, 2 and 3 machines—micrometer adjustment for diameter; cam blank.