



18" x 6' Monarch Motor Drive Lathe

Dimensions and Specifications of 18 in. x 6 ft. Monarch Motor Drive Lathe

| | |
|---|---------------------------------------|
| Swing over bed..... | 18 $\frac{5}{8}$ " |
| Swing over carriage..... | 12 $\frac{1}{2}$ " |
| Takes between centers, tailstock flush..... | 2' 2" |
| Takes between centers, tailstock overhung..... | 2' 7" |
| Base length..... | 6' |
| Base length shipping weight without motor..... | 3450 lbs. |
| Weight extra two feet..... | 300 lbs. |
| Hole through spindle..... | 1 $\frac{9}{16}$ " |
| Front spindle bearing..... | 3" x 5" |
| Rear spindle bearing..... | 2 $\frac{1}{4}$ " x 4 $\frac{1}{4}$ " |
| Center Morse taper..... | No. 4 |
| Spindle nose, diameter and threads per inch..... | 2 $\frac{3}{4}$ "—6 thd. |
| Back gear ratio, double..... | 3 : 1 and 10 : 1 |
| Lead screw diameter and threads per inch..... | 1 $\frac{1}{2}$ "—4 thd. |
| Range of threads per inch, quick change..... | 3 to 46 |
| Range of feeds per inch, quick change..... | 12 to 184 |
| Number of threads and feed changes, regular quick change..... | 32 |
| Thread cutting range, semi-quick change..... | 3 to 46 |
| Range of feeds per inch, semi-quick change..... | 12 to 184 |
| Headstock base length..... | 27" |
| Tailstock base length..... | 13 $\frac{1}{2}$ " |
| Tailstock, spindle diameter..... | 2 $\frac{3}{8}$ " |
| Tailstock, spindle traverse and setover..... | 8 $\frac{1}{4}$ " and 1" |
| Steady rest opening, regular..... | 6" |
| Maximum capacity oversize steady rests we can furnish..... | 12" |
| Carriage length..... | 27" |
| Carriage bridge width..... | 7 $\frac{1}{4}$ " |
| Compound rest top slide travel..... | 5" |
| Countershaft friction pulleys, size..... | 12" x 4" |
| Countershaft speed..... | 190 R.P.M. |
| Size of lathe tool..... | $\frac{3}{4}$ " x 1 $\frac{5}{8}$ " |
| Motor, size recommended ordinary service..... | 3 H.P. |
| Motor, constant speed, recommended..... | 1200 R.P.M. |
| Motor, variable speed, recommended..... | 500—1500 R.P.M. |
| Distance, spindle center to floor..... | 42 $\frac{1}{2}$ " |
| Head and countershaft cone step diameters, double back gears..... | 7, 9, and 11" |
| Head and countershaft cone step face, double back gears..... | 3 $\frac{13}{16}$ " |
| Speed of geared head driving pulley..... | 275 R.P.M. |
| Geared head driving pulley, diameter, face..... | 14" x 4" |
| Width of bed..... | 15 $\frac{3}{4}$ " |
| Depth of bed..... | 13 $\frac{1}{2}$ " |
| Length of bed, 6', and in multiples of 2 feet up to..... | 22' |
| Maximum collet capacity..... | 1 $\frac{1}{8}$ " |
| Maximum diameter of work which can be relieved..... | 7" |
| Maximum amount of relief..... | $\frac{9}{32}$ " |
| Actual number of flutes that can be relievee: 3, 4, 5, 6, 7, 8, 10, 12 and 14. | |
| Actual threads cut with full quick change gear box and semi-quick change gear box: 3, 3 $\frac{1}{4}$, 3 $\frac{1}{2}$, 4, 4 $\frac{1}{2}$, 5, 5 $\frac{1}{2}$, 5 $\frac{3}{4}$, 6, 6 $\frac{1}{2}$, 7, 8, 9, 10, 11, 11 $\frac{1}{2}$, 12, 13, 14, 16, 18, 20, 22, 23, 24, 26, 28, 32, 36, 40, 44 and 46. | |
| Spindle speeds obtained on geared head lathe with driving pulley operated at recommended speeds: 14, 28, 41, 53, 92, 165, 248 and 320. | |
| Regular equipment consists of face plate, dog plate, steady rest, compound rest, centers, chasing dial, chasing stop, wrenches. | |

THE MONARCH MACHINE TOOL COMPANY

SIDNEY, OHIO, U. S. A.