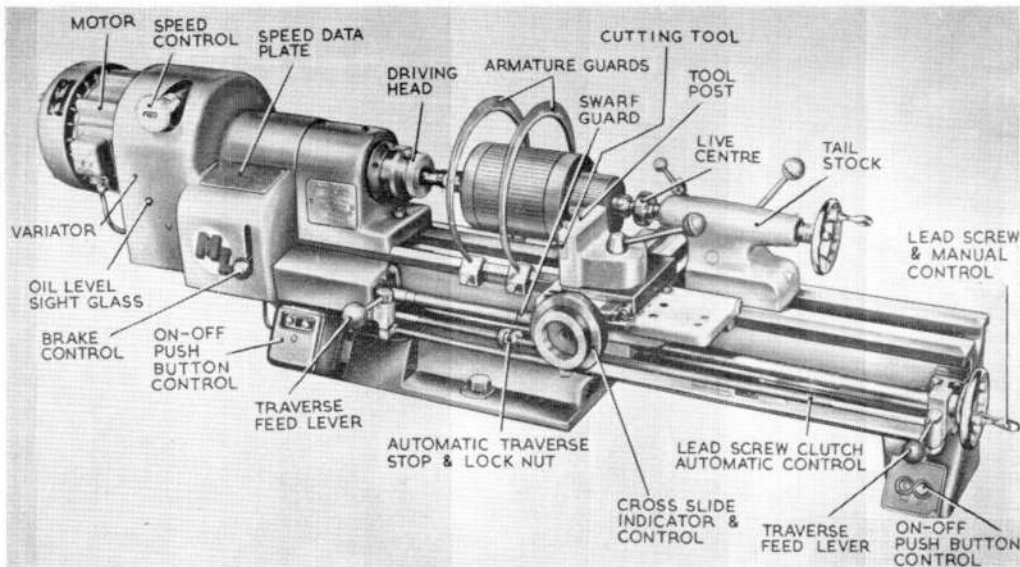


COMMUTATOR AND SLIP-RING SURFACING MACHINE



Ref. No. 4A/2406
Dimensions... ... 6 ft. 8 $\frac{3}{4}$ in. \times 1 ft. 9 $\frac{3}{4}$ in. \times 1 ft. 11 $\frac{3}{4}$ in.
Weight 700 lb. (Approx.)
Associated publication A.P.4343S, Vol. 1, Sect. 13, Chap. 11

BRIEF DESCRIPTION

The commutator and slip-ring surfacing machine is a precision machine tool designed specifically to produce a surface finish on commutators and slip-rings of armatures up to 9 $\frac{1}{2}$ in. diameter and 2 ft. 6 in. shaft length. A surface finish of 15 micro-inch over 0.03 in. can be attained together with ovality and concentricity of 0.0004 in. relative to the armature shaft.

The machine is driven by a 1.5 h.p. 400V, 3-phase motor through a variable speed device and should be mounted on a bench 2 ft. 6 in. high, 8 ft. long and 2 ft. 6 in. wide.

A mica undercutting machine (*Ref. No. 3A/3715*) can be used as an attachment to the surfacing machine. The undercutter is mounted on a bracket designed to be bolted on to the tailstock of the commutator surfacing machine. It has a linear stroke cutter, operated by a hand lever, and micrometer control for depth of undercut. The length of the cutting stroke may be adjusted by movement of the tailstock quill.

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