

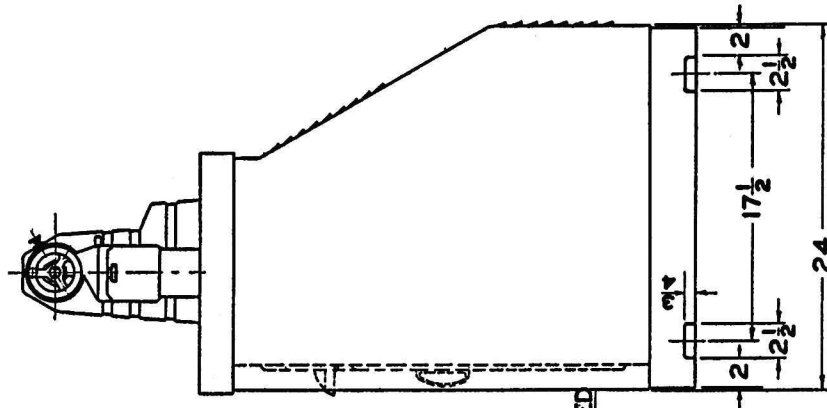
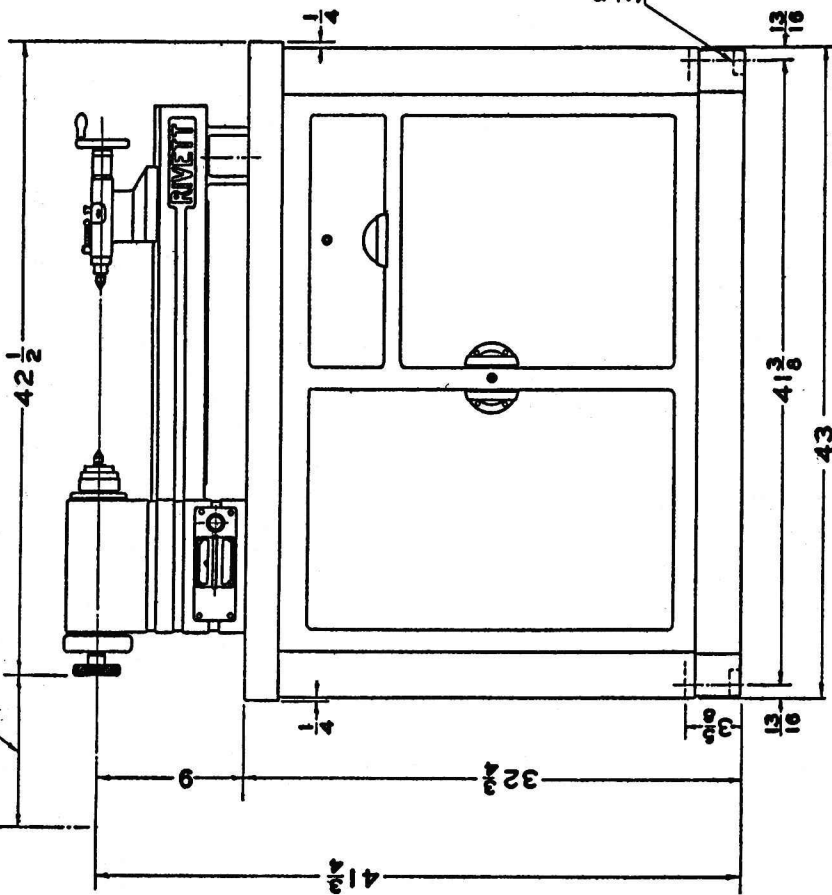
RIVETT

**OPERATING
AND
MAINTENANCE
INSTRUCTIONS**

RIVETT LATHE & GRINDER Inc.

BRIGHTON · BOSTON · MASS · U · S · A ·

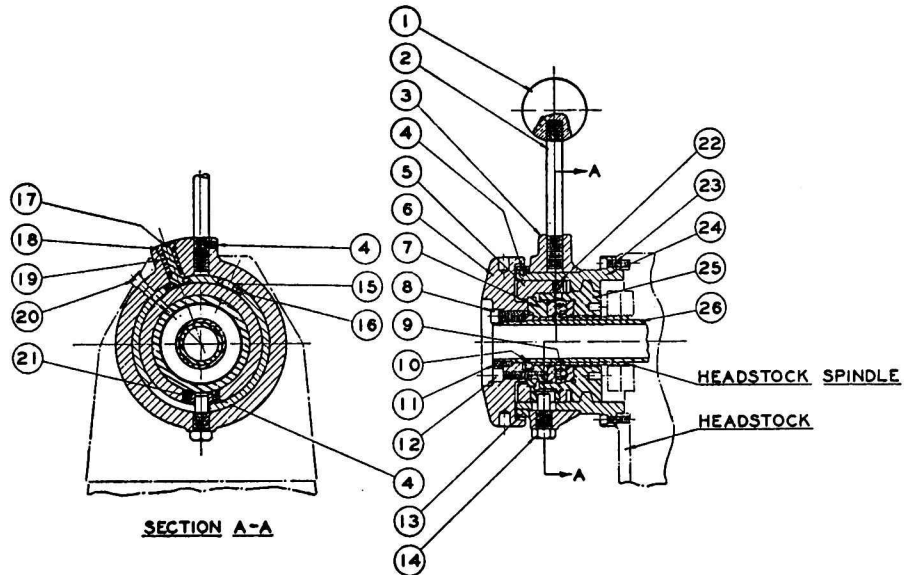
10" REQUIRED TO WITHDRAW
DRAW-IN SPINDLE



715 LATHE ON
FABRICATED CABINET
FLOOR PLAN

RLC-48

RIVETT LATHE & GRINDER INC.



ROTARY
CHUCK CLOSER

RLC-46

PARTS LIST

Reference Number	Symbol	Name of Part
1		Amer. Insul. #1028 Bell Handle
2	715-2-498	Bell Handle Stud
3	715-2-257	Chuck Closer Handle
4		Allen #10-32 x 3/16 Set Screw
5	715-2-188	Collet Ejecting Collar
6	715-2-293	Spindle Knob
7	715-2-189	Thrust Bearing Collar
8	715-2-638	Collar Adjusting Screw
9	715-2-117	Thrust Bearing
10	715-2-191	Pronged Collar
11		#5-40 x 1/2 Set Screw
12		Allen #10-32 x 1 Cap Screw
13	715-2-419	Handle Retaining Ring
14	715-2-497	Operating Stud
15	918-2-152	Detent Plunger Bushing
16		#8-32 x 1/8 Set Screw
17	918-2-655	Detent Plunger
18	918-2-153	Handle Detent Bushing
19	918-2-666	Detent Plunger Spring
20		Gits Oil Cup #301-R
21	715-2-151	Operating Stud Bushing
22	918-2-355	Collar Locking Pin
23		#8-32 x 1/2 Fill. Head Screw
24	715-2-253	Chuck Closer Guard
25	715-2-637	Chuck Closer Screw
26	715-2-468	Draw-In Spindle

CW	L1	L2	L3	TOGETHER
CCW	L2	L1	L3	
LOW	T1	T2	T3	NONE
HIGH	T6	T4	T5	T1-T2-T3

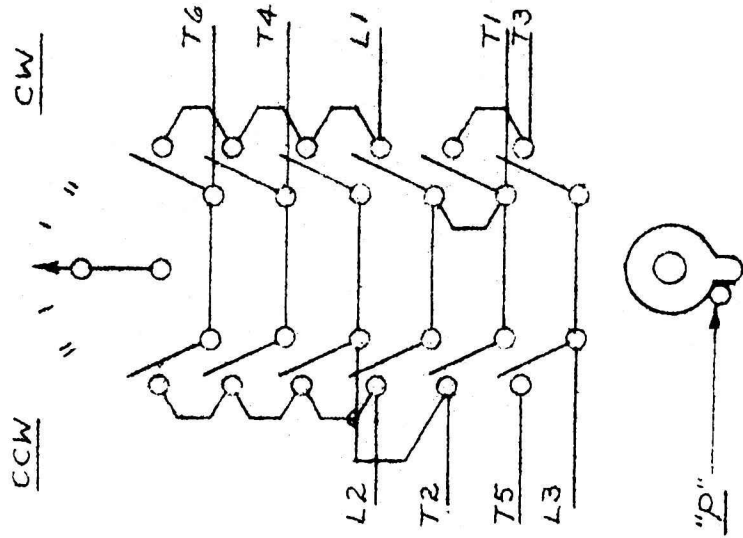


Diagram shows view facing terminal screws with Drum Switch in vertical position.

NOTE: For converting Drum Switch from non-rev. to reversing remove stop pin "P" & invert name plate.

SIZE 00 DRUM SWITCH
2 SPEED VAR. TORQUE AND
CONST. TORQUE

ALLEN-BRADLEY CO.
MILWAUKEE, WIS.

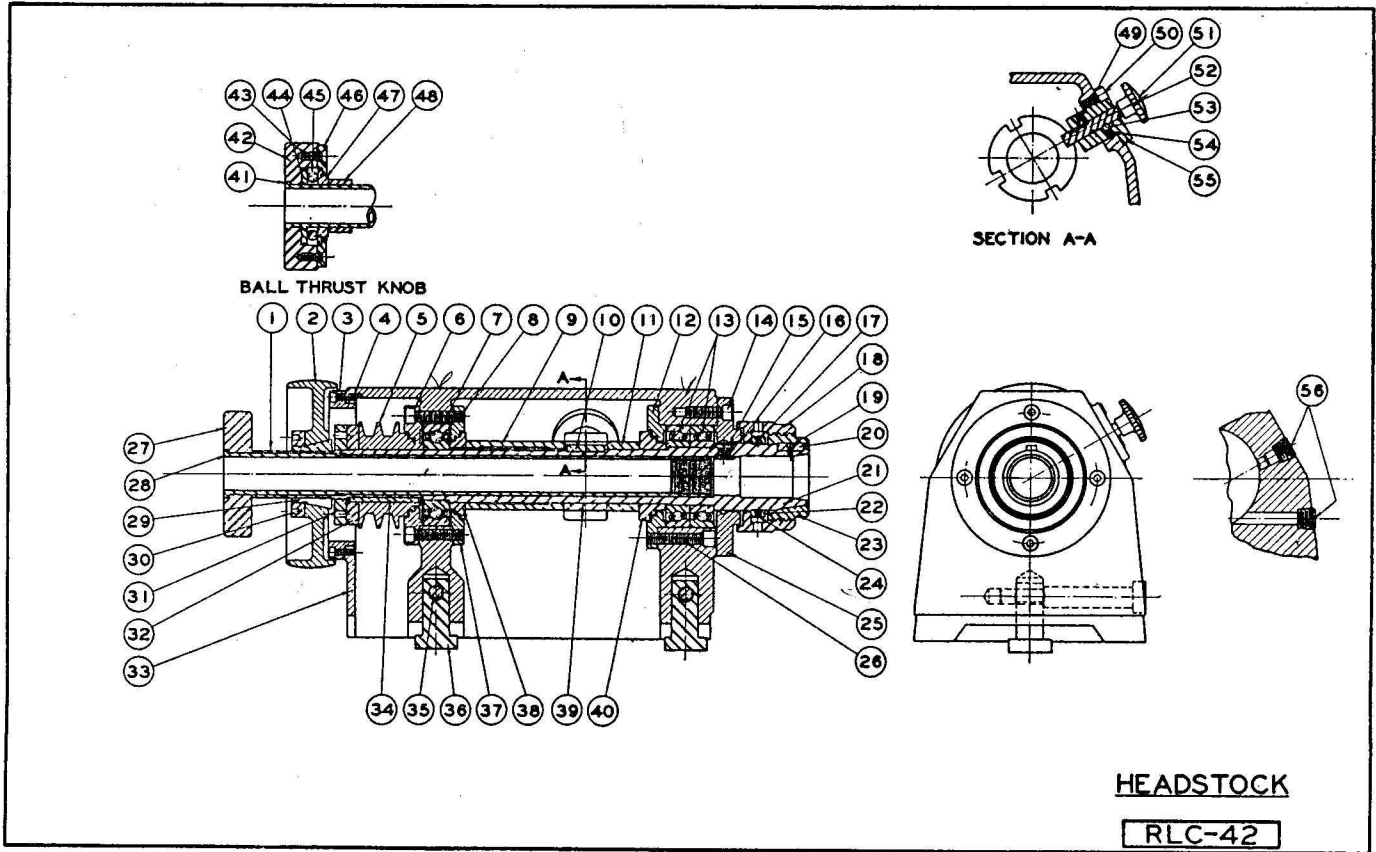
MAXIMUM RATINGS
3/4 H.P. - 110 220
440 + 550 VOLTS

BULLETIN 353
Y-13127

U.S.D.C. 11-2-42

B-2497

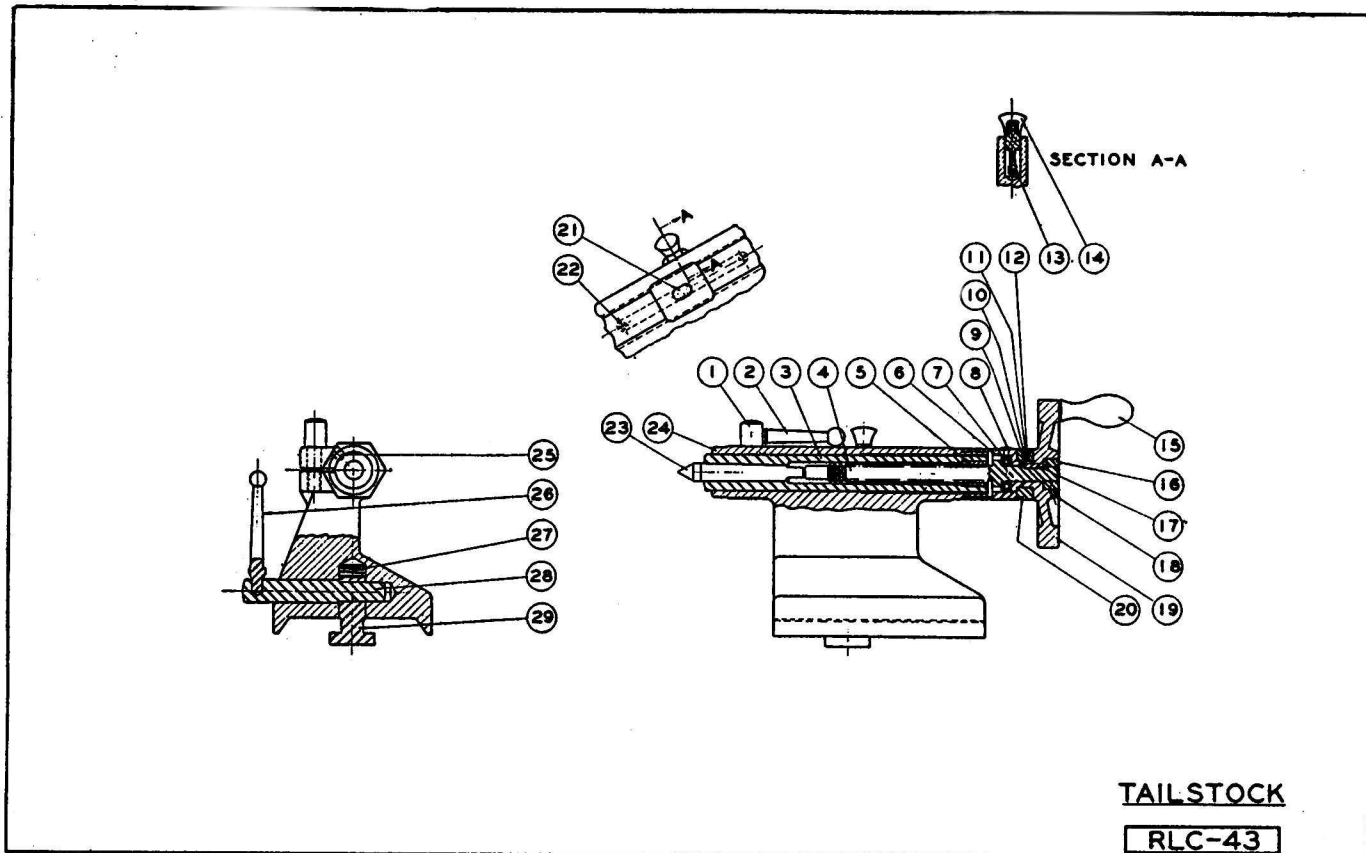
RIVETT LATHE & GRINDER INC.



PARTS LIST

Reference Number	Symbol	Name of Part	Reference Number	Symbol	Name of Part
1	715-4C-12-191	Draw-In Spindle Collar	29	715-4C-12-186	Handwheel Mounting Cone
2	715-12-701	Spindle Handwheel	30	715-12-328	Handwheel Locking Nut
3	715-12-376	Removable Plate	31	715-4C-12-325	Spindle Nut
4		Allen #8-32 x 1/2 Cap Screw	32	715-12-188	Bearing Adjusting Collar
5	715-12-384	Headstock Sheave	33	715-12-270	Headstock
6	715-12-377	Retaining Plate (R. of R. Brg.)	34	715-12-288	Sheave Key
7		MRC-206R Ball Bearing	35	715-12-127	Eccentric Binder
8		Allen 1/4-20 x 1-1/8 Cap Screw	36	715-12-497	Binder Stud
9	715-12-190	Spacing Collar, Long	37	715-12-378	Retaining Plate (F. of R. Brg.)
10	715-12-290	Locking Collar Key	38	715-12-474	Bearing Spacer (F. of R. Brg.)
11	715-12-191	Spacing Collar, Short	39	715-12-187	Locking Collar
12	715-12-375	Retaining Plate (R. of F. Brg.)	40	715-12-473	Bearing Spacer (R. of F. Brg.)
13		MRC-107KRDB Ball Bearing	41	715-4C-12-467	Draw-In Spindle
14		Allen 1/4-20 x 3/4 Cap Screw	42	715-4C-12-292	Draw-In Spindle Knob
15	715-4C-12-637	Chuck Key Screw	43		#10-32 x 1/2 Flat Head Screw
16	715-4C-12-287	Spindle Chuck Key	44	715-4C-12-405	Ball Race
17		#6-32 x 3/16 Set Screw	45		MRC-#5B Thrust Bearing
18	715-12-324	Spindle Nose Nut	46	715-4C-12-374	Retaining Plate
19		#4-40 x 3/16 Mach. Screw	47	715-4C-12-188	Thrust Collar
20	715-12-287	Spindle Nose Key	48	715-4C-12-189	Spindle Collar
21	715-4C-12-466	Headstock Spindle	49	918-12-289	Locking Pin Key
22	715-4C-12-326	Spindle Collar Nut	50		Allen #8-32 x 1/2 Cap Screw
23	715-12-251	Spindle Nose Guard	51	715-12-257	Locking Pin Handle
24		#6-32 x 3/16 Set Screw	52	715-12-354	Locking Pin
25	715-12-374	Retaining Plate (F. of F. Brg.)	53		5/32 Diameter Steel Ball
26		Allen 1/4-20 x 1-3/8 Cap Screw	54	918-12-666	Locking Pin Spring
27	715-4C-12-293	Draw-In Spindle Knob	55	715-12-274	Locking Pin Holder
28	715-4C-12-467	Draw-In Spindle	56		Allen 1/8 Pipe Plug

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PARTS LIST

Reference Number	Symbol	Name of Part
1	3-1/2 L22-638	Spindle Clamp Screw
2	3-1/2 L22-260	Clamp Screw Handle
3	715-22-466	Tailstock Spindle
4	715-22-556	Feed Screw
5	715-22-151	Spindle Bushing
6	715-22-324	Tailstock Nut
7		Norma Hoff. Type EW-3/8 Thrust Brg.
8		Bowen #00 Style 56 Oil Cup
9	608-22C-511	Cork Tip
10	103-4B-511	Brass Tip
11	608-22C-666	Dial Spring
12		#10-32 x 3/16 Allen Set Screw
13	918-22-354	Oiling Pin
14		Oiling Pin Knob, #B-878 Amer. Insul.
15		Cinn. Ball Handle, Model #820, Size #0
16	918-22-324	Handwheel Nut
17	507-22-287	Feed Screw Key
18		#10-32 x 3/16 Allen Set Screw
19	715-22-701	Tailstock Handwheel
20	715-22-192	Tailstock Dial
21	505-22-193	Graduated Scale
22		#5-40 x 1/4 Lg. Flat Head Screw
23	715-22-729	Center
24	715-22-508	Tailstock
25	918-22-637	Spindle Guide Screw
26	506-22-260	Binder Handle
27	608-22-481	Binder Stud Spring
28	715-22-129	Binder Eccentric
29	505-22-500	Binder Stud

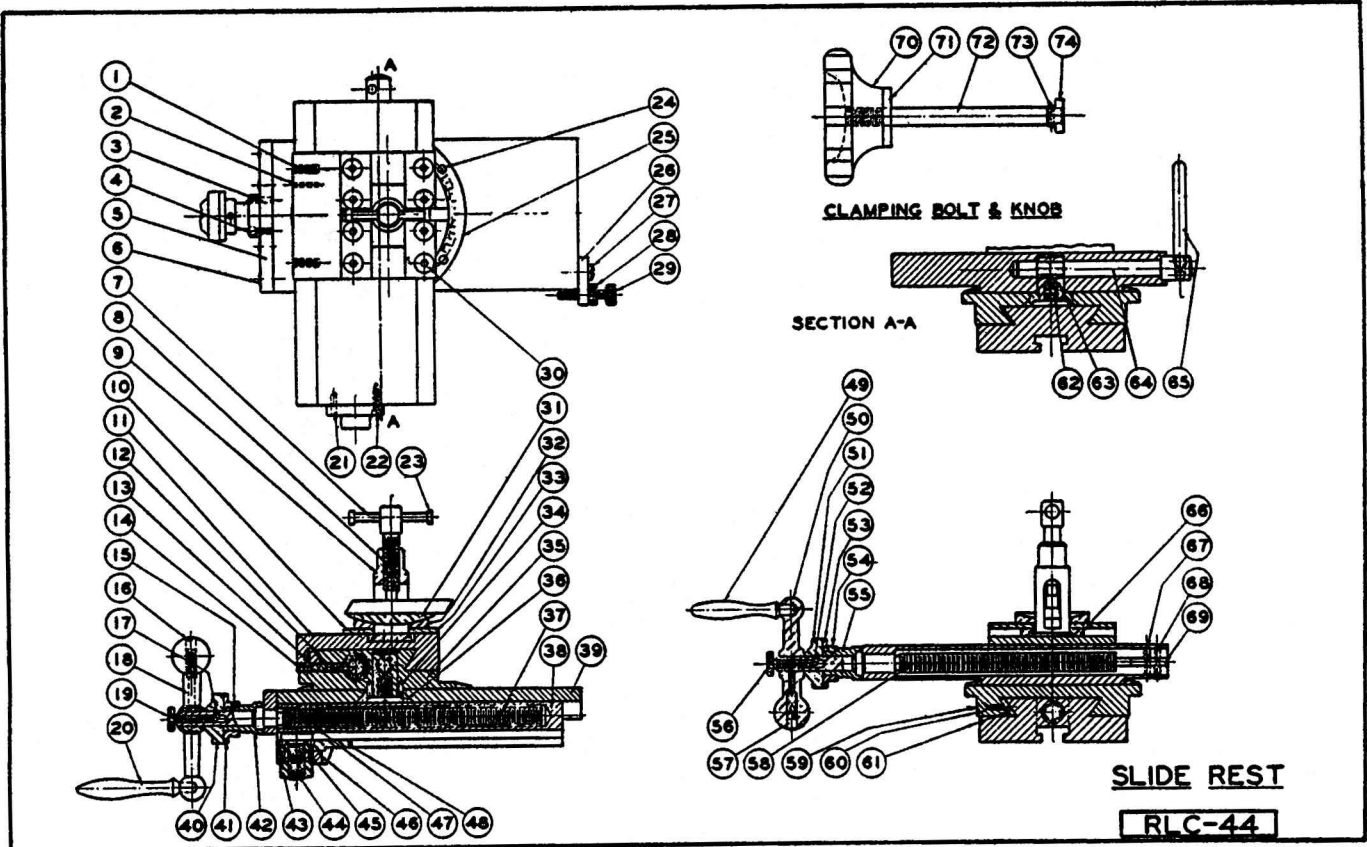
SLIDE REST

(Guide Plate Type)

The guide plate type slide rest mounts directly on lathe bed and is set at right angles to the lathe line of centers by guide plate held against front bevel of bed. This guide plate mounts in T-slot and may be adjustably set in any desired traverse position. The two slide movements are controlled by $7/16$ "-10 pitch, full depth Acme thread screws working in long bronze nuts operated by ball handles and fitted with large adjustable dials graduated to .001". The top slide may be swivelled to any position, the angle being read on dial graduated over its full circumference and there locked by binder. The tool post swivably mounts in oblong block in T-slot having replaceable steel facing and takes square tool bits or tool holders. Oil slide ways frequently with a good grade of machine oil.

When bronze feed screw nuts become worn after long use, new nuts, supplied by us, may be easily installed.

RIVETT LATHE & GRINDER INC.



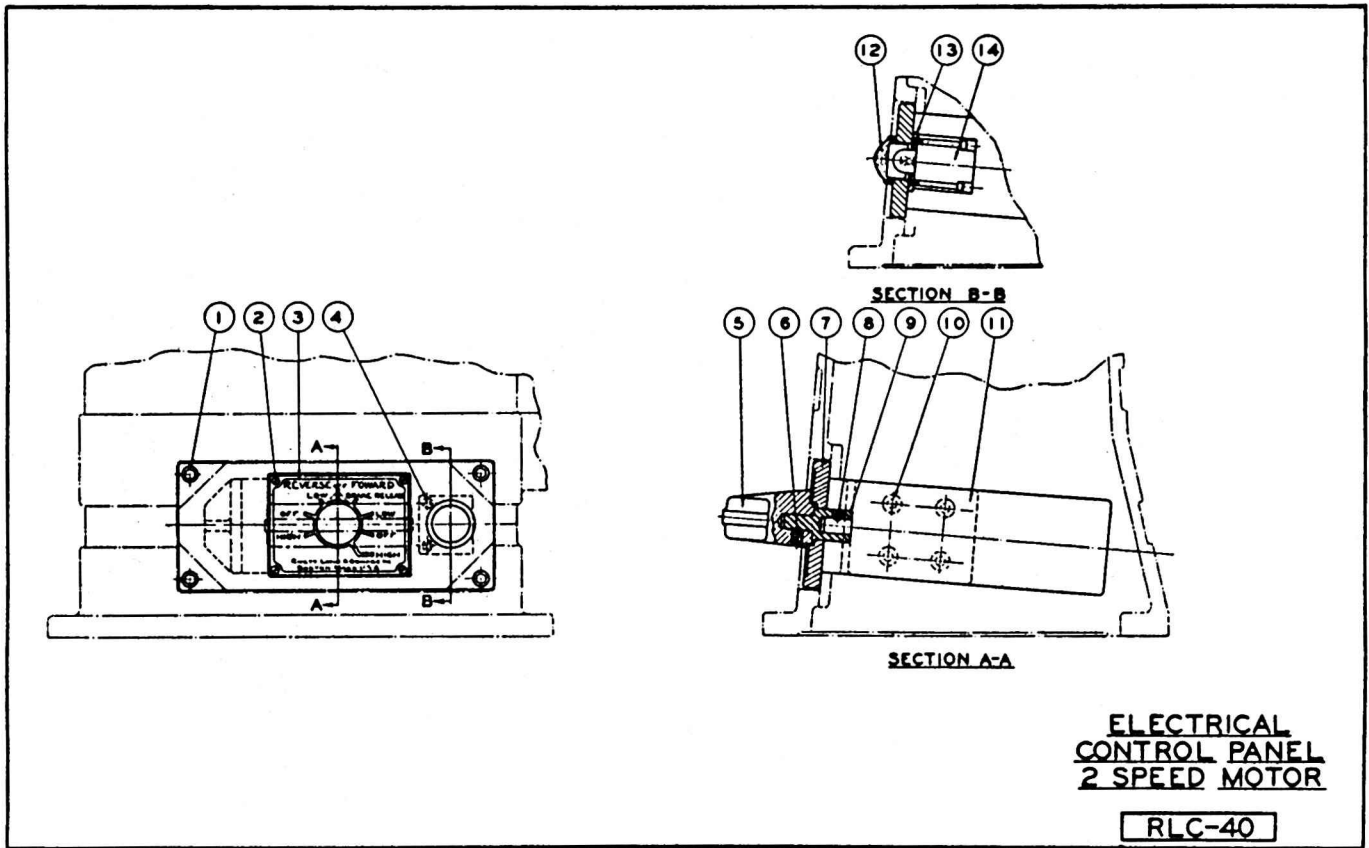
PARTS LIST

Reference Number	Symbol	Name of Part	Reference Number	Symbol	Name of Part
1	506-9-646	Slide Gib Screw	38	715-9-115	Base
2	106-13-355	Upper Slide Gib Dowel	39	715-9-462	Bottom Slide
3	506-9-357	Indicator Support Pin	40	506-9-195	Feed Screw Dial
4	506-9-646	Bearing Plate Screw	41	506-9-217	Indicator Flange
5	715-9-375	Feed Screw Bearing Plate	42	715-9-568	Indicator Flange Support
6		#10-32 x 3/8 Fill. Head Cap Screw	43		5/8-16 Hex. Nut
7	506-9-242	Clamp Screw Handle	44	715-9-638	Guide Plate Clamp Screw
8	506-9-948	Tool Holder Clamp Screw	45		#5-40 x 5/16 Flat Head Screw
9	715-9-733	Tool Post	46	715-9-376	Guide Plate
10	715-9-374	Top Slide Plate	47	715-9-325	Bottom Slide Feed Screw Nut
11	715-9-461	Top Slide	48	715-9-514	Guide Plate Tongue
12	715-9-245	Top Slide Gib	49	LH4-260	Top Slide Feed Screw Handle
13	506-9-245	Top Slide Feed Screw Nut Screw	50	506-9-265	Top Slide Feed Screw Ball Handle
14	715-9-324	Top Slide Feed Screw Nut	51	506-9-193	Feed Screw Dial
15		5/32-40 x 1/8 Allen Set Screw	52	506-9-127	Feed Screw Dial Binder
16	506-9-642	Bottom Slide Ball Handle Ret. Screw	53	506-9-217	Indicator Flange
17	506-9-127	Feed Screw Dial Binder	54		5/32-40 x 1/8 Allen Set Screw
18	506-9-261	Bottom Slide Feed Screw Ball Handle	55	715-9-568	Indicator Flange Support
19	506-9-647	Dial Binder Screw	56	506-9-647	Dial Binder Screw
20	506-9-260	Bottom Slide Feed Screw Handle	57	506-9-949	Top Slide Ball Handle Ret. Screw
21	506-9-357	Indicator Support Pin	58	715-9-557	Top Slide Feed Screw
22	506-9-646	Bearing Plate Screw	59	103-16-199	Lower Slide Gib Dowel
23	506-9-188	Collar for Clamp Screw Handle	60		#10-32 x 3/4 Set Screw
24		#4-40 x 1/4 Lg. Fill. Head Cap Screw	61	715-9-246	Bottom Slide Gib
25	505-9-193	Graduate Ring	62	715-9-637	Binder Stud Screw
26	506-9-133	Bottom Slide Stop Block	63	715-9-497	Binder Stud
27	506-9-947	Stop Block Screw	64	715-9-128	Eccentric Binder
28	506-9-326	Bottom Slide Stop Screw Check Nut	65	507-9-260	Eccentric Binder Handle
29	506-9-643	Bottom Slide Stop Screw	66	715-9-127	Tool Post Binder
30	505-9-637	1/4-28 Flat Head Screw	67	506-9-650	Lower Swivel Block Screw
31	506-9-249	Tool Holder Grip	68	506-9-199	Lower Swivel Block Dowel
32	715-9-521	Tool Holder Washer	69	715-9-134	Lower Swivel Block
33	715-9-374	Top Slide Plate	70	715-24-292	"W" Bolt Knob
34	715-9-199	Binder Stud Cone Dowel	71	506-23-522	"W" Bolt Washer
35	715-9-503	Lower Swivel	72	715-24-142	Clamping Bolt
36	715-9-186	Binder Stud Cone	73	LRMS-199	Pin for Stud Head
37	715-9-556	Bottom Slide Feed Screw	74	918-344-267	Stud Head

ELECTRICAL CONTROL PANEL

Four way switch with single knob mounts on electrical control panel in left end base of lathe bed and provides two speeds forward and reverse, and brake release positions. Pilot light also mounted on electrical panel indicates when power is available through disconnect switch. This panel is held by four Allen cap screws and may be removed for examining or rewiring switch or pilot light. When push button control, for magnetic starter, is used, start and stop buttons may be installed adjacent to panel and standard High and Low both Forward and Reverse carried on panel exactly as when drum switch control only is used.

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PARTS LIST

Reference Number	Symbol	Name of Part
1		Allen 1/4-20 x 3/8 Cap Screw
2		#6-32 x 3/16 Round Head Screw
3	918-23-381	Motor Operating Plate
4		#10-32 x 3/8 Round Head Screw
5	918-23-294	Switch Handle
6		Allen 1/4-20 x 3/8 Set Screw
7		Switch Bracket
8		Clear Bullseye
9	715-23-378	Pilot Light Mounting
10		Pilot Light Receptacle
11		Neon Lamp

Plate
file with

HEADSTOCK

Headstock is illustrated and described in bulletin attached. The headstock is totally enclosed with integrally cast mounts for spindle ball bearings. Front spindle bearings are preloaded. Rear bearing floats to compensate for expansion and contraction. No adjustment is required. Spindle nose is of long taper key-drive type consisting of keyed taper nose, guard and retaining nut. When using draw-in collets, nose guard is left in place to bind retaining nut. Draw-in collets mount directly in spindle mouth and are opened and closed by draw-in spindle. When using jaw chucks and face plates the nose guard is removed, the keyed chuck or plate located on taper and locked in place by retaining nut. When tightening nut, spindle is locked by engaging locking pin at rear of headstock in notched collar on spindle. Handwheel is mounted on left end of spindle for turning same by hand when setting up, indexing, etc.

Headstock bearings are grease packed in assembly and should not be relubricated, under normal operating conditions, for several months after machine has been put into operation. At this time approximately 1/2 to 3/4 cubic inch per lubrication point may be introduced with grease gun by removing plugs at upper rear of headstock and inserting grease fitting. It is very important to guard against introducing particles of grit or any foreign matter when relubricating.

Recommended lubricant:-New York, New Jersey S-59 non-fluid oil.

REPLACEMENT OF DRIVING VEE BELTS TO SPINDLE

Vertical matched Vee belts from drive to lathe spindle may be replaced at any time without disturbing drive or disassembling lathe spindle or headstock. Remove draw-in spindle, loosen handwheel nut with special spanner wrench provided and draw assembly of wheel, sleeve and nut off lathe spindle. Remove Vee belts from driving sheave below and with a short hook withdraw through uncovered opening in end of headstock. Slip new belts one at a time downward through uncovered opening and place on spindle sheave. Finally, place belts on driving sheave. Replace handwheel, using care to avoid runout, and lock by tapered sleeve and nut.