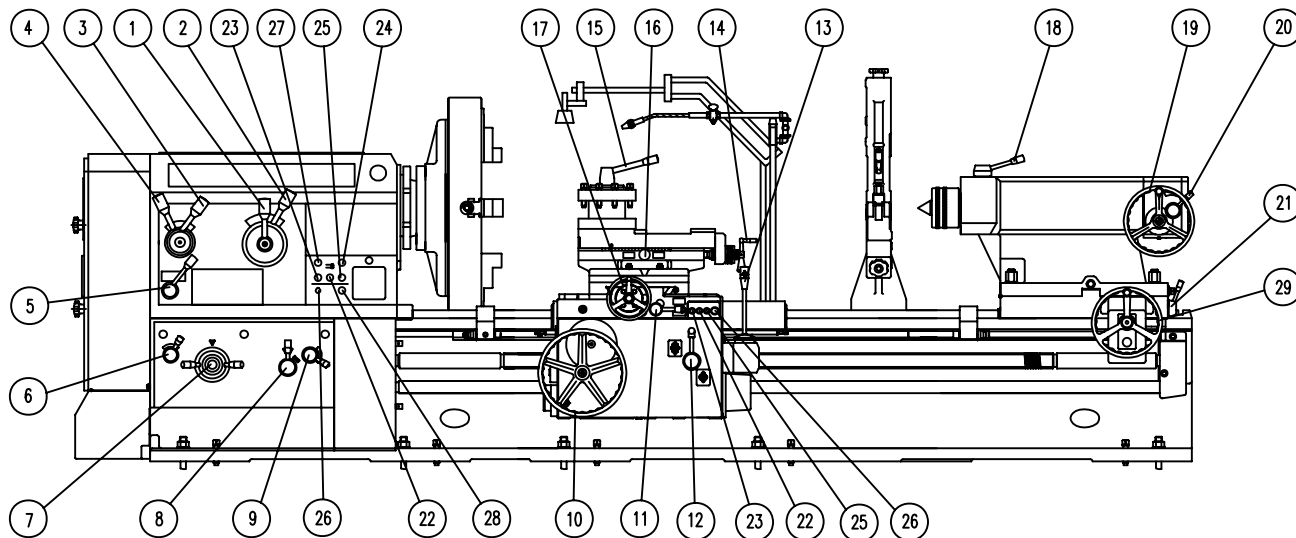


Control system of this serial machine is controlled by electrics, hydraulics and mechanics. Spindle control is by headstock or apron. Single handle with crossed slot on apron may control common feed and rapid travel for apron and top tool post.

Name and application of each handle (hand wheel) please see drawing 15.1.



DRAWING 15.1 MACHINE CONTROL

serial no.	name and application	serial no.	name and application	serial no.	name and application
1	handle for spindle speed change	11	handle for connecting lead screw or feed rod in saddle	21	handle for positioning pin of tailstock
2	handle for spindle speed change	12	handle for split nut	22	rotary button for spindle brake
3	handle for shift of left and right threads	13	control handle for longitudinal and cross feeds and button for rapid travel	23	button for reverse rotation or forward rotation at high speed for spindle
4	handle for coarse pitch	14	handle for travel of top tool post	24	button of point-move of spindle
5	handle for shift between forward and reverse rotation of spindle	15	handle for fixing and releasing square tool post	25	button of forward rotation of spindle
6	handle for shift between metric and inch threads	16	rotary button for mechanic and manual changes of top tool post	26	button for stop and emergency stop of main motor
7	handle for adjusting pitch and feed rate	17	hand wheel for cross travel of saddle	27	button for spindle stop
8	handle for adjusting pitch and feed rate	18	handle for clamping tailstock sleeve	28	start button for main motor
9	handle for connecting feed rod/lead screw	19	hand wheel for travel of tailstock sleeve	29	hand-wheel for tailstock travel
10	hand wheel for longitudinal travel of saddle	20	handle for shift between rapid and slow travel of tailstock sleeve		