

# 540

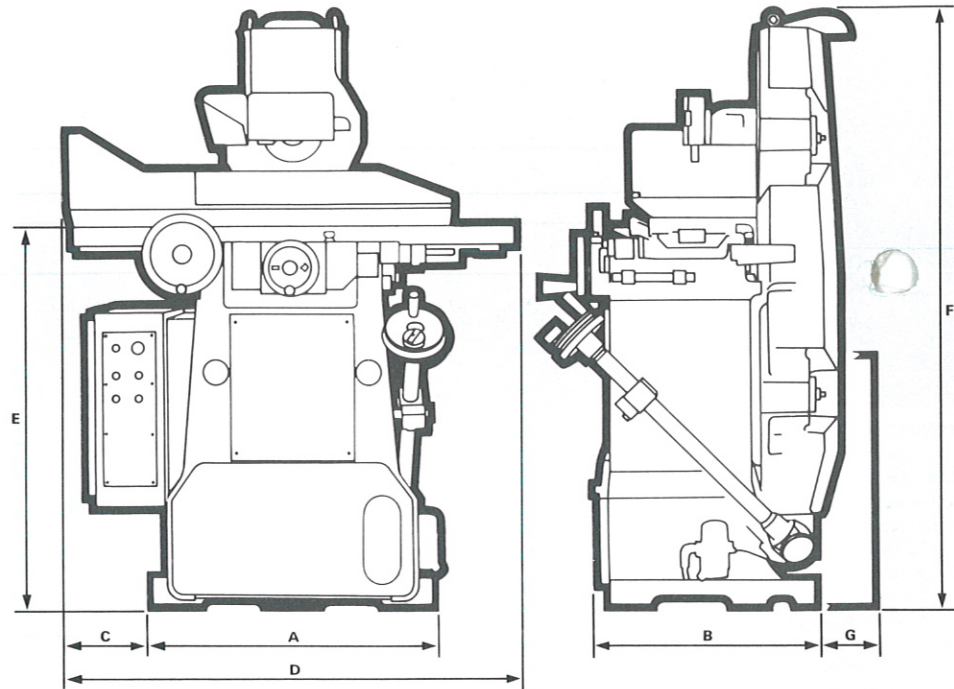
## MACHINE DIMENSIONS

### 540

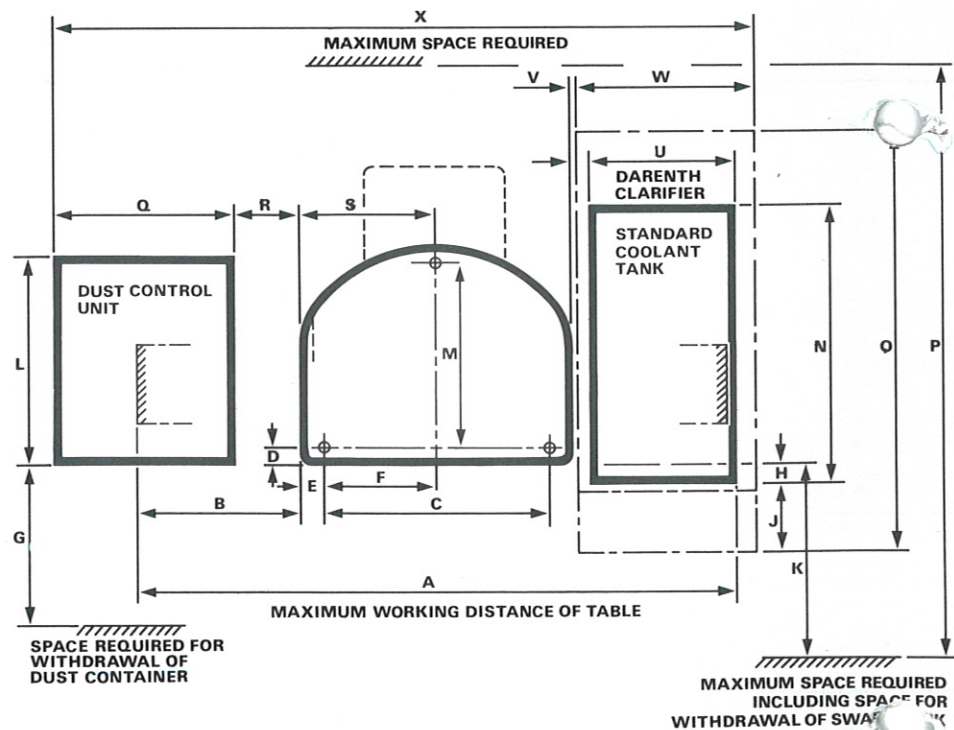
A	736mm	29"
B	597mm	23½"
C	196mm	7½"
D	1168mm	46"
E	1035mm	40½"
F	1651mm	65"
G	Nil	Nil

### 540L

A	746mm	29½"
B	702mm	27½"
C	192mm	7½"
D	1168mm	46"
E	1035mm	40½"
F	1880mm	74"
G	190mm	7½"

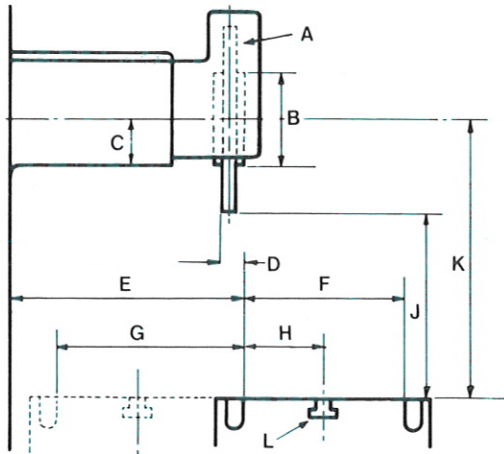


	540	540L
A	1651mm 65"	1651mm 65"
B	457mm 18"	452mm 17½"
C	696mm 27½"	708mm 27½"
D	39mm 1½"	32mm 1½"
E	19mm ¾"	19mm ¾"
F	349mm 13½"	354mm 13½"
G	559mm 22"	559mm 22"
H	51mm 2"	51mm 2"
J	251mm 9½"	251mm 9½"
K	711mm 28"	711mm 28"
L	565mm 22½"	565mm 22½"
M	539mm 21½"	651mm 25½"
N	749mm 29½"	749mm 29½"
O	1165mm 45½"	1165mm 45½"
P	1854mm 73"	1854mm 73"
Q	485mm 19½"	485mm 19½"
R	203mm 8"	110mm 4½"
S	368mm 14½"	373mm 14½"
T	64mm 2½"	65mm 2½"
U	394mm 15½"	394mm 15½"
V	25mm 1"	65mm 2½"
W	495mm 19½"	495mm 19½"
X	1944mm 76½"	1900mm 74½"





# WHEELHEAD CAPACITIES

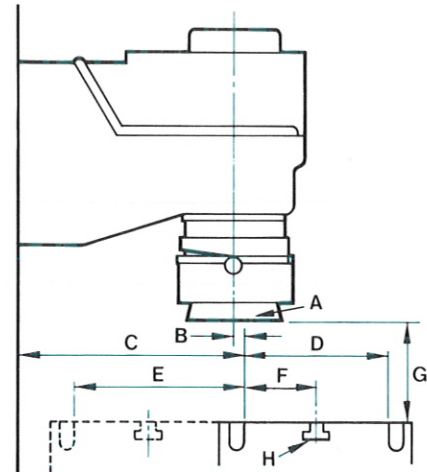


**540**

A	180×13×31,75mm 7"×½"×1¼" Bore, Grinding Wheel
B	90mm 3½" dia.
C	44mm 1¾"
D	16mm ⅝"
E	214mm 8⅞" approx.
F	150mm 6"
G	168mm 6⅝" min.
H	75mm 3"
J	240mm 9⅞" max.
K	330mm 13" max. 50mm 2" min. 160mm 6⅝" min. (540 C.P. ONLY)
L	12,7mm ½" Standard Tee Slot

**540L**

A	200×20×31,75mm 8"×¾"×1¼" Bore, Grinding Wheel
B	102mm 4" dia.
C	44mm 1¾"
D	20mm ¾"
E	214mm 8⅞" approx.
F	150mm 6"
G	168mm 6⅝" min.
H	75mm 3"
J	405mm 15⅞" max.
K	505mm 19⅞" max. 100mm 3⅞" min.
L	12,7mm ½" Standard Tee Slot



**540VS**

A	100×10×31,75mm 4"×⅜"×1¼" Bore, 65mm, 2½" Body Depth, Cup Grinding Wheel
B	5mm ⅜"
C	214mm 8⅞" approx.
D	150mm 6"
E	168mm 6⅝" min.
F	75mm 3"
G	165mm 6½" max.
H	12,7mm ½" Standard Tee Slot

## Standard Equipment

### 540

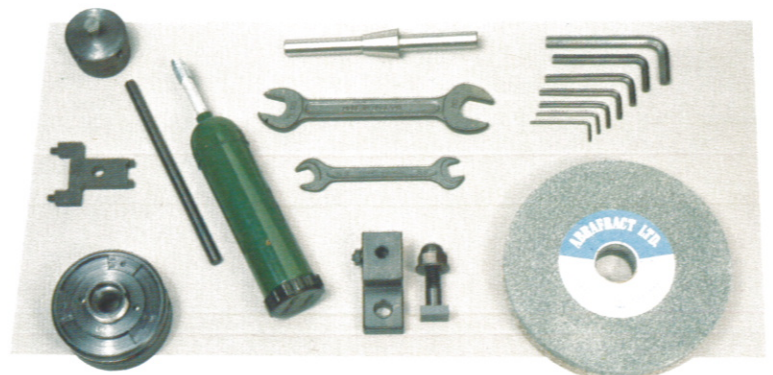
Two grinding wheels 180 × 13 × 31,75mm bore, (one for general use and one for cast iron). Grinding wheel flange. Automatic lubrication system. Mandrel for balancing complete wheel assembly. Diamond holder, less diamond. Table guards and wheel guard with dust exhaust nozzle. Machine equipped for wet grinding less pump and tank. Interlocked table handwheel. Oil gun, spanners and wrenches. Push buttons for wheelhead, hydraulic system and coolant dust exhaust. Motors and electrical control gear suitable for operating on any standard 3 phase AC supply.

### 540L

Two grinding wheels 200×20×31,75mm bore (one for general use and one for cast iron). Powered elevation to wheelhead. Saddle lock. Two speed wheelhead motor allowing selection of 1325/2650 r.p.m. Low voltage lighting. And as 540.

### 540VS

Two wheel flanges. Automatic downfeed to wheelhead. Powered elevation to wheelhead. Electric pump and coolant service fittings, incorporating Darenth Paper roll clarifier. Internal belting. And as 540.







# SPECIFICATIONS

	540	540L	540VS
Vertical movement of wheelhead (max.)	280mm 11"	405mm 15 <sup>15</sup> / <sub>16</sub> "	190mm 7 <sup>1</sup> / <sub>2</sub> " 100×10×31,75mm bore 4"× <sup>3</sup> / <sub>8</sub> "×1 <sup>1</sup> / <sub>2</sub> " bore 65mm body depth 2 <sup>1</sup> / <sub>2</sub> " body depth
Size of grinding wheel (standard)	180×13×31,75mm bore 7"× <sup>1</sup> / <sub>2</sub> "×1 <sup>1</sup> / <sub>2</sub> " bore	200×20×31,75mm bore 8"× <sup>3</sup> / <sub>4</sub> "×1 <sup>1</sup> / <sub>2</sub> " bore	150×10×31,75mm bore 6"× <sup>3</sup> / <sub>8</sub> "×1 <sup>1</sup> / <sub>2</sub> " bore
Size of grinding wheel (max.)*	180×25×31,75mm bore 7"×1"×1 <sup>1</sup> / <sub>4</sub> " bore	200×25×31,75mm bore 8"×1"×1 <sup>1</sup> / <sub>4</sub> " bore	63mm body depth 2 <sup>1</sup> / <sub>2</sub> " body depth 5070 r.p.m.
Speed of grinding wheel	3000 r.p.m.	1325 & 2650 r.p.m.	
Net weight (approx.)	914 kg 2015 lb	1016 kg 2240 lb	920 kg 2029 lb
Gross weight (approx.)	1118 kg 2465 lb	1270 kg 2800 lb	1165 kg 2569 lb
Shipping dimensions (approx.)	4,04m <sup>3</sup> 142,6 ft <sup>3</sup>	4,26m <sup>3</sup> 150,4 ft <sup>3</sup>	4,94m <sup>3</sup> 174 ft <sup>3</sup>

\*Recessed wheels for use with Diaform and Optidress units

## COMMON TO ALL MODELS

Table	Working surface of table Longitudinal traverse of table, hand Longitudinal traverse of table, hydraulic Total cross traverse of table hand and hydraulic Traverse speed range per minute Table traverse per revolution of handwheel Number of tenon slots Width of tenon slot Size of tee bolt required	457×152mm 483mm 470mm 168mm 1,5 to 18m 60mm 1 14,2875mm 12,7mm	18"×6" 19" 18-5" 6-5/8" 5 to 60 ft 2-35" 1 0-5625" 1/2"
Feeds	Crossfeed handwheel graduated in Crossfeed fine feed knob graduated in Crossfeed range per stroke at each reversal Crossfeed per revolution of crossfeed handwheel Vertical feed handwheel graduated in (basic 540) Vertical feed per revolution of handwheel Vertical feed handwheel graduated in (all other models) Vertical feed per revolution of handwheel Automatic downfeed min to max (models 540AP, 540LA & 540VS) Optional two rate automatic downfeed at coarse and fine rates min. to max.	0,05mm 0,002mm 0,178 to 1,78mm 10mm 0,002mm 0,5mm 0,001mm 0,2mm 0,001 to 0,006mm 0,001 to 0,020mm	0-001" 0-0001" 0-007" to 0-07" 0-40" 0-0001" 0-02" 0-00005" 0-01" 0-00005" to 0-0003" 0-00005" to 0-001"
Motors	Wheelhead motor Hydraulic pump motor Elevation motor (if applicable)	1,5 kW 0,55 kW 0,18 kW	2 HP 1/2 HP 1/2 HP
Capacities	Hydraulic system working pressure Hydraulic tank capacity (approx.)	7,03 kg/cm <sup>2</sup> 15,5 litres	100 lb/in <sup>2</sup> 3-4 gallons

Customers using the metric system can have the machine fitted with metric lead screws, dials, etc., on request as standard.

## ADDITIONAL EQUIPMENT

(Not illustrated on pages 18, 19, 20 & 21)

Dual Imperial Metric calibrated dials.  
Low voltage lighting equipment with transformer.  
'Trav-a-dial' traverse gauge.  
'D.O.M.' linear optical measuring units.  
Westwind air bearing spindle unit complete with filters, etc., in lieu of standard wheelhead.  
Variable speed wheelhead motor drive 1000 4000 r.p.m. in lieu of standard.

Two speed wheelhead motor giving spindle speeds of 1500/3000 r.p.m., in lieu of standard. (Standard on 540L).  
Locking device for cross saddle, for use when form grinding. (Standard on 540L).  
Table mounted diamond holder, minimum height 6" (152mm).  
Additional wheelflange.  
Additional grinding wheel, either standard grade.