

1.03.1 List of text pages

Chapter	Denomination	Ser.-No.
1.00	HEADING ILLUSTRATION WITH TRADEMARK OF MANUFACTURER	
1.01	INTRODUCTION	1.1
1.02	LEGAL RIGHTS LETTER OF GUARANTEE CONDITIONS OF THE GUARANTEE	1.2 - 1.3
1.03	ACCEPTANCE IDENTIFICATION OF THE MACHINE VARIANT	1.4
1.03.1	CONTENTS	1.5 - 1.7
1.03.2	List of text pages	1.5 - 1.6
1.04	List of figures	1.7
1.05	TECHNICAL DATA (for data of electric equipment see chapter "ELECTRIC EQUIPMENT")	1.8 - 1.9
1.05.1	ACCESSORIES	1.10 - 1.11
1.05.2	Standard accessories	1.10
1.05.3	Extra accessories	1.10
2.00	Appendices	1.11
2.01	PUTTING INTO OPERATION	2.1 - 2.3
2.02	Transport	2.1
2.03	Unpacking	2.1
2.04	Cleaning	2.2
2.05	Foundation, erection, levelling	2.2 - 2.3
3.00	ARRANGEMENTS FOR OPERATION	2.3
3.01	DESCRIPTION OF MECHANISM	3.1 - 3.10
3.02	Main drive	3.3
3.03	Feed-changing box	3.3 - 3.4
3.04	Feed clutch	3.4
3.05	Starting and main drive reversing mechanism	3.4
3.06	Spindle	3.4 - 3.5
	Feed engaging head	3.5
	5	5

RF50/1250
/1600

1.04 TECHNICAL DATA

1.8

RF50/12
/16

For the sake of simplicity the type designations have been marked in the Manual with the marks "a" and "b" as follows:

RF50/1250 = type "a"

RF50/1600 = type "b"

		Dimensions in mm	
		Max. possible diameter	
		In steel 600 N/mm ²	In cast iron 260 N/mm ²
Boring,	without drilling, feed rate 0,25 mm/r	50	63
	drilled to 1/2 dia. mm	100	120
Tapping,	Whitworth thread, inch	1 1/4"	1 3/4"
	Metric fine thread, mm	50	60

Spindle

	Type "a"	Type "b"
Distance to side of sleeve max. mm	1250	1600
Distance to side of sleeve min. mm		350
Distance to baseplate max. mm		1420
Distance to baseplate min. mm		350
Travel mm		300
Spindle bearing seat dia / quill dia mm		40/78
Morse taper No.		5
Number of speeds		12
Range of speeds, with 50 cycles r/min	45-63-90-125-180-250- 355-500-710-1000- 1400-2000	

5

8

Spin

Ran

Num

Ran

Sle

Bas

Wor

T-s

Mac

Ove

We

ac

Ca

Spindle

	Type "a"	Type "b"
Range of speeds with 60 cycles, r/min	50-71-100-140-200- 280-400-560-800-1120- 1600-2240	
Number of feeds	9	
Range of feeds	0,05-0,075-0,112- 0,17-0,25-0,37-0,56- 0,84-1,25	
Sleeve dia. mm	360	

Baseplate

Working surface: length x width mm	1325x930	1675x930
T-slots, number and spacing .. mm	4x200	4x200

Machine

Overall dimensions	mm	
length x width x height	Type "a" : 2190x950x2830	Type "b" : 2540x950x2830
Weight including standard accessories	kg	
	Type "a" : 3050	Type "b" : 3200
Case dimensions	mm	
length x width x height	Type "a" : 2500x1300x3200	Type "b" : 2800x1300x3200