

NEW NEBEL



IMPERIAL

— 20"/40" EXTENSION BED GAP LATHE —

Nebel Machine Tool Corp., Cincinnati 25, Ohio, U. S. A.





IMPERIAL

S P E C I F I C A T I O N S

CAPACITY

Swing over ways.....	24½"
Swing through gap.....	42"
Swing over compound rest.....	13"
Size of tools.....	¾" x 1⅝"
Steady rest capacity.....	½" to 7"
Small face plate diameter.....	24"
Large face plate diameter (extra equipment).....	40"

HEADSTOCK

Spindle speeds, standard, number.....	18
Spindle speeds, standard range with 1200 rpm motor.....	11 to 666 rpm
Spindle speeds, standard range with 1800 rpm motor.....	16 to 1000 rpm
Spindle speeds, with 2-speed motor, number.....	36
Spindle speeds, range with 1200/600 rpm motor.....	5 to 666 rpm
Spindle speeds, range with 1800/900 rpm motor.....	8 to 1000 rpm
Spindle nose, taper key drive, ASA std. B 5.9 size.....	L 2
Centers, ASA std. B 5.10.....	No. 5
Hole through spindle.....	2"

BED

Width of sliding bed.....	22⅜"
Depth of sliding bed.....	11"
Depth of lower bed.....	12⅞"
Length of bed 8' 8½" and multiples of 2 ft. up to.....	30' 8½"

CARRIAGE

Carriage length on bed.....	29"
Compound rest travel.....	7"
Width of bridge.....	11½"

FEEDS-THREADS

Threads, number.....	60
Threads per inch.....	1, 1¼, 1⅜, 1⅞, 1½, 1⅝, 1⅞, 1¾, 1⅞, 2, 2¼, 2½, 2¾, 2⅞, 3, 3¼, 3⅝, 3½, 3¾, 4, 4½, 5, 5½, 5¾, 6, 6½, 6¾, 7, 7½, 8, 9, 10, 11, 11½, 12, 13, 13½, 14, 15, 16, 18, 20, 22, 23, 24, 26, 27, 28, 30, 32, 36, 40, 44, 46, 48, 52, 54, 56, 60, 72.

Feed changes, number.....	60
Feed, range.....	.0027" to .192"
Leadscrew threads per inch, Acme R.H.....	2
Leadscrew diameter.....	1¾"

TAILSTOCK

Spindle diameter.....	4"
Spindle traverse.....	10½"
Length on bed.....	20"

TAPER ATTACHMENT

Maximum taper per ft.....	4½"
Turns at one setting.....	24"

MOTOR

Horsepower recommended.....	15 to 20
Single speed, rpm.....	1200 or 1800
2-speed, rpm.....	1200/600 or 1800/900

WEIGHT

Weight, crated, 8' 8½" bed.....	10,000
Weight crated, each additional 2 ft.....	2,000
Weight boxed for export, 8' 8½" bed.....	11,700
Weight boxed for export each additional 2 ft.....	1700
Dimensions of case, 8' 8½" bed.....	6'2" x 5'4½" x 12'2"

STANDARD EQUIPMENT

Chasing dial, jack support for upper bed, 24" face plate, compound rest with standard tool post, L2 taper key drive spindle nose, steady rest, two lathe centers and necessary wrenches. Machine arranged for motor drive but not including motor or electrical equipment.

EXTRA EQUIPMENT

Extension rest with standard toolpost, taper attachment, longitudinal power rapid traverse, hardened and ground steel bed ways, hydraulic duplicating attachment, large 40" face plate, chip pan. Coolant pump, special tool blocks, special capacity steady rests, follow rest, micrometer carriage stop and many others.

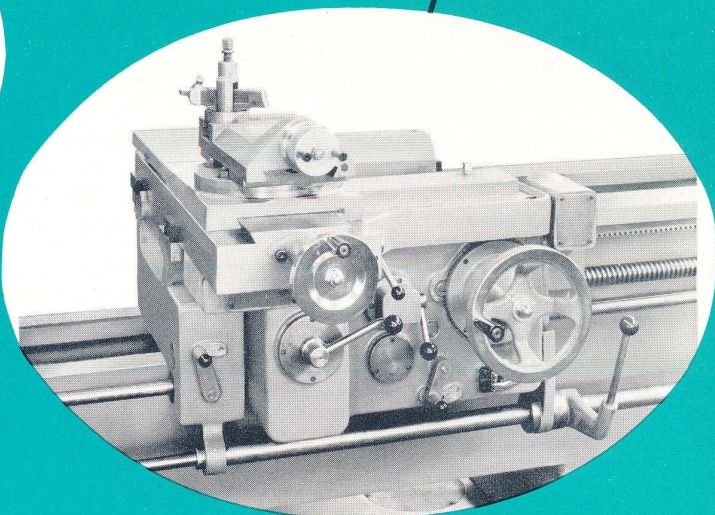
E X T E N S I O N B E D G A P D I M E N S I O N S

Length of bed (nominal)	8 ft.	10 ft.	12 ft.	14 ft.	16 ft.	18 ft.	20 ft.	22 ft.	24 ft.	26 ft.	28 ft.	30 ft.
Maximum width of gap..	2'8"	3'8"	4'8"	5'8"	6'8"	7'8"	8'8"	9'8"	10'8"	11'8"	12'8"	13'8"
Distance from face plate to end of gap.....	2'0"	3'0"	4'0"	5'0"	6'0"	7'0"	8'0"	9'0"	10'0"	11'0"	12'0"	13'0"
Distance between centers, gap closed.....	2'8"	4'8"	6'8"	8'8"	10'8"	12'8"	14'8"	16'8"	18'8"	20'8"	22'8"	24'8"
Distance between centers, gap opened.....	5'4"	8'4"	11'4"	14'4"	17'4"	20'4"	23'4"	26'4"	29'4"	32'4"	35'4"	38'4"

Nebel Machine Tool Corp., Cincinnati 25, Ohio, U.S.A., *workhorse of the metalworking shop since 1899*



Enclosed quick change gear box. Completely enclosed, lubricated automatically. All gears heat treated and finished. 60 feed and thread changes obtained through exclusive Nebel-designed selector.



Wide carriage has 166 square inches of bearing surface on bed. Cross feed control lever located conveniently close to operator on extended carriage bridge. Cross feed has compensating type nut. One-shot plunger lubricates cross slide and bed ways. Wings fitted with shear wipers.

Double wall apron. One-piece double wall construction provides inboard and outboard bearing support for all shafts. Gears are heat treated and finished, and lubricated by an enclosed system. All moving parts run on anti-friction bearings.

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Handwheel is

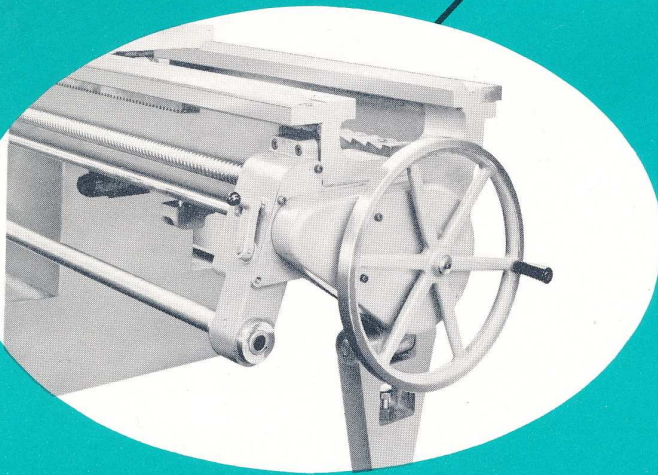


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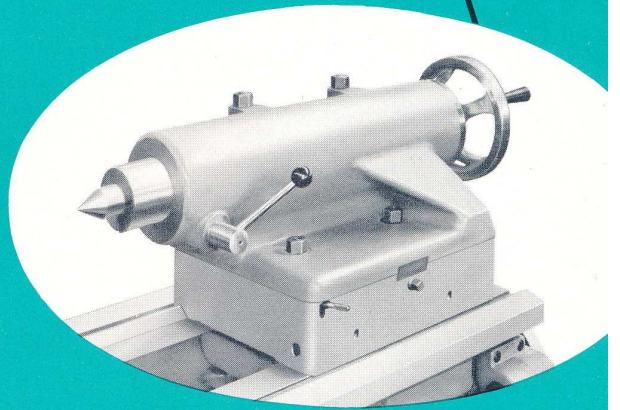
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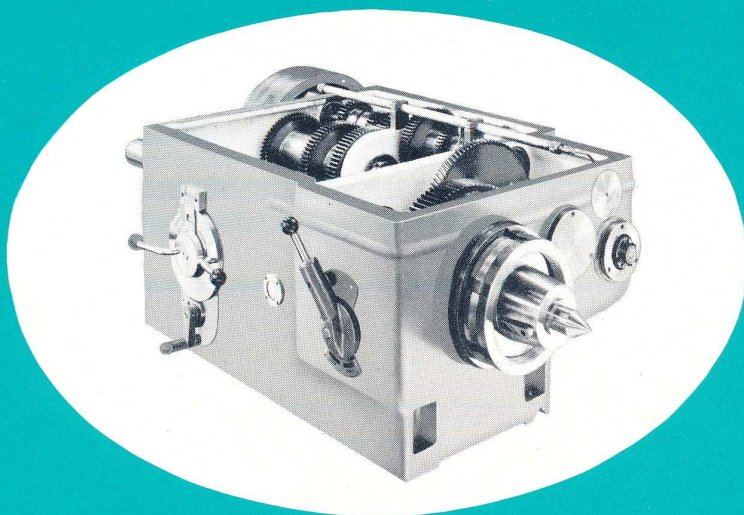
Power Traverse Screw moves the great weight of the sliding upper bed without effort on the part of operator. Handwheel is provided for close adjustments.



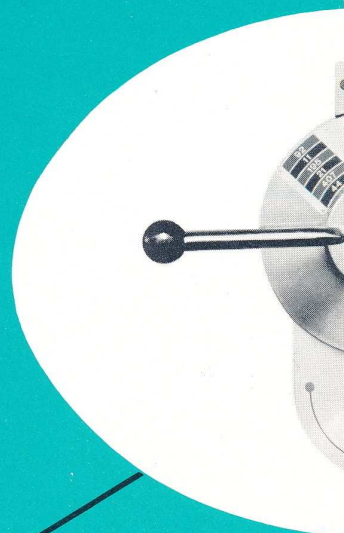
Heavy duty tailstock has 4" diameter spindle, a spindle traverse of 10½", a bearing length of 20" on the bed, and takes a No. 5 ASA standard center. Although the Imperial tailstock weighs 600 lbs., a hook and latch arrangement allows operator to "pick-up" the tailstock and move it with power from the longitudinal feed.

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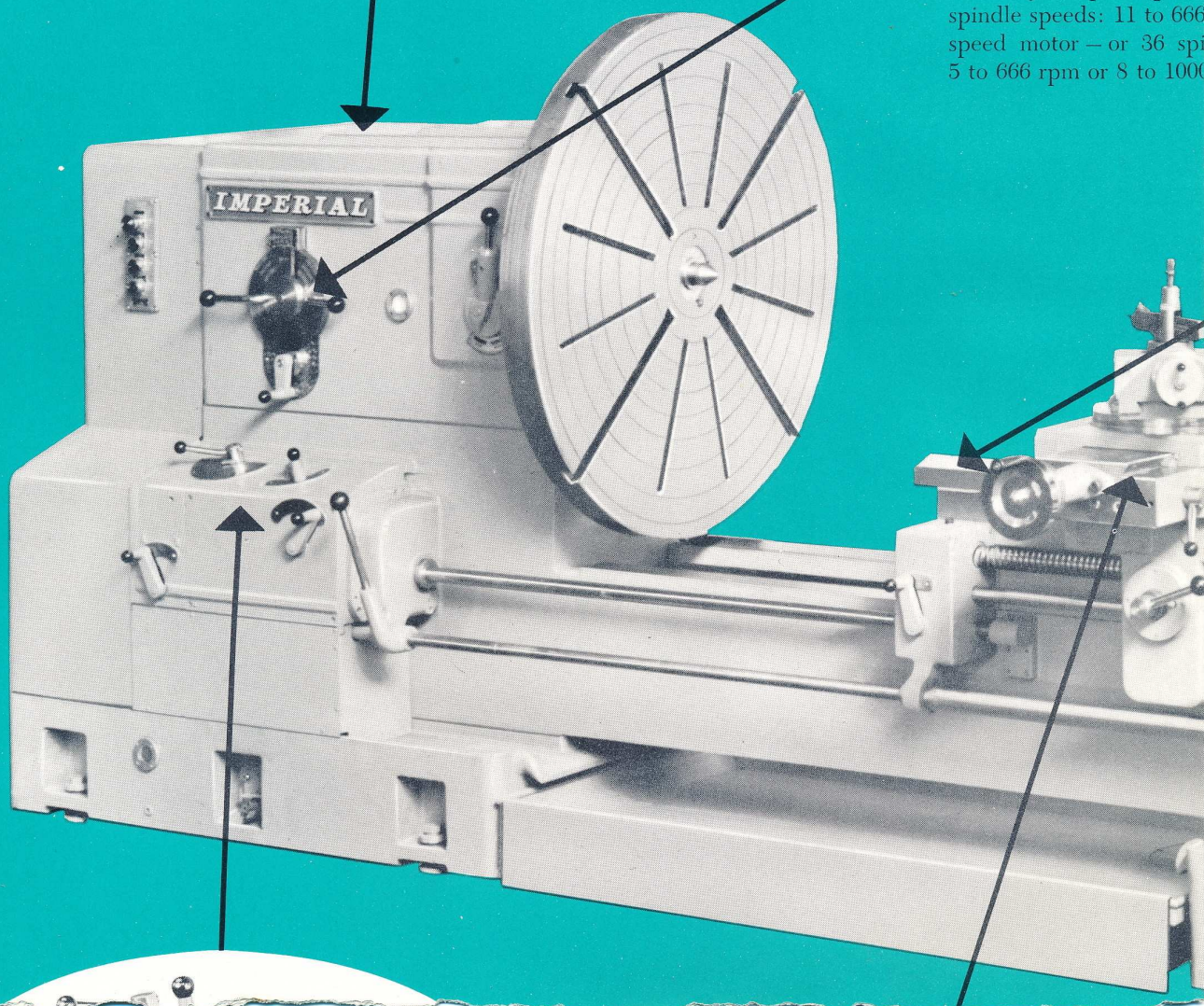
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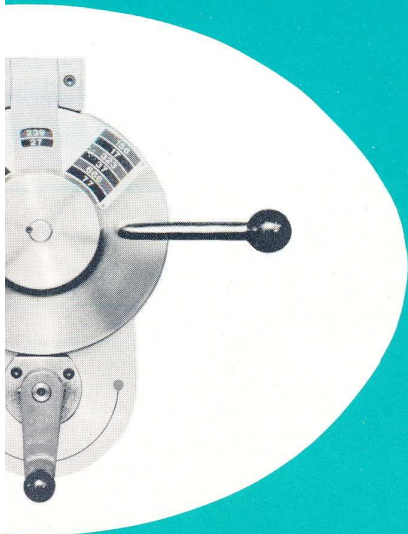


Powerful geared headstock: Smartly engineered, perfectly balanced, the Imperial headstock delivers plenty of power to the spindle. Shaved and hardened steel gears and anti-friction bearings throughout. 3-bearing spindle. Automatic oil spray lubrication system.

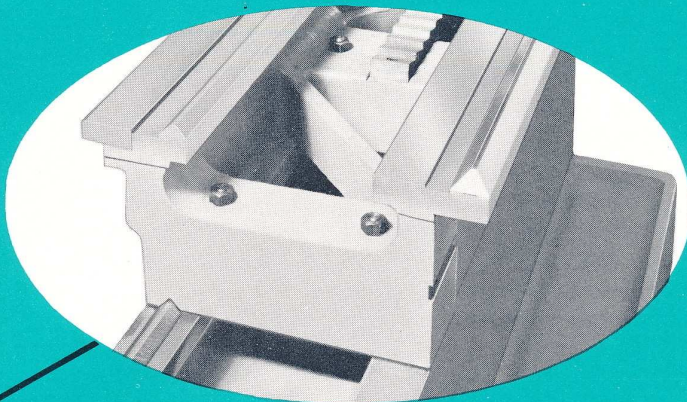


Direct Reading Sp
color-keyed speed plate
spindle speeds: 11 to 666
speed motor — or 36 spi
5 to 666 rpm or 8 to 1000

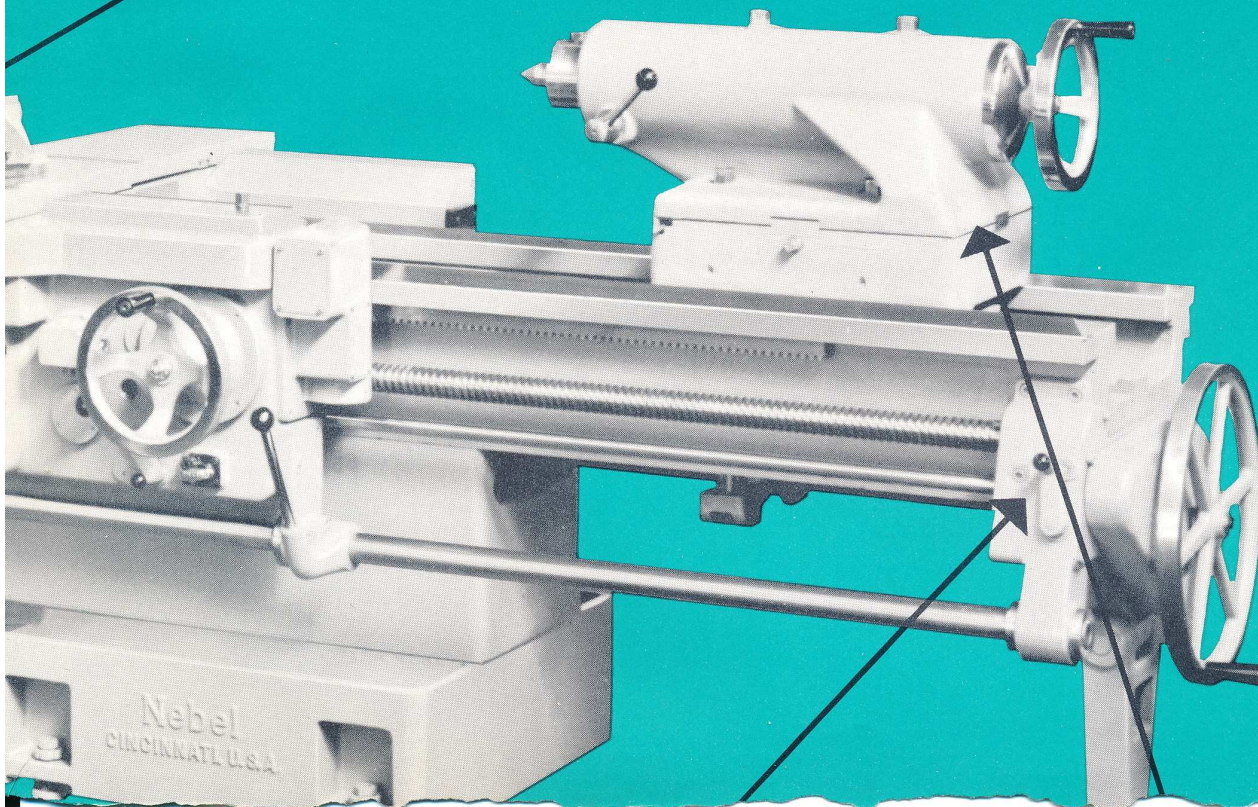




Speed Selector: 2 levers and control the entire range of 18 rpm or 16 to 1000 rpm with single handle speeds with 2-speed motor: rpm.

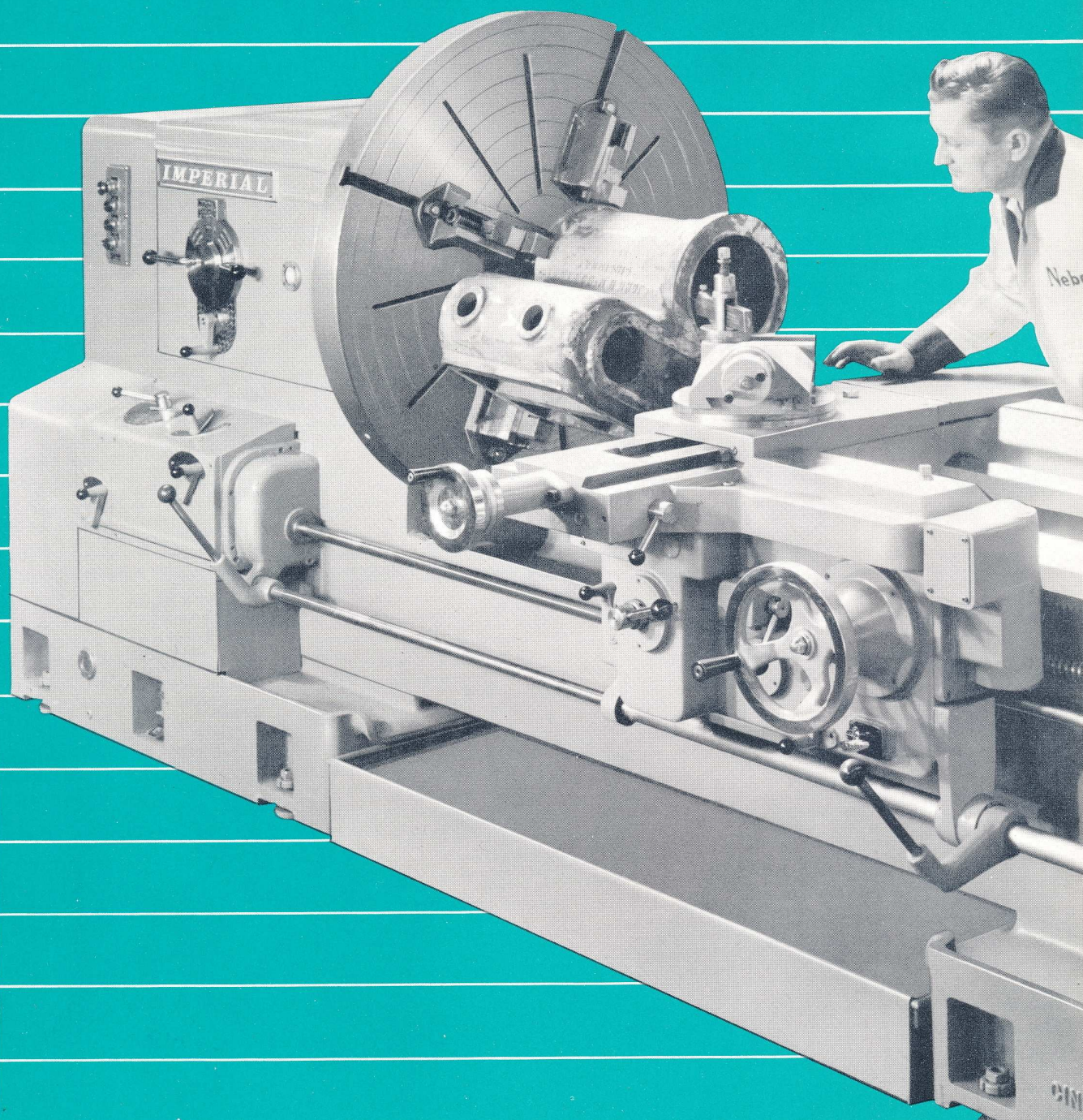


Unique bed design. Combination box girth and diagonal ribbing on the sliding upper bed, and the double flat and single v of the lower, represent Nebel's unique design for greater rigidity and longer life accuracy. Hardened and ground steel carriage way inserts available as extra equipment.



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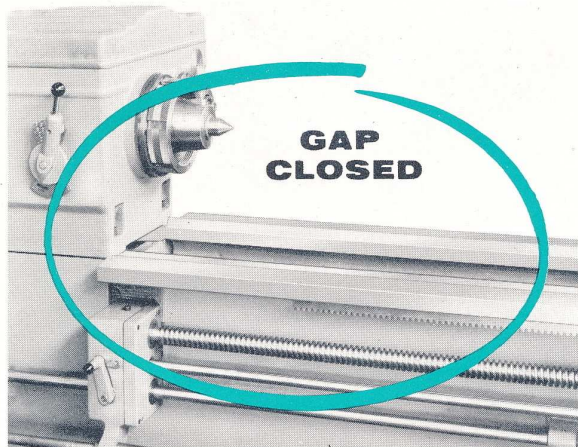
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IMPERIAL EXTENSION BED GAP LATHE DOES DOUBLE DUTY



With the gap closed, the new Imperial will accommodate all your standard engine lathe turning up to 24½" in diameter.



Moving the sliding upper bed to the right opens up a wide, deep gap that will swing outsize work up to 42" in diameter.



NEW NEBEL IMPERIAL COSTS LESS

than competitive lathes

yet offers comparable capacity, speed, power and weight!

"Absolutely the biggest bargain ever offered in a new metal-working lathe." That's the best way to describe the all new Nebel 20"/40" Imperial extension bed gap lathe.

For this versatile new lathe will turn all your engine lathe work up to 24½" diameter — and in the wide, deep gap, it will swing all your odd-shaped, outsize jobs up to 42" in diameter.

The new Imperial has 18 spindle speeds ranging from 11 to 666 rpm (or 16 to 1000 rpm) — and with a 2-speed motor, you can have 36 spindle speeds

ranging from 5 to 666 rpm (or 8 to 1000 rpm). It has automatic lubrication, 3-bearing spindle, anti-friction bearings throughout headstock. It's arranged for a 10- or 20-hp main drive motor . . . and it's Nebel designed, engineered and built for long life accuracy, years of trouble-free service. When you buy an Imperial, you're in for a new experience in operating ease, efficiency and economy. Nebel Machine Tool Corp., Cincinnati 25, Ohio, U.S.A.

Compare the **IMPERIAL . . .** and you'll buy the **IMPERIAL!**

	IMPERIAL	LATHE Z
Swing over ways	24½"	20½"
Swing over gap	42"	41¾"
Spindle speeds, number	18 (36 with 2-speed motor)	24
Spindle speeds, range, rpm	11-666	11-673
Main drive motor, hp	15-20	10
Weight, net, lbs.	10,000	8200



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