

J. W. Clark  
M.C. F59

OPERATOR'S MANUAL

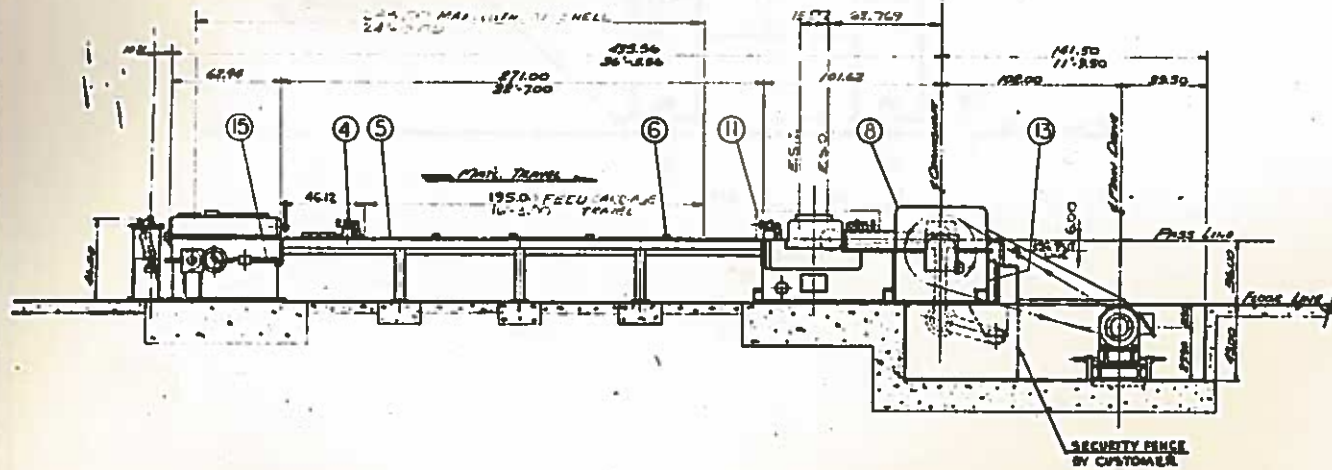
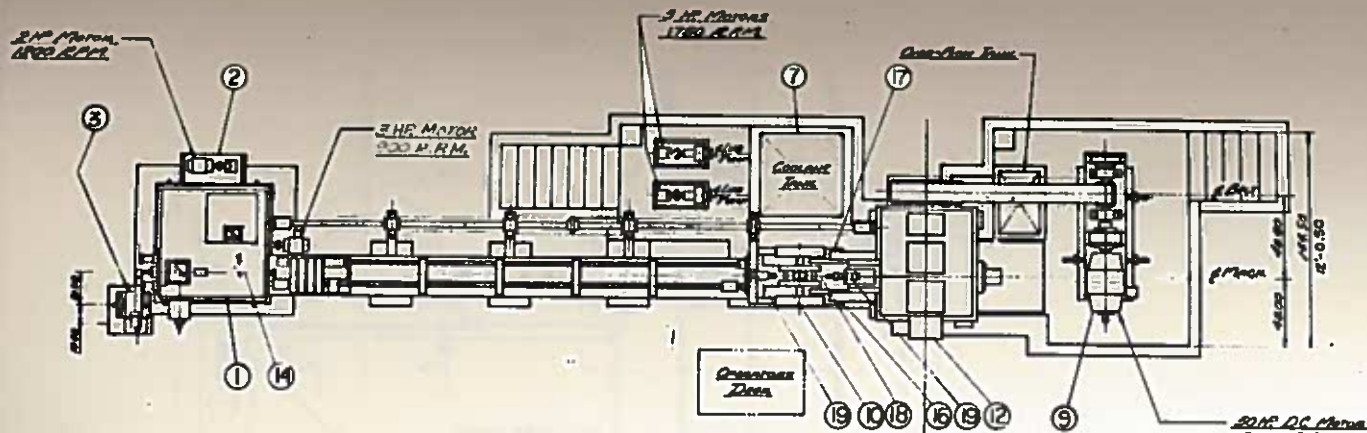
FOR General Electric Corp.  
Wilmington, North Carolina  
Title 1" Cold Pilger Mill  
Serial # 34101

NOTE:

THE ABOVE SERIAL NUMBER SHOULD BE USED WHEN REFERRING TO  
THIS EQUIPMENT IN ANY CORRESPONDENCE CONCERNING SPARE  
OR REPLACEMENT PARTS.

## SPECIFICATIONS

- |  |                                  |                              |
|--|----------------------------------|------------------------------|
| 1.   | Maximum Diameter Starting Shell: | 1"                           |
| 2.   | Finished Tube Size Range:        | 1/4" to 3/4"                 |
| 3.   | Maximum Length Starting Shell:   | 24'-0"                       |
| 4.   | Die Diameter:                    |                              |
|  | Nominal                          | 8.062"                       |
|  | Maximum                          | 8.188"                       |
|  | Minimum                          | 7.937"                       |
| 5.   | Pinion Pitch Diameter            | 7.714"                       |
| 6.   | Working Die Length               | 12.000"                      |
| 7.   | Stroke of Machine:               | 15.551"                      |
| 8.   | Machine Turning:                 |                              |
|  | Constant Turning                 | 74°                          |
| 9.   | Machine Speed Range:             | 100 to 300 SPM               |
| 10.  | Machine Feed Range:              | .025" - .100"                |
|  | Cams Furnished                   | .025" - .100"                |
| <p><u>Note:</u> The feed range per revolution is infinitely variable and adjustable within limits of .025" - .100" feed range while the machine is being operated.</p> |                                  |                              |
| 11.  | Main Drive Motor Horsepower:     | 50 HP, D. C.<br>300/1200 RPM |
| 12.  | Tube Loading                     | Rear loading,<br>manually    |



Part No.	Desc	Description
1	3017742	FEED & TURN MOTOR
2	3017747	FEED DRIVE
3	3017743	MANDREL W/ LUBE ASSY.
4	3017745	FEED CASING
5	3017746	FEED CASING BED
6	3017748	FEED SCREEN SUPPLY
7	3017749	COOLANT TANK
8	3017750	MOTOR
9	3017751	MAIN DRIVE
10	3017752	LUB. SCHEMATIC
11	3017753	AIR SCHEMATIC
12	3017754	FEED BOLT TWIN
13	3017755	TOOLING ARR'Y
14	3017756	MANDREL ROD ARR'Y
15	3017757	CRANK LAY'UT
16	3017758	PITCHING DEVEL. M/T
17	3017759	MILL SHAFT ARR'Y
18	3017760	SPACER BELL ARR'Y
19	3017761	CRANK LAY'UT
20	3017762	MACH. BED SECTIONS
21	3017763	SECTION TURN CRANK
22	3017764	FEED TURN SECTIONS
23	3017765	FEED TURN SECTIONS
24	3017766	FEED TURN SECTIONS
25	3017767	FEED TURN SECTIONS
26	3017768	FEED TURN SECTIONS
27	3017769	FEED TURN SECTIONS
28	3017770	FEED TURN SECTIONS
29	3017771	FEED TURN SECTIONS
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31	3017773	FEED TURN SECTIONS
32	3017774	FEED TURN SECTIONS
33	3017775	FEED TURN SECTIONS
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55	3017797	FEED TURN SECTIONS
56	3017798	FEED TURN SECTIONS
57	3017799	FEED TURN SECTIONS
58	3017800	FEED TURN SECTIONS
59	3017801	FEED TURN SECTIONS
60	3017802	FEED TURN SECTIONS
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68	3017810	FEED TURN SECTIONS
69	3017811	FEED TURN SECTIONS
70	3017812	FEED TURN SECTIONS
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96	3017838	FEED TURN SECTIONS
97	3017839	FEED TURN SECTIONS
98	3017840	FEED TURN SECTIONS
99	3017841	FEED TURN SECTIONS
100	3017842	FEED TURN SECTIONS

MACHINE TOLERANCE UNLESS OTHERWISE SPECIFIED  
 DIM. UNLESS OTHERWISE SPECIFIED  
 DIM. UNLESS OTHERWISE SPECIFIED  
 DIM. UNLESS OTHERWISE SPECIFIED  
 DIM. UNLESS OTHERWISE SPECIFIED

DATE: 6-28-54  
 DRAWN BY: J.E.C.  
 CHECKED BY: J.E.C.  
 APPROVED BY: J.E.C.  
 1407998

**MEKAY** THE MEKAY MACHINE COMPANY  
 1' COOL PUMP M/T  
 GENERAL ARRANGEMENT  
 34101-00001

1407998.2

34101-

# Constant Turn Gears

## Tube Reducer #5

### Note to file

The original gears were replaced with 82057533-01 and 82057549-02 to increase the turning angle from 51 degrees to 74 degrees. This change was made in approx. 1996 after we had some experience running TR #7 with a turning angle of 74 degrees. TR's 3 and 4 were also changed to a larger turning angle.

If anyone ever wanted to convert the mill back to entry end turning with the original cam, etc., these gears would have to be replaced with the gears that came with the new mill (82057533 and 82057549).

JW Clark  
9/21/2010