





608-15

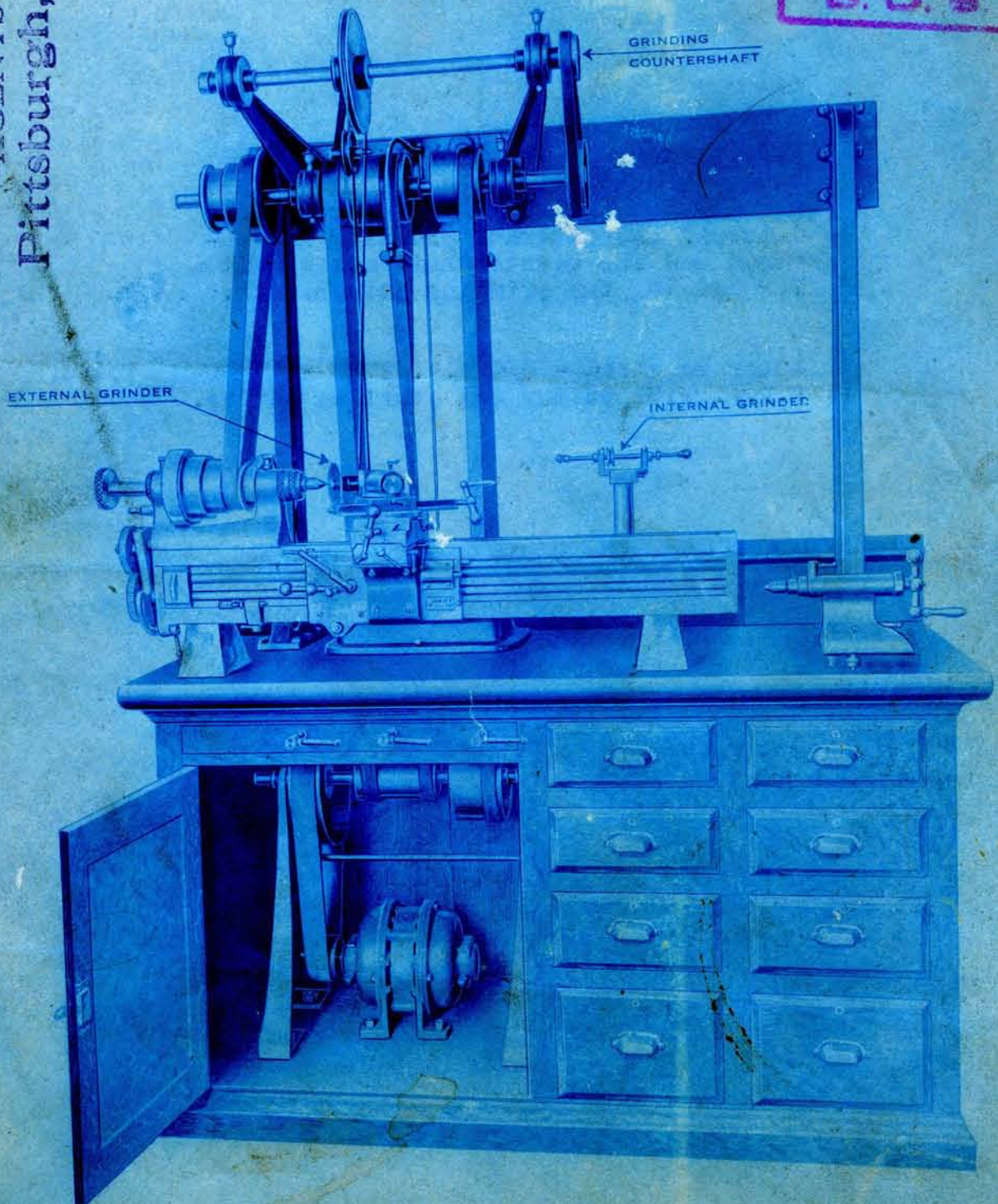
This photograph shows the method of mounting a Rivett Lathe on Oak Cabinet and driving by individual motor; also internal and external grinding attachments and the countershaft attachment for driving the grinding attachments.

Motor required -  $3/4$  H.P. 1700 to 1800 R.P.M. with pulley and starting device.



SOMERS, FITLER & TODD CO.  
AGENTS  
Pittsburgh, Pa.

RECEIVED  
NOV 30 1928  
E. O. S.



and External  
Motor Internal Grinder and Grinder Chucks  
are not required Equipment of Lathes and Cabnets

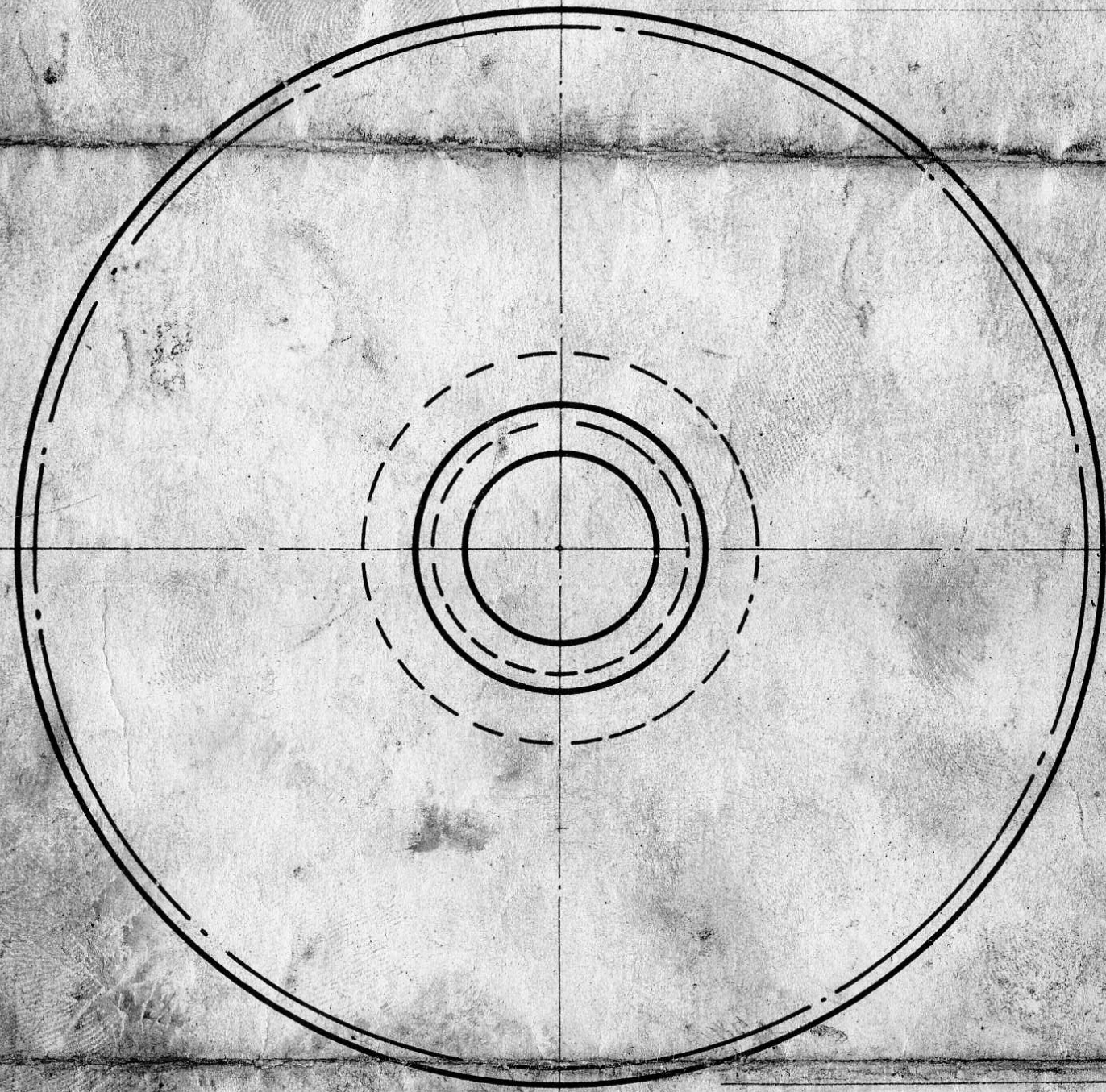


Fractional Dimensions to Finished Surfaces  $\pm .005$   
 Standard Reamed Holes  $\begin{matrix} +.0000 \\ -.0005 \end{matrix}$

A	5-19-41	ADDED	ETG
B	2-20-48	Was C.I.	ETG

NOTE:  $\text{\textcircled{A}}$   
 LEAVE  $\frac{1}{32}$  FOR  
 $\frac{1}{2}$ " IN ASSEMBLY

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 LEAVE  $\frac{1}{32}$  FOR  
 $\frac{1}{2}$ " IN ASSEMBLY



18 PITCH - 78 TEETH

$\frac{1}{16}$ " ALL OVER

18 PITCH - 29 TEETH

PATT # 8L12-230

TOOL # 43  
 587  
 688  
 MATERIAL: TOOL # 1942  
 $\text{\textcircled{A}}$  HUNT SPILLER  
 #8J ALLOY CAST IRON

vanadium  $\nabla$  5688

# BACK GEAR

**V. R. L. & G. Co.**  
 BOSTON, MASS.

Re Drawn by R. L. R.  
 Traced by R. L. R. Date 10-4-37  
 Checked by \_\_\_\_\_ Scale FULL

**608-12-230**



*Dave Wenthorn*

VANADIUM CORPORATION OF AMERICA

Bridgeville, Pa.

Req. No. 5563

January 1, 1929

Order No.     

Order following for Machine Tools for Phys. Laboratory Precision Lathe

1 - only #608 Rivett Precision Back-gearred Screw Cutting Lathe, consisting of bed, pedestals, pedestal bolts, lead screw, feed rod, carriage, carriage stop, set of change gears, headstock center and center chuck, screw draw-in spindle, driving plate, tailstock, tailstock center, compound slide rest, set of slide rest tools, T rest and horizontal safety motor drive, incl. countershaft, pulleys, shifters, cast iron guard, sheet metal belt guard.

Price Net f.o.b. Boston, Mass. \$960.00

Charge to Phys. Lab.

Deliver to Phys. Lab. Mach. Shop Via freight

January 8, 1929

Req. No. 5563

Mr. O.M.S.

Material covered by above requisition number had been ordered 1-8-29

on Order No. DD 842

From Somers, Pitler & Todd

Shipment promised one week

Via Freight

T.P.O.  
Purchasing Department



VANADIUM CORPORATION OF AMERICA

Bridgeville, Pa.

Req. No. 5564

January 1, 1929

Order No. \_\_\_\_\_

Order following for Machine Tools for Phys. Lab. Precision Lathe

1 - only Oak Cabinet with motor drive jackshaft, countershaft plank, support for countershaft plank, belt guard and belt shifters, f.o.b. Boston, Mass. \$260.00

1 - only Taper Attachment for #608 Rivett Precision Lathe

Price f.o.b. Boston, Mass. \$70.00

Charge to Phys. Lab.

Deliver to Phys. Lab. Mach Shop via freight

Req. No. 5564

Order No. DD 834

Mr. O.M.S.

Material covered by above requisition number has been received Jan. 14, 1929

1 - Oak Cabinet      1 - box parts

From Somers, Fidler & Todd

Delivered to Phys. Lab.

C. J. K.  
Receiving Clerk

Req. No. 5564

January 5, 1929

Mr. O.M.S.

Material covered by above requisition number has been ordered 1-5-29

on Order No. DD 834

From Somers, Fidler & Todd

Shipment promised one week

Via Freight

F.P.Guth  
Purchasing Department



# GEAR TABLE

FOR  
STANDARD  
THREADS

# 608 LATHE

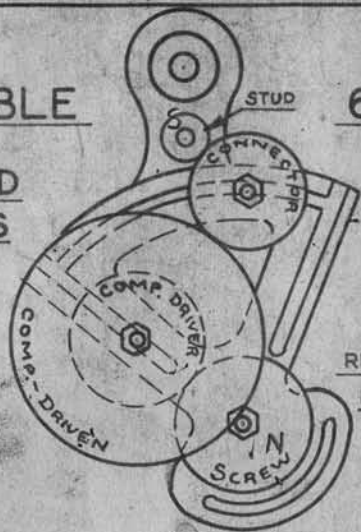
LATHE SCREW  
CONSTANT = 4

LEAD SCREW = 8 P

RIVETT L. & G. INC.  
BRIGHTON DIST.  
BOSTON, MASS. U.S.A.

FORMULA.

$$N = \frac{2S \times P}{C \times L}$$



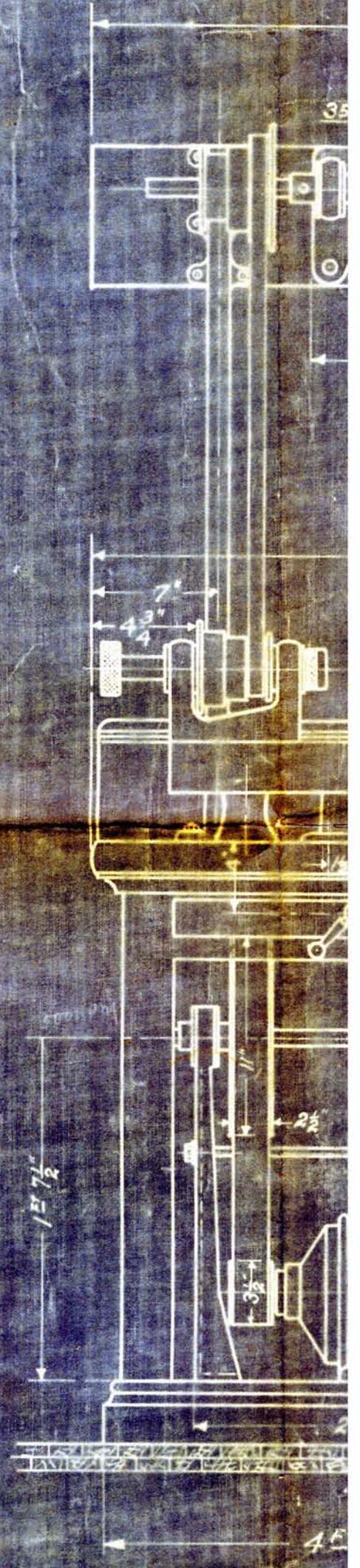
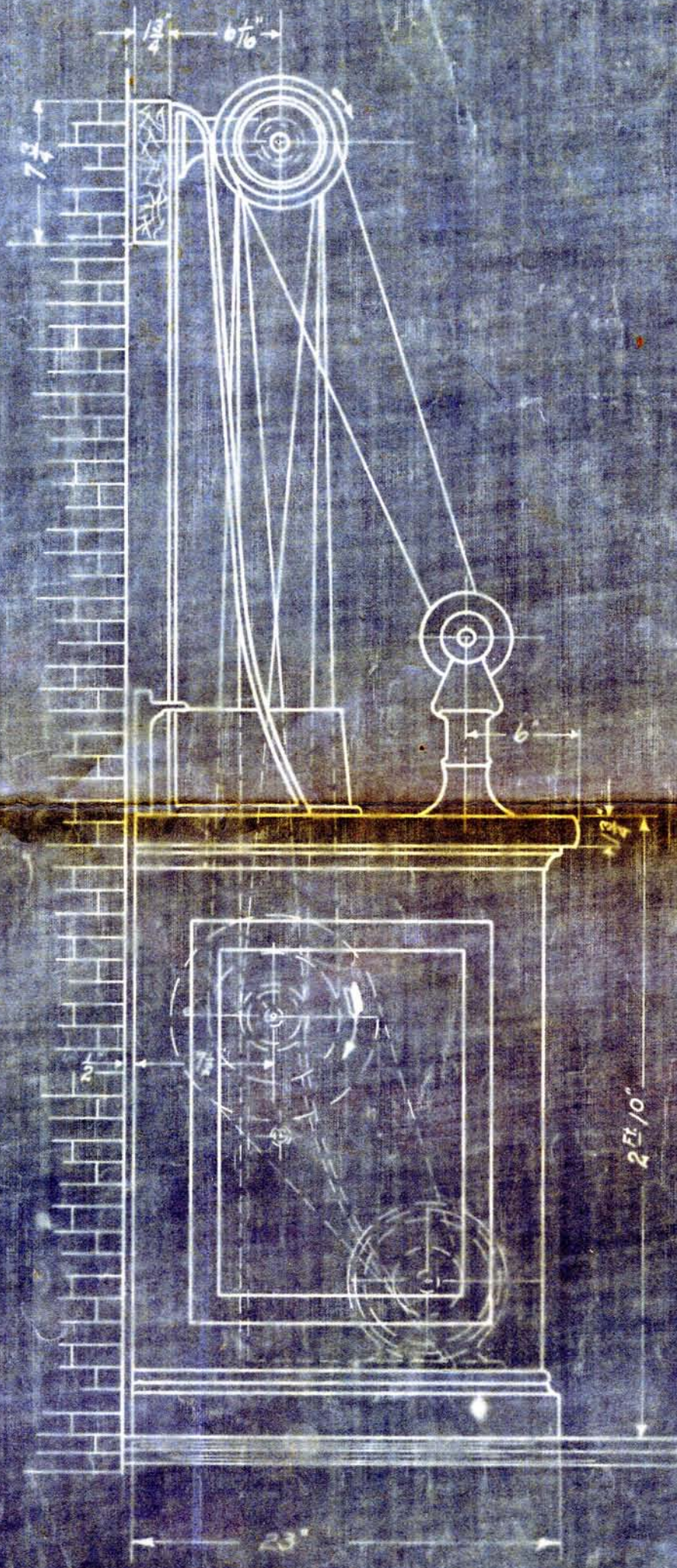
No. THREATS	STUD	COMPOUND			No. THREATS	STUD	COMPOUND		
		DRIVEN	DRIVER	SCREW			DRIVEN	DRIVER	SCREW
10	24			60	30	24	120	60	90
11	24			66	32	24	120	60	96
1 1/2	24			69	34*	24	120	60	102*
12	24			72	36	24	120	60	108
13	24			78	38*	24	120	60	114*
14	24			84	40	24	120	60	120
15	24			90	44	24	120	30	66
16	24			96	48	24	120	30	72
17*	24			102*	52	24	120	30	78
18	24			108	56	24	120	30	84
19*	24			114*	60	24	120	30	90
20	24			120	64	24	120	30	96
22	24	120	60	66	68*	24	120	30	102*
24	24	120	60	72	72	24	120	30	108
25	24			150	76*	24	120	30	114*
26	24	120	60	78	80	24	120	30	120
27	24	120	60	81	90*	24	120	30	135*
28	24	120	60	84	100	24	120	30	150

S = NO. OF TEETH ON STUD GEAR.  
P = NO. OF THREADS TO BE CUT.  
C = RATIO OF COMPOUND.  
L = NO. OF THREADS PER INCH  
ON LEAD SCREW  
N = NO. OF TEETH IN GEAR ON LEAD SCREW

\* - SPECIAL THREADS - GEARS  
NOT FURNISHED WITH  
STANDARD EQUIPMENT.

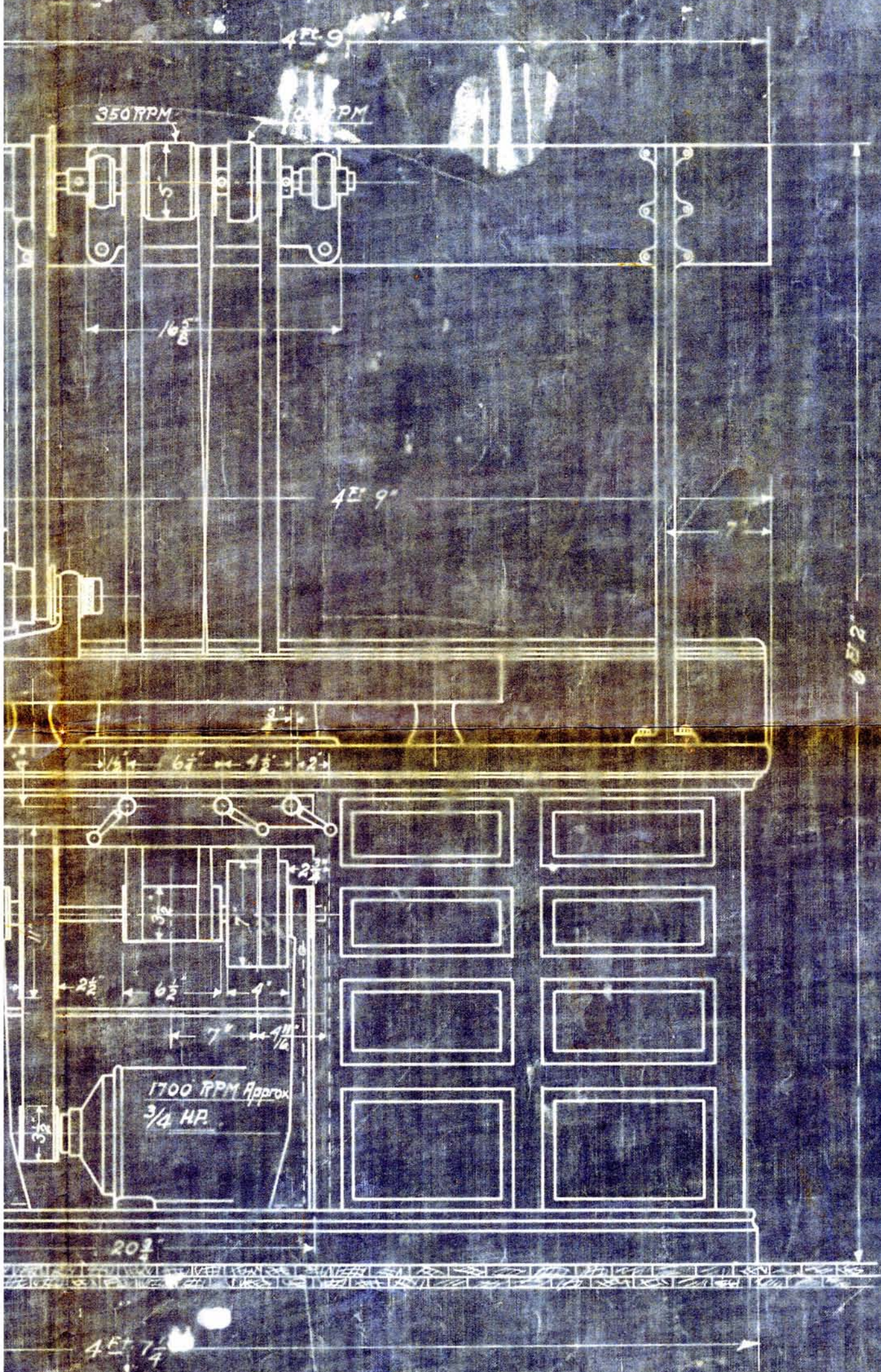
GT-10







2	Mar 10, 17	Redrawn and Traced
	M-5-19	without error



LATHE MOUNTED ON CABINET  
MOTOR DRIVE

**R. L. & G. Co.**  
BOSTON, MASS.

Drawn by JMS  
Traced by  
Checked by

Date Mar  
Scale 1/2"

LMC

File 105