

DATA OF TEST OF NILES-BEMENT-POND CAR-WHEEL LATHE.

Pond 42-inch motor-driven car-wheel lathe
At West Albany Car Shops, N.Y.C. & H.R. R.R. 36-inch Krupp and Paige Wheels,

May 11, 1910.

Continuous Run from 7 a.m. until 5.53 p.m., one hour for nooning.		Average.	
Pair No.	1 2 3 4 5 6 7 8 9 10 11	2 min., 28 sec.	11
Putting in lathe.	3 2 2 3 2 2 2 3 2 3 2	9 min., 23 sec.	2
Roughing.	11 8 9 9 9 9 9 9 11 10 10	5 min., 7 sec.	10
Finishing.	5 6 4 3 5 4 6 4 7 5 5	1 min., 0 sec.	5
Taking out.	1 1 1 1 1 1 1 1 1 1 1	17 min., 58 sec.	1
Time from floor to floor.	20 17 16 16 17 16 18 17 21 19 18	3/16 inch.	18
Depth of cut.	3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16	13/32 inch.	3/16
Feed.	13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32	14.4 feet.	13/32
Speed.	16 16 17 15 14 12 13 18 12 14 15		15
Average.			
Pair No.	12 13 14 15 16 17 18 19 20 21 22	2 min., 28 sec.	22
Putting in lathe.	2 4 2 2 2 2 4 3 2 2 3	9 min., 23 sec.	3
Roughing.	9 11 12 8 9 8 4 6 7 5 5	5 min., 7 sec.	11
Finishing.	5 5 5 8 4 5 4 6 7 5 5	1 min., 0 sec.	6
Taking out.	1 1 1 1 1 1 1 1 1 1 1	17 min., 58 sec.	1
Time from floor to floor.	17 21 23 15 17 17 20 18 17 18 21	3/16 inch.	21
Depth of cut.	3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16	13/32 inch.	3/16
Feed.	13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32	14.4 feet.	13/32
Speed.	15 13 10 14 12 15 11 12 10 14 12		12
Average.			
Pair No.	23 24 25 26 27 28 29 30 31 32 33	2 min., 28 sec.	33
Putting in lathe.	2 3 2 2 3 3 3 3 3 3 1	9 min., 23 sec.	1
Roughing.	9 11 9 10 7 10 9 10 10 7 10	5 min., 7 sec.	10
Finishing.	5 5 6 5 6 5 6 5 4 3 5	1 min., 0 sec.	5
Taking out.	1 1 1 1 1 1 1 1 1 1 1	17 min., 58 sec.	1
Time from floor to floor.	17 21 17 19 16 20 18 18 17 14 17	3/16 inch.	17
Depth of cut.	3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16 3/16	13/32 inch.	3/16
Feed.	13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32 13/32	14.4 feet.	13/32
Speed.	14 13 11 14 20 15 17 17 16 21 18		18
Average time for turning, 17 min., 58 sec. Total time for 33 pairs, 9 hours, 53 min.			

Fig. 2.