

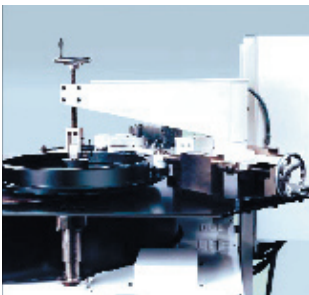
LAPMASTER[®]

MODEL 48

AIR BEARING OPTICAL POLISHING MACHINE



Yoke for workholder ring showing positive drive to roller bar bearing, and reciprocating drive housed below work table surface.



Conditioning weight in position on lap.



Workholder ring & working face of conditioning weight.

- The Lapmaster 48 air bearing optical polishing machine is designed for production of large area high quality plano optics, or where high outputs are required.
- The machine has a 48 inch (1219mm) optical pitch annular lap, and three work stations that can be reciprocated.
- As with other machines in the series, unlike conventional so called "worm and wheel" polishers, the pitch lap spindle is not mounted on a mechanical reduction gearbox. The unique air bearing feature has the pitch lap and its support plate riding on a very thin cushion of compressed air. This gap is only a few thousandths of an inch wide.
- Drive is from an electric motor via a lay shaft, and is transferred to the lap using a multi vee drive belt located on the periphery of the support plate.
- This approach considerably reduces the vibration at the polishing surface.

FEATURES AND TECHNICAL SPECIFICATIONS

PITCH LAP

- The pitch lap is manufactured and cast by Lapmaster International to suit the requirements of the customer. This is specified by measuring the pitch hardness using the Twyman penetration test. Various groove patterns can be cut, most commonly concentric grooves, but cross hatched or diamond patterns may be specified.
- The depth of pitch is approximately 2 inches (50mm). Externally it is retained by an aluminium band, internally a stack of removable micarta rings is used. A full pitch lap recasting service is offered by Lapmaster International.



MODEL 48

FEATURES AND TECHNICAL SPECIFICATIONS

PITCH LAP CONDITIONING.

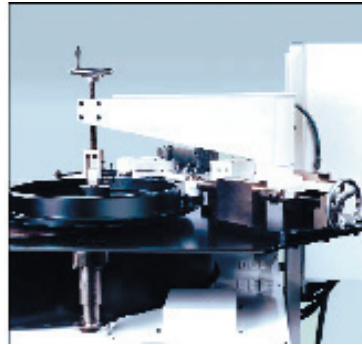
- A glass disc faced conditioning weight is fitted to the fourth work station situated at the rear of the machine. The precise lateral position of this weight relative to the lap plate track can be controlled. This is positively driven to ensure continuous rotation of the weight and drive is applied to one of the yoke roller bar bearing assemblies. The conditioning load can be controlled by the addition or removal of semicircular weight plates, which locate in a recess in the weight.
- A manually operated screw hoist is fitted which allows the weight to be suspended above the lap when the machine is not in use. It can also be swung clear of the worktable so that inspection or cleaning can be carried out.

WORKHOLDER RING

- The machine can accommodate unblocked and irregular shaped pieces, which are laid loose in the cut outs of the workholder. This consists of a Tufnol disc locating on a shoulder within the workholder ring to keep it clear of the pitch surface. The internal diameter of the workholder ring 15.75 inches (400mm), and is made of aluminium, faced with small squares of glass cemented in to a machined recess.
- The three workholder ring stations are fitted with positive drive, ensuring continuous rotation. The drive system incorporates a clutch mechanism so that the ring is only positively driven in conditions are such that it stalls or cogs.
- As well as this feature an eccentric oscillating motion drive is incorporated allowing reciprocation of the work across the lap plate track. This has several benefits, particularly with larger work; it avoids tracking or shadowing marks, and allows greater flatness control as more of the pitch lap surface is used for polishing. The amplitude of the reciprocation is adjustable via a simple screwed mechanism.

TEMPERATURE CONTROL FACILITY

- Machines can be provided in two different forms:
 - i) Plumbed ready for connection to an in-house water supply system or
 - ii) Complete with a freestanding temperature control system, which incorporates a thermostat, refrigerator and heater and allows pumping of recirculated water through the support plate below the pitch lap.



- This permits better flatness control, and by temperature adjustment, modification of the flow properties of the pitch matrix. voltages and frequencies, details on request.

PITCH TRIMMING BAR

- This tool can be fitted to the central recess of the lap and to the work table. It is fitted with a special pitch cutting tool which is traversed across the lap surface.
- It is used for cutting concentric grooves, or facing off the pitch, following the fitting of a newly cast lap, or if significant damage should occur to the surface. The cutting tool can be raised or lowered to permit various depths of cut to be made.

FACILITIES

- Electrical Power, Compressed air.



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Lapmaster has a policy of continued development and the specifications outlined above are subject to change without notice.