



PRECISION VARIABLE-SPEED LATHE

Model: 1224BV, 1236BV, 1340BV

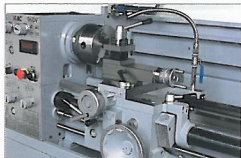
PRECISION VARIABLE-SPEED LATHE

Model: 1224BV, 1236BV, 1340BV



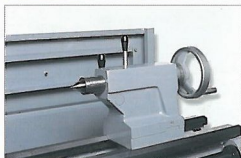
•HEADSTOCK & GEARBOX•

- Headstock housing is made of high tensile-stress relieved cast iron (FC25). Which is oil reservoir and splash lubricated.
- Dynamically balanced spindle with 40mm (1-9/16") diameter spindle bore is made of forged steel with induction hardened and precision internal and external ground, and supported by 2 precision taper roller bearings.
- Electronic infinitely speed with A.C inverter. 2 headstock gear speed ranges supply a high torque in low range from 40-365 r.p.m. in high range from 218 - 2000 r.p.m.
- The quick change gearbox is available in either metric or imperial form, dependent on the specification of the machine. These provide a wide range of threads, together with a suitable selection of longitudinal and cross feeds. Cross feed are approximately half of the longitudinal feeds.
- The leadscrew is connected to the gearbox through a shear pin, to protect the machine during overload thread cutting; feeds haft also equipped adjustable safety overload slipping clutch to prevent from accidental damage to the feed cutting.
- Totally enclosed gearbox is oil reservoir has easier lubrication worked by splashing lubricant.



•CARRIAGE & APRON•

- The saddle carries a full length cross slide on which is mounted the top slide. The top slide can be swiveled through 360°.
- Both cross slide and top slide feed screws are located by ball thrust bearing to carry axial loads. Both are incorporated backlash eliminator.
- Saddle, cross-slide and top slide fitted with adjustable taper gib strips for wear compensation.
- The double walled apron is arranged with a conventional half nut for screw cutting, which is oil reservoir has easier lubrication worked by splashing lubricant.
- Integrated automatic control for longitudinal and cross feeds, forward and reverse feeds. Both feed motions and screw cutting are fully interlocked to prevent simultaneous engagement of feeds and threads.
- Two cone type adjustable overload slipping clutch are mounted in the apron; one for accidental damage to the feed mechanisms; one for apron handwheel, when operator holds the apron handwheel while in thread cutting or carriage fixed in the bed, provides protection against damage to the thread cutting mechanisms.
- The apron handwheel is equipped with an easily read, re-settable dial, useful for positioning the carriage. Right hand and left hand operation handwheel on request.



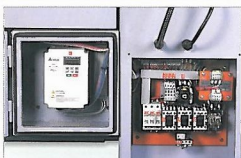
•TAILSTOCK•

- The hardened and ground tailstock quill with dia. 40mm (1-9/16") and inner taper MT#3; has graduated in either metric or imperial scale, is carried in a precision honed bore.
- The barrel feed handwheel mechanism incorporates a ball thrust bearing to carry axial loads.
- The tailstock can be set over to correct for parallelism or for the turning of shallow tapers.



•STAND•

- The stand features an integral tray and full length shelves to make maximum provision for the storage of tools and accessories. The cabinet door can be locked for security.



•ELECTRICS•

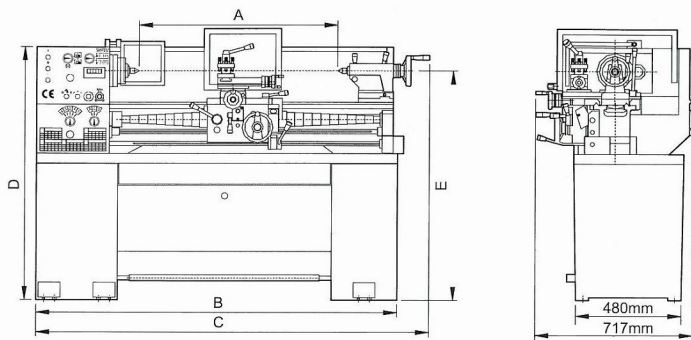
- The electrical installation conforms to "CE" standard and includes: reversing push button starter with no-volt and overload release protection, mushroom head stop button and lockable isolator switch, operating on a 24 volt control circuit, safety cut-off switches fitted to the main drive enclosure and included for the optional chuck guard.
- Emergency stop button is equipped on the front of the headstock, jogging switch button for easy gear engagement and inching spindle.
- Interlock switches are incorporated in the electrical safety package and are operated by the end cover door and the optional chuck guard, which can shut down machine entirely for changing belt or end gear train for threading and cutting.
- Different electrics can be supplied to special order for voltages other than those specified.



•END GEAR TRAIN•

•"CE" STANDARD•





| TYPE | A | B | C | D | E |
|---------|---------------|-------------------|-------------------|-------------------|-------------------|
| 1224 BV | 610 mm 24 in | 1335 mm 52-1/2 in | 1480 mm 58-1/4 in | 1150 mm 45-1/4 in | 1043 mm 41 in |
| 1236 BV | 900 mm 36 in | 1640 mm 64-1/2 in | 1785 mm 70-1/4 in | 1150 mm 45-1/4 in | 1043 mm 41 in |
| 1340 BV | 1000 mm 40 in | 1740 mm 68-1/2 in | 1885 mm 74-1/4 in | 1163 mm 45-3/4 in | 1056 mm 41-1/2 in |

BRIEF SPECIFICATION

| MODEL | 1224BV | 1236BV | 1340BV |
|----------------------------------|----------------------------------|----------------------------------|----------------------------------|
| Swing Over Bed | 306mm 12 inch | 306mm 12 inch | 330mm 13 inch |
| Swing Over Cross Slide | 186mm 7-5/16 inch | 186mm 7-5/16 inch | 210mm 8-5/16 inch |
| Height Of Center | 153mm 6 inch | 153mm 6 inch | 165mm 6-1/2 inch |
| Distance Between Center | 610mm 24 inch | 915mm 36 inch | 1000mm 40 inch |
| BED | | | |
| Width Of Bedways | 190mm 7-1/2 inch | 190mm 7-1/2 inch | 190mm 7-1/2 inch |
| Total Length Of Bed Gap Type | 1220mm 48 inch | 1525mm 60 inch | 1625mm 64 inch |
| Swing Over Gap | 445mm 17-1/2 inch | 445mm 17-1/2 inch | 470mm 18-1/2 inch |
| Length Of Gap | 240mm 9-1/2 inch | 240mm 9-1/2 inch | 240mm 9-1/2 inch |
| Width In Front Of Face Plate | 150mm 6 inch | 150mm 6 inch | 150mm 6 inch |
| SPINDLE | | | |
| Spindle Nose Mounting | D1-4 Camlock | | |
| Spindle Bore | 40mm 1-9/16 inch | | |
| Taper Of Spindle Bore | M.T. No. 5 | | |
| Number Of Spindle Speeds | Variable speed change | | |
| Range Of Spindle Speeds | 40-2000 R.P.M. | | |
| TOOL SLIDE | | | |
| Total Travel Of Cross Slide | 170mm 6-3/4 inch | | |
| Total Travel Of Top Slide | 90 mm 3-1/2 inch | | |
| Max. Size Cutting Tool | 13 mm 1/2 inch | | |
| TAILSTOCK | | | |
| Total Travel Of Tailstock Barrel | 100mm 4 inch | | |
| Taper In Tailstock Barrel | M.T. No. 3 | | |
| Diameter Of Barrel | 40mm 1-9/16 inch | | |
| THREAD | | | |
| Lead Screw Diameter & Pitch | Dia. 25. mm 1 inch, Pitch 4mm | | |
| Number Of Inch Threads | 8 | | |
| Range Of Inch Threads | 3-24 TPI | | |
| Number Of Metric Pitches | 21 | | |
| Range Of Metric Pitches | 0.50-10 mm | | |
| FEEDS | | | |
| Feed Rod Diameter | Dia. 19mm 3/4 inch | | |
| Number Of Feed Change | 21 | | |
| Range Of Longitudinal Feeds | 0.040-0.800 mm/rev | | |
| Range Of Cross Feeds | 0.020-0.400 mm/rev | | |
| MOTOR | | | |
| Main Spindle Motor | 2 HP 1.47 Kw | 2 HP 1.47 Kw | 3 HP 2.2 Kw |
| Coolant Pump Motor | 1/8 HP 0.1 Kw | 1/8 HP 0.1 Kw | 1/8 HP 0.1 Kw |
| WEIGHT & PACKING SIZE | | | |
| Machine Net weight-approx | 500 KGS | 550 KGS | 600 KGS |
| Machine gross weight-approx | 620 KGS | 670 KGS | 720 KGS |
| Packing size (L x W x H) | 1485x760x1530mm 59x30x60 inch | 1790x760x1530mm 71x30x60 inch | 1890x760x1550mm 75x30x61 inch |

We reserve the right to modify and improve our products.

● FEATURES ●

- The Lathe equipped with an electronically controlled variable speed inverter control.
- Two infinitely variable speed ranges are available, 40-365 r.p.m. in lower range step and 218-2000 r.p.m. in high range step.
- There are variable speed selectors in the obverse side of Headstock, turning the knobs can change spindle speeds. Equipped with digital readout R.P.M. speed meter on the front of Headstock, showing directly the actual spindle running speed, adjusting spindle speed easily and changing speeds conveniently. Sensitive speed control accompanied with an electronic tachometer and digital display.
- Close type Headstock, Gearbox and Apron have inner oil reservoir in which lubrication worked by splashing lubricant.
- Hardened and ground gears in headstock. 40 mm, (1-9/16 inch) hole through spindles. Spindle supported with 2 precision taper roller bearings.
- With longitudinal and cross automatic feeding systems. The feed road and handwheel for apron are equipped with adjustable safety overload slipping clutch to ensure proper cutting load.
- Lathe bed made of high tensile cast iron in rigid structure is hardened and ground.
- Lathe equipped with electro brake and foot brake giving rapid braking.
- Tool cabinet mounted between two floor stands accompanied with lock can be put in all accessories and tools, safe and administrate conveniently.
- Outside shape designed under entirely consideration, neat and beautiful outlook. All control knobs are located on the front of headstock, control easily.

STANDARD ACCESSORIES

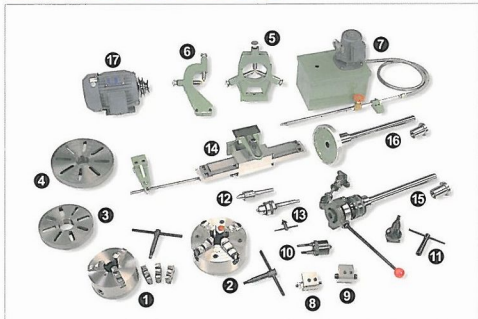


- 1. Main motor 2 HP 4P (3 HP is optional)
- 2. Back plate for chuck
- 3. 4-way toolpost
- 4. Screw wrench for 4-way toolpost
- 5. Threading dial indicator
- 6. Change gears
- 7. Tool box
- 8. Center sleeve M.T. No. 5x3
- 9. Two dead centers M.T. No. 3
- 10. Camlock spindle wrench
- 11. Oil gun (piston oiler)
- 12. Spare paint (on request)
- 13. Screw driver
- 14. Spanner (double-ended wrench)
- 15. Hexagonal wrench
- 16. Splash guard
- 17. Operation manual and parts list

CE MARKS FOR EUROPEAN-EXTRA COST:

Chuck guard
Leadscrew protection cover
CE standard electrical elements and electrical parts

• OPTIONAL ACCESSORIES •



- 1. 3-jaw scroll chuck 6 inch (165 mm.)
- 2. 4-jaw independent chuck 8 inch (200 mm.)
- 3. Face plate 10 inch (250 mm.)
- 4. Face plate 12 inch (300 mm.)
- 5. Steady rest
- 6. Follow rest
- 7. Coolant system
- 8. Micro type carriage stop
- 9. Single type carriage stop
- 10. 4-position carriage stop
- 11. American toolpost (T-slot single toolpost)
- 12. Live center (MT. No. 3)
- 13. Drill chuck 1/2 inch (13 mm.) W/arbor
- 14. Taper attachment
- 15. 5C collet attachment / Lever type
- 16. 5C collet attachment / Handwheel type
- 17. 3 HP motor extra cost
- 18. Quick change toolpost
- 19. Chuck guard
- 20. Toolpost guard
- 21. Work lamp (quartz halogen lamp)

Please indicate the following specifications on your order

1. Leadscrew and reading dial in imperial (inch) or metric (mm).
2. left-hand or right-hand Apron handwheel.