

'ABHIJAT' make Second operation turret lathes are available in different models viz STL - 25, STL - 32 & STL - 42. The machines cater to both bar work and manual or pneumatic chuck work. Pre-turned, Forged or Cast blanks can be used. The basic machine with 6 position turret, rigid cross slide & vertical slide enables variety of turning, drilling threading operation to be done simultaneously.

MACHINE CONSTRUCTION

The machine base is a rigid fabricated construction. The spindle is mounted in precision ball bearings. The bearings are mounted directly in the head stock, for higher accuracy and rigidity. The drive pulley is mounted outside the head stock for ease of speed change or belt change.

We offer a direct drive version which is ideal for machining of non-ferrous threaded components. This drive provides only higher spindle speed range and much higher switching cycles are possible, compared to the counter shaft drive.

STANDARD EQUIPMENT

- Cross Slide • Vertical Slide • Six position turret • Mechanical, hand operated collet chucking equipment • Electricals

EXTRA EQUIPMENT AND ACCESSORIES:-

- Coolant equipment • All tool holders for cross & vertical slides and turret. • Hand operated chuck with Back plate
- Long turning attachment • Bar feed Attachment • Counter shaft drive • Machine lamp • Auto feed attachment for Turret
- We also offer any special tooling attachments as per customer's requirement.

NC controller for Turret are also available

- Programmable feed 20 to 400 mm/mnt. • Semiskilled operator • Friendly programming • Repeatability ± 0.02 • Manual setting Arrangement provided • Overlapping of cross slide and vertical slide operations possible • Uniformity of feed for better finish and improved tool life. • Threading with tap or Die nut possible in cycle

Technical Specifications		Models			
		STL-25/110	STL-32/110	STL-42/150	
a) Collet Chucking Capacity	i) Round bright bar mm	ϕ 25	ϕ 32	ϕ 42	
	ii) Hexagon bright bar mm	22A/F	28A/F	36A/F	
	iii) Square bright bar mm	18A/F	22A/F	30A/F	
b) 3 Jaw True Chuck size mm		ϕ 110	ϕ 110	ϕ 150	
c) Cross Slide Travel mm		60	60	60	
d) Vertical Slide Travel mm		25	25	40	
e) Turret	i) No. Of stations	6	6	6	
	ii) Tools Reception bore mm(in)	ϕ 19.05 (ϕ 3/4")	ϕ 19.05 (ϕ 3/4")	ϕ 30	
	iii) Dia of Turret mm	ϕ 120	ϕ 120	ϕ 150	
	iv) Dist. Between turret face to spindle	215max	315max	360max	
f) Spindle Drive	i) Motor Power	0.37/1KW	0.37/1KW	1.5/2.2KW	
	ii) Motor speed	750/3000rpm	750/3000rpm	750/3000rpm	
	iii) Direct Drive	1) No. of speeds	6	-	-
		2) Speed range	315-3200	-	-
iv) Counter Shaft Drive	1) No. of speeds	12	8	8	
	2) Speed range	125-4000rpm	100-1400rpm	100-1400rpm	
g) Automatic Threading Attachment	Capacity	i) Ferrous mm	M5-M14	M5-M20	M10-M24
		ii) Non ferrous mm	M5-M16	M5-M24	M10-M24
h) Long Turning Attachment	Max Turning Length mm	75	75	75	
i) Dimensions & Weights	i) Weight of the Machine	Net Kgs.	350	425	650
		Gross Kgs.	435	510	800
	ii) Floor space without feed tube mm		1180x1150	1280x1250	1500x1400
	iii) Case Dimensions mm		1200x700x1525	1200x700x1525	1500x800x1700



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