

## Product Brochure For L666D

### Centre Lathe - CK-100

660 x 3000mm Turning Capacity - 105mm Bore

Includes Digital Readout System, Quick Change Toolpost & Taper Turning Attachment



ORDER CODE:	L666D
MODEL:	CK-100
Swing Over Bed (mm):	660
Distance Between Centres (mm):	3000
Spindle Bore (mm):	105
Swing In Gap (mm):	870
Swing Over Cross-slide (mm):	420
Digital Readout System Fitted:	Yes
Quick Change Toolpost Fitted:	Yes
Leadscrew Covers Fitted:	Yes
Taper Turning Attachment:	Yes
Coolant System:	Yes
Tool Height To Suit (mm):	25
Centre Height (mm):	330
Spindle Nose Size or Type:	D1-8 Camlock
Bed Width (mm):	405
Headstock Spindle Taper (MT):	7
Tailstock Taper (MT):	5
Cross Slide Travel (mm):	310
Compound Slide Travel (mm):	145
Leadscrew Type:	Metric
Metric Cross Feed (X-Axis) (mm/rev):	0.027 - 1.07
Imperial Cross Feed (X-Axis) (inch/rev):	~
Metric Longitudinal Feed (Z-Axis) (mm/rev):	0.063 - 2.52
Imperial Longitudinal Feed (Z-Axis) (inch/rev):	~
Metric Thread Steps & Pitch (No. / mm):	22 (1 - 14)
Imperial Thread Steps & TPI (No. / TPI):	28 (2 - 28)
3 Jaw Chuck Diameter (mm):	325
4 Jaw Chuck Diameter (mm):	400
Spindle Steps / Speeds (No. / rpm):	12 (36 - 1600)
Motor Power (kW / hp):	9 / 12
Voltage / Amperage (V / amp):	415
Nett Weight (kg):	4400

### Features

- 2 Axis digital readout system
  - Quick change toolpost
  - Taper turning attachment fitted to saddle
  - Triple bearings supporting headstock spindle
  - Adjustable taper roller bearings providing spindle accuracy
  - Precision 'V'-beds & headstock gears are all hardened & ground
  - Multiple discs forward and reversing clutch system
  - Adjustable feed stop system with 6 individual sliding stops
  - Overload protection on drive motor and coolant system
  - Universal enclosed gearbox incorporating metric & imperial thread capabilities
  - Foot operated spindle brake with safety cut out switch
  - X & Z axis rapid traverse selection lever incorporated on the saddle @ 4.5m/min
  - 405mm wide induction hardened heavy duty cast iron bed
  - Removable gap bed allowing work piece to swing up to 870mm
  - Cross slide handle disengages when auto feed is used
  - Saddle hand wheel disengages when auto feed is used
  - Adjustable clutch for auto feeds protects machine from overloading during machining
  - Chuck guard fitted with safety micro switch
  - Micro switch on side access door
  - Powered longitudinal and cross feeds
  - Metric calibrated feed dials
- Coolant system with flexible hose enabling operator to manipulate flow direction

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- Oil sight glass for head stock and gearbox & apron
- Lubrication pump on saddle oiling slides
- Low voltage halogen work light
- D1-8 camlock spindle for quick chuck removal
- 12 spindle speeds 36-1600rpm
- Large 105mm spindle bore
- 9kW / 12HP 415V main motor

### Includes

- 2 Axis digital readout system
- Quick change toolpost
- Taper turning attachment fitted to saddle
- Leadscrew Cover
- 325mm 3-jaw chuck with reverse jaws
- 400mm 4-jaw chuck
- Face plate
- Fixed steady
- Travelling steady
- Dead centres
- Thread chasing dial
- Foot brake
- Coolant system
- Work light
- Chuck guard
- Rear splash guard
- Spindle reducing bush

### Specific Features



Digital Read Out



Safety Chuck Guard



Induction Hardened Bedways



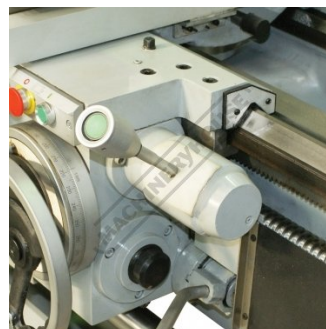
Leadscrew Covers



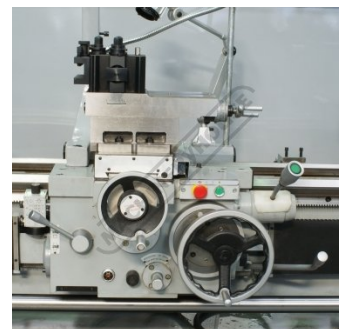
Compound Slide



Saddle Right View



Rapid Traverse Selection Lever on Saddle

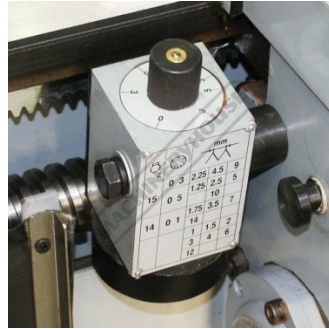


Saddle Controls

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Saddle Left View



Thread Chasing Dial



Feed Stop System



Fixed Steady



Travelling Steady



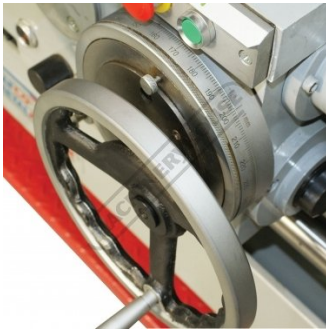
Foot Brake



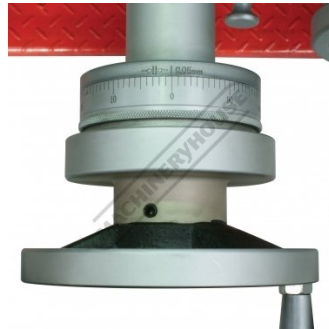
Tailstock



Tailstock Quill



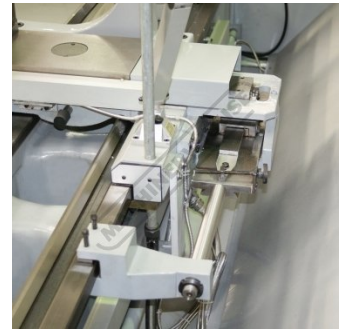
Saddle Hand Wheel



Cross Slide Hand Wheel



Tailstock Hand Wheel



Taper Turning Attachment



Taper Turning Attachment Angle

mm		mm		mm		mm	
T	II	III	IV	T	II	III	IV
1	2	3	4	0.5	1	2	4
2	2.5	4.5	3	2.25	4.5		
4	1.25	2.5	5	10	1.25	2.5	5
7	2.75	5.5	11		2.75	5.5	
8	1.5	3	6	12	0.75	1.5	3
11	1.75	3.5	7	14	1.75	3.5	7

Thread Chart

mm		mm		mm		mm	
A	B	C	D	A	B	C	D
1	0.063	0.09	0.18	0.36	0.71	0.007	0.008
2	0.071	0.10	0.20	0.40	0.80	0.008	0.009
3	0.079	0.21	0.42	0.83	0.011	0.009	0.18
4	0.079	0.11	0.22	0.44	0.88	0.010	0.010
5	0.081	0.23	0.46	0.92	0.014	0.009	0.19
6	0.084	0.12	0.24	0.48	0.95	0.010	0.101
7	0.087	0.25	0.49	0.99	0.017	0.010	0.21
8	0.13	0.27	0.53	1.07	1.00	0.017	0.114
9	0.14	0.29	0.58	1.17	1.04	0.020	0.124
10	0.15	0.31	0.60	1.20	1.08	0.024	0.134
11	0.21	0.42	1.25	2.50	0.008	0.120	0.20
12	0.16	0.32	0.64	1.28	2.00	0.008	0.127
13	0.17	0.34	0.68	1.36	2.16	0.010	0.140
14				1.45	2.24		0.010
15				1.61	2.52		0.08

Feed Chart

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**Recommended Accessories**

**A358**  
 Sky Hook Lifting Device



**A358A**  
 Chuck Hook



**G666**  
 Lathe Leadscrew Cover Kit



**L300**  
 Magnetic Swarf Remover



**M9991**  
 Magnetic Floor Sweeper



**L453**  
 Lathe Turning Tool Kit - 3 piece  
 Insert Type



**L459**  
 Lathe Threading Tool Kit - Insert  
 Type



**L467**  
 Professional Lathe Parting Tool  
 Kit - Insert Type



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**L297**  
 Quick Change Toolpost



**L297A**  
 Quick Change Toolpost Holder - Std



**D1272**  
 Metric 135° Precision HSS Drill Set - 25 Piece



**D1282**  
 Imperial 135° Precision HSS Drill Set - 29 Piece



**D126**  
 Metric 135° Precision HSS Drill Set - 170 Pieces



**C294**  
 Industrial Drill Chuck - Keyless Type



**D454A**  
 4MT x JT3 Drill Chuck Arbor



**D119**  
 Metric 2MT HSS Drill Set



**D424**  
 Drill Sleeve - Morse Taper



**D422**  
 Drill Sleeve - Morse Taper



**D425**  
 Drill Sleeve - Morse Taper

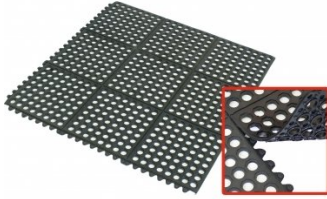


**M800**  
 Rubber Mat - Anti-Fatigue



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**M805**  
 Rubber Mat - Anti-Fatigue



**S090A**  
 Soluble Metal Cutting Fluid - 1 Litre



**S090**  
 Soluble Metal Cutting Fluid - 5 Litre



**S076**  
 Cutting Tool Lubricant Fluid - 500ml



**S077**  
 Drilling, Tapping & Cutting Tool Lubricant Spray - 400g



**S075**  
 Cutting Tool Lubricant Paste - 200g



**S074**  
 Cutting Tool Lubricant Paste - 500g



**O000**  
 SpillFix Universal Organic Absorbent



**O043**  
 Rust & Corrosion Preventive



**O042**  
 General Purpose Lubricant & Corrosion Inhibitor



**O040**  
 Rust & Corrosion Preventive



**O044**  
 Rust & Corrosion Preventive

