

Product Brochure For L682

Centre Lathe - AL-336

Ø300 x 900mm Turning Capacity - Ø38mm Spindle Bore
 18 Geared Head Speeds 65 ~ 1810rpm, Includes Light, Foot Brake,
 Coolant System & Cabinet Stand



Ex GST
\$5,490.00

Inc GST
\$6,039.00

ORDER CODE:	L682
MODEL:	AL-336
Swing Over Bed (mm):	300
Distance Between Centres (mm):	900
Spindle Bore (mm):	38
Swing In Gap (mm):	450
Swing Over Cross-slide (mm):	180
Digital Readout System Fitted:	Optional
Quick Change Toolpost Fitted:	Optional
Leadscrew Covers Fitted:	-
Taper Turning Attachment:	-
Coolant System:	Yes
Tool Height To Suit (mm):	12
Centre Height (mm):	150
Spindle Nose Size or Type:	D1-4 Camlock
Bed Width (mm):	180
Headstock Spindle Taper (MT):	5
Tailstock Taper (MT):	3
Cross Slide Travel (mm):	170
Compound Slide Travel (mm):	75
Leadscrew Type:	Imperial
Metric Cross Feed (X-Axis) (mm/rev):	-
Imperial Cross Feed (X-Axis) (inch/rev):	0.009 - 0.236
Metric Longitudinal Feed (Z-Axis) (mm/rev):	-
Imperial Longitudinal Feed (Z-Axis) (inch/rev):	0.04 - 1.22
Metric Thread Steps & Pitch (No. / mm):	32 (0.4 - 7)
Imperial Thread Steps & TPI (No. / TPI):	36 (4 - 60)
3 Jaw Chuck Diameter (mm):	160
4 Jaw Chuck Diameter (mm):	200
Spindle Steps / Speeds (No. / rpm):	18 (65 - 1810)
Motor Power (kW / hp):	1.5 / 2
Voltage / Amperage (V / amp):	240 / 10
Nett Weight (kg):	595

Description

The AL-336 high quality centre lathe with a turning capacity of Ø300 x 900mm is well known in the industry for its metal turning capabilities & is suitable for the model engineer or general maintenance workshops.

Featuring an induction hardened vee bedways are precision ground that allows the saddle to smoothly slide over it, full gear driven spindle speeds ranging from 65 - 1810rpm are selectable via the gear selector levers that are accessible from the front of headstock for your convenience & certainly makes this lathe package well sort after.

The 2hp single phase 240V motor is ample power to drive the 3 & 4 jaw chucks, auto feed & screw cutting thread system and the adjustable taper roller spindle bearings ensures accuracy & smooth operation even when under cutting load. A great range of cross, longitudinal feed speeds & metric & imperial screw cutting threads are easy accessible & selected via the separate gearbox located underneath the headstock for your convenience.

Supplied with a large range of standard accessories including a 150mm 3 jaw self centring chuck, 200mm 4 jaw independent chuck with D1-4 camlock for quick change over, face plate, spindle safety foot brake, chuck guard with safety interlock switch, thread chasing dial, rear splash guard, coolant pump system, work light, fixed & traveling steadies & that rounds up most of the great features on this fantastic centre lathe. The floor stand is equipped with a slide out swarf tray that makes it very easy to clean down and remove your waste material swarf.

Features

- Gear drive headstock for quick change of spindle speeds
- Precision 'V'-beds are hardened and ground, incorporating a rigid webbed casting

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- Slide out swarf tray from front of machine
- Low voltage work light
- Foot operated spindle brake with safety cut out switch
- Change gears for metric and imperial thread cutting
- Oil sight glass for head stock and gearbox
- Adjustable taper roller bearings support the spindle
- 18 spindle speeds from 65 to 1810rpm
- Inching button is incorporated on the control panel for convenient spindle speed selection
- Enclosed quick action gearbox for thread cutting and auto feeding
- Powered longitudinal and cross feeds
- D1-4 camlock spindle for quick chuck changes and safe reverse direction turning. ISO standard
- Removable gap bed-way for larger diameter jobs
- Dual calibrated dials (except for saddle hand-wheel)
- Chuck & change gear guards are fitted with micro switches

Includes

- 3-jaw chuck with reverse jaws
- 4-jaw chuck
- Face plate
- Fixed steady
- Travelling steady
- Coolant system
- Change gears
- Dead centres
- Thread-chasing dial
- Safety chuck guard
- Work light
- Stand
- Foot brake
- Rear splash guard & slide out swarf tray
- Tool box
- Instruction booklet

Specific Features



Headstock

METRIC THREAD PITCH LIST									
	B4	C4	C3	C2	A4	D2	E4	A2	E2
M1	0.4	0.45	0.5		0.5		0.7	0.75	
M2	0.8	0.9	1		1.2	1.25	1.4	1.5	1.75
M3	1.6	1.8	2	2.25	2.4	2.5	2.8	3	3.5
M4	3.2	3.6	4	4.5	4.8	5	5.6	6	7
THREAD PER INCH									
	A2	A3	G3	A4	C3	C3	A5	A5	B4
Z	24	24	36	24	22	24	26	24	24
M1	4	4 1/2	9 1/2	5	5 1/2	6	6 1/2	7	7 1/2
M2	8	9	19	10	11	12	13	14	15
Z	46	46	36	46	44	46	52	46	46
M1	16	18	19	20	22	24	26	28	30
M2	32	36	38	40	44	46	52	56	60

Metric Thread Chart

FEED CHARTS									
Position	E2	E3	A2	E4	E1	C3	C4	A5	D5
S1	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
S2	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S3	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003
S4	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
S5	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
S6	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
S7	0.007	0.007	0.007	0.007	0.007	0.007	0.007	0.007	0.007
S8	0.008	0.008	0.008	0.008	0.008	0.008	0.008	0.008	0.008
S9	0.009	0.009	0.009	0.009	0.009	0.009	0.009	0.009	0.009
S10	0.010	0.010	0.010	0.010	0.010	0.010	0.010	0.010	0.010

Feed Charts

INDICATOR TABLE			
T	T-P-I	SCALE	T-P-I
0	4	8	14
	16	24	30
	32	40	46
	48	56	62
T	T-P-I	SCALE	T
4 1/2	8	14	24-6-8
5	4-8	15	4-8
5 1/2	8	18	2-4-6-8
6	4-8	19	8
6 1/2	8	20	1-8
7	4-8	22	2-4-6-8
7 1/2	8	26	2-4-6-8
8	4-8	28	1-8
9 1/2	8	30	2-4-6-8
10	2-4-6-8	36	1-8
11	4-8	38	2-4-6-8
12	1-8	44	1-8
13	4-8	52	1-8

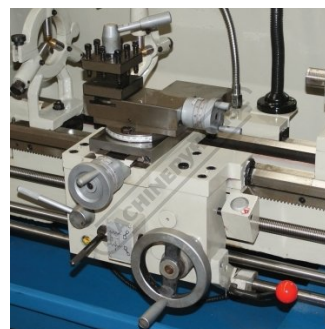
Thread Chase-Indicator Table

SPINDLE SPEED			
	1	2	3
I	360	1810	1095
II	100	500	300
III	280	1400	840
IV	235	1200	700
V	65	330	200
VI	180	910	550

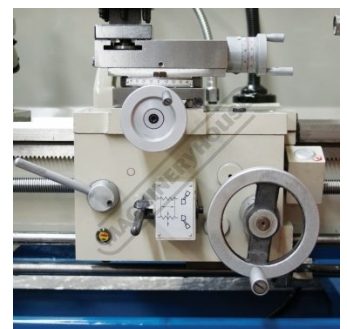
18 Spindle speeds 65-1810rpm



Chuck Guard With Safety Micro Switch

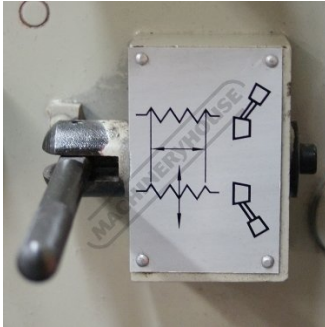


Saddle Right View



Saddle Control

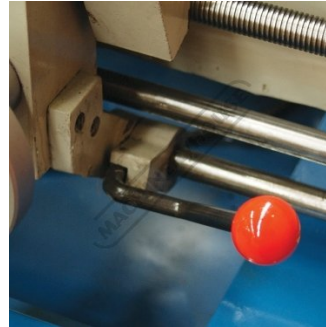
Product Brochure For L682



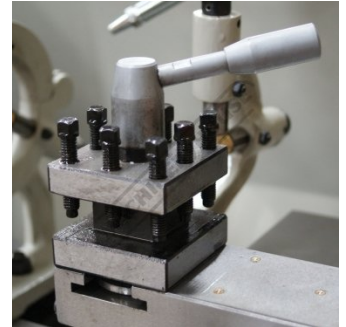
Feed Engagement Lever



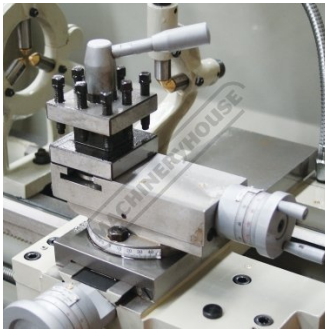
Thread Chasing Dial



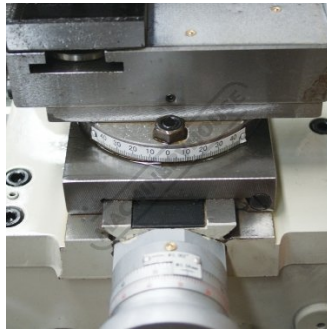
Forward Reverse Spindle Lever



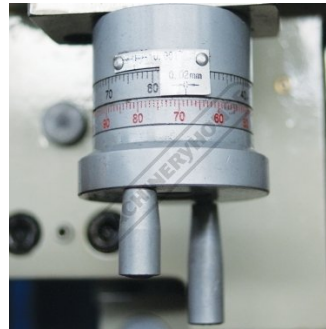
Toolpost



Compound Slide



Swivel Compound Slide



Compound Slide Hand Wheel



Crossslide Hand Wheel



Saddle Hand Wheel



Lamp and Coolant Hose



3 Point Fixed Steady



2 Point Travelling Steady



Tailstock



Tailstock Quill



Tailstock Hand Wheel



Induction Hardened Bedways

Product Brochure For L682

Recommended Accessories

M002

Steel Machine Mount & Rubber Insert



L682D

Centre Lathe



D694

1500mm Optimum Magnetic Digital Readout Scale



D5249

Scale - Backing Plate & Cover



P235

Coolant Pump & Tank



L292

Quick Change Toolpost



L295

Quick Change Toolpost



L277

Vertical Mill Slide



Product Brochure For L682

C980

5C Collet Lathe Adaptor



L015

Right Hand Turning Tool Holder



L016

Left Hand Turning Tool Holder



L0099

Lathe Turning Tool Kit - 7 piece Insert Type



L450

Lathe Turning Tool Kit - 3 piece Insert Type



L456

Lathe Threading Tool Kit - Insert Type



L464

Professional Lathe Parting Tool Kit - Insert Type



L073

Parting Tool Holder - Suits 1/2" HSS Tool Bit



L076

Knurling Tool Holder Kit



C052

3MT Live Centre



C045

3MT Pipe Centre - 70° Cone



C290

Heavy Duty Drill Chuck - Keyed Type



Product Brochure For L682

D443A

3MT x JT3 Drill Chuck Arbor



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



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



G660

Lathe Leadscrew Cover Kit



G659

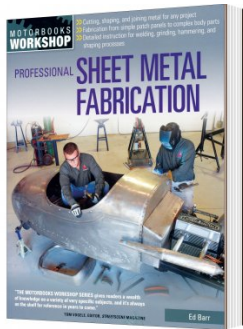
Lathe Leadscrew Cover Kit - Concertina



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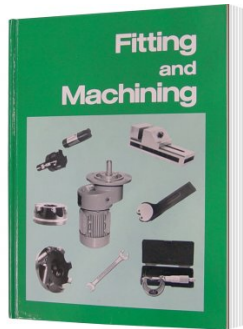
L3455

Professional Sheet Metal
Fabrication Book



L341

Fitting and Machining Technical
Book



L300

Magnetic Swarf Remover



M9991

Magnetic Floor Sweeper



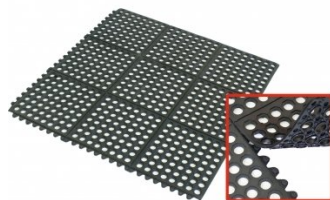
M800

Rubber Mat - Anti-Fatigue



M805

Rubber Mat - Anti-Fatigue



O000

SpillFix Universal Organic
Absorbent



O043

Rust & Corrosion Preventive



O042

General Purpose Lubricant &
Corrosion Inhibitor



O040

Rust & Corrosion Preventive



O044

Rust & Corrosion Preventive

