

## Product Brochure For L183

### Centre Lathe - AL-335

300 x 910mm Turning Capacity

Includes Cabinet Stand



ORDER CODE:	L183
MODEL:	AL-335
Swing Over Bed (mm):	300
Distance Between Centres (mm):	910
Spindle Bore (mm):	38
Swing In Gap (mm):	450
Swing Over Cross-slide (mm):	178
Digital Readout System Fitted:	Optional
Quick Change Toolpost Fitted:	Optional
Leadscrew Covers Fitted:	~
Taper Turning Attachment:	~
Coolant System:	~
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):	76
Leadscrew Type:	Imperial
Metric Cross Feed (X-Axis) (mm/rev):	~
Imperial Cross Feed (X-Axis) (inch/rev):	0.014 - 0.344
Metric Longitudinal Feed (Z-Axis) (mm/rev):	~
Imperial Longitudinal Feed (Z-Axis) (inch/rev):	0.05 - 1.29
Metric Thread Steps & Pitch (No. / mm):	36 (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):	9 (75 - 1400)
Motor Power (kW / hp):	1.5 / 2
Voltage / Amperage (V / amp):	240 / 10
Nett Weight (kg):	460

### Description

A high quality specification, floor standing, heavy duty metal turning lathe suitable for the enthusiastic home model engineer, general maintenance and small work shops. Featuring a precision ground, induction hardened bed, fully gear driven spindle with hardened and ground gears with a speed range of 75 - 1400rpm, selectable via the front of headstock mounted gear selection levers.

2hp single phase 240 volt motor is supplied on machine, taper roller spindle bearings, range of cross and longitudinal feed speeds selected on a separate gearbox, thread chasing dial, chuck guard with safety interlock, splash guard and work lamp.

Supplied with a large range of standard accessories including a 150mm(6") 3 jaw self centring chuck, 200mm(8") 4 jaw independent chuck, face plate and dead centres. 5 to 3 MT reduction sleeve, steady rest, follow rest, standard tool post, floor stand with a swarf tray. Change gears and toolbox with maintenance tools.

### Features

- Gear driven headstock for quick change of spindle speeds
- Precision V-beds are induction hardened and ground, incorporated with rigid webbed castings
- Low voltage halogen work light
- Change gears for metric and imperial thread cutting
- Adjustable taper roller bearings support the spindle
- 9 spindle speeds from 75 to 1400rpm
- Saddle hand wheel mounted on right side of apron reducing swarf contacting the hand
- Inching button is incorporated on the control panel for convenient spindle speed selection
- Quick-action gearbox for thread cutting and auto feeding

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- D1-4 camlock spindle for quick and accurate chuck removal and safe reverse direction turning. ISO standard
- External adjustable cross feed lead-screw nut
- Powered longitudinal and cross feeds
- Bed wipers on saddle
- Removable gap bed-way for larger diameter jobs
- Dual calibrated dials (except for saddle hand-wheel)
- Chuck guard fitted with safety micro switch
- 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
- Change gears
- Dead centre
- Thread-chasing dial
- Rear splash guard & swarf tray
- Safety chuck guard
- Cabinet stand
- Spanners
- Tool box
- Instruction booklet

### Specific Features



Headstock



Speed Levers

CAUTION NO CHANGE OF LEVER WHEN GEARS AND SHAFTS ARE RUNNING			
	SPINDLE SPEEDS		
	1	2	3
A	270	1400	840
B	75	380	220
C	200	1050	640

POWER

Spindle Speed Chart



Switches



Feed and Thread Gearbox

Metric Feed Chart									
position	E2	E3	E4	B2	B3	C3	C4	A1	
48T	1.291	1.107	0.996	0.922	0.830	0.738	0.711	0.632	
100T	0.331	0.283	0.256	0.236	0.212	0.190	0.182	0.162	
24T	0.646	0.553	0.498	0.461	0.415	0.369	0.356	0.316	
24T	0.166	0.142	0.128	0.118	0.106	0.095	0.091	0.081	
24T	0.323	0.277	0.249	0.230	0.208	0.184	0.178	0.158	
120T	0.083	0.071	0.064	0.059	0.053	0.047	0.046	0.041	
48T	0.161	0.138	0.125	0.115	0.104	0.092	0.089	0.079	
48T	0.041	0.035	0.032	0.030	0.027	0.024	0.023	0.020	

Metric Feed Chart

Imperial Feed Chart									
position	E2	E3	E4	B2	B3	C3	C4	A1	
48T	0.054	0.046	0.042	0.038	0.035	0.031	0.030	0.026	
100T	0.014	0.013	0.011	0.010	0.009	0.008	0.008	0.007	
24T	0.027	0.023	0.021	0.019	0.017	0.015	0.015	0.013	
24T	0.007	0.006	0.006	0.005	0.005	0.004	0.004	0.003	
24T	0.013	0.012	0.010	0.010	0.009	0.008	0.007	0.007	
120T	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	
48T	0.006	0.006	0.005	0.005	0.004	0.004	0.004	0.003	
48T	0.002	0.002	0.002	0.001	0.001	0.001	0.001	0.001	

Imperial Feed Chart

Threads Metric Pitches mm											
position	D4	C4	C3	C2	A4	B2	E4	A2	E2		
48T	0.4	0.45	0.5	0.5625	0.6	0.625	0.7	0.75	0.875		
100T	0.8	0.9	1	1.125	1.2	1.25	1.4	1.5	1.75		
24T	1.6	1.8	2	2.25	2.4	2.5	2.8	3	3.5		
24T	3.2	3.6	4	4.5	4.8	5	5.6	6	7		

Threads Imperial Pitches 1/inch											
position	A2	A3	C3	A4	C3	C3	C3	A1	D4		
48T	Z 24	24	38	24	22	24	26	24	24		
100T	MII 4	4 1/2	5 1/2	5	5 1/2	6	6 1/2	7	7 1/2		
24T	MI 8	9	19	10	11	12	13	14	15		
24T	Z 48	48	38	48	44	48	52	48	48		
120T	MII 16	18	19	20	22	24	26	28	30		
48T	MI 32	36	38	40	44	48	52	56	60		

Metric and Imperial Thread Charts

Product Brochure For L183

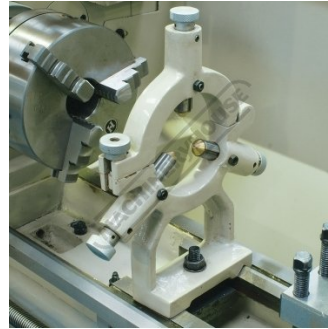
INDICATOR TABLE					
$\frac{1}{8}$ inch	4	4½	5	6	7
SCALE	1-8	1	1*5	1*3*5*7	1*5
$\frac{1}{4}$ inch	8	9	10	11	12
SCALE		1*5	1*3*5*7	1*5	1-8
$\frac{3}{8}$ inch	13	14	15	16	18
SCALE	1*5	1*3*5*7	1*5		1*3*5*7
$\frac{1}{2}$ inch	19	20	22	24	28
SCALE	1*5	1-8	1*3*5*7		1*3*5*7

**CAUTION**

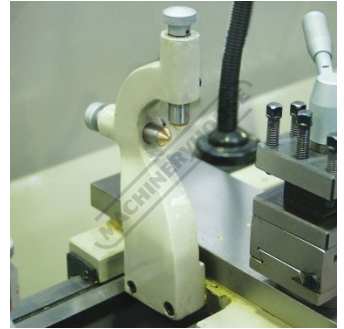
Indicator Table



Chuck Guard



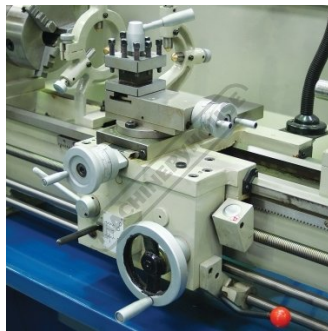
3 Point Steady



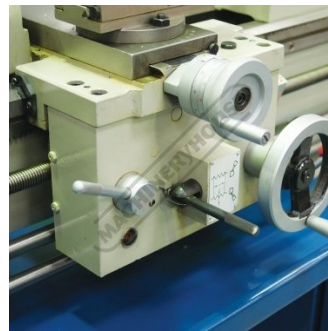
2 Point Steady



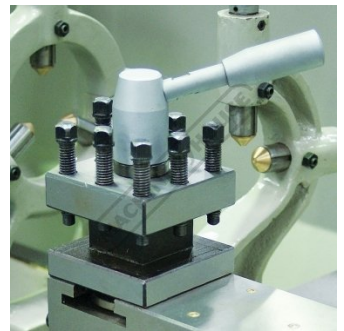
Halogen Light



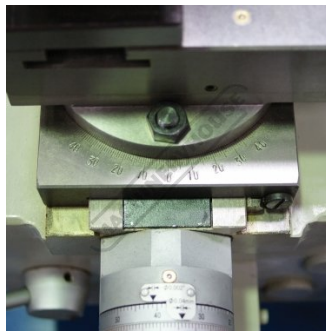
Saddle



Saddle Left View



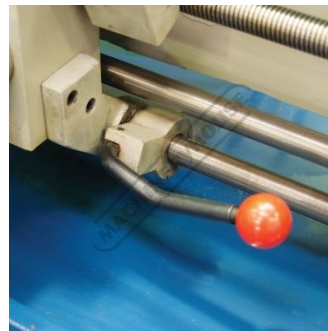
Toolpost



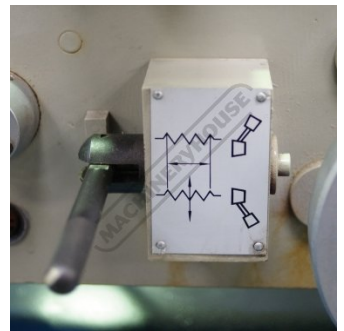
Compound Slide



Thread Chasing Dial



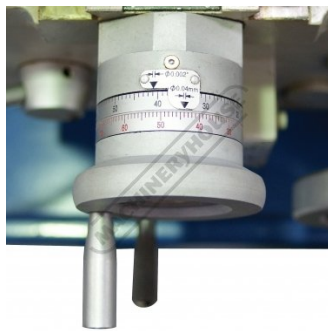
Forward Reverse Spindle Lever



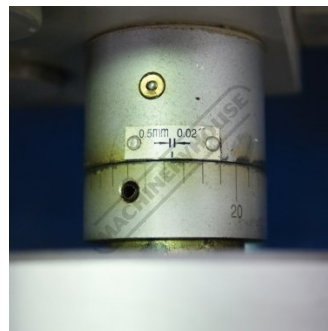
Feed Engagement Lever



Compound Slide Hand Wheel



Cross Feed Handle

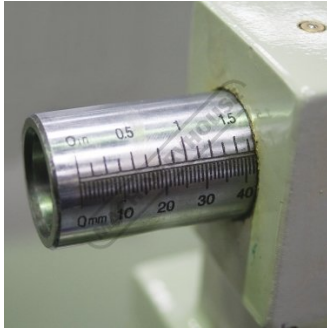


Saddle Hand Wheel

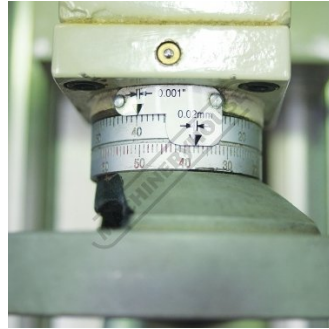


Tailstock

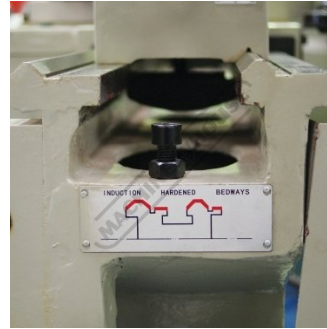
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Tailstock Quill



Tailstock Handle



Induction Hardened Bedways

**Recommended Accessories**

G660

Lathe Leadscrew Cover Kit



G659

Lathe Leadscrew Cover Kit - Concertina



L300

Magnetic Swarf Remover



M9991

Magnetic Floor Sweeper



L0099

Lathe Turning Tool Kit - 7 piece Insert Type



L0098

Carbide Inserts - General Purpose



L450

Lathe Turning Tool Kit - 3 piece Insert Type



L456

Lathe Threading Tool Kit - Insert Type



Product Brochure For L183

L464

Professional Lathe Parting Tool Kit - Insert Type



L074

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



L0007

Part Off Blade - High Speed Steel Bit



C052

3MT Live Centre



C290

Heavy Duty Drill Chuck - Keyed Type



D443A

3MT x JT3 Drill Chuck Arbor



L076

Knurling Tool Holder Kit



P235

Coolant Pump & Tank



L295

Quick Change Toolpost



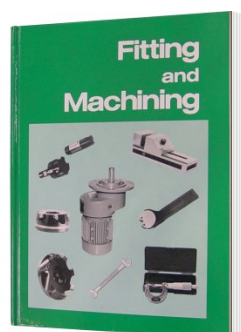
L295A

Quick Change Toolpost Holder - Std



L341

Fitting and Machining Technical Book



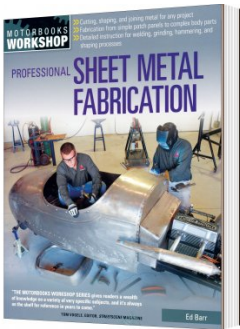
L345

Handy Workshop Tips & Techniques - 1st Edition



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**L3455**  
Professional Sheet Metal Fabrication Book



**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



**L277**  
Vertical Mill Slide



**D720C**  
200mm Easson Digital Readout Scale



**D734**  
900mm Easson Digital Readout Scale



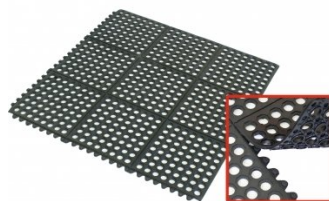
**C980**  
5C Collet Lathe Adaptor



**M800**  
Rubber Mat - Anti-Fatigue



**M805**  
Rubber Mat - Anti-Fatigue



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



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



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S076

Cutting Tool Lubricant Fluid - 500ml



S077

Drilling, Tapping & Cutting Tool Lubricant Spray - 400g



S074

Cutting Tool Lubricant Paste - 500g



O043

Rust & Corrosion Preventive



O042

General Purpose Lubricant & Corrosion Inhibitor



O044

Rust & Corrosion Preventive

