

## Product Brochure For L254D

### Centre Lathe - CHAMPION 1550

Ø390 x 1250mm Turning Capacity - Ø55mm Spindle Bore  
Includes Digital Readout System



**JESCO**



**On Sale**

**Ex GST**

**Inc GST**

**\$35,930.00**

**\$41,319.50**

**\$34,021.74**

**\$39,125.00**

ORDER CODE:	L254D
MODEL:	DASHIN CHAMPION 1550
Swing Over Bed (mm):	390
Distance Between Centres (mm):	1250
Spindle Bore (mm):	55
Swing In Gap (mm):	610
Swing Over Cross-slide (mm):	240
Digital Readout System Fitted:	Yes
Quick Change Toolpost Fitted:	Optional
Leadscrew Covers Fitted:	Yes
Taper Turning Attachment:	~
Coolant System:	Yes
Tool Height To Suit (mm):	20
Centre Height (mm):	195
Spindle Nose Size or Type:	D1-6 Camlock
Bed Width (mm):	270
Headstock Spindle Taper (MT):	6
Tailstock Taper (MT):	4
Cross Slide Travel (mm):	230
Compound Slide Travel (mm):	120
Leadscrew Type:	Metric
Metric Cross Feed (X-Axis) (mm/rev):	0.02 - 0.50
Imperial Cross Feed (X-Axis) (inch/rev):	~
Metric Longitudinal Feed (Z-Axis) (mm/rev):	0.040 - 1.00
Imperial Longitudinal Feed (Z-Axis) (inch/rev):	~
Metric Thread Steps & Pitch (No. / mm):	39(0.2 - 14)
Imperial Thread Steps & TPI (No. / TPI):	40(2 - 72)
3 Jaw Chuck Diameter (mm):	232
4 Jaw Chuck Diameter (mm):	250
Spindle Steps / Speeds (No. / rpm):	16 (25 - 2000)
Motor Power (kW / hp):	5.5 / 7.5
Voltage / Amperage (V / amp):	415
Nett Weight (kg):	1500

### Description

Manufactured in Taiwan, Jesco has been producing high-quality center lathes for over 30 years. As the OEM manufacturer for a prominent British lathe brand, Jesco ensures exceptional craftsmanship and reliability.

The Champion model stands out with its geometric progression gear speed selector, ensuring effortless and precise speed adjustments. This all-inclusive lathe package is equipped with essential features to deliver precise, high-quality metal parts, making it the trusted choice for professionals who demand excellence in metal turning.

### Features

- 2 Axis digital readout system
- Precision Taiwanese machine, sold for over 45 years
- Adjustable taper roller bearings providing spindle accuracy
- Precision 'V'-beds & headstock gears are all hardened & ground
- Overload protection on drive motor and coolant system
- Universal enclosed gearbox incorporating metric & imperial thread capabilities
- Inching button incorporated on the control panel for convenient spindle speed selection
- Foot operated spindle brake with safety cut out switch

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- 270mm wide induction hardened heavy duty cast iron bed
- Removable gap bed allowing work piece to swing up to 610mm
- Powered longitudinal and cross feeds
- Clutch in apron enabling pressure adjustment for feeding in both axis
- Dual calibrated dials incorporating metric & imperial graduations on Cross and Compound Dials
- Coolant system with flexible hose enabling operator to manipulate flow direction
- Oil sight glass for head stock and gearbox
- Lubrication pump on saddle oiling slides
- Change gears for metric and imperial thread cutting
- D1-6 camlock spindle for quick chuck removal
- 16 spindle speeds from 25-2000rpm in geometric progression
- Large 55mm spindle bore
- 5.5kW / 7.5HP 415V main motor

### Includes

- 2 Axis digital readout system
- 232mm 3-jaw chuck with reverse jaws
- 250mm 4-jaw chuck
- Leadscrew cover
- Face plate
- Fixed steady
- Travelling steady
- Dead centres
- Thread chasing dial
- Foot brake
- Coolant system
- Rear splash guard
- Spindle reducing bush

### Specific Features



Front View



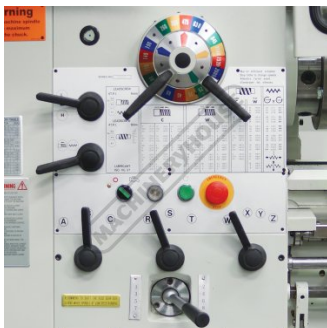
Left View



DRO



Headstock



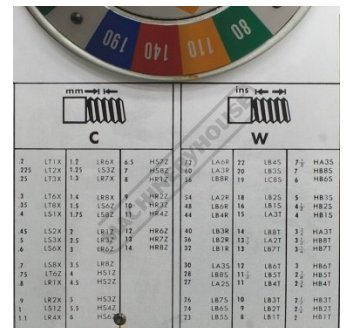
Headstock Levers



Spindle Speed Levers



Leadscrew Levers



Thread Charts

Product Brochure For L254D

mod.	c	d.p.	w	mm	ins
3	HT5X	44	HB4R	84	LCT1 8015
4	HS1X	40	HB3R	85	LCT14 8017
5	HS3X	36	HB2R	86	LCT8 8018
6	HS6X	32	HB1R	88	LCS1 8019
7	HS8X	30	HA35	10	LCS4 806
8	HS1X	28	HB5C	12	LCS4 806
9	HR2X	26	HB7S	15	LCS1 806
10	HS12	24	HB8S	20	LCS1 806
1.25	HS32	22	HB4S	25	LCS6 810
1.5	HS62	20	HB3S	30	LCS6 812
1.75	HS82	19	HB2S	35	HCS2 814
2	HS12	18	HB1S	40	HCS4 814
2.25	HR22	18	HB1S	40	HCS2 810
2.5	HR32	15	HA3T	75	HCR3 830
2.75	HR42	14	HBRT	100	HCS8 840
3	HR62	13	HB7T	1	
3.25	HR72	12	HB6T	1	
3.5	HR82	11	HB4T	1	
4	HR12	10	HB3T	1	
4.5	HR22	9	HB2T	1	
5	HR32	8	HB1T	1	

Charts



Feed Levers

GEAR	PITCH	SCALE
13T	1 1.5 2 3 4 5 6 7 8 9 10 11 12	1 1.25 1.5 1.75 2 2.25 2.5 2.75 3 3.25 3.5 3.75 4 4.25 4.5 4.75 5 5.25 5.5 5.75 6 6.25 6.5 6.75 7 7.25 7.5 7.75 8 8.25 8.5 8.75 9 9.25 9.5 9.75 10 10.25 10.5 10.75 11 11.25 11.5 11.75 12 12.25 12.5 12.75 13 13.25 13.5 13.75 14 14.25 14.5 14.75 15 15.25 15.5 15.75 16 16.25 16.5 16.75 17 17.25 17.5 17.75 18 18.25 18.5 18.75 19 19.25 19.5 19.75 20 20.25 20.5 20.75 21 21.25 21.5 21.75 22 22.25 22.5 22.75 23 23.25 23.5 23.75 24 24.25 24.5 24.75 25 25.25 25.5 25.75 26 26.25 26.5 26.75 27 27.25 27.5 27.75 28 28.25 28.5 28.75 29 29.25 29.5 29.75 30 30.25 30.5 30.75 31 31.25 31.5 31.75 32 32.25 32.5 32.75 33 33.25 33.5 33.75 34 34.25 34.5 34.75 35 35.25 35.5 35.75 36 36.25 36.5 36.75 37 37.25 37.5 37.75 38 38.25 38.5 38.75 39 39.25 39.5 39.75 40 40.25 40.5 40.75 41 41.25 41.5 41.75 42 42.25 42.5 42.75 43 43.25 43.5 43.75 44 44.25 44.5 44.75 45 45.25 45.5 45.75 46 46.25 46.5 46.75 47 47.25 47.5 47.75 48 48.25 48.5 48.75 49 49.25 49.5 49.75 50 50.25 50.5 50.75 51 51.25 51.5 51.75 52 52.25 52.5 52.75 53 53.25 53.5 53.75 54 54.25 54.5 54.75 55 55.25 55.5 55.75 56 56.25 56.5 56.75 57 57.25 57.5 57.75 58 58.25 58.5 58.75 59 59.25 59.5 59.75 60 60.25 60.5 60.75 61 61.25 61.5 61.75 62 62.25 62.5 62.75 63 63.25 63.5 63.75 64 64.25 64.5 64.75 65 65.25 65.5 65.75 66 66.25 66.5 66.75 67 67.25 67.5 67.75 68 68.25 68.5 68.75 69 69.25 69.5 69.75 70 70.25 70.5 70.75 71 71.25 71.5 71.75 72 72.25 72.5 72.75 73 73.25 73.5 73.75 74 74.25 74.5 74.75 75 75.25 75.5 75.75 76 76.25 76.5 76.75 77 77.25 77.5 77.75 78 78.25 78.5 78.75 79 79.25 79.5 79.75 80 80.25 80.5 80.75 81 81.25 81.5 81.75 82 82.25 82.5 82.75 83 83.25 83.5 83.75 84 84.25 84.5 84.75 85 85.25 85.5 85.75 86 86.25 86.5 86.75 87 87.25 87.5 87.75 88 88.25 88.5 88.75 89 89.25 89.5 89.75 90 90.25 90.5 90.75 91 91.25 91.5 91.75 92 92.25 92.5 92.75 93 93.25 93.5 93.75 94 94.25 94.5 94.75 95 95.25 95.5 95.75 96 96.25 96.5 96.75 97 97.25 97.5 97.75 98 98.25 98.5 98.75 99 99.25 99.5 99.75 100

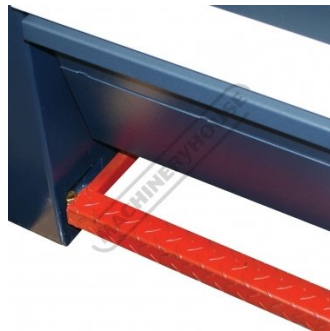
Indicator Table



Safety Chuck Guard



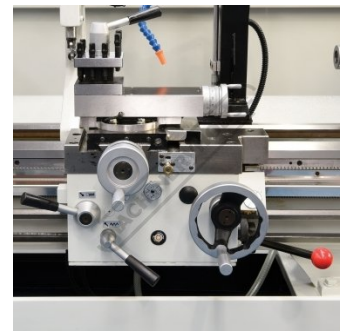
3 Jaw Chuck



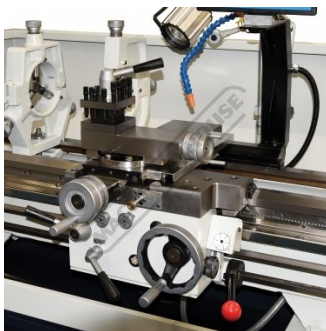
Foot Brake



Slide Out Chip Tray



Saddle Controls



Saddle Right View



Coolant Nozzle and Work Light



Saddle Left View



Leadscrew Covers



Spindle Engagement Lever



Thread Chasing Dial



One Shot Lubrication

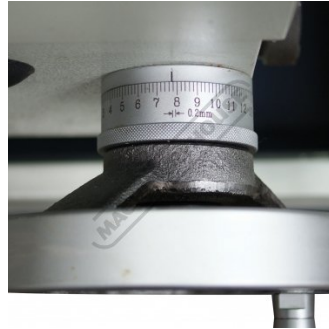


Feed Engagement Dials

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Crossfeed Dial-Dual Calibrated



Saddle Hand Wheel



Compound Slide Dial - Dual Calibrated



Swivel Compound Slide



Toolpost



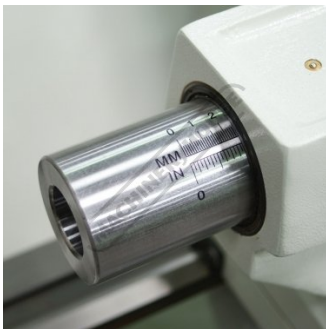
2 Point Travelling Steady



3 Point Fixed Steady



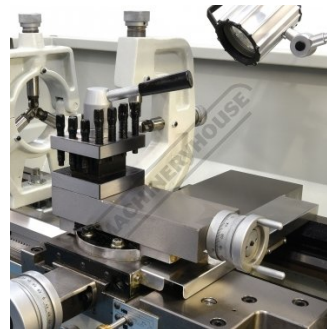
Tailstock



Tailstock Quill



Tailstock Handle



Compound Slide



Induction Hardened Cast Iron Bed

Product Brochure For L254D

**Recommended Accessories**

L046  
Right Hand Turning Tool Holder

L047  
Left Hand Turning Tool Holder

L039  
Right Hand Turning Tool Holder

L040  
Left Hand Turning Tool Holder



L452  
Lathe Turning Tool Kit - 3 piece  
Insert Type

L458  
Lathe Threading Tool Kit - Insert  
Type

L466  
Professional Lathe Parting  
Tool Kit - Insert Type

C054  
4MT Live Centre



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**C046**  
4MT Pipe Centre - 70° Cone



**C290**  
Heavy Duty Drill Chuck - Keyed Type



**C294**  
Industrial Drill Chuck - Keyless Type



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



**D424**  
Drill Sleeve - Morse Taper



**D422**  
Drill Sleeve - Morse Taper



**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



**D119**  
Metric 2MT HSS Drill Set



**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



S091

Soluble Metal Cutting Fluid - 20 Litre



G662

Lathe Leadscrew Cover Kit



A358

Sky Hook Lifting Device



A358A

Chuck Hook



L300

Magnetic Swarf Remover



M9991

Magnetic Floor Sweeper



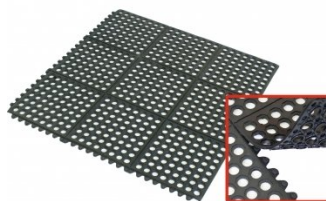
M800

Rubber Mat - Anti-Fatigue



M805

Rubber Mat - Anti-Fatigue



O043

Rust & Corrosion Preventive



Product Brochure For L254D

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O042

General Purpose Lubricant &  
Corrosion Inhibitor



O044

Rust & Corrosion Preventive

