

Product Brochure For L682

Centre Lathe - AL-336

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

On Sale

Ex GST	Inc GST
\$6,698.00	\$7,702.70
\$5,900.00	\$6,785.00



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.

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Features

- Gear drive headstock for quick change of spindle speeds
- Precision 'V'-beds are hardened and ground, incorporating a rigid webbed casting
- 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
MI	0.4	0.45	0.5	0.5	0.7	0.75			
MI	0.8	0.9	1	1.2	1.25	1.4	1.5	1.75	
MI	1.6	1.8	2	2.25	2.4	2.5	2.8	3	3.5
MI	3.2	3.6	4	4.5	4.8	5	5.6	6	7

THREAD PER INCH									
	A2	A3	C3	A4	C3	C3	A5	B4	
Z	24	24	38	24	22	24	26	24	24
MI	4	4 1/2	5	5 1/2	6	6 1/2	7	7 1/2	
MI	8	9	10	11	12	13	14	15	
Z	48	48	38	48	44	48	52	48	48
MI	16	18	19	20	22	24	26	28	30
MI	32	36	38	40	44	46	52	56	60

Metric Thread Chart

mm										
Position	E2	E3	A2	E4	E1	C3	C4	A5	D5	B5
SI	0.1500	0.2000	0.2500	0.3000	0.3500	0.4000	0.4500	0.5000	0.5500	0.6000
SI	0.7500	1.0000	1.2500	1.5000	1.7500	2.0000	2.2500	2.5000	2.7500	3.0000
SI	3.7500	5.0000	6.2500	7.5000	8.7500	10.0000	11.2500	12.5000	13.7500	15.0000
SI	18.7500	25.0000	31.2500	37.5000	43.7500	50.0000	56.2500	62.5000	68.7500	75.0000

inch										
Position	E2	E3	A2	E4	E1	C3	C4	A5	D5	B5
SI	0.00787	0.01041	0.01289	0.01543	0.01791	0.02031	0.02271	0.02511	0.02751	0.03000
SI	0.03150	0.04167	0.05184	0.06200	0.07217	0.08234	0.09251	0.10268	0.11285	0.12302
SI	0.12319	0.16333	0.20347	0.24361	0.28375	0.32389	0.36403	0.40417	0.44431	0.48445
SI	0.48459	0.64611	0.80763	0.96915	1.13067	1.29219	1.45371	1.61523	1.77675	1.93827

Feed Charts

INDICATOR TABLE				
T	T-P-I	SCALE	T-P-I	SCALE
0	4	8		
	16	24		
	32	40		
	48	56		
16	4 1/2	8	14	2-4-6-8
	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
	9	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

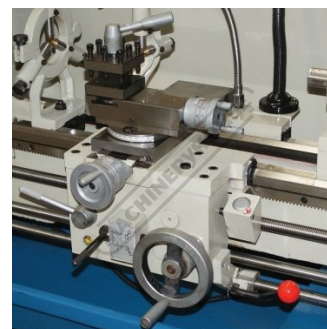
Thread Chase-Indicator Table

SPINDLE SPEED /min				
	1	2	3	
I II	A	360	1810	1095
I	B	100	500	300
	C	280	1400	840
II	A	235	1200	700
	B	65	330	200
	C	180	910	550

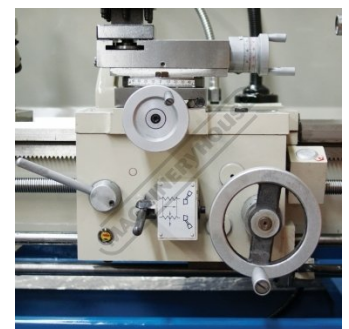
18 Spindle speeds 65-1810rpm



Chuck Guard With Safety Micro Switch

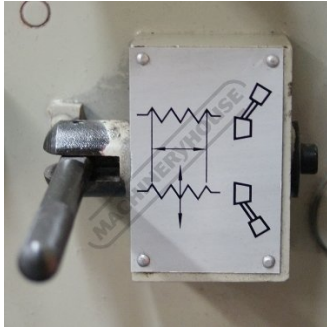


Saddle Right View



Saddle Control

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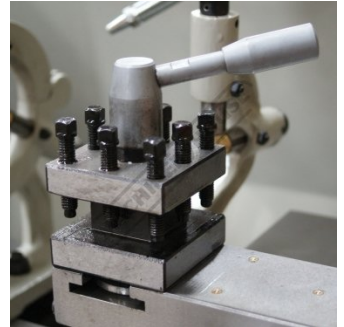
Feed Engagement Lever



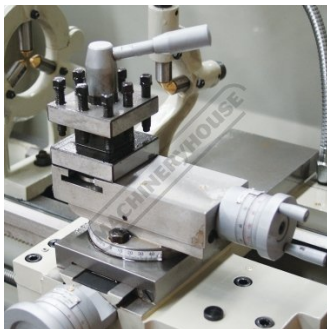
Thread Chasing Dial



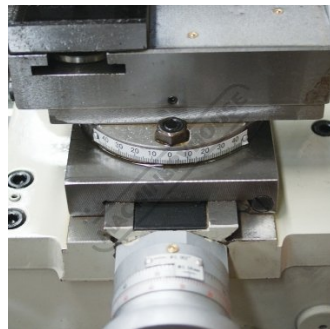
Forward Reverse Spindle Lever



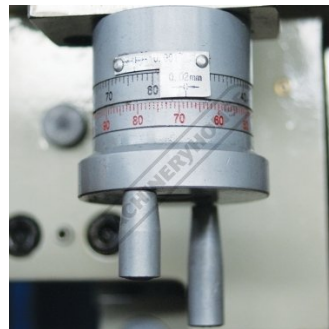
Toolpost



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

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Recommended Accessories

M002
Steel Machine Mount & Rubber
Insert



L682D
Centre Lathe



D694
1500mm Optimum Magnetic
Digital Readout Scale



D5229
920mm Sino Digital Readout
Scale



D5249
Scale - Backing Plate & Cover



D5204
Sino Digital Readout Lathe
Mounting Bracket Kit



P235
Coolant Pump & Tank



L292
Quick Change Toolpost



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L295
Quick Change Toolpost



L277
Vertical Mill Slide



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



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C045
3MT Pipe Centre - 70° Cone



C290
Heavy Duty Drill Chuck - Keyed Type



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



S074
Cutting Tool Lubricant Paste - 500g



G660
Lathe Leadscrew Cover Kit

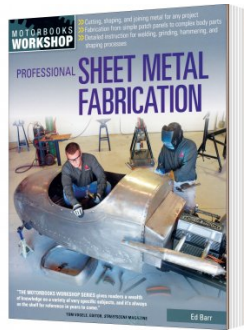


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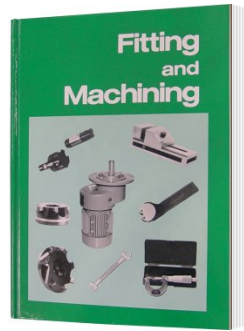
G659
Lathe Leadscrew Cover Kit -
Concertina



L3455
Professional Sheet Metal
Fabrication Book



L341
Fitting and Machining Technical
Book



L345
Handy Workshop Tips &
Techniques - 1st Edition



L300
Magnetic Swarf Remover



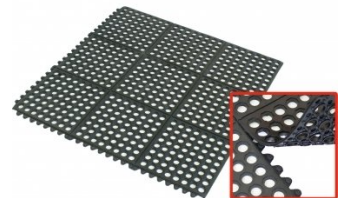
M9991
Magnetic Floor Sweeper



M800
Rubber Mat - Anti-Fatigue



M805
Rubber Mat - Anti-Fatigue



O043
Rust & Corrosion Preventive



O042
General Purpose Lubricant &
Corrosion Inhibitor



O044
Rust & Corrosion Preventive

