

Product Brochure For K008

## Centre Lathe & Tooling Package Deal - AL-336

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

**Package Deal**

Ex GST                      Inc GST  
**\$6,090.00              \$6,699.00**

Package Contents - SAVE \$275.00 (Inc)	
1 x L682 - Centre Lathe AL-336	<b>\$6,039.00</b>
1 x L450 - Lathe Turning Tool Kit - 3 piece Insert Type	<b>\$297.00</b>
1 x L456 - Lathe Threading Tool Kit - Insert Type	<b>\$242.00</b>
1 x L464 - Professional Lathe Parting Tool Kit - Insert Type	<b>\$198.00</b>
1 x C052 - 3MT Live Centre	<b>\$88.00</b>
1 x D443A - 3MT x JT3 Drill Chuck Arbor	<b>\$22.00</b>
1 x C290 - Heavy Duty Drill Chuck - Keyed Type	<b>\$88.00</b>
<b>Normal Price (Inc):</b>	<b>\$6,974.00</b>



ORDER CODE:	K008
MODEL:	AL-336 Package Deal
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

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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, guarded leadscrew cover, 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
- 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

- Turning tool kit (L450)
- Threading tool kit (L456)
- Parting tool kit (L464)
- Live centre (C052)
- Keyed drill chuck (C290)
- Drill chuck arbour (D44A)
- 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

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Specific Features



AL-336 Lathe



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	4.5	9	5	5	6	6	7	7
MI	8	9	19	10	11	12	13	14	15
Z	48	48	38	48	44	48	52	48	48
MI	16	16	19	20	22	24	26	28	30
MI	32	36	38	40	44	48	52	56	60

Metric Thread Chart

Metric Feed Charts											
Position	E2	E3	A2	E4	E1	C3	C4	A5	D5	B5	
SI	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15
SI	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30
SI	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45
SI	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60
SI	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75
SI	0.90	0.90	0.90	0.90	0.90	0.90	0.90	0.90	0.90	0.90	0.90
SI	1.10	1.10	1.10	1.10	1.10	1.10	1.10	1.10	1.10	1.10	1.10
SI	1.25	1.25	1.25	1.25	1.25	1.25	1.25	1.25	1.25	1.25	1.25
SI	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50
SI	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75	1.75
SI	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00
SI	2.25	2.25	2.25	2.25	2.25	2.25	2.25	2.25	2.25	2.25	2.25
SI	2.50	2.50	2.50	2.50	2.50	2.50	2.50	2.50	2.50	2.50	2.50
SI	2.75	2.75	2.75	2.75	2.75	2.75	2.75	2.75	2.75	2.75	2.75
SI	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00
SI	3.25	3.25	3.25	3.25	3.25	3.25	3.25	3.25	3.25	3.25	3.25
SI	3.50	3.50	3.50	3.50	3.50	3.50	3.50	3.50	3.50	3.50	3.50
SI	3.75	3.75	3.75	3.75	3.75	3.75	3.75	3.75	3.75	3.75	3.75
SI	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00
SI	4.25	4.25	4.25	4.25	4.25	4.25	4.25	4.25	4.25	4.25	4.25
SI	4.50	4.50	4.50	4.50	4.50	4.50	4.50	4.50	4.50	4.50	4.50
SI	4.75	4.75	4.75	4.75	4.75	4.75	4.75	4.75	4.75	4.75	4.75
SI	5.00	5.00	5.00	5.00	5.00	5.00	5.00	5.00	5.00	5.00	5.00
SI	5.25	5.25	5.25	5.25	5.25	5.25	5.25	5.25	5.25	5.25	5.25
SI	5.50	5.50	5.50	5.50	5.50	5.50	5.50	5.50	5.50	5.50	5.50
SI	5.75	5.75	5.75	5.75	5.75	5.75	5.75	5.75	5.75	5.75	5.75
SI	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00
SI	6.25	6.25	6.25	6.25	6.25	6.25	6.25	6.25	6.25	6.25	6.25
SI	6.50	6.50	6.50	6.50	6.50	6.50	6.50	6.50	6.50	6.50	6.50
SI	6.75	6.75	6.75	6.75	6.75	6.75	6.75	6.75	6.75	6.75	6.75
SI	7.00	7.00	7.00	7.00	7.00	7.00	7.00	7.00	7.00	7.00	7.00
SI	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25	7.25
SI	7.50	7.50	7.50	7.50	7.50	7.50	7.50	7.50	7.50	7.50	7.50
SI	7.75	7.75	7.75	7.75	7.75	7.75	7.75	7.75	7.75	7.75	7.75
SI	8.00	8.00	8.00	8.00	8.00	8.00	8.00	8.00	8.00	8.00	8.00
SI	8.25	8.25	8.25	8.25	8.25	8.25	8.25	8.25	8.25	8.25	8.25
SI	8.50	8.50	8.50	8.50	8.50	8.50	8.50	8.50	8.50	8.50	8.50
SI	8.75	8.75	8.75	8.75	8.75	8.75	8.75	8.75	8.75	8.75	8.75
SI	9.00	9.00	9.00	9.00	9.00	9.00	9.00	9.00	9.00	9.00	9.00
SI	9.25	9.25	9.25	9.25	9.25	9.25	9.25	9.25	9.25	9.25	9.25
SI	9.50	9.50	9.50	9.50	9.50	9.50	9.50	9.50	9.50	9.50	9.50
SI	9.75	9.75	9.75	9.75	9.75	9.75	9.75	9.75	9.75	9.75	9.75
SI	10.00	10.00	10.00	10.00	10.00	10.00	10.00	10.00	10.00	10.00	10.00

Feed Charts

INDICATOR TABLE					
T	T-P-I	SCALE	T-P-I	SCALE	
0	4	8	8		
	16	24	40		
	32	40	56		
	48	56			
T	T-P-I	SCALE	T	T-P-I	SCALE
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		
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		

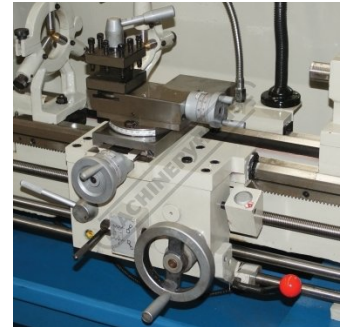
Thread Chase-Indicator Table

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

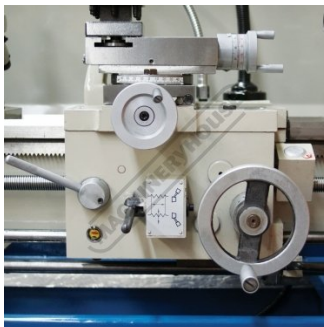
18 Spindle speeds 65-1810rpm



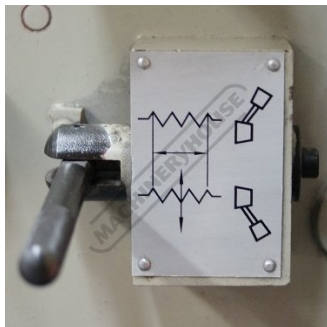
Chuck Guard With Safety Micro Switch



Saddle Right View



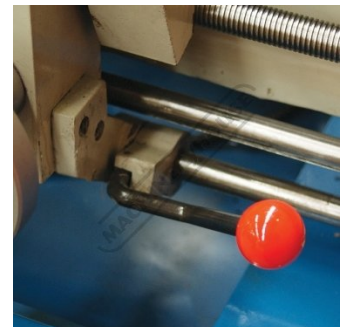
Saddle Control



Feed Engagement Lever



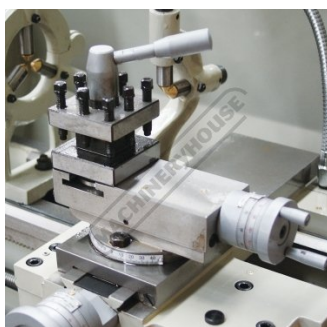
Thread Chasing Dial



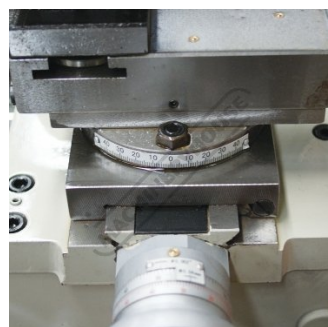
Forward Reverse Spindle Lever



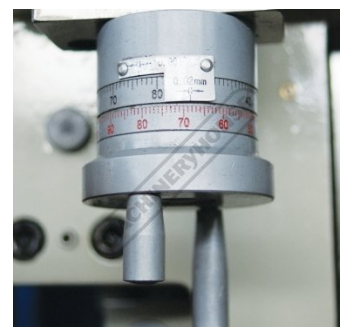
Toolpost



Compound Slide



Swivel Compound Slide



Compound Slide Hand Wheel

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Crossslide Hand Wheel



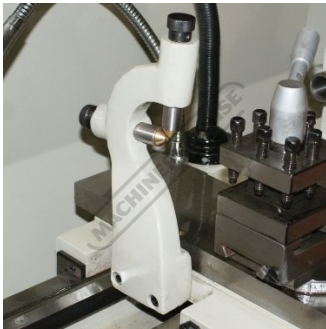
Saddle Hand Wheel



Lamp and Coolant Hose



3 Point Fixed Steady



2 Point Travelling Steady



Tailstock



Tailstock Quill



Tailstock Hand Wheel



Induction Hardened Bedways



12mm Lathe Toolset



12mm Lathe Threading



12mm Lathe Parting Tool



3MT Live Centre



16mm Drill Chuck



Arbour

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**Recommended Accessories**

L682D  
 Centre Lathe



D695  
 3-Axis Optimum Digital Readout Counter - 1µm



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



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**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



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**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

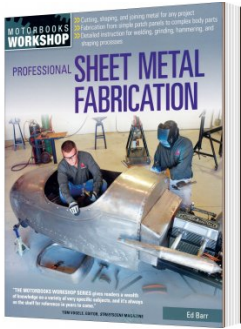


**G659**  
 Lathe Leadscrew Cover Kit - Concertina

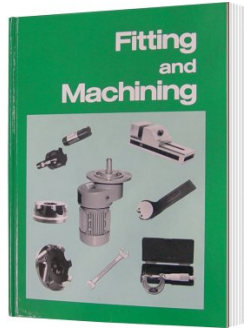


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**L3455**  
Professional Sheet Metal Fabrication Book



**L341**  
Fitting and Machining Technical Book



**L300**  
Magnetic Swarf Remover



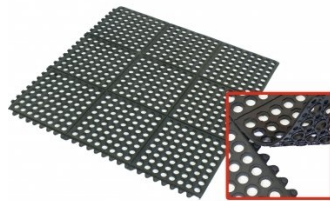
**M9991**  
Magnetic Floor Sweeper



**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

