

Product Brochure For L664D

Centre Lathe - CK-100

660 x 2000mm Turning Capacity - 105mm Spindle Bore
 Includes Digital Readout System, Quick Change Toolpost & Taper Turning Attachment



ORDER CODE:	L664D
MODEL:	CK-100
Swing Over Bed (mm):	660
Distance Between Centres (mm):	2000
Spindle Bore (mm):	105
Swing In Gap (mm):	870
Swing Over Cross-slide (mm):	420
Digital Readout System Fitted:	Yes
Quick Change Toolpost Fitted:	Yes
Leadscrew Covers Fitted:	Yes
Taper Turning Attachment:	Yes
Coolant System:	Yes
Tool Height To Suit (mm):	25
Centre Height (mm):	330
Spindle Nose Size or Type:	D1-8 Camlock
Bed Width (mm):	405
Headstock Spindle Taper (MT):	7
Tailstock Taper (MT):	5
Cross Slide Travel (mm):	310
Compound Slide Travel (mm):	145
Leadscrew Type:	Metric
Metric Cross Feed (X-Axis) (mm/rev):	0.027 - 1.07
Imperial Cross Feed (X-Axis) (inch/rev):	~
Metric Longitudinal Feed (Z-Axis) (mm/rev):	0.063 - 2.52
Imperial Longitudinal Feed (Z-Axis) (inch/rev):	~
Metric Thread Steps & Pitch (No. / mm):	22 (1 - 14)
Imperial Thread Steps & TPI (No. / TPI):	28 (2 - 28)
3 Jaw Chuck Diameter (mm):	325
4 Jaw Chuck Diameter (mm):	400
Spindle Steps / Speeds (No. / rpm):	12 (36 - 1600)
Motor Power (kW / hp):	9 / 12
Voltage / Amperage (V / amp):	415
Nett Weight (kg):	3600

Features

- 2 Axis digital readout system
- Quick change toolpost
- Taper turning attachment fitted to saddle
- Triple bearings supporting headstock spindle
- Adjustable taper roller bearings providing spindle accuracy
- Precision 'V'-beds & headstock gears are all hardened & ground
- Multiple discs forward and reversing clutch system
- Adjustable feed stop system with 6 individual sliding stops
- Overload protection on drive motor and coolant system
- Universal enclosed gearbox incorporating metric & imperial thread capabilities
- Foot operated spindle brake with safety cut out switch
- X & Z axis rapid traverse selection lever incorporated on the saddle @ 4.5m/min
- 405mm wide induction hardened heavy duty cast iron bed
- Removable gap bed allowing work piece to swing up to 870mm
- Cross slide handle disengages when auto feed is used
- Saddle hand wheel disengages when auto feed is used
- Adjustable clutch for auto feeds protects machine from overloading during machining
- Chuck guard fitted with safety micro switch
- Micro switch on side access door
- Powered longitudinal and cross feeds
- Metric calibrated feed dials
- Coolant system with flexible hose enabling operator to manipulate flow direction

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- Oil sight glass for head stock and gearbox & apron
- Lubrication pump on saddle oiling slides
- Low voltage halogen work light
- D1-8 camlock spindle for quick chuck removal
- 12 spindle speeds 36-1600rpm
- Large 105mm spindle bore
- 9kW / 12HP 415V main motor

Includes

- 2 Axis digital readout system
- Quick change toolpost
- Taper turning attachment fitted to saddle
- Leadscrew cover
- 325mm 3-jaw chuck with reverse jaws
- 400mm 4-jaw chuck
- Face plate
- Fixed steady
- Travelling steady
- Dead centres
- Thread chasing dial
- Foot brake
- Coolant system
- Work light
- Chuck guard
- Rear splash guard
- Spindle reducing bush

Specific Features



Digital Read Out



Safety Chuck Guard



Induction Hardened Bedways



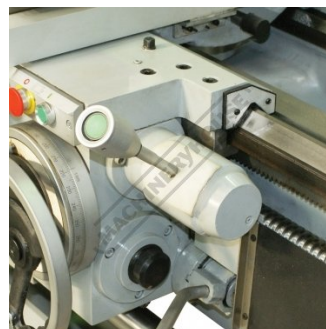
Leadscrew Covers



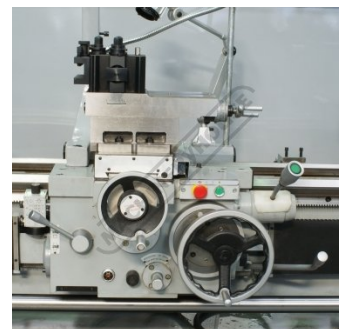
Compound Slide



Saddle Right View



Rapid Traverse Selection Lever on Saddle

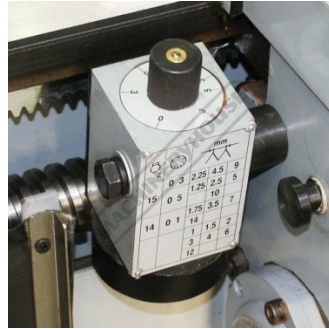


Saddle Controls

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Saddle Left View



Thread Chasing Dial



Feed Stop System



Fixed Steady



Travelling Steady



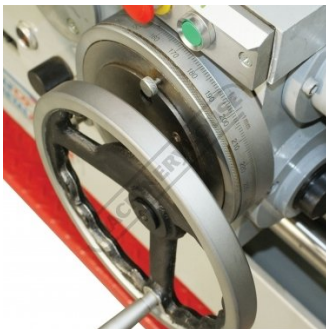
Foot Brake



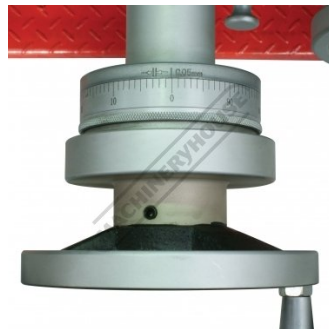
Tailstock



Tailstock Quill



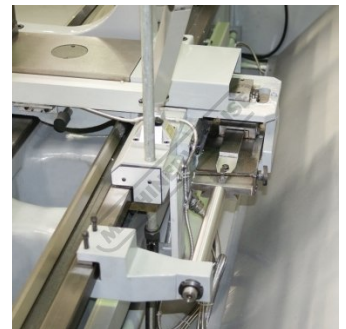
Saddle Hand Wheel



Cross Slide Hand Wheel



Tailstock Hand Wheel



Taper Turning Attachment



Taper Turning Attachment Angle

mm	mm				mm				
	A	B	C	D	A	B	C	D	
1	0.003	0.008	0.16	0.36	0.71	0.003	0.008	0.16	0.36
2	0.007	0.10	0.20	0.40	0.80	0.007	0.10	0.20	0.40
3	0.013	0.21	0.42	0.83	1.66	0.013	0.21	0.42	0.83
4	0.019	0.32	0.64	1.28	2.56	0.019	0.32	0.64	1.28
5	0.025	0.43	0.86	1.72	3.44	0.025	0.43	0.86	1.72
6	0.031	0.54	1.08	2.16	4.32	0.031	0.54	1.08	2.16
7	0.037	0.65	1.30	2.60	5.20	0.037	0.65	1.30	2.60
8	0.043	0.76	1.52	3.04	6.08	0.043	0.76	1.52	3.04
9	0.049	0.87	1.74	3.48	6.96	0.049	0.87	1.74	3.48
10	0.055	0.98	1.96	3.92	7.84	0.055	0.98	1.96	3.92
11	0.061	1.09	2.18	4.36	8.72	0.061	1.09	2.18	4.36
12	0.067	1.20	2.40	4.80	9.60	0.067	1.20	2.40	4.80
13	0.073	1.31	2.62	5.24	10.48	0.073	1.31	2.62	5.24
14	0.079	1.42	2.84	5.68	11.36	0.079	1.42	2.84	5.68
15	0.085	1.53	3.06	6.12	12.24	0.085	1.53	3.06	6.12

Feed Chart

mm	mm				mm			
	I	II	III	IV	I	II	III	IV
1	1	2	4	8	0.5	1	2	4
2	1	2.5	4.5	9	0.5	1	2.5	4.5
4	1.25	2.5	5	10	1.25	2.5	5	10
7	1	2.75	5.5	11	1	2.75	5.5	11
8	1.5	3	6	12	0.75	1.5	3	6
11	1.75	3.5	7	14	1.75	3.5	7	14

Thread Chart

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Recommended Accessories

L453

Lathe Turning Tool Kit - 3 piece
 Insert Type



L459

Lathe Threading Tool Kit - Insert
 Type



L467

Professional Lathe Parting Tool
 Kit - Insert Type



L297

Quick Change Toolpost



L297A

Quick Change Toolpost Holder -
 Std



C294

Industrial Drill Chuck - Keyless
 Type



D454A

4MT x JT3 Drill Chuck Arbor



D1272

Metric 135° Precision HSS Drill
 Set - 25 Piece



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D1282
Imperial 135° Precision HSS
Drill Set - 29 Piece



D126
Metric 135° Precision HSS Drill
Set - 170 Pieces



D119
Metric 2MT HSS Drill Set



D424
Drill Sleeve - Morse Taper



D422
Drill Sleeve - Morse Taper



D425
Drill Sleeve - Morse Taper



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



Product Brochure For L664D

A358
Sky Hook Lifting Device



A358A
Chuck Hook



G664
Lathe Leadscrew Cover Kit



L300
Magnetic Swarf Remover



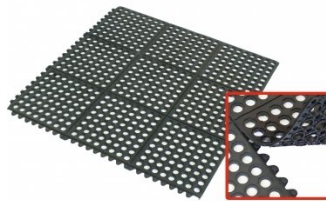
M9991
Magnetic Floor Sweeper



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

