



通用技术沈阳机床
GENERTEC SHENYANG MACHINE TOOL

Product Introduction

CA series Common Lathe



SHENYANG MACHINE TOOL CO., LTD

This machine tool can undertake all kinds of turning work, such as turning internal and external cylindrical surfaces, conical surfaces and other rotating surfaces. Turning end face and various threads metric, inch, modular and radial pitch threads. It can also drill holes, ream holes and pull oil grooves.

This machine tool can process materials such as steel, cast iron and nonferrous metals.

The dimensional accuracy of the parts machined on this machine bed can reach IT7 level, and a smaller surface roughness value can be obtained. Saddle lathe can not only complete the above turning work, but also be especially suitable for processing flat parts and odd parts.

This machine tool has the function of manual braking. Convenient operation, sensitive and reliable braking.

Novel appearance

The appearance design of the machine tool integrates the concept of ergonomics into the mature machine tool structure to enhance the operating feel. The main sheet metal parts adopt striking blue and gray stamping parts, and the overall effect is beautiful.

Perfect function

CA series lathes can turn the end faces, inner and outer cylinders and strange rotating surfaces of heavy materials. More accurate processing of various metric, English, modulus, diameter pitch threads. In addition, drilling, reaming, oil drawing and other work can also be easily completed.

Complete in specifications

CA series products have complete specifications and various categories. Including straight lathe, saddle lathe and large aperture lathe.

Excellent performance

40A series lathe is equipped with large diameter spindle front bearing, and it has more models than similar products.

■ Technical Parameters

Name		Unit	CA6140A	CA6240A	CA6150A	CA6250A
Maximum workpiece slewing diameter on the bed		mm		Φ400		Φ500
Maximum workpiece slewing diameter on the tool holder		mm		Φ210		Φ300
The slewing diameter inside the saddle×effective length		mm	—	Φ630×210	—	Φ720×210
Maximum workpiece length/Maximum cutting length		mm	750/650(Only CA6140A) ; 1000/900 ; 1500/1400 ; 2000/1900			
Width and hardness of bed		mm		400 , Rc52		400 , Rc52
The size of tool bar section dimensions		mm		25×25		25×25
Spindle						
Spindle speed range(series)	Co-rotation	r/min		11-1600(24)		11-1600(24)
	Reverse	r/min		14-1580(12)		14-1580(12)
The inner hole of spindle and type and code of spindle end		mm		Φ52 , A6		Φ52 , A6
Tapered hole at front end of spindle		-		Mohs 6#		Mohs 6#
Feeding						
The spindle longitudinal feed per revolution (64Kinds)	Standard	mm/r		0.08-1.59		0.08-1.59
	Decrease feed	mm/r		0.028-0.054		0.028-0.054
	Increase feed	mm/r		1.71-6.33		1.71-6.33
The spindle transverse feed per revolution (64Kinds)	Standard	mm/r		0.04-0.79		0.04-0.79
	Decrease feed	mm/r		0.014-0.027		0.014-0.027
	Increase feed	mm/r		0.86-3.16		0.86-3.16
Tool holder						
Tool holder transverse stroke		mm		320		320
Small tool holder distance traveled		mm		140		140
The rotation angle of tool holder turntable		°		±90		±90

The rapid traverse speed of the tool holder	Longitudinal	m/min	4	4
	Transverse	m/min	2	2
Tail-stock				
Maximum stroke of the tail-stock spindle		mm	150	150
Tail-stock spindle diameter		mm	Φ75	Φ75
Taper of tail-stock spindle hole		-	Mohs 5#	Mohs 5#
The range of processing thread				
Metric thread (Kinds)		mm	1-192(44)	1-192(44)
Inch thread (Kinds)		t.p.i	2-24(21)	2-24(21)
Modular thread (Kinds)		mm	0.25-48(39)	0.25-48(39)
Pitch thread (Kinds)		D.P	1-96(37)	1-96(37)
Main motor power		KW	7.5	7.5
Machine tool net weight				
750mm		kg	1990	—
1000mm		kg	2070	2140
1500mm		kg	2220	2290
2000mm		kg	2570	2640
Machine dimensions (length× width× height)				
750mm		mm	2418×1000×1267	—
1000mm		mm	2668×1000×1270	2668×1037×1312
1500mm		mm	3168×1000×1270	3168×1037×1312
2000mm		mm	3668×1000×1270	3668×1037×1312

Note: The parameters provided in the table are for reference only, if there is any change, please refer to the actual product.

Name		Unit	CA6140B/A	CA6240B/A	CA6150B/A	CA6250B/A
Maximum workpiece slewing diameter on the bed		mm		Φ400		Φ500
Maximum workpiece slewing diameter on the tool holder		mm		Φ210		Φ300
The slewing diameter inside the saddle×effective length		mm	—	Φ630×210	—	Φ720×210
Maximum workpiece length/Maximum cutting length		mm		1000/900 ; 1500/1400 ; 2000/1900		
Width and hardness of bed		mm		400 , Rc52		400 , Rc52
The size of tool bar section dimensions		mm		25×25		25×25
Spindle						
Spindle speed range(series)	Co-rotation	r/min		10-1400(24)		10-1400(24)
	Reverse	r/min		14-1580(12)		14-1580(12)
The inner hole of spindle and type and code of spindle end		mm		Φ80 , A28		Φ80 , A28
Tapered hole at front end of spindle		-		Φ90mm(1:20)		Φ90mm(1:20)
Feed						
The spindle longitudinal feed per revolution (64Kinds)	Standard	mm/r		0.11-1.6		0.11-1.6
	Decrease feed	mm/r		0.028-0.11		0.028-0.11
	Increase feed	mm/r		1.76-6.4		1.76-6.4
The spindle transverse feed per revolution (64Kinds)	Standard	mm/r		0.05-0.8		0.05-0.8
	Decrease feed	mm/r		0.014-0.05		0.014-0.05
	Increase feed	mm/r		0.88-3.2		0.88-3.2
Tool holder transverse stroke						
Small tool holder distance traveled		mm		320		320
The rotation angle of tool holder turntable		mm		140		140

The rapid traverse speed of the tool holder	Longitudinal	°	±90	±90
	Transverse	m/min	4	4
Tool holder transverse stroke		m/min	2	2
Tail-stock				
Maximum stroke of the tail-stock spindle		mm	150	150
Tail-stock spindle diameter		mm	Φ75	Φ75
Taper of tail-stock spindle hole		-	莫氏 5 号	莫氏 5 号
The range of processing thread				
Metric thread (Kinds)		mm	1-192(44)	1-192(44)
Inch thread (Kinds)		t.p.i	1/2-24(28)	1/2-24(28)
Modular thread (Kinds)		mm	0.25-48(39)	0.25-48(39)
Pitch thread (Kinds)		D.P	1/2-96(38)	1/2-96(38)
Main motor power		KW	7.5	7.5
Machine tool net weight				
1000mm		kg	2070	2140
1500mm		kg	2220	2290
2000mm		kg	2570	2640
Machine dimensions (length× width× height)				
1000mm		mm	2668×1000×1270	2668×1037×1315
1500mm		mm	3168×1000×1270	3168×1037×1315
2000mm		mm	3668×1000×1270	3668×1037×1315

Note: The parameters provided in the table are for reference only, if there is any change, please refer to the actual product.

■ Machine Configuration

Name	Quantity	Unit	CA6140A	CA6240A	CA6150A	CA6250A
Three-jaw chuck						
Φ250K11250C/A16	1	Set	◆	◆	◆	◆
Φ250K11250C/A28	1	Set				
Four-jaw chuck						
Φ400K72400/A26	1	Set		◇		◇
Φ400K72400/A28	1	Set				
Face plate						
Φ600	1	Set		◇		◇
Centre Frame						
Φ20-Φ125	1	Set	◇	◇	◇	◇
Φ100-Φ205	1	Set	◇	◇		
Φ125-Φ250	1	Set			◇	◇
Follow the knife stands						
Φ20-Φ80	1	Set	◇	◇	◇	◇
Top						
5 S25-2	1	Set	◆	◆	◆	◆
Centre sleeve						
6/5 S25-10	1	Set	◆	◆	◆	◆
0011230L	1	Set				
Adjustable sizing block						
-	1	Set	◇	◇	◇	◇
Live center						
-	1	Set	◇	◇	◇	◇

Name	Quantity	Unit	CA6140B/A	CA6240B/A	CA6150B/A	CA6250B/A
Three-jaw chuck						
Φ250K11250C/A16	1	Set				
Φ250K11250C/A28	1	Set	◆	◆	◆	◆
Four-jaw chuck						
Φ400K72400/A26	1	Set				
Φ400K72400/A28	1	Set		◇		◇

Face plate						
Φ600	1	Set		◇		◇
Centre Frame						
Φ20-Φ125	1	Set	◇	◇	◇	◇
Φ100-Φ205	1	Set	◇	◇		
Φ125-Φ250	1	Set			◇	◇
Follow the knife stands						
Φ20-Φ80	1	Set	◇	◇	◇	◇
Top						
5 S25-2	1	Set	◆	◆	◆	◆
Centre sleeve						
6/5 S25-10	1	Set				
0011230L	1	Set	◆	◆	◆	◆
Adjustable sizing block						
-	1	Set	◇	◇	◇	◇
Live center						
-	1	Set	◇	◇	◇	◇

注：◆ Standard configuration ◇ Optional configuration: It means that there is no such configuration, if you need special configuration, please contact us.

■ Foundation drawing

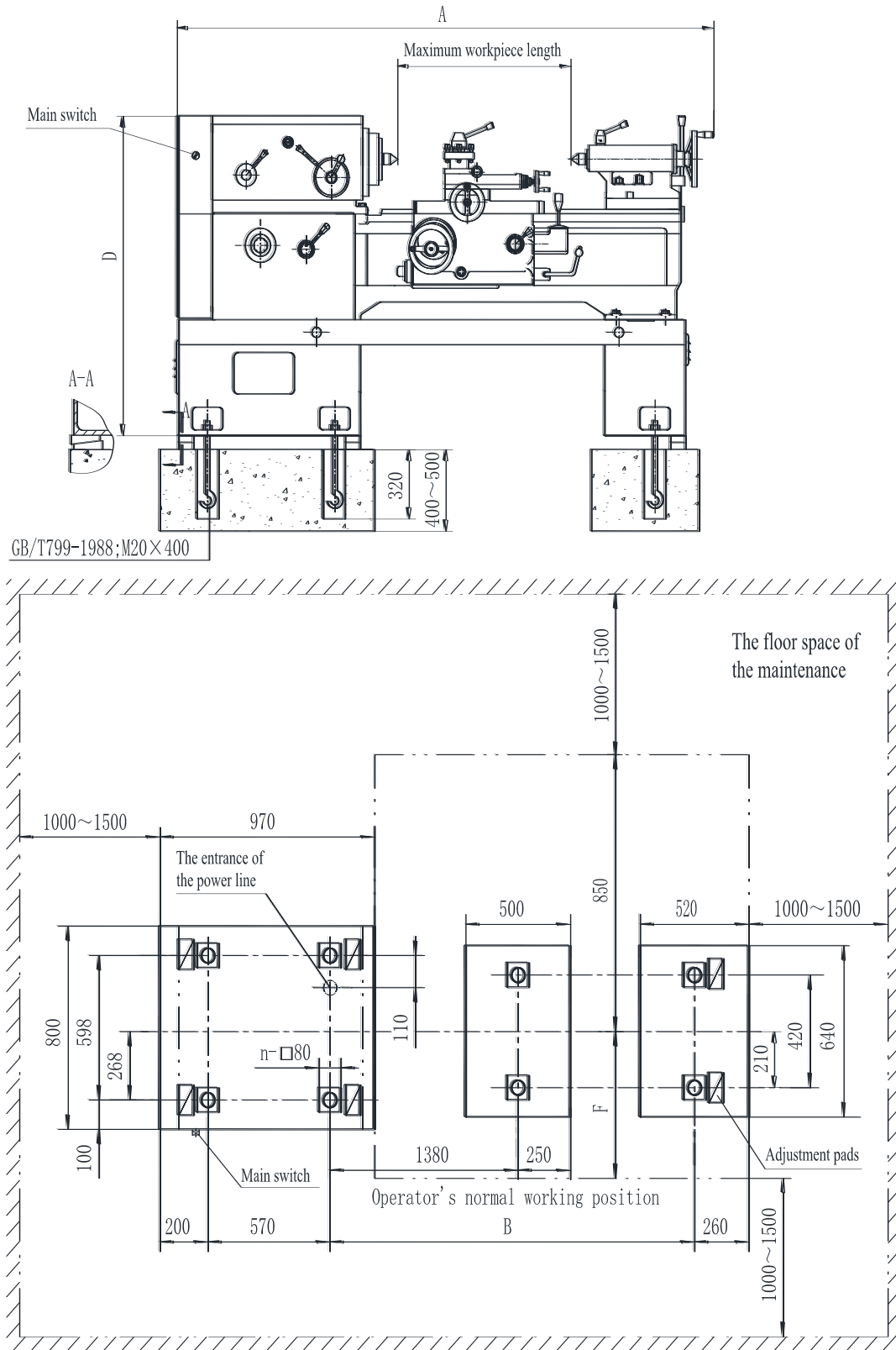


Figure1 Foundation drawing

Table1 The size comparison table of CA-A series

Maximum workpiece length	A	B	Maximum swing diameter	D	F
750	2418	1370	400	1267	600
1000	2668	1620	500	1312	640
1500	3168	2120			
2000	3668	2620			

Note: When the maximum workpiece length is 2000, there is a middle bed leg foundation.

Table2 The size comparison table of CA-B/A series

Maximum workpiece length	A	B	Maximum swing diameter	D	F
1000	2668	1620	400	1270	600
1500	3168	2120	500	1315	640
2000	3668	2620			



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