

Product Brochure For L254D

## DASHIN CHAMPION 1550 - Centre Lathe

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

**Ex GST**                      **Inc GST**  
**\$29,950.00**      **\$32,945.00**



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

The Dashin Champion 1550 Industrial quality centre lathe is manufactured in Taiwan to a precision engineering high tolerance & superior excellence to cope with the everyday turning job or task and is widely found in many engineering workshops around Australia. This versatile model has a very popular & distinctive user-friendly geometric progression gear speed selector that has been bases of the well-known machine made in the UK.

This lathe package is complete with the most desirable features required to turn out quality precise parts we all require from a metal turning lathe.

### 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
- 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

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- 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

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mod.	c	d.p.	w	mm	ins
3	HT5X	44	HB4R	84	LCT1 8015
4	HS1X	40	HB3R	85	LCT14 8015
5	HS3X	36	HB2R	86	LCTB 8015
6	HS6X	32	HB1R	88	LCS1 8015
7	HS8X	30	HA35	10	LCS4 8015
8	HS1X	28	HB5C	12	LCS4 8015
9	HR2X	26	HB7S	15	LCS1 8015
10	HS12	24	HB6S	20	LCS1 8015
1.25	HS32	22	HB4S	25	LCS4 8015
1.5	HS62	20	HB3S	30	LCS4 8015
1.75	HS82	19	HC9S	35	HCS2 814
2	HR12	18	HB2S	40	HCS4 814
2.25	HR22	18	HB1S	40	HCS2 814
2.5	HR32	15	HA3T	75	HCR3 830
2.75	HR42	14	HBRT	80	HCR3 830
3	HR62	13	HR7T	1	
3.25	HR72	12	HR6T	1	
3.5	HR82	11	HB4T	1	
4	HR12	10	HR3T	1	
4.5	HR22	9	HR2T	1	
5	HR32	8	HR1T	1	

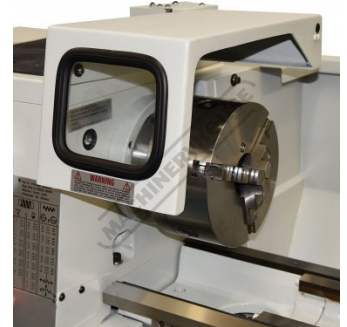
Charts



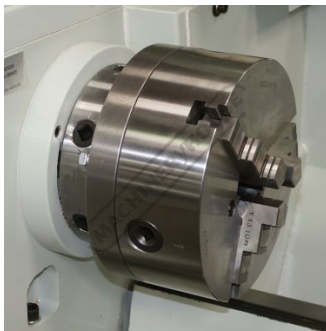
Feed Levers

GEAR	PITCH	SCALE	
13T	1 1.5 2 3 4 5 6 7 8 9 10 11 12 13	1	
14T	0.2 0.25 0.3 0.4 0.5 1 1.25 1.5 2 2.5 3 4 5 6 7 8 9 10 11 12 13 14 15 16 18 20 22 24 25 28 30 32 36 40 45 48 50 55 60 65 70 75 80 85 90 95 100	1 1.25 1.5 2 2.5 3 3.5 4 4.5 5 5.5 6 6.5 7 7.5 8 8.5 9 9.5 10 10.5 11 11.5 12 12.5 13 13.5 14 14.5 15 15.5 16 16.5 17 17.5 18 18.5 19 19.5 20 20.5 21 21.5 22 22.5 23 23.5 24 24.5 25 25.5 26 26.5 27 27.5 28 28.5 29 29.5 30 30.5 31 31.5 32 32.5 33 33.5 34 34.5 35 35.5 36 36.5 37 37.5 38 38.5 39 39.5 40 40.5 41 41.5 42 42.5 43 43.5 44 44.5 45 45.5 46 46.5 47 47.5 48 48.5 49 49.5 50 50.5 51 51.5 52 52.5 53 53.5 54 54.5 55 55.5 56 56.5 57 57.5 58 58.5 59 59.5 60 60.5 61 61.5 62 62.5 63 63.5 64 64.5 65 65.5 66 66.5 67 67.5 68 68.5 69 69.5 70 70.5 71 71.5 72 72.5 73 73.5 74 74.5 75 75.5 76 76.5 77 77.5 78 78.5 79 79.5 80 80.5 81 81.5 82 82.5 83 83.5 84 84.5 85 85.5 86 86.5 87 87.5 88 88.5 89 89.5 90 90.5 91 91.5 92 92.5 93 93.5 94 94.5 95 95.5 96 96.5 97 97.5 98 98.5 99 99.5 100	1 1.25 1.5 2 2.5 3 3.5 4 4.5 5 5.5 6 6.5 7 7.5 8 8.5 9 9.5 10 10.5 11 11.5 12 12.5 13 13.5 14 14.5 15 15.5 16 16.5 17 17.5 18 18.5 19 19.5 20 20.5 21 21.5 22 22.5 23 23.5 24 24.5 25 25.5 26 26.5 27 27.5 28 28.5 29 29.5 30 30.5 31 31.5 32 32.5 33 33.5 34 34.5 35 35.5 36 36.5 37 37.5 38 38.5 39 39.5 40 40.5 41 41.5 42 42.5 43 43.5 44 44.5 45 45.5 46 46.5 47 47.5 48 48.5 49 49.5 50 50.5 51 51.5 52 52.5 53 53.5 54 54.5 55 55.5 56 56.5 57 57.5 58 58.5 59 59.5 60 60.5 61 61.5 62 62.5 63 63.5 64 64.5 65 65.5 66 66.5 67 67.5 68 68.5 69 69.5 70 70.5 71 71.5 72 72.5 73 73.5 74 74.5 75 75.5 76 76.5 77 77.5 78 78.5 79 79.5 80 80.5 81 81.5 82 82.5 83 83.5 84 84.5 85 85.5 86 86.5 87 87.5 88 88.5 89 89.5 90 90.5 91 91.5 92 92.5 93 93.5 94 94.5 95 95.5 96 96.5 97 97.5 98 98.5 99 99.5 100
18T	1 1.25 1.5 2 2.5 3 3.5 4 4.5 5 5.5 6 6.5 7 7.5 8 8.5 9 9.5 10 10.5 11 11.5 12 12.5 13 13.5 14 14.5 15 15.5 16 16.5 17 17.5 18 18.5 19 19.5 20 20.5 21 21.5 22 22.5 23 23.5 24 24.5 25 25.5 26 26.5 27 27.5 28 28.5 29 29.5 30 30.5 31 31.5 32 32.5 33 33.5 34 34.5 35 35.5 36 36.5 37 37.5 38 38.5 39 39.5 40 40.5 41 41.5 42 42.5 43 43.5 44 44.5 45 45.5 46 46.5 47 47.5 48 48.5 49 49.5 50 50.5 51 51.5 52 52.5 53 53.5 54 54.5 55 55.5 56 56.5 57 57.5 58 58.5 59 59.5 60 60.5 61 61.5 62 62.5 63 63.5 64 64.5 65 65.5 66 66.5 67 67.5 68 68.5 69 69.5 70 70.5 71 71.5 72 72.5 73 73.5 74 74.5 75 75.5 76 76.5 77 77.5 78 78.5 79 79.5 80 80.5 81 81.5 82 82.5 83 83.5 84 84.5 85 85.5 86 86.5 87 87.5 88 88.5 89 89.5 90 90.5 91 91.5 92 92.5 93 93.5 94 94.5 95 95.5 96 96.5 97 97.5 98 98.5 99 99.5 100	1 1.25 1.5 2 2.5 3 3.5 4 4.5 5 5.5 6 6.5 7 7.5 8 8.5 9 9.5 10 10.5 11 11.5 12 12.5 13 13.5 14 14.5 15 15.5 16 16.5 17 17.5 18 18.5 19 19.5 20 20.5 21 21.5 22 22.5 23 23.5 24 24.5 25 25.5 26 26.5 27 27.5 28 28.5 29 29.5 30 30.5 31 31.5 32 32.5 33 33.5 34 34.5 35 35.5 36 36.5 37 37.5 38 38.5 39 39.5 40 40.5 41 41.5 42 42.5 43 43.5 44 44.5 45 45.5 46 46.5 47 47.5 48 48.5 49 49.5 50 50.5 51 51.5 52 52.5 53 53.5 54 54.5 55 55.5 56 56.5 57 57.5 58 58.5 59 59.5 60 60.5 61 61.5 62 62.5 63 63.5 64 64.5 65 65.5 66 66.5 67 67.5 68 68.5 69 69.5 70 70.5 71 71.5 72 72.5 73 73.5 74 74.5 75 75.5 76 76.5 77 77.5 78 78.5 79 79.5 80 80.5 81 81.5 82 82.5 83 83.5 84 84.5 85 85.5 86 86.5 87 87.5 88 88.5 89 89.5 90 90.5 91 91.5 92 92.5 93 93.5 94 94.5 95 95.5 96 96.5 97 97.5 98 98.5 99 99.5 100	
20T	1 1.25 1.5 2 2.5 3 3.5 4 4.5 5 5.5 6 6.5 7 7.5 8 8.5 9 9.5 10 10.5 11 11.5 12 12.5 13 13.5 14 14.5 15 15.5 16 16.5 17 17.5 18 18.5 19 19.5 20 20.5 21 21.5 22 22.5 23 23.5 24 24.5 25 25.5 26 26.5 27 27.5 28 28.5 29 29.5 30 30.5 31 31.5 32 32.5 33 33.5 34 34.5 35 35.5 36 36.5 37 37.5 38 38.5 39 39.5 40 40.5 41 41.5 42 42.5 43 43.5 44 44.5 45 45.5 46 46.5 47 47.5 48 48.5 49 49.5 50 50.5 51 51.5 52 52.5 53 53.5 54 54.5 55 55.5 56 56.5 57 57.5 58 58.5 59 59.5 60 60.5 61 61.5 62 62.5 63 63.5 64 64.5 65 65.5 66 66.5 67 67.5 68 68.5 69 69.5 70 70.5 71 71.5 72 72.5 73 73.5 74 74.5 75 75.5 76 76.5 77 77.5 78 78.5 79 79.5 80 80.5 81 81.5 82 82.5 83 83.5 84 84.5 85 85.5 86 86.5 87 87.5 88 88.5 89 89.5 90 90.5 91 91.5 92 92.5 93 93.5 94 94.5 95 95.5 96 96.5 97 97.5 98 98.5 99 99.5 100	1 1.25 1.5 2 2.5 3 3.5 4 4.5 5 5.5 6 6.5 7 7.5 8 8.5 9 9.5 10 10.5 11 11.5 12 12.5 13 13.5 14 14.5 15 15.5 16 16.5 17 17.5 18 18.5 19 19.5 20 20.5 21 21.5 22 22.5 23 23.5 24 24.5 25 25.5 26 26.5 27 27.5 28 28.5 29 29.5 30 30.5 31 31.5 32 32.5 33 33.5 34 34.5 35 35.5 36 36.5 37 37.5 38 38.5 39 39.5 40 40.5 41 41.5 42 42.5 43 43.5 44 44.5 45 45.5 46 46.5 47 47.5 48 48.5 49 49.5 50 50.5 51 51.5 52 52.5 53 53.5 54 54.5 55 55.5 56 56.5 57 57.5 58 58.5 59 59.5 60 60.5 61 61.5 62 62.5 63 63.5 64 64.5 65 65.5 66 66.5 67 67.5 68 68.5 69 69.5 70 70.5 71 71.5 72 72.5 73 73.5 74 74.5 75 75.5 76 76.5 77 77.5 78 78.5 79 79.5 80 80.5 81 81.5 82 82.5 83 83.5 84 84.5 85 85.5 86 86.5 87 87.5 88 88.5 89 89.5 90 90.5 91 91.5 92 92.5 93 93.5 94 94.5 95 95.5 96 96.5 97 97.5 98 98.5 99 99.5 100	
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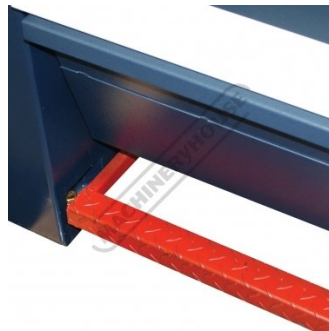
Indicator Table



Safety Chuck Guard



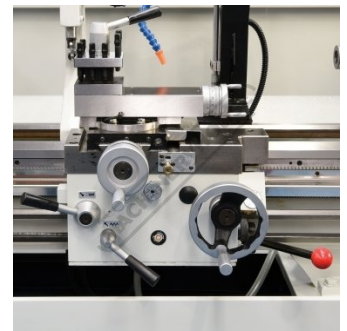
3 Jaw Chuck



Foot Brake



Slide Out Chip Tray



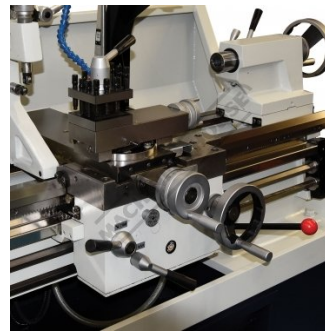
Saddle Controls



Saddle Right View



Coolant Nozzle and Work Light



Saddle Left View



Leadscrew Covers



Spindle Engagement Lever



Thread Chasing Dial



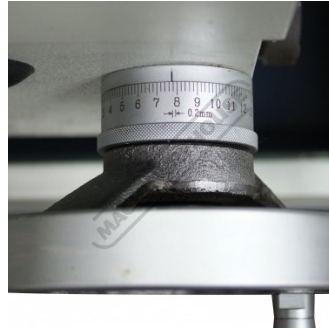
One Shot Lubrication



Feed Engagement Dials



Crossfeed Dial-Dual Calibrated



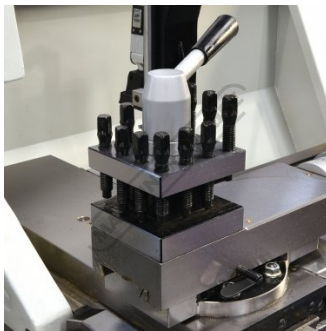
Saddle Hand Wheel



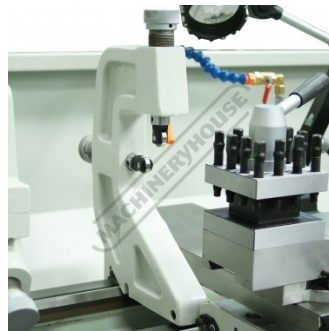
Compound Slide Dial - Dual Calibrated



Swivel Compound Slide



Toolpost



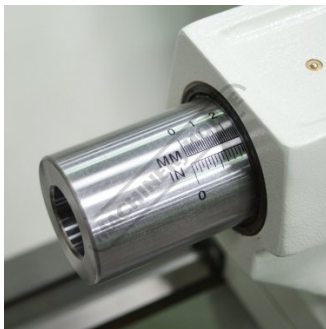
2 Point Travelling Steady



3 Point Fixed Steady



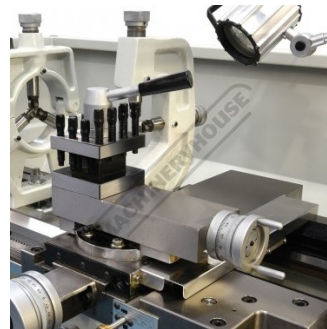
Tailstock



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 Precision HSS Drill Set - 25 Piece



**D1282**  
Imperial Precision HSS Drill Set - 29 Piece



**D126**  
Metric 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



Product Brochure For L254D

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



S091

Soluble Metal Cutting Fluid - 20 Litre



G662

Lathe Leadscrew Cover Kit



A358

Sky Hook Lifting Device



A358A

Chuck Hook



L300

Magnetic Swarf Remover



M991

Magnetic Floor Sweeper



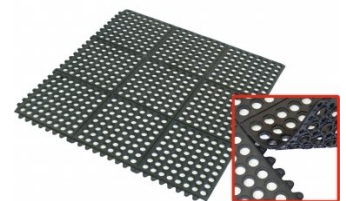
M800

Rubber Mat - Anti-Fatigue



M805

Rubber Mat - Anti-Fatigue



Product Brochure For L254D

O000

SpillFix Universal Organic Absorbent



O000A

Natural Zeolite Absorbent



O043

Rust & Corrosion Preventive - Penetrant & Lubrication



O042

General Purpose Lubricant & Corrosion Inhibitor



O040

Rust & Corrosion Preventive - Penetrant & Lubrication



O044

Rust & Corrosion Preventive - Penetrant & Lubrication

