

Product Brochure For L682

AL-336 - Centre Lathe

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

Ex GST **Inc GST**
\$5,590.00 **\$6,149.00**



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.

Features

- Gear drive headstock for quick change of spindle speeds
- Precision 'V'-beds are hardened and ground, incorporating a rigid webbed casting

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- 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	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
MI	1.6	1.8	2	2.25	2.4	2.5
MI	3.2	3.6	4	4.5	4.8	5
THREAD PER INCH						
	A2	A3	G3	A4	C3	C3
Z	24	24	38	24	22	24
MI	4	4 1/2	9 1/2	5	5 1/2	6
MI	8	9	19	10	11	12
Z	46	46	38	46	44	46
MI	16	18	19	20	22	24
MI	32	36	38	40	44	46

Metric Thread Chart

FEED CHARTS										
Position	E2	E3	A2	E4	E1	C3	C4	A5	D5	B5
SI	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001
SI	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
SI	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003
SI	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
SI	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
SI	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
SI	0.007	0.007	0.007	0.007	0.007	0.007	0.007	0.007	0.007	0.007
SI	0.008	0.008	0.008	0.008	0.008	0.008	0.008	0.008	0.008	0.008
SI	0.009	0.009	0.009	0.009	0.009	0.009	0.009	0.009	0.009	0.009
SI	0.010	0.010	0.010	0.010	0.010	0.010	0.010	0.010	0.010	0.010
SI	0.012	0.012	0.012	0.012	0.012	0.012	0.012	0.012	0.012	0.012
SI	0.015	0.015	0.015	0.015	0.015	0.015	0.015	0.015	0.015	0.015
SI	0.020	0.020	0.020	0.020	0.020	0.020	0.020	0.020	0.020	0.020
SI	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025
SI	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030
SI	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040
SI	0.050	0.050	0.050	0.050	0.050	0.050	0.050	0.050	0.050	0.050
SI	0.060	0.060	0.060	0.060	0.060	0.060	0.060	0.060	0.060	0.060
SI	0.075	0.075	0.075	0.075	0.075	0.075	0.075	0.075	0.075	0.075
SI	0.100	0.100	0.100	0.100	0.100	0.100	0.100	0.100	0.100	0.100
SI	0.125	0.125	0.125	0.125	0.125	0.125	0.125	0.125	0.125	0.125
SI	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150
SI	0.200	0.200	0.200	0.200	0.200	0.200	0.200	0.200	0.200	0.200
SI	0.250	0.250	0.250	0.250	0.250	0.250	0.250	0.250	0.250	0.250
SI	0.300	0.300	0.300	0.300	0.300	0.300	0.300	0.300	0.300	0.300
SI	0.400	0.400	0.400	0.400	0.400	0.400	0.400	0.400	0.400	0.400
SI	0.500	0.500	0.500	0.500	0.500	0.500	0.500	0.500	0.500	0.500
SI	0.600	0.600	0.600	0.600	0.600	0.600	0.600	0.600	0.600	0.600
SI	0.800	0.800	0.800	0.800	0.800	0.800	0.800	0.800	0.800	0.800
SI	1.000	1.000	1.000	1.000	1.000	1.000	1.000	1.000	1.000	1.000
SI	1.250	1.250	1.250	1.250	1.250	1.250	1.250	1.250	1.250	1.250
SI	1.500	1.500	1.500	1.500	1.500	1.500	1.500	1.500	1.500	1.500
SI	2.000	2.000	2.000	2.000	2.000	2.000	2.000	2.000	2.000	2.000
SI	2.500	2.500	2.500	2.500	2.500	2.500	2.500	2.500	2.500	2.500
SI	3.000	3.000	3.000	3.000	3.000	3.000	3.000	3.000	3.000	3.000
SI	4.000	4.000	4.000	4.000	4.000	4.000	4.000	4.000	4.000	4.000
SI	5.000	5.000	5.000	5.000	5.000	5.000	5.000	5.000	5.000	5.000
SI	6.000	6.000	6.000	6.000	6.000	6.000	6.000	6.000	6.000	6.000
SI	8.000	8.000	8.000	8.000	8.000	8.000	8.000	8.000	8.000	8.000
SI	10.000	10.000	10.000	10.000	10.000	10.000	10.000	10.000	10.000	10.000
SI	12.500	12.500	12.500	12.500	12.500	12.500	12.500	12.500	12.500	12.500
SI	15.000	15.000	15.000	15.000	15.000	15.000	15.000	15.000	15.000	15.000
SI	20.000	20.000	20.000	20.000	20.000	20.000	20.000	20.000	20.000	20.000
SI	25.000	25.000	25.000	25.000	25.000	25.000	25.000	25.000	25.000	25.000
SI	30.000	30.000	30.000	30.000	30.000	30.000	30.000	30.000	30.000	30.000
SI	40.000	40.000	40.000	40.000	40.000	40.000	40.000	40.000	40.000	40.000
SI	50.000	50.000	50.000	50.000	50.000	50.000	50.000	50.000	50.000	50.000
SI	60.000	60.000	60.000	60.000	60.000	60.000	60.000	60.000	60.000	60.000
SI	80.000	80.000	80.000	80.000	80.000	80.000	80.000	80.000	80.000	80.000
SI	100.000	100.000	100.000	100.000	100.000	100.000	100.000	100.000	100.000	100.000
SI	125.000	125.000	125.000	125.000	125.000	125.000	125.000	125.000	125.000	125.000
SI	150.000	150.000	150.000	150.000	150.000	150.000	150.000	150.000	150.000	150.000
SI	200.000	200.000	200.000	200.000	200.000	200.000	200.000	200.000	200.000	200.000
SI	250.000	250.000	250.000	250.000	250.000	250.000	250.000	250.000	250.000	250.000
SI	300.000	300.000	300.000	300.000	300.000	300.000	300.000	300.000	300.000	300.000
SI	400.000	400.000	400.000	400.000	400.000	400.000	400.000	400.000	400.000	400.000
SI	500.000	500.000	500.000	500.000	500.000	500.000	500.000	500.000	500.000	500.000
SI	600.000	600.000	600.000	600.000	600.000	600.000	600.000	600.000	600.000	600.000
SI	800.000	800.000	800.000	800.000	800.000	800.000	800.000	800.000	800.000	800.000
SI	1000.000	1000.000	1000.000	1000.000	1000.000	1000.000	1000.000	1000.000	1000.000	1000.000

Feed Charts

INDICATOR TABLE					
T	T-P-I	SCALE	T	T-P-I	SCALE
0	4	8	14	24	40
	16	24	32	40	48
	48	56			
T	T-P-I	SCALE	T	T-P-I	SCALE
16	4 1/2	8	14	24	40
	5	4-8	15	24	40
	5 1/2	8	18	24	40
	6	4-8	19	24	40
	6 1/2	8	20	24	40
	7	4-8	22	24	40
	7 1/2	8	26	24	40
	8	4-8	28	24	40
	9 1/2	8	30	24	40
	10	2-4-6-8	36	24	40
	11	4-8	38	24	40
	12	1-8	44	24	40
	13	4-8	52	24	40

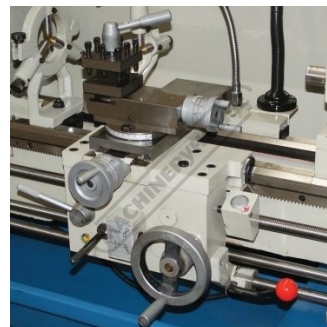
Thread Chase-Indicator Table

SPINDLE SPEED			
		1	2
I	A	360	1810
I	B	100	500
I	C	280	1400
II	A	235	1200
II	B	65	330
II	C	180	910

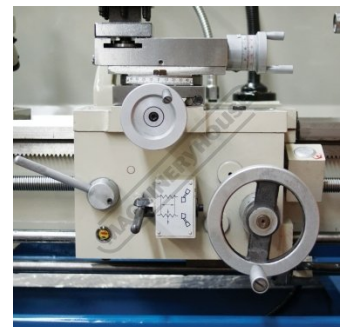
18 Spindle speeds 65-1810rpm



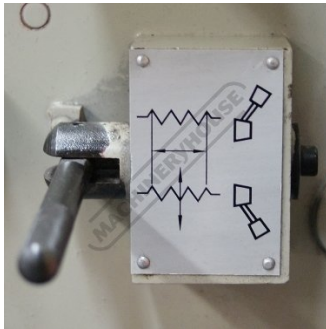
Chuck Guard With Safety Micro Switch



Saddle Right View



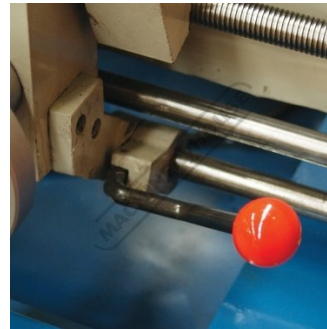
Saddle Control



Feed Engagement Lever



Thread Chasing Dial



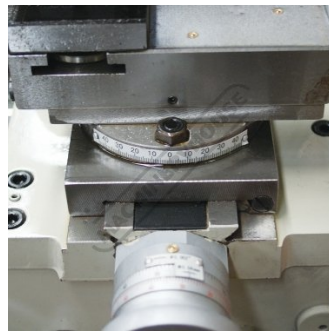
Forward Reverse Spindle Lever



Toolpost



Compound Slide



Swivel Compound Slide



Compound Slide Hand Wheel



Crossslide Hand Wheel



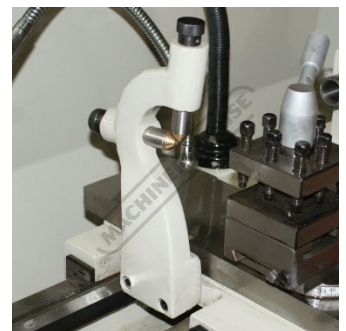
Saddle Hand Wheel



Lamp and Coolant Hose



3 Point Fixed Steady



2 Point Travelling Steady



Tailstock



Tailstock Quill



Tailstock Hand Wheel



Induction Hardened Bedways

Recommended Accessories

M002
 Steel Machine Mount & Rubber
 Insert



L682D
 Centre Lathe



D695
 3-Axis Optimum Digital Readout
 Counter - 1µm



D694
 1500mm Optimum Magnetic
 Digital Readout Scale



D5211
 220mm Sino Digital Readout
 Scale



D5229
 920mm Sino Digital Readout
 Scale



D5249
 Scale - Backing Plate & Cover



D5204
 Sino Digital Readout Lathe
 Mounting Bracket Kit



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P235
Coolant Pump & Tank



L292
Quick Change Toolpost



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



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L076
 Knurling Tool Holder Kit



C052
 3MT Live Centre



C045
 3MT Pipe Centre - 70° Cone



C290
 Heavy Duty Drill Chuck - Keyed Type



D443A
 3MT x JT3 Drill Chuck Arbor



D1272
 Metric Precision HSS Drill Set - 25 Piece



D1282
 Imperial Precision HSS Drill Set - 29 Piece



D126
 Metric 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



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S075
Cutting Tool Lubricant Paste - 200g



S074
Cutting Tool Lubricant Paste - 500g



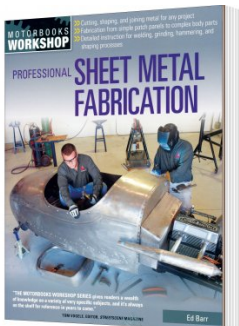
G660
Lathe Leadscrew Cover Kit



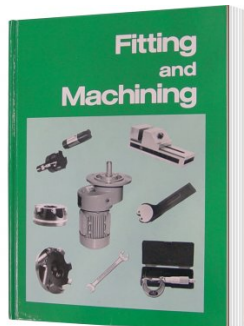
G659
Lathe Leadscrew Cover Kit - Concertina



L3455
Professional Sheet Metal Fabrication Book



L341
Fitting and Machining Technical Book



L300
Magnetic Swarf Remover



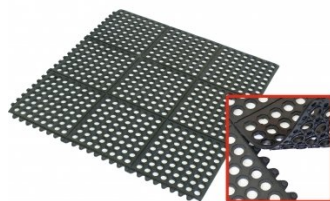
M9991
Magnetic Floor Sweeper



M800
Rubber Mat - Anti-Fatigue



M805
Rubber Mat - Anti-Fatigue



O000
SpillFix Universal Organic Absorbent



O000A
Natural Zeolite Absorbent



Product Brochure For L682

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www.machineryhouse.com.au

O043

Rust & Corrosion Preventive -
Penetrant & Lubrication



O042

General Purpose Lubricant &
Corrosion Inhibitor



O040

Rust & Corrosion Preventive -
Penetrant & Lubrication



O044

Rust & Corrosion Preventive -
Penetrant & Lubrication

