



ISO 9001-2000
No.951032010

Most Economical, High Precision, High Speed

Second Operation Lathe Models



SOL 25/100 & SOL 32/110

Speed, Precision, Economy, Versatility

Specifications

Arrow second operation lathe is ideal for manufacturing components of shop and complex turned parts both from bar, blank & forgings. Components can be easily held by using collect as well as chuck.

Special Features

Headstock & Spindle Assembly: A robust cast iron Headstock mounted on the base frame of conum sheet. Precious bearings are mounted on the spindle. Spindles are duly case hardened, thread grounded to maintain spindle runout withing 0.005m.

Main Drive: Spindle policy is be in connected through V.Belts through a two speed motor which is fitted inside the cabinet, 16 speeds can be achieved by changing different speeds to achieve optimum cutting speeds required for various components.

Cross slide and vertical slide: The lever operated slide is mounted on the front side. It is designed to take heavy depth of cuts, including plunge foring.

The vertical slide is lever operated and it is mounted on the headstock, it can be used for parting, grooving chanfering.

Bar Feed

Gravity weight operated Bar feed can be supplied optionally for bar length upto 5 metres.

Coolant System

Compact Coolant tanks with motor centre fitted inside the cabinet.

Automatic Threading

This system can be used for threading by using tap or dia. The length of the tap and die can be adjusted by the stopper. Spindle is reverted automatically when this stopper touches the limit switch. Both L.H. and R.H. threading can be done.

Long turning attachments

A special longitudinal turning attachment can be fixed on the cross slide, this can be used for turning straight as well as taper turning.

Standard Accessories

- Six position turreted with indexing mechanism.
- Single vertical slide with tool holder.
- Cross slide attachment with single open tool holder.
- Quick collet chucking mechanism without collet.
- Automatic threading system.
- Conversion kit for 5 collet for SOL32/110.

Optional Accessories

- Long turning attachment
- Colon system
- Chuck with back plate
- Barfeed attachment
- Pneumatic clamping
- Cluth brake mechanism

The company reserved the right to change specifications without prior notice

Specific Capacity & Other Specifications

Model	Second Operation Lathe		
		SOL25/100	SOL32/110
Round meter	upto mm	25	32
Hexagonal width A/F	upto mm	22	28
Square width A/F	upto mm	19	22
Distance collet to turret lacc	upto mm	240	240
Turning length with long turning attacmnt	upto	70	70
Six position torrent		Available as Std. Equipment	Std.
Min. Distance from Turrent to Spindle	mm	75	75
Max. Distance from Turrent to Spindle	mm	225	225
Stroke	mm	70	70
Diameter of Tool Bore	mm	19.05 H7	9.05
Threading Capacity external/internal		MS to M1 for ferrous and MS to M1 for non-ferrous	
Spindle Speeds	mm	125 - 3050	125 - 3050
Bar feed	mtrs	3	3
Slide			
Cross Slide Travel	mm	60	60
Vertical Slide Travel	mm	25	25
Total Power Consumption			
Main Spindle Motor Power	kw	0.55/2.2	0.55/2.2
Main Spindle Motor RPM	rpm	750/3000	750/300
Coolant Pump Motor Power	kw	0.08	0.08
Coolant Pump Motor RPM	rpm	3000	3000
Weight of machine	Net - kgs	480	450
	Gross - kgs	485	485
Floor space without bar feed	mm	0.6 - 1.2	
Volume of see worthy backing	cu.m.	2	



ARROW MACHINE TOOLS

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