

## Product Brochure For L191D

### Centre Lathe - CL-38A

Ø410 x 1000mm Turning Capacity - Ø52mm Spindle Bore  
Includes Digital Readout System & Quick Change Toolpost



**On Sale**

Ex GST	Inc GST
<b>\$15,190.00</b>	<b>\$17,468.50</b>
<b>\$13,900.00</b>	<b>\$15,985.00</b>

ORDER CODE:	L191D
MODEL:	CL-38A
Swing Over Bed (mm):	410
Distance Between Centres (mm):	1000
Spindle Bore (mm):	52
Swing In Gap (mm):	580
Swing Over Cross-slide (mm):	255
Digital Readout System Fitted:	Yes
Quick Change Toolpost Fitted:	Yes
Leadscrew Covers Fitted:	Yes
Taper Turning Attachment:	~
Coolant System:	Yes
Tool Height To Suit (mm):	20
Centre Height (mm):	205
Spindle Nose Size or Type:	D1-6 Camlock
Bed Width (mm):	250
Headstock Spindle Taper (MT):	6
Tailstock Taper (MT):	4
Cross Slide Travel (mm):	210
Compound Slide Travel (mm):	140
Leadscrew Type:	Metric
Metric Cross Feed (X-Axis) (mm/rev):	0.025 - 0.85
Imperial Cross Feed (X-Axis) (inch/rev):	~
Metric Longitudinal Feed (Z-Axis) (mm/rev):	0.05 - 1.7
Imperial Longitudinal Feed (Z-Axis) (inch/rev):	~
Metric Thread Steps & Pitch (No. / mm):	39 (0.2 - 14)
Imperial Thread Steps & TPI (No. / TPI):	45 (2 - 72)
3 Jaw Chuck Diameter (mm):	200
4 Jaw Chuck Diameter (mm):	250
Spindle Steps / Speeds (No. / rpm):	16 (45 - 1800)
Motor Power (kW / hp):	3.3 / 4.5
Voltage / Amperage (V / amp):	415
Nett Weight (kg):	1550

#### Features

- 2 axis digital readout system
- Quick change toolpost
- Triple bearings supporting headstock spindle
- Adjustable taper roller bearings providing spindle accuracy
- Precision 'V'-beds & headstock gears are all hardened & ground
- One piece cast iron base increases rigidity
- 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
- 250mm wide induction hardened heavy duty cast iron bed
- Removable gap bed allowing work piece to swing up to 580mm
- Chuck guard fitted with safety micro switch
- Powered longitudinal and cross feeds
- Adjustable 6 position length-stop on bed-way for accurate repetitive operation
- Dual calibrated dials incorporating metric & imperial graduations

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- Coolant system with flexible hose enabling operator to manipulate flow direction
- Oil sight glass for head stock and gearbox
- Low voltage halogen work light
- Lubrication pump on saddle oiling slides
- D1-6 camlock spindle for quick chuck removal
- Large 52mm spindle bore
- 2 speed, 4.5hp, 415V motor

### Includes

- 2 Axis digital readout system
- Quick change toolpost
- Concertina leadscrew covers
- 200mm 3-jaw chuck with reverse jaws
- 250mm 4-jaw chuck
- Face plate
- Fixed steady with roller bearings
- Travelling steady with roller bearings
- Dead centres
- Thread chasing dial
- Foot brake
- Coolant system
- Work light
- Rear splash guard
- Spindle reducing bush

### Specific Features



Left View



2 Axis SINO Digital Readout



Safety Chuck Guard



V Bed



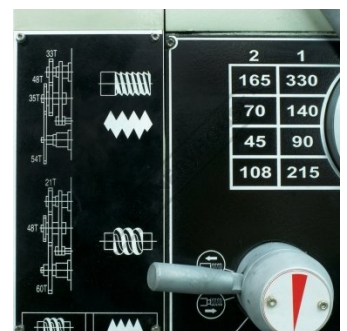
Head Stock Control



Speed Selectors



Feed Gearbox



Back Gear Set Up Chart

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mod	dp	C		C (ins)	
3	HCT12	050	LCT1W	002	
4	HCT12	055	LCT2W	0022	
5	HCT12	065	LCT3W	003	
6	HCT12	085	LCT4W	0033	
7	HCT12	105	LCT5W	004	
8	HCT12	130	LCT6W	005	
9	HCT12	155	LCT7W	006	
10	HCT12	180	LCT8W	007	
11	HCT12	210	LCT9W	008	
12	HCT12	240	LCT10W	009	
13	HCT12	280	LCT11W	011	
14	HCT12	320	LCT12W	014	
15	HCT12	360	LCT13W	017	
16	HCT12	400	LCT14W	021	
17	HCT12	450	LCT15W	026	
18	HCT12	500	LCT16W	032	
19	HCT12	560	LCT17W	040	
20	HCT12	630	LCT18W	050	
21	HCT12	710	LCT19W	063	
22	HCT12	800	LCT20W	080	
23	HCT12	900	LCT21W	100	
24	HCT12	1000	LCT22W	125	
25	HCT12	1100	LCT23W	150	
26	HCT12	1200	LCT24W	180	
27	HCT12	1300	LCT25W	210	
28	HCT12	1400	LCT26W	250	
29	HCT12	1500	LCT27W	300	
30	HCT12	1600	LCT28W	360	
31	HCT12	1700	LCT29W	420	
32	HCT12	1800	LCT30W	500	
33	HCT12	1900	LCT31W	600	

Module and Diametral Pitch and Feed Chart

mm		
0.2	LCT1Z	1.2
0.25	LCT2Z	1.25
0.25	LCT3Z	1.3
0.3	LCT6Z	1.4
0.38	LCT8Z	1.5
0.4	LCS1Z	1.75
0.45	LCS2Z	2.0
0.5	LCS3Z	2.25
0.6	LCS6Z	2.5
0.7	LCS8Z	2.75
0.75	LCT8Y	3.0
0.9	LCT17Z	3.25
1.0	LCT3Z	3.5
1.1	LCT4Z	4.0
1.2	LCR6Z	5.0
1.25	LCS3Y	5.5
1.3	LCR7Z	6.0
1.4	LCR8Z	6.5
1.5	LCS2Y	7.0
1.75	LCS8Y	8.0
2.0	LCR1Y	9.0
2.25	LCR2Y	10.0
2.5	LCR3Y	11.0
2.75	LCR4Y	12.0
3.0	LCR6Y	13.0
3.25	LCR7Y	14.0
3.5	LCR8Y	15.0
4.0	HCR3Z	NUTS
4.5	HCS2Y	ENGAGRD

Thread Chart Metric

in		
72	LAR6V	22
60	LAR3V	20
56	LBR6V	19
54	LAR2V	18
48	LBR6V	18
44	LBR4V	15
40	LBR3V	14
36	LAS6V	13 1/2
32	LBR1V	13
30	LAS3V	12
28	LBS6V	11 1/2
27	LAS2V	11
26	LBS7V	10
24	LBS6V	9
23	LBS5V	8
7 1/2	LBS4V	7
7	LCS2V	6
5	LBS2V	5
4 1/2	LBS1V	4 1/2
4	LAT3V	4
3 1/4	LBT8V	3 1/4
3 1/2	LAT2V	3 1/2
3 1/4	LBT7V	3 1/4
3	HBT6V	3
2 1/2	HBT5V	2 1/2
2 3/4	HBT4V	2 3/4
2 1/2	HBT3V	2 1/2
2 1/4	HBT2V	2 1/4
2	HBT1V	2

Inch Thread Chart



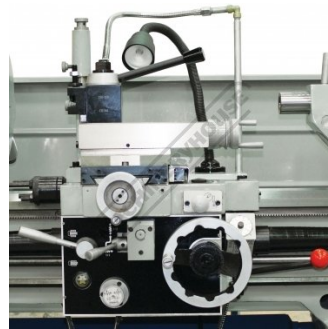
Leadscrew Covers



Saddle



Saddle Left View



Saddle Front View



One Shot Side Way Lubrication



Foot Break



Saddle Stop



Adjustable 4 Position Saddle Stop



Spindle Engagement Handle



Thread Chasing Dial



Feed and Threading Lever



Cross Feed Handle



Saddle Hand Wheel

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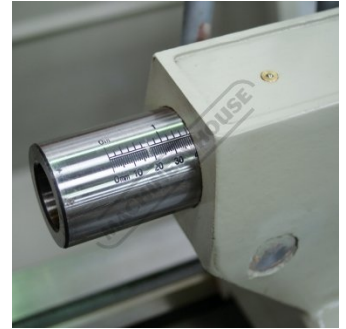
Compound Side Hand Wheel



Quick Change Toolpost Rear View



Tailstock



Tailstock Quill Scale



Tailstock Hand Wheel

**Recommended Accessories**

2JA6051  
TOOL HOLDER FOR QCTP

L046  
Right Hand Turning Tool Holder

L047  
Left Hand Turning Tool Holder

L039  
Right Hand Turning Tool Holder



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**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



**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



**D126**  
Metric 135° Precision HSS Drill Set - 170 Pieces



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**D1272**  
Metric 135° Precision HSS Drill Set - 25 Piece



**D1282**  
Imperial 135° Precision HSS Drill Set - 29 Piece



**D119**  
Metric 2MT HSS Drill Set



**G660**  
Lathe Leadscrew Cover Kit



**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



**S074**  
Cutting Tool Lubricant Paste - 500g



**S091**  
Soluble Metal Cutting Fluid - 20 Litre



**A358**  
Sky Hook Lifting Device



**A358A**  
Chuck Hook



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L300  
Magnetic Swarf Remover



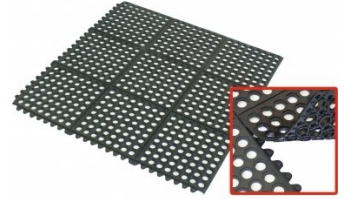
M9991  
Magnetic Floor Sweeper



M800  
Rubber Mat - Anti-Fatigue



M805  
Rubber Mat - Anti-Fatigue



O043  
Rust & Corrosion Preventive



O042  
General Purpose Lubricant & Corrosion Inhibitor



O044  
Rust & Corrosion Preventive

