

## HAFCO AL-336



### Centre Lathe & Tooling Package Deal

Ø300 x 900mm Turning Capacity - Ø38mm Spindle Bore



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AL-336 Lathe



Headstock

METRIC THREAD PITCH LIST							
	B4	C4	C3	A4	E4	A2	E2
MI	0.4	0.45	0.5	0.5	0.7	0.75	
MI	0.8	0.9	1	1.2	1.4	1.5	1.75
MI	1.6	1.8	2	2.25	2.4	2.5	2.8
MI	3.2	3.6	4	4.5	4.8	5	5.6
MI	6	7					

THREAD PER INCH								
	A2	A3	C3	A4	C3	C3	A5	B4
Z	24	24	28	24	22	24	28	24
MI	4	4.5	5	5.5	6	6.5	7	7.5
MI	8	9	10	11	12	13	14	15
Z	48	48	48	44	48	52	48	48
MI	16	18	20	22	24	26	28	30
MI	32	36	38	40	44	48	52	56

Metric Thread Chart

Metric Feed Chart										
Position	E2	E3	A2	E4	E1	C3	C4	A5	D5	B5
SI	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01
SI	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02
SI	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03
SI	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04
SI	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05
SI	0.06	0.06	0.06	0.06	0.06	0.06	0.06	0.06	0.06	0.06
SI	0.07	0.07	0.07	0.07	0.07	0.07	0.07	0.07	0.07	0.07
SI	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08
SI	0.09	0.09	0.09	0.09	0.09	0.09	0.09	0.09	0.09	0.09
SI	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10
SI	0.12	0.12	0.12	0.12	0.12	0.12	0.12	0.12	0.12	0.12
SI	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15
SI	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20
SI	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
SI	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30
SI	0.40	0.40	0.40	0.40	0.40	0.40	0.40	0.40	0.40	0.40
SI	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50
SI	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60
SI	0.80	0.80	0.80	0.80	0.80	0.80	0.80	0.80	0.80	0.80
SI	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
SI	1.25	1.25	1.25	1.25	1.25	1.25	1.25	1.25	1.25	1.25
SI	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50
SI	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00
SI	2.50	2.50	2.50	2.50	2.50	2.50	2.50	2.50	2.50	2.50
SI	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00
SI	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00
SI	5.00	5.00	5.00	5.00	5.00	5.00	5.00	5.00	5.00	5.00
SI	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.00
SI	8.00	8.00	8.00	8.00	8.00	8.00	8.00	8.00	8.00	8.00
SI	10.00	10.00	10.00	10.00	10.00	10.00	10.00	10.00	10.00	10.00
SI	12.50	12.50	12.50	12.50	12.50	12.50	12.50	12.50	12.50	12.50
SI	15.00	15.00	15.00	15.00	15.00	15.00	15.00	15.00	15.00	15.00
SI	20.00	20.00	20.00	20.00	20.00	20.00	20.00	20.00	20.00	20.00
SI	25.00	25.00	25.00	25.00	25.00	25.00	25.00	25.00	25.00	25.00
SI	30.00	30.00	30.00	30.00	30.00	30.00	30.00	30.00	30.00	30.00
SI	40.00	40.00	40.00	40.00	40.00	40.00	40.00	40.00	40.00	40.00
SI	50.00	50.00	50.00	50.00	50.00	50.00	50.00	50.00	50.00	50.00
SI	60.00	60.00	60.00	60.00	60.00	60.00	60.00	60.00	60.00	60.00
SI	80.00	80.00	80.00	80.00	80.00	80.00	80.00	80.00	80.00	80.00
SI	100.00	100.00	100.00	100.00	100.00	100.00	100.00	100.00	100.00	100.00
SI	125.00	125.00	125.00	125.00	125.00	125.00	125.00	125.00	125.00	125.00
SI	150.00	150.00	150.00	150.00	150.00	150.00	150.00	150.00	150.00	150.00
SI	200.00	200.00	200.00	200.00	200.00	200.00	200.00	200.00	200.00	200.00
SI	250.00	250.00	250.00	250.00	250.00	250.00	250.00	250.00	250.00	250.00
SI	300.00	300.00	300.00	300.00	300.00	300.00	300.00	300.00	300.00	300.00
SI	400.00	400.00	400.00	400.00	400.00	400.00	400.00	400.00	400.00	400.00
SI	500.00	500.00	500.00	500.00	500.00	500.00	500.00	500.00	500.00	500.00
SI	600.00	600.00	600.00	600.00	600.00	600.00	600.00	600.00	600.00	600.00
SI	800.00	800.00	800.00	800.00	800.00	800.00	800.00	800.00	800.00	800.00
SI	1000.00	1000.00	1000.00	1000.00	1000.00	1000.00	1000.00	1000.00	1000.00	1000.00

Feed Charts

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

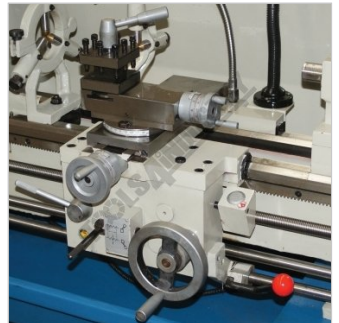
Thread Chase-Indicator Table

SPINDLE SPEED /min			
	1	2	3
I A	360	1810	1095
B	100	500	300
C	280	1400	840
II A	235	1200	700
B	65	330	200
C	180	910	550

18 Spindle speeds 65-1810rpm



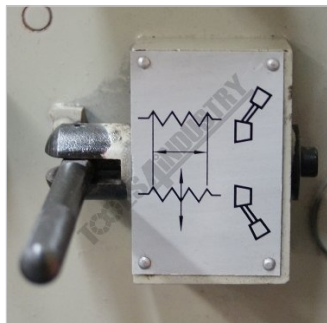
Chuck Guard With Safety Micro Switch



Saddle Right View



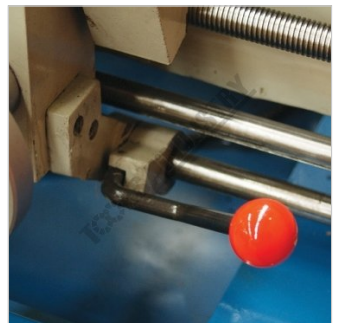
Saddle Control



Feed Engagement Lever



Thread Chasing Dial



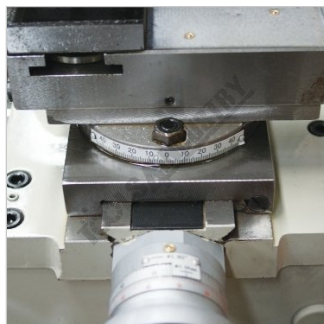
Forward Reverse Spindle Lever



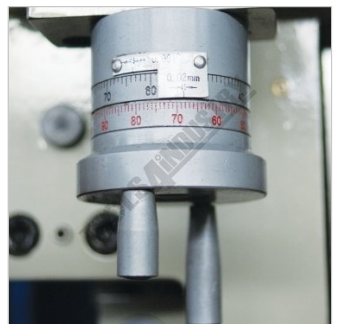
Toolpost



Compound Slide



Swivel Compound Slide



Compound Slide Hand Wheel

**HAFCO Centre Lathe & Tooling Package Deal AL-336**



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



12mm Lathe Toolset



12mm Lathe Threading



12mm Lathe Parting Tool



3MT Live Centre



16mm Drill Chuck



Arbour

## HAFCO Centre Lathe & Tooling Package Deal AL-336

### 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, guarded leadscrew cover, 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
- 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

- Turning tool kit (L450)
- Threading tool kit (L456)
- Parting tool kit (L464)
- Live centre (C052)
- Keyed drill chuck (C290)
- Drill chuck arbour (D44A)
- 3-jaw chuck with reverse jaws
- 4-jaw chuck
- Face plate
- Fixed steady
- Travelling steady

## HAFCO Centre Lathe & Tooling Package Deal AL-336

- 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

### Specifications

<b>ORDER CODE</b>	K008
<b>MODEL</b>	AL-336 Package Deal
<b>Swing Over Bed (mm)</b>	300
<b>Distance Between Centres (mm)</b>	900
<b>Spindle Bore (mm)</b>	38
<b>Swing In Gap (mm)</b>	450
<b>Swing Over Cross-slide (mm)</b>	180
<b>Digital Readout System Fitted</b>	Optional
<b>Quick Change Toolpost Fitted</b>	Optional
<b>Leadscrew Covers Fitted</b>	~
<b>Taper Turning Attachment</b>	~
<b>Coolant System</b>	Yes
<b>Tool Height To Suit (mm)</b>	12
<b>Centre Height (mm)</b>	150
<b>Spindle Nose Size or Type</b>	D1-4 Camlock
<b>Bed Width (mm)</b>	180
<b>Headstock Spindle Taper (MT)</b>	5
<b>Tailstock Taper (MT)</b>	3
<b>Cross Slide Travel (mm)</b>	170
<b>Compound Slide Travel (mm)</b>	75
<b>Leadscrew Type</b>	Imperial
<b>Metric Cross Feed (X-Axis) (mm/rev)</b>	~
<b>Imperial Cross Feed (X-Axis) (inch/rev)</b>	0.009 - 0.236
<b>Metric Longitudinal Feed (Z-Axis) (mm/rev)</b>	~
<b>Imperial Longitudinal Feed (Z-Axis) (inch/rev)</b>	0.04 - 1.22
<b>Metric Thread Steps &amp; Pitch (No. / mm)</b>	32 (0.4 - 7)
<b>Imperial Thread Steps &amp; TPI (No. / TPI)</b>	36 (4 - 60)
<b>3 Jaw Chuck Diameter (mm)</b>	160
<b>4 Jaw Chuck Diameter (mm)</b>	200
<b>Spindle Steps / Speeds (No. / rpm)</b>	18 (65 - 1810)
<b>Motor Power (kW / hp)</b>	1.5 / 2
<b>Voltage / Amperage (V / amp)</b>	240 / 10
<b>Nett Weight (kg)</b>	595