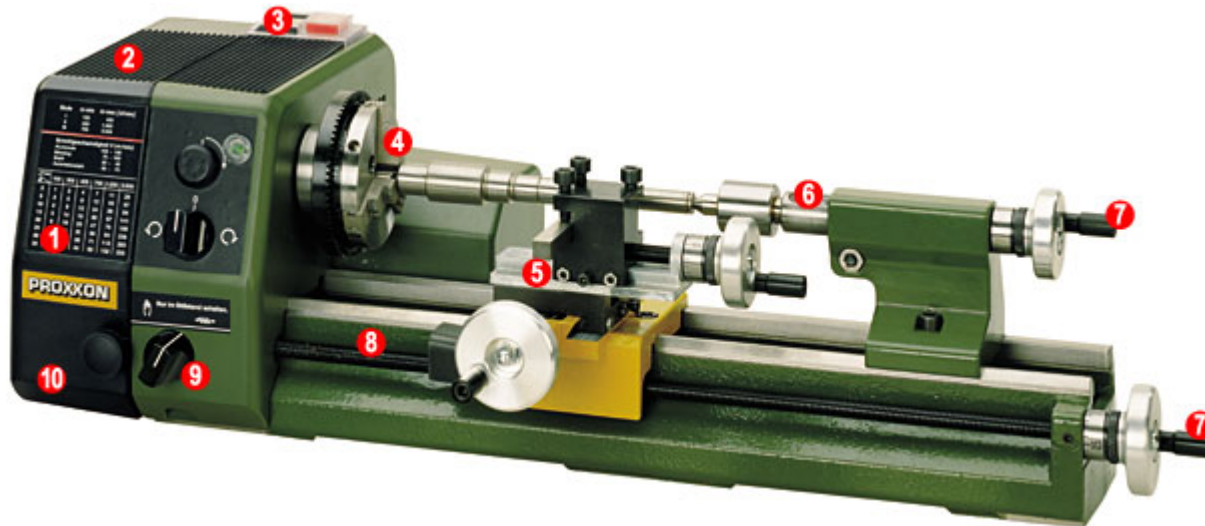




Complete with chuck, live centre and top slide (for taper turning).



Precision Lathe PD 230/E

For spindle speeds from 100 to 3,000 rpm. Useable on materials such as plastic, steel, brass, aluminium. Complete with automatic feed, thread cutting facility, gear chuck, live centre and top slide for taper turning. Used to part, machine stock and cut tapers. The numerous optional accessories enable one to drill, mill and slot.

Technical Data:

Centre distance 230 mm, swing 56 mm. Height over cross slide 28 mm. Cross slide travel 60 mm and top slide 45 mm. Tool holder for cutters 8 x 8 mm. Spindle bore 10.5 (spindle run out 0.01 mm without chuck), with MT 1 (short). Fitted with precision ball bearings. The thread cutting facility yields the most important pitches: 0.5 - 0.625 - 0.7 - 0.75 - 0.8 - 1.0 - 1.25 - 1.5 mm (metric). Spindle speeds of 300, 900 and 3,000 rpm are provided. The automatic feed may be set either 0.05 or 0.1 mm/revolution. Tailstock barrel feed of 30 mm and MT 1 (short). The capacitor motor operates at 220 - 240 Volt, 50 Hz mains with 140 W input / 60 W output as well as bi-directional operation. Workpieces are fitted to the 3 jaw chuck (2 - 35 mm) and with outside jaws (24 - 68 mm). Feed knobs have a feed of 1 mm/revolution. Each revolution is calibrated in 40 divisions, with one division = 0.025 mm. Weight approx. 10 kg. Overall dimensions approx. 530 x 250 x 150 mm.

The quality is clear to the touch and sight. The PD 230/E is made for people which are associated with quality. It is not necessary to have the proficiency of a trained mechanic to handle the PD 230/E.

- ❶ Gear casing with table showing the suitable cutting speed corresponding to material and diameter.
- ❷ Headstock spindle with 10.5 mm bore and MT 1 taper.
- ❸ Main switch with emergency stop function and restart protection.
- ❹ 3 jaw chuck, 2 - 68 mm capacity.
- ❺ Note: The top slide, used for taper turning, and the tool holder are included as standard!
- ❻ MT 1 live centre included as standard.
- ❼ Handwheels with adjustable scales.
1 division = 0.025 mm.
1 revolution = 1 mm.
- ❽ The lathe bed is of cast iron with ground prism for tool rest and tailstock, ensuring minimal deflection even at high loads.
- ❾ The automatic feed may be set to either 0.05 or 0.1 mm/revolution.
- ❿ Combination of 3 speeds (attained by swapping drive belt position) and electronic speed control yield speeds of 100 to 3,000 rpm.

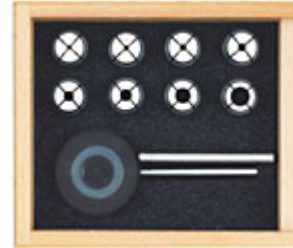
NO 24 004

Four Jaw Chuck

The 4 jaws are adjusted independently, thus clamping asymmetrical pieces such as ovals, squares, odd-shaped workpieces. The jaws are reversible and hardened, giving a capacity of 80 mm. The workpiece must be centred manually.

NO 24 030**Collet Set for accurate use on round components**

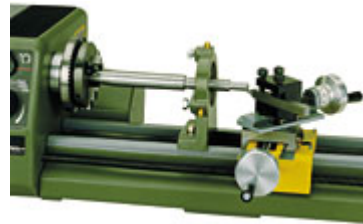
One each 2.0 - 2.5 - 3.0 - 4.0 - 5.0 - 6.0 - 8.0 and 10 mm are included. Concentric accuracy better than 0.2 mm, much better than a chuck. The collets are mounted in the place of the headstock chuck. Supplied in a wooden box and lid.

**NO 24 042****Centre Turning Attachment**

Used for highest accuracy with high rotational precision. One faceplate, 2 fixed MT 1 (short) centres, and 1 drive dog are included. Supplied in a wooden box with sliding lid.

**NO 24 070****Fixed Steady**

Used when turning long, slender pieces, capacity up to 40 mm. Also used when the tailstock cannot be utilised.

**NO 24 080****Radius Cutting Attachment, complete with pointed tool**

Usable on both the PD 230 and the PD 400 and is mounted on the cross slide in place of the tool holder. Cuts concave and convex shapes, to depth of 1.0 mm in steel, as well as non-ferrous metals and plastics. Radii or 3/4 spheres of diameter up to 32 mm are possible. Complete with pointed tool 8 x 8 x 80 mm.

**NO 24 061****Gear Chuck**

Capacity to 10 mm, with key and MT1, for tailstock.

NO 24 020

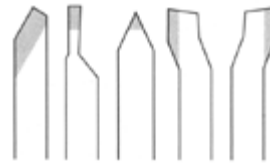
All accessories meet German quality standards. The lathe tools are made of quality Cobalt HSS, pre-ground. Packed in wooden boxes with

sliding lid. 5 piece set.

One each roughing out, parting, finishing cut, left and right cutter.

8 x 8 x 80 mm

NO 24 530



Example

Three Piece Thread Cutting Set

External thread, internal thread (ground to 60°, metric), one general cutting. Supplied in wooden box.

6 x 8 x 80 mm

NO 24 540

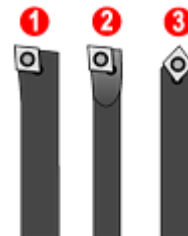
**Cutter Set with Tungsten Inserts**

Three holders:

- 1** Roughing out (8 x 8 x 70 mm)
- 2** Boring bar (8 x 8 x 90 mm, holes from 12 mm)
- 3** Longitudinal work (both 8 x 8 x 70 mm)

Standard tungsten inserts, 55°, plated. Three additional inserts securing screw and key TX 8 are included. Supplied in a wood box with sliding lid.

NO 24 555 Complete

**Tungsten Disposable Tips**

Standard tungsten inserts (coated, 55°). For the holders as described above.

NO 24 557 Set (10 pieces)

Three Piece Centre Drill Set

HSS, DIN 333 (type A) 60°. Complete set with sizes of 2.0 - 2.5 and 3.15 mm.

NO 24 630

