

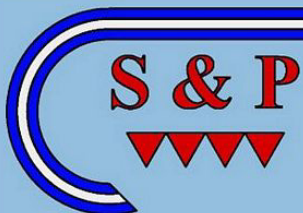
PRECISE PRODUCTIVE AFFORDABLE



LNT36/42/51/65

S-SERIES CNC Multi-Slide Turning Center

An Innovative Automatic Bar Machine with Siemens 840D Controller



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LNT36/42/51/65 S-SERIES

CNC Automatic Turning Center

Superior to Conventional Cam and CNC



CNC Multi-Slide

Automatic turning center, model **LNT 36 / 42 / 51 / 65 S-SERIES**. Combining the advantages of cam operated automatics and modern CNC multi-axis control technology result in fast set up and easy operation for both experienced and non- experienced operators.

This newly designed automatic lathe comprises of 3 compound cross slides and one all-tool-driven 8-position turret mounted on the top of a **compound slide** with one set of toolholders to achieve fast turns.

The cross slides perform longitudinal turning, complex contouring, thread chasing, part-offetc with single point carbide tipped tools or conventional form tools. Up to 3~4 tools can do machining at the same time which reduce working cycle time dramatically.

For machining complex parts, the turret tools equipped with VDI 30 tooling system. The fixed tools perform drilling, boring, ID threading, recessing. The live tools do cross drilling, tapping, milling, slotting on OD, and off center drilling, tapping, slotting on face end.

A synchronous driven Pick-Off Device on turret, can pick up a part-off workpiece for back machining while the main spindle is doing the regular turning on the second workpiece. This set up will further increase the real productivity.

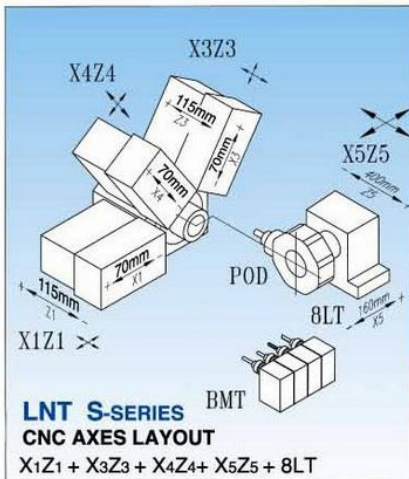
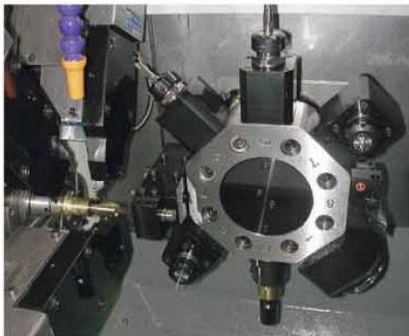
Over lapped machining with multi-slide tools is a sophisticated design. It always performs much faster than other conventional CNC lathes.

Selected optional attachments are: Hydraulic or Servo Live Tools for back machining, Chip Conveyor, Workpiece Belt Conveyor, Automatic Bar Feeder....etc.

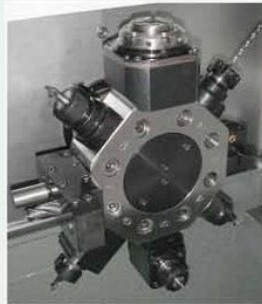


Machining Samples

The LNT automatics are special designed for the metal working industries. Such as aviation, vehicles, computer, plumbing fittings, optical instrument, and many others. It is good for machining all kinds of materials, ranging from aluminum, brass, steels, high alloy steels, and stainless steels.



The Siemens 840D CNC Controller, provides a user-friendly console with a dialog programming, creating a simple operation environment. The graphic tool tracing, make the training and operations much easier.



The 8-position servo turret with extra long X-travel quill-type is in a **compound slide** design. The toolholders on the simplified turret tool drum can have 2-3 tools at one position thanks to "Turret-Gang" innovative application.



The Pick Off Device with collet mounted on the turret, actuated by a hydraulic system, is servo driven synchronously with the main spindle while catching the work piece and performing the burrless cut off operations. After indexing to the opposite direction, the work piece is ready for back machining. The back machining tool platform allows for mounting up to 4 gang tool holders or up to 3 live tool holders.



Automatic Bar Feeder Interface is a standard offer, Several types of bar feeder can be selected for these LNT automatic lathes.



Servo Live Tools
for Back Machining



3-J Chuck
for Sub-Spindle



ID Chuck
for Sub-Spindle

LNT S-SERIES Technical data:

Subject to modify

Model	LNT36S	LNT42S	LNT51S	LNT65S
Unit	Metric (Inch)			
Capacities				
Collet bar capacity, dia.(through bore)	ø36mm(1.42")	ø42mm(1.65")	ø50.8mm (2")	ø65 mm (2.56")
Max. turning length	120 mm (4.72")			
Spindle				
Center height of spindle (approx.)	1,000 mm (40")			
Collet chuck type	F42(ø36mm)	F48(ø42mm)	F58(ø51mm)	F72(ø65mm)
Power of spindle motor	10KW (13.4HP)		13.5 KW (18 HP)	
Max. Spindle speed	6,000 rpm	5,000 rpm	4,500 rpm	4,000 rpm
Compound Slide				
Cross slide travel (X-axis)	70 mm (2.75")			
Longitudinal slide travel (Z-axis)	115 mm (4.52")			
Rapid traverses ,X-axis and Z	15 M/min			
Working feeds, X-axis and Z	5 M/min			
Resolution	0.001 mm (0.0001")			
Tool Turret Slide				
Numbers of tool position	8 positions			
Type of tool shank	VDI-30x55			
Cross slide travel (X-axis)	160 mm (6.3")			
Longitudinal slide travel (Z-axis)	400 mm (15.8")			
Turning tool section	16 mmSq. (5/8")			
Indexing time	0.28 sec / 180° -0.6 sec			
Power live tool motor	5kW(6.7HP)			
Sub Spindle				
Collet chuck type	HB32	TNS40	4"-3 Jaw Chuck	
Max. turning length	ø65mm (ø2.56")			
Motor	5kW			
Max. Spindle speed	3,000 rpm			
Machine Space , Weight and Power Requirements				
Overall dimension (L x W x H)	2,554x1,778x1,935 mm (100.6"x 70"x 76.2")			
Machine weight	3,000 kg (6,600 lb)			
Hydraulic tank capacity	30 L			
Hydraulic pump motor	1 kW			
Coolant tank capacity	180 L			
Coolant pump motor	0.5 kW			
Lubrication capacity	2L,10cc / 11 min			
Total power required	20 KVA		25 KVA	

CNC controller 840D standard functions:

- * Parts program storage at length of 3,000M
- * Graphic trace of tool path
- * Multiple canned cycles
- * Automatic chamfering & corner rounding
- * Simultaneously controllable 10 axes
- * Interface RS232C
- * Tool offset memory 100 sets
- * Tool nose radius compensation
- * Constant surface speed control
- * Oriented spindle stop
- * Rigidity tapping
- * C-axis

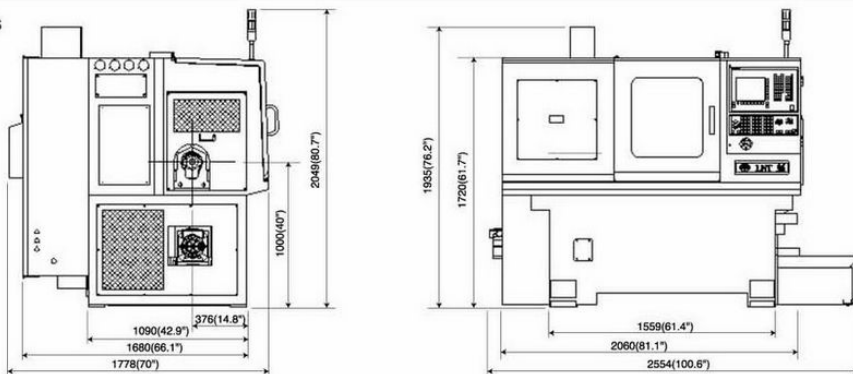
Standard Equipment:

1. Spindle-Collet Chuck System (Standard)
2. 48-Pos. Spindle Dividing System
3. 8-Pos. Servo Tool Turret (with Tool Driven)
4. Air Blow, Coolant & Hydraulic system
5. Automatic Lubrication System
6. Bar Loader Interface
7. Front Door Interlock and Work Lamp
8. Tool Box and Tool Kits
9. Control Cabinet Heat Exchanger
10. Pick-off Device
11. Back Machining Toolholders
12. Workpiece Belt Conveyer
13. Oil mist Collector

Optional Accessories:

1. Sub Spindle with 4"-3 Jaw Chuck
2. Sub Spindle with ID Chucking
3. Servo Live Tool Unit
4. Chip Conveyer with Cart (Screw / Pallet Type)
5. Hydraulic Live Tool Unit
6. Automatic Bar Loader

Dimensions



S & P

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