

Note:
Accessories and insertion tools for
the PD 400 system,
see pages 54 - 57.



Complete with change gears to cut threads
(in 19 steps from 0.2 to 3.0mm).
Clearly positioned and easy to change.

Main switch with auto-start protection
and emergency off.

RÖHM precision feed
(Ø 100mm).

Powerful capacitor motor with 550W
output power.

Selector
for auto-feed.

Switch for clockwise, off and
counter-clockwise rotation.

Apron handwheel.

Quick-change tool post with
2 holders (with stop and height
adjustability).



***The Lathe PD 400 is the heart of a multifunctional and expandable system
and is unequalled in its class!***

Ideal for straight and cross cuts, taper turning, internal and external thread cutting, slotting, etc. Useable on materials such as steel, non-ferrous metals, aluminium and alloys. Negligible tolerances even under heavy loads. The wide range of accessories complements the lathe's functions. The bed is already equipped with a milled and tapped surface for securing mill/drill PF 400.

Technical data:

Distance between centres 400mm and cross slide travel 85mm, over the top slide is 116mm. Solid, ribbed bed is made from quality cast iron with ground and hardened ways. Oversized spindle with 2 adjustable taper bearings, MK3 taper and 20.5mm bore. Run-out, without chuck, 5/1,000mm. Includes the precision 3 jaw chuck, 100mm diameter. Six spindle speeds are provided via belt drive: stage 1: 80 – 330 – 1,400rpm and stage 2: 160 – 660 – 2,800rpm. Powerful, quiet motor

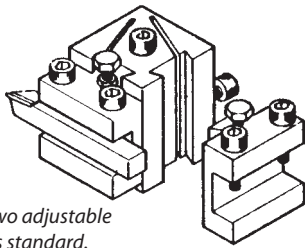
with 550W power output. All adjusting wheels fitted with scales that may be zeroed. One division = 0.025mm.

The auto feed has speeds of 0.07 or 0.14mm/rev.

An integrated gearbox, for LH and RH threads, with change gears provides 19 metric pitches: 0.2 - 0.25 - 0.3 - 0.35 - 0.4 - 0.45 - 0.5 - 0.6 - 0.7 - 0.75 - 0.8 - 0.9 - 1.0 - 1.25 - 1.5 - 1.75 - 2.0 - 2.5 - 3.0mm. Imperial threads of 10 - 48 TPI are also possible.

A rotating centre MK 2 and tailstock chuck of 10mm capacity, B12 taper, are included. Lead screw with acme thread 12 x 1.5, top slide 52mm and





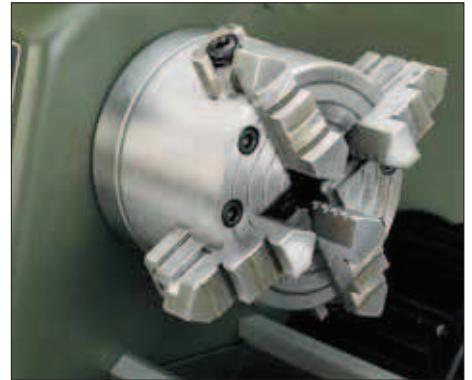
A tool holder with two adjustable inserts is included as standard.

Tool post

Including two holders. Provides quick tool changes with easy height adjustment.
NO 24 415

Individual quick-change holder

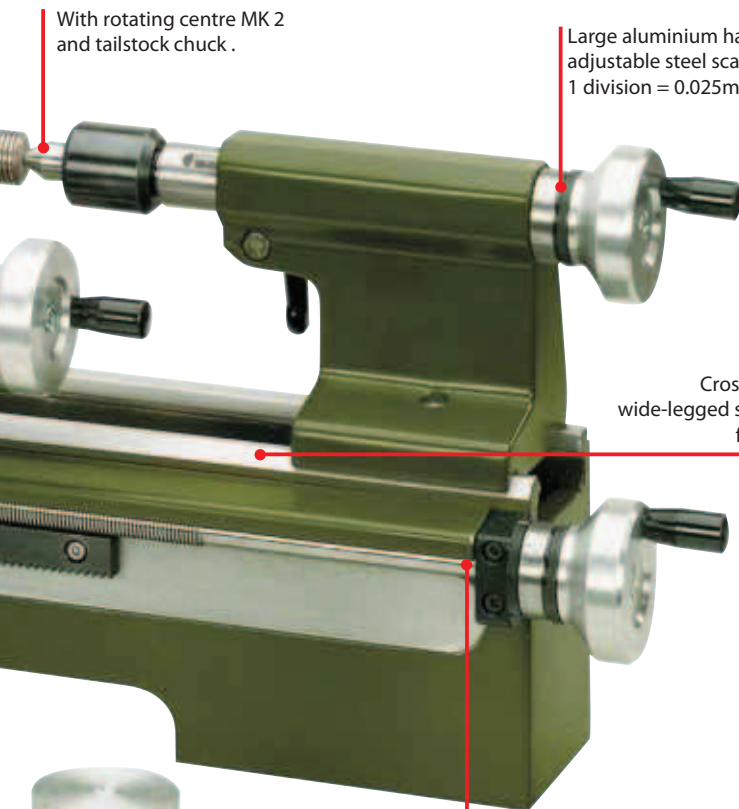
Fits the tool post of PD 400.
NO 24 416



4 jaw chuck with independent jaws

Used to mount irregularly and asymmetrically shaped objects. Each jaw is adjusted individually and centering is thus achieved manually. Hardened, reversible jaws. Chuck diameter 100mm.

NO 24 410



With rotating centre MK 2 and tailstock chuck.

Large aluminium handwheels and adjustable steel scale
1 division = 0.025mm.

Cross-braced cast iron bed, wide-legged shape, and prism slides for apron and tailstock.



4 jaw chuck, self-centering

The jaws are not independently adjustable, i.e. they are self-centering. High accuracy. Chuck diameter 100mm.

NO 24 408



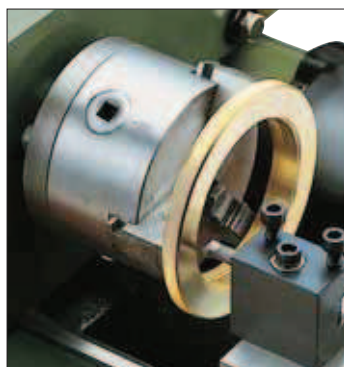
Protected lead screw with 12 x 1.5 Acme thread.

Note:

Lathe PD 400 is now also available in CNC version with spindles running in ball bearings, stepping motor, control unit and easy to use WINDOWS compatible software. A special brochure is available. Feel free to ask for a copy.

adjustable to turn tapers, with graduations up to 45°. Tailstock with MK 2. 24mm diameter and 40mm travel (with graduations).

Overall size approx. 900 x 400 x 300mm (L x W x H). Weight approx. 45kg. Uses cutting tools 10 x 10mm.



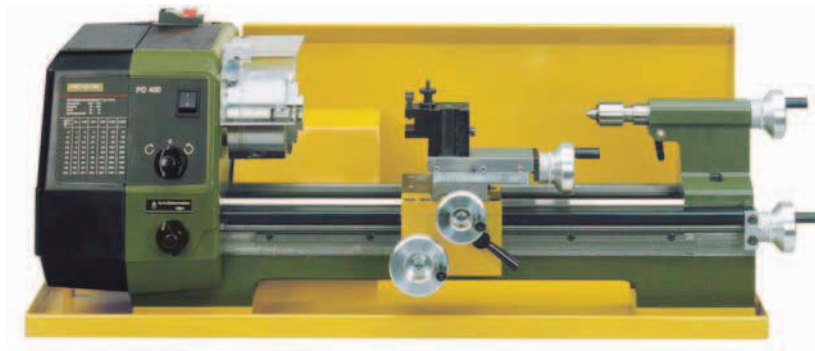
NO 24 400



Faceplate and clamps

Is fitted instead of the standard chuck. Ideal for clamping larger and asymmetrically shaped work pieces. Ø 125 mm. 2 continuous T-slots. With clamping jaws.

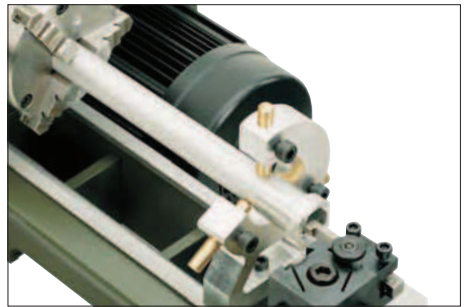
NO 24 412



Splash guard and chip collecting tray for lathe PD 400

Made from 1.5mm steel plate, powder coated. A welded cover protects the motor. Mounting holes and raised base to secure the lathe are pre-drilled. Seeping through of coolant is impossible. Length 800 x width 270 x height 290mm.

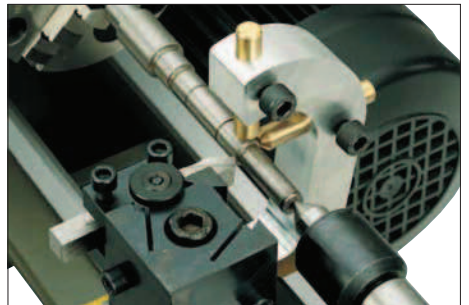
NO 24 402



Fixed steady

Used on the PD 400 when turning long, slender work. Fitted directly to the bed-ways and is used when the tailstock support is inadequate. Maximum Ø 50mm.

NO 24 404



Travelling steady

Fitted to the carriage of the lathe. Indispensable when turning long, slender pieces. Maximum Ø 50mm.

NO 24 406



Collet set

For accurate use on round components. One each 2.0 – 3.0 – 4.0 – 5.0 – 6.0 – 8.0 – 10 – 12 and 14mm are included. Concentric accuracy better than 0.002mm, much better than a chuck. One soft collet for making a custom size yourself. The included collet attachment is mounted in the place of the headstock chuck.

Supplied in a wooden box.

NO 24 419

Collets only

Mill/drill PF 400

Kit also includes the mounting flange and screws (the mounting surface on the PD 400 is already machined). Work surface of steel (150 x 110mm), with 3 milled T-slots for the standard T-nuts, is supplied. Two screws secure the work surface to the cross slide.

NO 24 304



Centre turning accessory for the PD 400

Ideal when turning with highest possible accuracy. Supplied with 2 dead centres (MK2 and MK3), drive/face plate with 30mm bore as well as reducing bushes 30/20mm and 30/15mm. A threaded drive pin screws into the headstock flange and the drive plate.

NO 24 414

Gear tooth chuck (10mm) with adapter

Industrial quality, however not as accurate as the collets. With 10mm adaptor which fits into the 10mm collet. Includes the chuck key.



NO 24 110