



## **(GT-5) Gang Tool Lathe**

### **Machine Features & Specifications**

We are delighted to present the **GT-5** and other models of gang tool lathes that are the affordable option for a variety of uses for gang tool lathes. We are confident that you will find this product a versatile, flexible and reliable addition to your company's manufacturing capabilities. Our single-piece heavy casting is the culmination of years of experience in machine tool manufacturing and offers the best features for gang tool and turret lathe construction. These machines are ideal for dedicated production applications. We can add parts catchers, chip conveyors and auto loading systems to maximize the machines usefulness. We have also developed post processors for the GSK controls in Autodesk's cloud product Fusion 360 CAM software to solve the programming challenges involved with this type of 5-Axis work.

CNC New, Inc. machines provide speed, power, and accuracy in a very compact footprint. All the electrical component suppliers provide the highest-grade hardened CNC controls, liquid-tight motor cables that are available for machine tool manufacturers. This 5-axis system is from GSK CNC systems with the capability to perform indexing and interpolation functions through the use of an integrated C-axis. Servo driven spindle motors and drives have much greater low rpm torque and rapid duty cycles than vector type spindle motors and drives.

CNC New, Inc. provides sales, service, and support for the products we manufacture. All electronic components including cables, motors, and drives are provided by the same manufacture and results in single-source responsibility for the support of the machine. Spare part components are available from our facility in southern California and we are able to provide prompt support, service, and parts for the life of your machine.

The GT-5 tool holders are high precision Swiss tool holders that can utilize 1" bore tools that will provide rigidity and flexibility not previously available with gang tool designed machines. The GT-5 is the ideal platforms for the addition of vibratory bowl feeder systems, as well as gravity feed systems and track loaders. We also are offering the first affordable robotic arm loading system built by GSK. Compact design combined with large ball screws and Axis servomotors results an in very robust machine system.

### **Single Piece Casting: Meehanite casting:**

The **GT-5** is built from a 2,200 lb single piece casting. The castings have been designed with many access ports to improve the serviceability of the machines. The chip and coolant flow are directed to the back of the machine on the GT-5. The table on the GT-5 starts at 44.5 mm center height and we add tool table riser plates to get to the desired tool holder center height. We are providing large X & Z servo axis motors with this system and the rigidity of the machine can accommodate extremely aggressive machining applications. This machine is the real Industrial Strength gang tool system that will meet the needs of customers in today's competitive market.

### **Cross Slide: Linear bearings provide for low friction feed:**

The GT-5 cross slide design incorporates a high performance positioning system featuring high preload, low friction, four circuit, roller linear bearings and a precision-ground ball screw mounted in a super precision thrust bearing. Linear guides are 25mm sets and are extremely rigid. Ball-screws are precision ground, 25mm, 6mm-Lead X-Axis and 10mm-Lead Z-Axis.

### **Work Holding: Wide range of collet chucks:**

The GT-5's standard spindle is A2-4 mountings that will allow the use of 5C, 16C, 2J, 3J pull back or dead length type collet chucks. We also have available a 5" three jaw chuck and other optional collet chucks on request. The machines come standard with a hydraulic collet closer, but can be quoted with a pneumatic system on request. We offer an optional drawtube with thinner wall tubing that will facilitate feeding 1" material for the GT-5 on request. We also offer the MicroCentric wide opening collet chucks and collets for feeding headed parts.

### **C-Axis Spindle: Mill and turn difficult parts efficiently:**

The C-axis spindle selection allows for the flexibility and capability to do parts that normally require machinery that costs significantly more. With the greater center heights, it is now possible to use 30 and 40-millimeter live spindles and grinding attachments. The C-Axis spindle allows you to mill and turn parts off center. Slots, cross-holes, bolt-hole circles, ID keyway broaching, and radial and axial milling, along with many other secondary processes that traditionally require a milling machine/machining center, can be performed on our gang tool lathes in combination with turning operations. The C-Axis spindle achieves performance in the most complex duty cycles and allows for the use of live tools.

### **Live Tooling: The flexibility to meet your needs:**

GSK 980TDi CNC control is a 5-Axis system and we have developed post processors in Fusion 360 to generate the code for our machines. Live tooling allows for a wide-range of drilling and milling operations to enhance the machine's flexibility for small to large lot runs. Additionally, because our gang lathes modular design, the available configuration options will enable you to create a machine that will more precisely fulfill your application requirements. We have available servo driven live tools that are gear driven. The spindles are available in ER-20 and ER-25 spindle configurations. The spindle themselves come in single, double, triple and quadruple configurations. The spindles are controlled as a programmable axis and can tap, or do complex milling operations. The servomotors powering the spindles are a 2hp, or 1Kw and have more than enough torque to do heavy milling work. We also have the option to offer High Speed Spindles configurations from NSK America on request.

### **Tool Holders & Options: Custom tool holders & options**

We recommend the ¾" center height tooling plates with the GT-5 lathes. The front lip of the T-Slot is much thicker with the ¾" holders than the earlier ½" tool holders by design. In order to take full advantage of the larger ball screws and motors and available tooling the ¾" tool option is the best selection. We offer options of riser blocks to bring you up to specific tool heights. On the tooling riser plates we have an extra thick front lip using larger T-Nuts and much more rigid tool holders and tooling. We have available tool holders that are easy mounting of 1, 2, 3, 7, and 8 position tool holders, for complex setups depending upon tool layouts. We also have tool holders for live tooling set-ups.

### **CNC Controls: Best Value & Reliability**

The GT-5 gang tool lathes are offered with GSK CNC controls, motors, and drives. This manufacturer is the second leading producer of CNC kits world wide annually and they build an industrial hardened CNC control system. These controls have adapted an operating system into hardware that has been designed to function in a manufacturing environment. This means that they have been designed to handle wide temperature changes, shaking, and air-borne contamination. Therefore those things will not affect the CNC operation in the same way that a PC-based control would be affected. All cabling is liquid tight with a minimum level of IP-65 ratings. With this CNC control you will have single source responsibility for the support of the entire machine electronic system.

<b>GT-5 Specifications</b>		
<b>Capacities</b>	S.A.E	Metric
Max Turning Diameter	11 in	280 mm
Max Swing Over Table	3.5 in	90 mm
Bar Capacity	0.98 in (Opt.1.06299in)	25 mm (Opt. 27 mm)
<b>Travels &amp; Feed Rates</b>		
X-Axis Travel	12 in	304 mm
Z-Axis Travel	8 in	203 mm
Rapid on X-Axis	590 in/min	15 m/mm
Rapid on Z-Axis	787 in/min	20 m/mm
Axis Max Feed Rate	400 in/min	10.15 m/min
<b>Spindle</b>		
Power Rating	7.5 hp	5.5 kw
RPM	100 – 4,500 rpm	100-4,500 rpm
Spindle Bore	1.41 in	36 mm
Drawtube bore	0.98 in	25 mm (Optional 27 mm)
Spindle Nose	A2-4	A2-4
Collet Actuator	Hydraulic Cylinder	Hydraulic Cylinder
<b>Base</b>		
Integral Casting	One Piece Construction	Slant Angle 45 Degree
Rail Span	14.25 in	362 mm
Casting Weight	2,200 lbs	1,000 kgs
Linear Rails	0.98 in P3 Accuracy	25 mm P3 Accuracy
Ball Screws Precision	Ground 0.98 in C3	Accuracy 25 mm
Auto Lubrication	Linear Rails and	Ball Screws
Head Stock	Cast Iron	
<b>Turret Workholding</b>		
Gang Turret Table HT.	1.732 in	45 mm
Table Length T-Slot	17.71 in	450 mm
Chuck Size	5.3 in	135 mm
Collet Nose Options	5C, 16C, 3J, Threaded	Dead Length
Center Height Holders	¾ in tool holders	Custom Blocks
<b>Precision</b>		
Positional Repeatability	±0.0001 (one tenth)	0.00254 mm
Positional Resolution	±0.00005 (50 millionths)	0.00127 mm
Positional Accuracy	±0.0001 (one tenth)	0.00254 mm
Spindle Runout	0.00005 (50 millionths)	0.00127 mm
C-Axis Indexing	Increment 0.001°	360,000 Radial Position
<b>Requirements</b>		
Coolant Capacity	15 gallons	60 Liters
Coolant Pump	¾ hp	0.5 Kilowatt
Power Required	7.5 KVA 25 amps	208-240 VAC 3-Phase
<b>Machine Dimension</b>		
Floor Space L X W	55 X 29 in	1,380 X 710 mm
Machine Height	55.3 in	1,430 mm
Sheet Metal Length	71.5 in	1,816.5 mm
Sheet Metal Width	48.9 in	1,140 mm
Machine Weight	3,600 lbs	1,636 kgs

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**GSK 980TDi CNC Control:**

GSK is the second largest CNC control builder in the world. They are producing approximately 500 CNC systems per week. This is not a PC based system, but a hardened CNC with the software built directly into the hardware providing maximum reliability. The modular design of the products allow quick replacement of major components if or when required. GSK provide complete CNC systems which includes all required motors, drives, cables, and controls. The NEW 980TDi CNC control with updated software/hardware is a very aggressive full-featured control with 2ms block processing and programs with G-codes and M-functions. This control uses the GSKLINK bus technology, matched with 17bit absolute encoders that carry out automatic recovery of the system power-on no-block mechanical zero return, servo parameter on-line modification or servo state on-line diagnosis, etc. We are using a servomotor and drives on the spindles to perform C-Axis functions. This combination will provide the best performance and number of duty cycles per minute, and will also facilitate the use of live tools. We have available post processors in Fusion 360 for the GSK CNC controls. Standard Features: 4-Axis simultaneous control, 5-axis digital feed control, 2-axis analog feed control, LAN interface Ethernet Port, complex curve surface machining speed: 8m/min optimum machining speed: 4m/min, Max. Positioning speed: 60m/min' max. Feedrate: 15m/min 1000 block look-ahead and spline interpolation, Excellent high-precision and high-speed interpolation, Supports macro programs (Macro B) more concise programs, Supports PLC online monitoring, edit, compile and signal follow functions, Supports multiple languages with a change of a parameter, Supports RS232, USB and network interfaces and data transfer, DNC machining and USB on-line machining, Color LCD monitor with 800 X600 resolution 8.4" or Optional 10.4", Rigid tapping, graphic programming, run and test program by hand wheel, 208v (Range 190-240) 3-phase system electronics. 64M program space 60Mb user storage (program capacity).

429-0015 CNC Control	Standard CNC control used with the GT-ISL gang tool lathe line with GSK selection.	GSK980TDi CNC controller 8.4" color LCD, 5 axis controllable (C-Axis), USB interface, inner PLC, rigid tapping, max rapid speed 60 m/min, 41/36 I/O contacts,
429-2060 X & Z Motors & Drives option	X & Z axis servomotors and drives used with the GT-5 lathe model. X-Axis motor has a built-in brake.	GSK Axis Package: Servomotor & drive: (1.5 KW, 1,500 Watts, 2 hp, Stall torque 6.2 Nm, Maximum thrust X-Axis is 1411 lb and 6,280 newtons and maximum thrust Z-Axis 847 lb and 3,768 newtons 2,500 rpm, 6A, 5000 ppr encoder, 130 mm flange.
429-3020 Spindle Motor & Drive	5hp C-Axis Spindle motor and drive package. Used with the GT-5 lathe model.	AC servomotor and drive (5 hp, 3.7 Kw, 3,700 Watts, max speed 7,000 rpm, and 4096 encoder. Maximum torque is 31 ft/lb or 43 Nm.

## **Spindle Drive Options**

### **C-Axis servo motor and spindle drive option:**

CNC New, Inc. is offering the C-Axis servo spindle motor and drive with the GSK CNC control manufacturers. The C-Axis option with live tools will mill and turn parts off center. Slots, cross-holes, bolt-hole circles, and many other secondary processes traditionally requiring a milling machine/machining center can be performed with the C-Axis option. This spindle option will also provide increased duty cycles per minute for high production turning with a bar feed or loader. We are providing a 3.7 kW motor or 5 with this model lathe.

## **Work Holding Options**

We offer a wide range of standard work holding options for ATA-S systems. ATS-S offers both the pull-back style collet chucks, and also provides dead length (or true length) collet chucks for all models, in addition to Warner & Swasey style chucks, S style collet chucks, and a broad range of other chucks.

### **CNC New Drawtube:**

319-1000	1	Modified drawtube allowing the bar feed through the spindle of 27 mm material. Standard drawtube allows for continuous feed of 25 mm material.	995.00
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### **Auto Strong 3-Jaw Chuck Options:**

329-5300	1	Auto Strong N-205 5" 3-Jaw hydraulic chuck includes drawtube and mounting for A2-4 spindle. Includes 1-valve hydraulic station.	1,250.00
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### **ATS Work Holding: Pull Back Design Collet Chucks:**

ATS-S is located in southern California and offers a broad range of options for work holding for A2-4, A2-5, and A2-6 spindle mounts. Collet chucks offer low inertia for fast cycle times. Low profile designs for minimum tool interference. ATS chuck body is case hardened steel, made in the USA and guaranteed 0.0002" T.I.R. on closing taper. Cost effective work holding solution, ideal for 1<sup>st</sup> operation, slug work and feed to length bar feeding. Easy installation with direct mount to machine spindle. Actuated by pullback motion of the drawtube. Available for use with C, J and S style collets. Includes drawtube, drawtube adapter and chuck body. 7-degree closing angle taper on 2J, 3J, and 22J collets. 10-degree closing taper angle on all C style collet systems. 15-degree closing taper on S collets.

320-1010	1	ATS A2-4 5C Threaded nose 3.5" length (Shorty) 5C Threaded nose=2 3/16-10 for use with step chucks.	\$990.00
320-1015	1	ATS A2-4 5C Threaded nose 5" length	\$1,090.00
320-1054	1	ATS A2-4 16C Pull back design collet chuck	\$1,290.00
	1	ATS A2-4 2J Pull back design collet chuck	Upon Request
	1	ATS A2-4 3J Pull back design collet chuck	Upon Request

**ATS Work Holding: True Length Design Collet Chucks:**

Innovative patented design providing fixed collet position ensuring linear accuracy. Ideal for second operation applications with parts transfers. Utilizes standard C, J, and S collets. 7 degree closing angle on J & S style collets, and 10 degree closing on all C style systems. Superior tool clearance with reduced body diameters. Adjustability feature enables user to adjust the T.I.R. of the system.

320-2010	1	ATS A2-4 5C True length collet chuck for GT-ISL.25 & 35 models. Includes dead length collet chuck, adapter and drawtube	\$3,190.00
320-2011	1	ATS A2-4 16C True length collet chuck	Upon Request
320-2012	1	ATS A2-4 3J True length collet chuck	Upon Request

**ATS Work Holding Options: True Length Nose Cap Chucks:**

Innovative patented design providing fixed collet position ensuring linear accuracy. Ideal for second operation applications with parts transfers. Utilizes standard Index and Brown & Sharpe style collets. System is adaptable to accept multibore collets. Adjustable feature enables user to adjust for T.I.R.

320-3015	1	ATS A2-4 Brown & Sharpe nose cap true length #22 collet chuck for GT-5/35 models. Includes dead length collet chuck, adapter and drawtube.	\$3,290.00
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**MicroCentric Wide Opening Collet Chuck:**

323-3200	1	MicroCentric wide opening collet chucks are designed to grip over the shoulder of headed parts. Collets open up to .394 (10) above the nominal clamping diameter. Six segmented double angle design collet with ID thread for mounting part stops or ejectors. Dead length design chuck hardened alloy steel precision ground for accuracy and long-term performance. Also available in 16C on request.	\$3,470.00
323-3205	1	5C Cartridge ejector assembly	\$335.00

323-6050	1	Wide opening collets are six-segmented design. Collets are made to order for specific applications. Information required is the following: <b>N</b> Nominal Clamping Diameter, <b>W</b> Opening Diameter, <b>L</b> Land Length, <b>R</b> Relief Diameter	Upon Request
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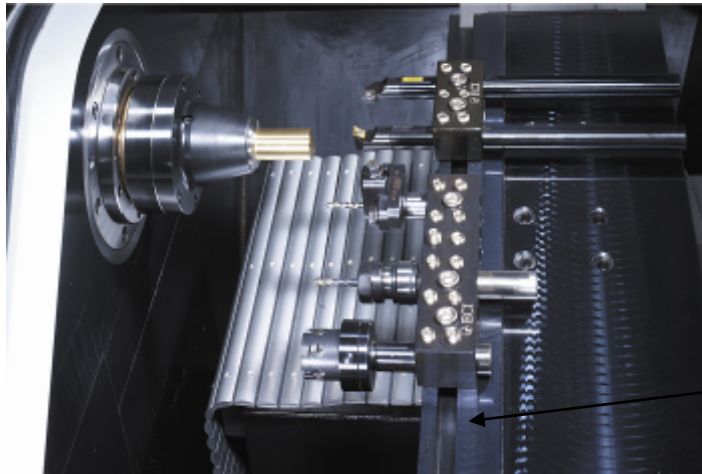
### **Machine Tool Riser Plates:**

Each model of GT-ISL has a very low table for the original flat table, which has three t-slots. Original table heights of the machines are as follows. GT-5 is at 45 mm or 1.77", GT-ISL-35 begins at 55 mm, or 2.1", the GT-ISL-45 starts at 70 mm or 2.7" center height, and the GT-ISL-50, which starts at 96 mm, or 3.77" center height. The riser plates are offered in 12" or 17" to cover the entire table for the GT-5 and GT-ISL-35. The 17" riser covers the entire t-slot or the original table. We offer 12" riser plates for the GT-ISL-45 and GT-ISL-50 models. The machines original table is 24" so if you want to use 3/4" tool holders on the entire travel of the models you would purchase two 12" risers that would cover the original t-slot of the machine. This flexibility allows us to install much larger live tool spindles and grinders on the machines and allows us to offer much stronger tool holders and tooling to compliment the larger motors and ball screws of the GT-ISL. (Optional 1/2" center height riser tool plate tables available on request.)

610-6010	1	GT-5 precision ground riser plate 12" length allowing the original 45mm table to utilize 3/4" tool holders.	\$595.00
610-6015	1	GT-5 precision ground riser plate 17" length to utilize 3/4" tool holders.	\$695.00
610-6020	1	GT-ISL-35 precision ground riser plate 12" length to utilize 3/4" tool holders.	\$595.00
610-6024	1	GT-ISL-35 precision ground riser plate 17" length to utilize 3/4" tool holders.	\$695.00



**Tool Holders:**



GT-27 Tool Plate

**CNC New Tool Holders:** [www.cncnew.com](http://www.cncnew.com)

**Round-shank tool holders:**

This section will address the needs of mounting round-shank tooling. The GT-ISL provides tool plate riser blocks that utilize the heavy-duty 3/4" center height tooling as the standard for each of the gang tool models. The fixed-height blocks offer rigidity and consistency of center height in two choices of bore diameters

The fixed type blocks allow the use of a modular approach that provides the ability to "group together" all, or part of a set-up for storage and reuse later. This approach can significantly reduce changeover times to a new job. The table located below illustrates some, but not all, of the available options. The largest block can accommodate 8 tools. The part numbers and pricing are all for 3/4" bore (but the 5/8" bore is available, as well).

Fixed 1-position block		Fixed 3-position block		Fixed 7-position block	
					
Part #	GT-1075R	Part #	GT-3075	Part #	GT-6075
\$110.00		\$150.00		\$350.00	

***A partial list of Posi-lock tooling for 3/4" center height machines:***

CNC New, Inc. Heavy Duty 3/4" Center Height Dove Tail Tooling		
Description	Part Number	List Price
1-Position, 3/4" Ctr. 3/4" Bore with lip	GT-1075	\$110.00
1-Position, 3/4" Ctr. 1" Bore with lip	GT-1175	\$110.00
2-Position, 3/4" Ctr. 3/4" Bore with lip	GT-2075	\$125.00
2-Position, 3/4" Ctr. 1" Bore with lip	GT-2175	\$125.00
3-Position, 3/4" Ctr. 3/4" Bore with lip	GT-3075	\$150.00
3-Position, 3/4" Ctr. 1" Bore with lip	GT-3175	\$150.00
7-Position, 3/4" Ctr. 3/4" Bore with lip	GT-7075	\$350.00
7-Position, 3/4" Ctr. 1" Bore with lip	GT-7175	\$350.00
8-Position, 3/4" Ctr. 3/4" Bore with lip	GT-8075	\$450.00
8-Position, 3/4" Ctr. 1" Bore with lip	GT-8175	\$450.00
Cutoff tool front mount	GT Cutoff Front	\$130.00
Square tool holder for 3/4" tools L type right	GT L Type Right	\$125.00
Square tool holder for 3/4" tools L type left	GT L Type Left	\$125.00
Square tool holder for 3/4" tools	GT Square 3/4"	\$125.00
Tool Post Extension Short 1"	GT-Ext-Short	\$210.00
Tool Post Extension Long 2"	GT-Ext-Long	\$240.00
Tall Tool Post up to 4"	GT-Tall-Post	\$325.00
Tool Post A-Type	GT-Tool-Post-A	\$300.00
Tool Post B-Type	GT-Tool-Post-B	\$300.00
Offset Post Adapter	GT-Offset-Post	\$225.00
Offset Post Assembly Rail	GT-Offset-Rail	\$140.00
Radial Live Tool Holder 180° Right Angle 30mm	GT-RLT-30	\$285.00
Axial Live Tool Holder 90° 30mm	GT-ALT-30	\$285.00
Vertical Live Tool Holder 30mm	GT-VLT-30	\$285.00

## **Electric Options: iSpeed3 Swiss Type Spindles**

### **NSK Live Tools: [www.nskamericacorp.com](http://www.nskamericacorp.com)**

The NSK "Astro" electric-driven live tool system is available as another option. Because they have electric motors, they put less of a demand on shop air compressors. The electric live tool motors can rotate forward or reverse. The controller governs right-hand or left-hand rotation. Electric options also offer more precise spindle speed control. Changes in incoming air pressure will alter the spindle speed of a pneumatic motor but will not affect an electric system's spindle speed. These spindles are available in an outside diameter of the following sizes  $\varnothing 0.75''$ ,  $\varnothing 0.79''$ ,  $\varnothing 0.87''$  and  $\varnothing 0.98''$  ( $\varnothing 19.05$ ,  $\varnothing 20$ ,  $\varnothing 22$  and  $\varnothing 25$  mm). Spindle RPM 1,000–80,000 with 150W output. These are single piece spindles and motors with shorter lengths which are ideal for use on gang tool lathes. The iSpeed3 series have sensorless motors and are equipped with super precision hybrid ceramic bearings for longer life. CNC New, Inc. provides tool holders that will allow mounting these spindles in axial, radial, or a vertical orientation. This option is an affordable option providing the use of two spindles with the system. Below is a sample of the most common selections used with our machines for the iSpeed Series Motor/Spindles.

<b>NSK Electric Option iSpeed3 Series One Piece Type</b>		
Part number	Description	List Price
AL-C1204	Airline Kit: includes: filter, regulator, pressure gauge, air on/off valve, 6ft. of air hose	\$350.00
NE273	iSpeed series control unit two spindle operation	\$2,315.00
BMJ-320	20mm 1,000-80,000 rpm spindle motor combination	\$2,780.00
BMJ-325	25mm, 1,000-60,000 rpm, spindle motor combination	\$3,102.00
9264	EMCD-BM3S-4M quick disconnect motor cable straight	\$400.00
DB25M	Electric interface cable	\$75.00
850-6025	Interface of electric control box to the specific CNC control	\$995.00

## **Electric Options: E3000 Series Electric Live Tools**

### **NSK Live Tools: [www.nskamericacorp.com](http://www.nskamericacorp.com)**

With the E3000 Series the spindles are available in both single motor/spindle combinations and also modular type where the spindle and motor are separate units screwed together. The diameters available include  $\varnothing 1.18''$ ,  $\varnothing 0.98''$ ,  $\varnothing 0.897$   $\varnothing 0.79''$  ( $\varnothing 30$ ,  $\varnothing 25$ ,  $\varnothing 22.8$ , and  $\varnothing 20$  mm). A motor can be rotated within the range of 5,000 rpm to the maximum output rating of the motor in increments of 1,000 rpm. Motors are available in speed ranges of up to 60,000 rpm. This option requires the purchase of a control unit and selector unit that supplies power and cooling to the motor mounted to the gang tool plate. The Astro E-3000 control has the capability of controlling four spindles, each with a unique speed setting (the spindles cannot be operated simultaneously). The addition of a communication cable is required if the operator desires to control spindle start/stop from within the part program.

The table below illustrates partial list of choices available. In "Description" of motors: 350W = 350 Watts (Power) "60K" = 60,000. Spindles come equipped with a 1/8" collet and chuck nut and two wrenches (with many other sizes available). All NSK live tooling systems include the spindle and a motor. The spindle contains the collet chuck that the cutting tool mounts to. Reduction gear units are available for electric spindles to increase cutting torque. When mounted, the reduction gear slows rotation of the spindle proportionally. They are available in up to 16:1 ratios. Use of a reduction gear will increase torque allowing for more aggressive cuts than possible when using only a spindle and motor. CNC New, Inc. provides tool holders that allow installing spindles in axial, radial, or vertical orientations. This is a partial list of the many options available from NSK for the E3000 series electric spindle option.

<b>NSK Electric Option E3000 Series</b>		
Part number	Description	List Price
CHK-6.35	1/4" collet (Other collets sizes available—call us for details)	\$89.0
AL-C1204	Airline kit includes filter, regulator, pressure gauge, air on/off valve, 6 ft. of air hose	\$350.0
NE-211	Control unit E3000 Series one motor can run unit only	\$2,025.0
NE-212	Selector unit operating four spindles (not simultaneously)	\$1,334.0
EM-3060J	60,000 rpm high torque motor	\$1,048.0
NR-3060S	Spindle (ceramic bearing) 60,000 rpm	\$1,152.0
RAS-151E	90-degree spindle, 7.49 K rpm. .98" diameter (25 mm) 1/4"	\$821.00
RAX-271E	90° Spindle 30,000 rpm speed reduction ratio 1/1.5	\$891.0
RAX-71E	90° Spindle 30,000 rpm speed ratio 1/6 5,000 rpm reduction	\$1,110.0
ARG-011E	Speed reducer ratio 1/4 30,000 to 7,500	\$228.0
ARG-021E	Speed reducer ratio 1/16 30,000 to 1,870	\$305.0
1768	EMSD-3000J 4 m motor cable (one required for each motor)	\$370.0
DB25M	Electric interface cable	\$75.0
850-6025	Interface of electric control box to the specific CNC control	\$1,495.0

## **CNC New Hydrodynamic Bar Feeders:**

CNC New, Inc. is now providing a very price-competitive solution for single bar hydrodynamic bar feed system. There are many benefits operating a hydraulic system over pneumatic and mechanical systems. A hydrodynamic bar feed is safe, quiet, and provides quick change overs. This bar feeder can handle material up to 1-3/4" diameter. We are offering a range of feed tubes to facilitate a broad range of sizes with less than 5-minute feed tube change over. The gang tool lathes have a short headstock so the loader type systems are not a good match for our machines. The material does not turn inside a loader so the length of the material that you can work with is limited. We have successfully built support stands that attach to the back of the spindle, and for specific production this concept can work. We also work with LNS, MTA, and Edge manufactures and their magazine-type bar feeds range from 6' to 12' foot material. Prices range from \$20,000 to \$32,000. We can provide information from these manufacturers on request.

We are offering two sizes of hydrodynamic systems to consider. The FB system can accommodate sizes from 4 mm to 26 mm, and the larger FT system ranges in sizes from 7 mm to 45 mm. The feed tubes are engineered to work with an 8 mm range of material. An example is that the 18 mm feed tube can work with material down to 10 mm diameter. These are approximate estimations and will be impacted by the type of material and the straightness of the bars. CNC New, Inc.'s hydrodynamic bar feeder system is 12.5' overall length and can accommodate material to a maximum length of 8.2'. We also recommend spindle liners with this item to maximize the support of the material and the quiet and safe operation of the system.

830-7010	1	FB-10 CNC Hydrodynamic bar feed system. Material to 10 mm (.39"). Overall length of system is 12.5', maximum bar length 8.2'. Does not include additional feed tubes. Dedicated to small part production of 10 mm or less. Will work with material to 3 mm in diameter depending on material and straightness of the bars.	\$4,495.00
830-7012	1	FB-12 CNC Hydrodynamic bar feed system. Material to 12 mm or .47". Overall length of system is 12.5', maximum bar length 8.2'. Dedicated to small part production of 12 mm or less. Will work with material to 4 mm in diameter depending on material and straightness of the bars.	4,495.00
830-7026	1	FB-26 CNC Hydrodynamic bar feed system. Material to 26 mm or 1.02". Overall length of system is 12.5', maximum bar length 8.2'. This system includes feed tubes of 13 mm, 18 mm, 20 mm, 26 mm on request. Best option for the GT-5 model lathe.	5,995.00

830-8018	1	FT-18 CNC Hydrodynamic bar feed system. Material to 18 mm or .70". Overall length of system is 12.5', maximum bar length 8.2'. This is a dedicated single bar unit able to handle bars from 10 mm to 18 mm.	\$5,995.00
830-8034	1	FT-34 CNC Hydrodynamic bar feed system. Material to 34 mm or 1.33". Overall length of system is 12.5', maximum bar length 8.2'. This unit comes with 18 mm, 26 mm, and 34 mm feed tubes. Able to work with 10 mm to 34 mm diameter bars. Good selection for use with the GT-5 and GT-7 models.	6,995.00
830-8042	1	FT-42 CNC Hydrodynamic bar feed system. Material to 42 mm or 1.65". Overall length of system is 12.5', maximum bar length 8.2'. This unit comes with 18 mm, 26 mm, 34 mm, and 42mm feed tubes. Good selection for use with the GT-10 lathe model.	6,995.00
830-8045	1	FT-45 CNC Hydrodynamic bar feed system. Material to 45 mm or 1.77". Overall length of system is 12.5', maximum bar length 8.2'. This unit comes with of 26 mm, 34 mm, 42 mm and 45 mm feed tubes. Good selection with the GT-15 lathe model.	6,995.00

**Other Machine Options & Considerations:**

	1	Foot Pedal Open/Close Chuck	395.00
	1	Additional M-Function w/Relay and Solenoid Valve	595.00
	1	Additional M-Function with Relay and Contactor	595.00
	1	Additional M-Function with Coolant Valve	995.00
	1	Addition M-Function with Relay	395.00
	1	Air input FLR	795.00
	1	NSK Air Live Tool Spindle Interface	795.00
	1	NSK Electric Live Tool Spindle Interface	1,495.00
	1	16 Additional M-Functions Outputs 16 Inputs	1,495.00
	1	Bar Feed Interface Based on MFG.	Upon Request
	1	Spindle liners 1/8", 3/16", 1/4", 5/16", 3/8", 7/16", 1/2", 5/8", 9/16", 3/4", 13/16", 7/8", 15/16"	Upon Request
	1	Automatic Tool Presetter, manual and automatic modes. User friendly	3,995.00
	1	Work Gauging Probe	9,750.00
	1	Coolant Tank Oil Skimmer	695.00
	1	Auxiliary Coolant Filter System	1,995.00
	1	4-Station Coolant Manifold with Loc Line and Shut Off Valves	795.00
	1	2 <sup>nd</sup> Coolant on/off for Coolant Fed Drills	1395.00
	1	High-Pressure Coolant System, 300 psi (21) bars	5,995.00
	1	High-Pressure Coolant, 1000 psi (69 bar)	7,995.00
	1	Remote Hand Wheel	795.00
	1	Remote Hand Wheel Color LCD	1295.00
	1	High-Intensity Lighting	695.00
	1	Rotary union for through Spindle Coolant	1995.00
	1	Enclosure Exhaust System	1,450.00
	1	Parts Catcher System	2,495.00
	1	Belt-Type Chip Conveyor System	3,795.00
	1	Internal High-Voltage Isolated Transformer for 380-480V operation	Upon Request
	1	Export Packaging	1,295.00