



(DSTT & DSPTT-40) Dual Spindle Turning Centers

Machine Features & Specifications

We are delighted to present the **DSTT-40 & DSPTT-40** dual spindle lathes. We are confident that you will find this product a versatile, flexible and reliable addition to your company's manufacturing capabilities. This dual spindle model has an A2-6 optional (A2-5) spindle nose on the main spindle and an A2-5 on the counter spindle. We offer this machine with 12-station static tool turret or 12-station power driven tool turrets, or one of each. We have the most affordable magazine bar feeds in the industry and the same for robotic arm loaders. 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. Our driven tool spindles can perform axial milling, drilling, boring, broaching, radial milling and gear hobbing, and tapping functions.

The **DSTT-40 & DSPTT-40** use the NEW 988TD CNC control is a dual-channel turning center CNC control developed by GSK Equipment Co., LTD. And is based on ARM+DSP dual core hardware architecture by connecting with the industrial Ethernet bus with the (GSK-Link), the servo drives and a remote I/O unit. The 988TD can control up to 10 axis and 4 spindles, each path includes 6 feed axis (including C Axis) in each path, 3-axis link and 3 spindles to realize the turning with compound milling operations. The servos motors use high-resolution absolute encoders that provide 0.1μm position precision, and 1ms interpolation period to perform a turning-milling compound machining and can provide the control performance for multi-axis turning and machining centers.

CNC New, Inc. provides sales, service, and support for the products we manufacture, assemble and import complete. All electronic components including cables, motors and drives are provided by GSK, which results in single source responsibility. 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. ATS Systems based in Southern California has a wide range of range of work holding options for the A2-5 and A2-6 spindles that would allow customers to use existing collet systems to facilitate quick change over of work holding collets for rapid changeovers. We are offering this machine with a six or twelve-foot bar feed systems and or a robotic arm loader systems

Single Piece Casting: Construction Meehanite Casting

The **DSTT & DSPTT-40** are built from a 9,921 lb single piece casting with the table at a 45° slant. The casting has been designed with many access ports to improve the serviceability of the machine. The chip and coolant flow are directed to the front of the machine for convenient installation of a chip conveyor on the side. We are providing large X & Z servo axis motors with this system, and the rigidity of the machine can accommodate extremely aggressive machining applications. These models are the real Industrial Strength Gang Tool & Turret Designed Machine Tool Systems that will meet the needs of customers in today's competitive market.

Cross Slide: Linear bearings provide for low friction feed

The **DSTT & DSPTT-40** cross slide design incorporates a high performance positioning system featuring high preload, low friction, four circuit, roller linear bearings manufactured by Swedish manufacture SKF, and a precision-ground ball screws manufactured by Taiwan manufactures PMI/Hiwin. Machine is available with optional roller bearings on request. The performance slide utilizes state-of-the-art AC brushless servomotors and digital drives. Linear guides are 30mm sets and are extremely rigid, and the ball-screws are precision ground, 32mm, 08 mm-Lead in a. Both the linear rail bearing blocks and ball screws are outfitted with brass lines and fittings with a timed lubrication system.

Spindle Options: Wide range of work holding options available

The **DSTT DSPTT-40** standard spindle option is a 45 mm diameter spindle with a 4,500 maximum rpm. Both spindles are A2-5 mounting that will allow offers a wide selection of work holding from ATS Systems. The machine can use a 6" chuck and has a 1.75" bar capacity. This spindle has a hydraulic collet closer and can bar feed material maximum 45 mm or 1.75". The option of A2-6 spindle is also available with this model lathe.

C-Axis Spindle: Mill and turn difficult parts efficiently

The **DSTT & DSPTT-40** spindle design allows for the flexibility and capability to do parts that normally require machinery that costs significantly more. 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, with many other secondary processes traditionally requiring a milling machine/machining center, can be performed on the gang 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.

DSTT-40 & DSPTT-40		
Capacities	S.A.E	Metric
Max Swing Over Bed	22.8 in	580 mm
Max Swing Over Carriage	13.7 in	350 mm
Max Turning Diameter	9.8 in	250 mm (with specific turret)
Max Between Chucks	18.8 in	480 mm
Max Turning Length	13.7 in	350 mm
Main Spindle		
Spindle Nose	A2-6	A2-6
Spindle Chuck	8"	203 mm
Spindle bore	2.4 in	61 mm
Bar Capacity	1.96 in	49 mm
Spindle Speed (Max)	4500 rpm	4500 rpm
Collet Actuator	Hydraulic Cylinder	Hydraulic Cylinder
Counter Spindle		
Spindle Nose	A2-5	A2-5
Spindle Chuck	6"	152.4 mm
Spindle Bore	2.2 in	56 mm
Bar Capacity	1.7 in	44 mm
Spindle Speed (Max)	4,500 rpm	4,500 rpm
Collet Actuator	Hydraulic Cylinder	Hydraulic Cylinder
Motor Power		
Main Spindle Motor	10 HP	7.5 kW
Counter Spindle Motor	7.5 HP	5.5 kW
X/Z Axis Motors	2.2/3.1 HP	1.5/2.3 kW
Hydraulic Station Motor	1.5 HP	1 kW
Travels & Feedrates		
X1, X2-Axis Travel	9.0 in	230 mm
Z1-Axis Travel	15.7 in in	400 mm
Z-2-Axis Travel	20.8 in	530 mm
Z2 (Sub Spindle) Travel	20.8 in	530
Rapid on X-Axis	945 in/min	24 m/min
Rapid on Z-Axis	945 in/min	24 m/min
Axis Max Feed Rate	400 in/min	10.15 m/min
Base		
Integral Casting	One Piece Construction	Slant Angle 45 Degree
Rail Span	15.7 in	400 mm
Linear Rails	X/Z 1.81 in P Accuracy	X/Z 30mm P Accuracy
Ball Screws Precision	X/Z Ground 1.26 in C3 Accuracy	X/Z Ground 3208 mm C3 Accuracy
Timed Auto Lubrication	Linear Rails &	Ball Screws
Head Stock	Cast Iron	Cast Iron
Precision		
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
Requirements		
Coolant Capacity	18.5 gallons	70 Liters
Coolant Pump	3/4 hp	0.5 Kilowatt
Power Required	30 KVA	Voltage 208-240 VAC 3-Phase
Machine Dimension		
Machine Height	72 in	1830 mm
Sheet Metal Length	120 in	3050 mm
Sheet Metal Width	70 in	1750 mm
Machine Weight	9921 lbs	4500 kgs

GSK 988TD CNC Control

• Product Introduction

GSK is the second largest producer of CNC kits annually producing approximately 500 CNC systems per week. On over 25 billion dollars worth of machine tools produced in China annually over 65% have GSK CNC components. This is not a PC based system, but a hardened CNC with the software burnt into the eproms of the hardware providing maximum reliability. The modular design of the products allow quick replacement of major components if and or when required. GSK provides complete CNC systems which includes all required motors, drives, cables, and controls. The the NEW 988TD CNC control is a dual-channel turning center CNC control developed by GSK Equipment Co., LTD. And is based on ARM+DSP dual core hardware architecture by connecting with the industrial Ethernet bus with the (GSK-Link), the servo drives and a remote I/O unit. The 988TD can control up o 10 axis and 4 spindles, each path includes 6 feed axis (including C Axis) in each path, 3-axis link and 3 spindles to realize the turning with compound milling operations. The servos motors use high-resolution absolute encoders that provide 0.1µm position precision, and 1ms interpolation period to perform a turning-milling compound machining and can provide the control performance for multi-axis turning and machining centers.

429-2070 X&Z Axis motor & drive	X & Z axis servomotors and drive package GT-10 & GT-15	GSK 10Nm Axis Package: (A2) servo motor & driver includes 2.5KW, 2,500 watts, 3.3HP, 10Nm, 7.3 lbf/ft, 2,500rpm, 10A, 130 flange
429-3040 Spindle Motor & Drive	10hp C-Axis Spindle motor & drive package. Used with model GT-10 model lathe. 220V.	AC servo motor and drive (10hp, max speed 7,000 rpm, and 5,000 line encoder. 63 ft-lb, 86 Newton Meters

- **Technical Characteristics**

- 10 Feed axis (including C-Axis), 4 spindles each path includes feed axis (including C-Axis) in each path, 3-Axis link and 3-Spindle to realize the turning and milling compound machining.
- Command unit 1 μ m, and 0.1 μ m, 1 μ m up to 240 m/min. 0.1 μ m up to 100 m/min
- The servo drive and I/O unit use connection control of the GSKLink bus
- Nested many PLC programs, PLC ladder on-line editing
- Part programs edited in the background
- Network interface, remote monitoring and file transmission
- USB interface, U disc file operation, system allocation and software upgrading

- **Technical Specifications**

- **Controllable Axis**
 - 10 feed axis (including C-Axis), 4 spindles; each path includes 6 feed axis in each path, 3-axis link and 3 spindles to realize compound turning and milling functions.
 - PLC controllable axis number 10, 6 axis in each path
- **Axis Feed Functions**
 - Least Command Unit: 0.001 mm and 0.0001 mm
 - Least Command Range: ± 99999999 X least command unit
 - Rapid Traverse Speed: max: 240 m/min in 0.001 mm command unit, max 100 m/min in 0.0001 mm command unit.
 - Rapid Override: F0, 25%, 50%, 100% real-time tuning
 - Cutting Feedrate: 0.01 mm/min ~ 100000 or 0.01 inch/min ~ 4000 inch/min (G98: feed per minute) 0.001 mm/rev ~ 500 mm/rev or 0.0001 inch/rev ~ 9.99 inch/rev (G99: feed per rev)
 - Feedrate Override: 0 \sim 150% 16-level real-time tuning
 - Interpolation mode: linear, circular, thread, polar, cylindrical interpolation and rigid tapping
- **Thread Function**
 - Thread Type: constant pitch straight thread/taper thread/end thread, variable pitch straight thread/taper thread/end thread
 - Thread Pitch: 0.01 \sim 500 mm (metric thread) or 0.0001 inch \sim 9.99 inch (inch thread)
 - Thread Run-Out: thread length, angle speed can be set
- **Acceleration/Deceleration Function**
 - Cutting Feed: Linear pre-acceleration/deceleration
 - Rapid Traverse: S-Type
 - Initial Speed: terminal speed and time acceleration/deceleration are set by the parameters
- **Spindle Function**
 - 3-channel spindle control in each path, 4-spindles, multi-spindle control
 - Spindle Speed: spindle speed specific by S or PLC signal range 0 rpm \sim 20000 rpm
 - Spindle Override: 50% \sim 120% 8-level real-time tuning
 - Spindle constant surface control
 - Rigid tapping

- **Tool Function**
 - Tool length compensation (tool offset): 99 groups
 - Tool Wear Compensation: 99 groups of tool wear compensation data
 - Tool Nose Radius Compensation: C-Type
 - Tool Setting Mode: fixed point tool setting, trial cutting tool setting, reference position return tool setting
- **Precision Compensation**
 - Backlash Compensation: compensation range (-9999 ~ 9999) x check unit
 - Memory Pitch Error Compensation: 1024 compensation points, compensation point number of each is set by parameter, each point compensation range (-700 ~ 700) X check unit
- **PLC Function**
 - 13 Basic Commands, 50 functional commands
 - PLC ladder on-line edit, real-time monitoring
 - 2-level PLC program up to 12000 steps the first level program refresh period 8 ms
 - PLC Programs (up to 16) the current running PLC program can be selected
- **I/O Unit**
 - Rapid I/O: 16 input/ 8 output
 - Operation Panel I/O: 118 input/ 96 output interface
 - Up to 4 GSKLink remote I/O Interfaces: each i/o has 72 input interfaces and 48 output
- **Human-Computer Interface**
 - Display in English, Spanish, Russian and Chinese
 - Two-dimensional tool path and solid graphic display
 - Servo State Monitoring
 - Servo parameter on-line allocation
 - Real-time Clock
 - On-line help
- **Operation Management**
 - Operation Mode: Auto, Manual, Edit, MDI, DNC, MPG and reference position return
 - Multi-level operation authorization management
 - Alarm log
 - Timed stop
- **Program Edit**
 - Program Capacity: 25M, 10000 programs (including subprogram and macro program)
 - Edit Mode: full screen edit part program edit on the background
 - Edit Function: searching, modifying and deleting programs/blocks/words, coping and deleting blocks
 - Program Format: ISO code (A set of G code, B system of G code) word without blank space, relative coordinates, absolute coordinate compound programming
 - Program Call: macro program call with parameters, 12-level subprogram nesting
 - Aided Programming: common used cycle commands using graphic aided programming
 - Grammar Check: executing the rapid grammar check for the program (do not run the program) after it has been edited
 - Path Preview: do not run programs, use the path preview function to check the program path

- **Communication Functions**
 - USB: U disc file operations, U disc file directly machining, upgrading PLC program and system software u disc
 - LAN: remote monitoring, network DNC machining, file transmission remotely upgrading PLC program, and system software, CAD/CAM
- **Safety Functions**
 - Emergency stop
 - Hardware travel limit
 - Many storage travel checks
 - Data backup and recover

LS-200 Twelve-Station Static Tool Turret:

For the **SL-15** and the **DSTT-40** lathe model we are offering static tooling turret with optional tool disk that includes the choice of VDI-40. CNC New 12-Station Turret inside mechanism employs parallel cam, featuring high indexing accuracy and fast tool change. Turret rotation is driven by hydraulic motor for high torque output and maximum stability. Turret clamping/ unclamping is operated through hydraulic power, assuring smooth motion and permitting for heavy duty machining. Boring tool capacity 32, 40 mm, O.D. facing tools 20, 25 mm and Facing tools 20, 25 mm. The turret has random tool selection function. Other turret options available on request.

LS-200	1	Hydraulic Turret LS-200 with selection of VDI-40
Center Height	MM	100
Number of tools	N	8T/10T/12T
Rotating Time (tool-to-tool)	Sec	0.6
Rotating Time (including locking)	Sec	0.7
Indexing Time	Sec	Total Indexing time for indexing 180° 8T 1.4 sec, 10T 1.7 sec, 12T 2 sec
Indexing Time	Sec	Total indexing time for indexing 180° (including locking) 8T 1.5 sec, 10T 1.8 sec, 12T 2.1 sec
Curvic coupling type		24180
Oil hydraulic motor type		WP100
Solenoid operated value		AC 110V DC 24V
Clamping force	Kg	Hydraulic working pressure (35-40) 35
Flow rate		L/min. 30
Thrusting force of hyd. Cyl	Kgf	3,800
Accuracy of repeatability	SEC	±0.003
Net Weight (without tool disk)	Kg	106

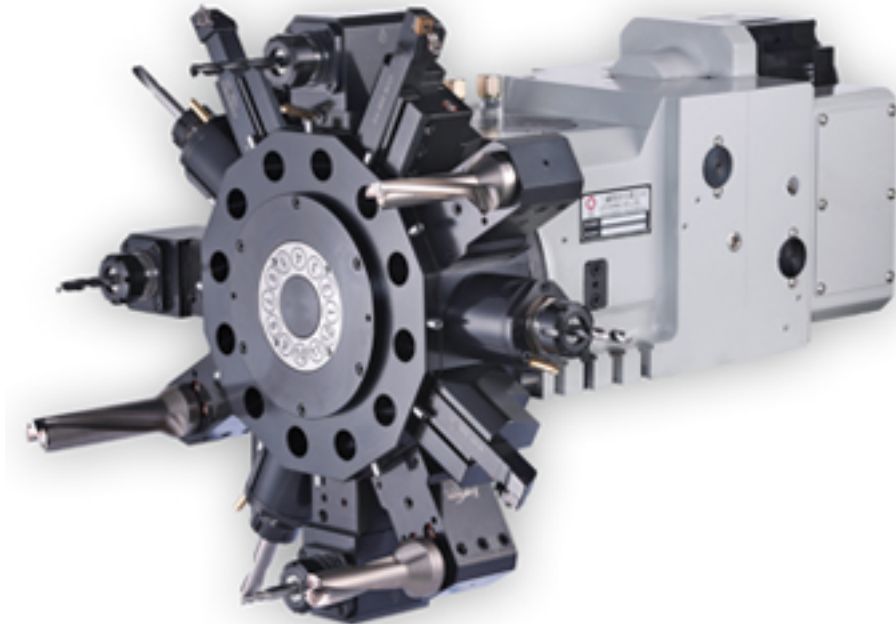


Billing Address: P.O. Box 4721, San Clemente CA 92674
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LS-200DTR 12-Station Power Tool Turret:

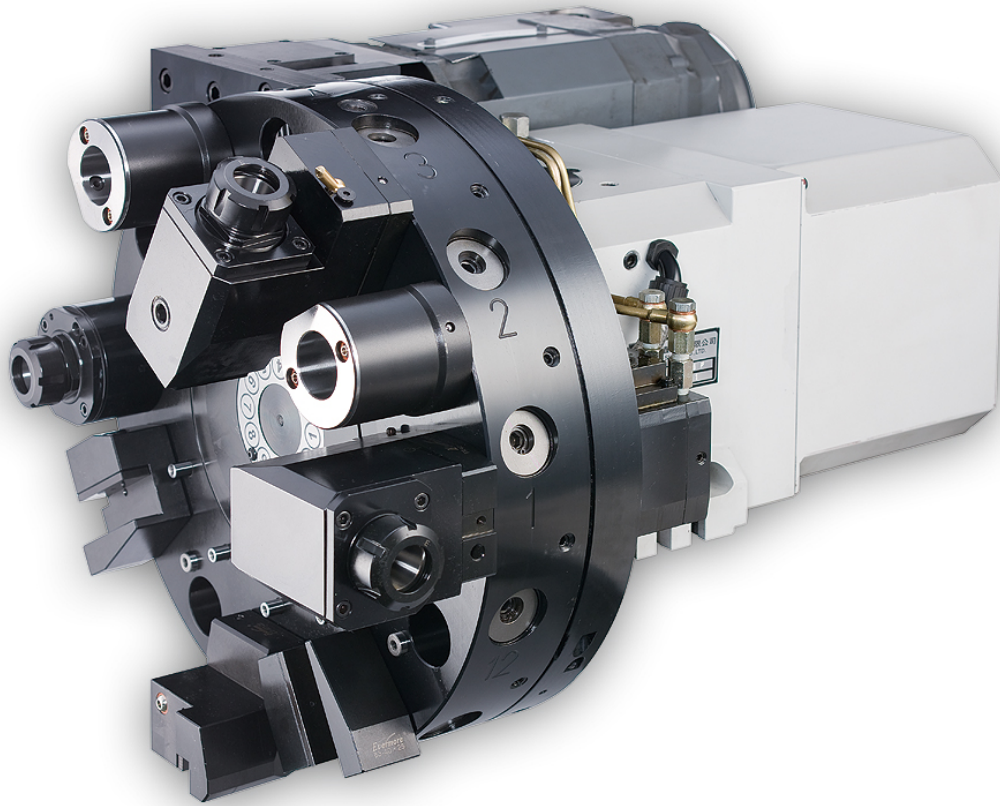
The SL-15 and DSPTT-40 Dual Spindle Twin turret turning centers have a LS-200DTR 12-Station Servo Turret manufactured by Lio Shing one of the largest manufactures of turrets in Taiwan with a gear ratio of 1-1, Hydraulic power source: P=40 kg/CM², and clamping force of 4,240. Design includes three-piece type curvic clutch ensures high precision accuracy. Tool holders are driven by a servomotor that features high torque output and with low noise. Repeatability accuracy reaches 0.003 mm. 4,000 maximum high speed. Inside mechanism employs parallel cam, featuring high indexing accuracy and fast tool change. Turret clamping/ unclamping is operated through hydraulic power, assuring smooth motion and permitting for heavy duty machining. The turret can be mounted at right or left side with random tool selection function. Tool Shank Specifications: VDI40, DIN5480 W20 X 0.8/, BMT65-ER32

LS-200DTR	1	Turret rotation and indexing is driven by servomotor, drive live tools powered servomotors that feature high torque output and low noise. Hydraulic cylinder clamping force of 4,240 kg.
Rotation		Servo Motor
Center Height	MM	100
Number of Tools	N	12-Station
Rotating Time (tool-to-tool)	Sec	0.47 Seconds
Rotating Tool (including locking)	Sec	0.57 Seconds
Total Indexing Time	Sec	180 Degrees 1.4 Seconds
Total Indexing Time	Sec	180 Degrees including locking 1.5 Seconds
Curvic Coupling Type		3-Piece Design
Gear Speed Ratio		Gear Ratio 1-1
Turret Servo Motor		Options, GSK, Fanuc, Mitsubishi
Hydraulic Working Pressure	Kg	40 kgf/cm
Flow Rate		L/min. 30
Thrusting Force of Hydraulic Cylinder	Kgf	4,240
Accuracy of Repeatability	SEC	±0.003 mm
Net Weight (No Motor)	Kg	245 kg



SL-15 & DSTT-40 LS-200SP Power Tool Turret:

This turret offered on the SL-15 Turret Lathe with a tailstock and the DSTT-40 Dual Spindle Twin Turret Power Tool Turret models. Includes 12-Station Powered Tool Turret where rotation and indexing are driven by a servomotor. Tool holders are driven by a spindle motor that features high torque output and with low noise. Repeatability accuracy reaches 0.003 mm. 4,000 maximum high speed. Inside mechanism employs parallel cam, featuring high indexing accuracy and fast tool change. Turret clamping/ unclamping is operated through hydraulic power, assuring smooth motion and permitting for heavy duty machining. The turret can be mounted at right or left side with random tool selection function. Tool shank specifications: VDI40, DIN5480 W20 X 0.8/ BMT65-ER32



Work Holding Options A2-5 Spindle Mount

We offer a wide range of standard work holding option on the A2-5 Spindle nose of the GT-10. The standard mount would facilitate a wide range of manufactures for different work holding options. Our standard work holding options come from ATS Systems located in Orange County California. They offer a wide range of collet chucks that include Dead length, or True Length collet chucks in addition to Warner & Swasey Style Chucks S style collet chucks. The standard work options from ATS listed below.

Auto Strong 3-Jaw Chuck Options:

329-6300	1	Auto Strong N-206 6" 3-Jaw hydraulic chuck includes drawtube and mounting for A2-5 spindle. Includes 3-value hydraulic station.	1,440.00
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ATS Work Holding: Pull Back Design Collet Chucks:

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 1st 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. Superior tool clearance with reduced body diameters.

320-1020	1	ATS A2-5 5C Tapered Nose 3.5" Length	1,200.00
320-1025	1	ATS A2-5 5C Threaded Nose 3.5" Length	1,290.00
320-1030	1	ATS A2-5 5C Threaded Nose 5" Length	1,290.00
320-1035	1	ATS A2-5 5C Tapered Nose 5" Length	1,190.00
320-1055	1	ATS A2-5 16C Tapered Nose 6.25" Length	1,390.00
320-1060	1	ATS A2-5 16C Collet Chuck Step Chuck Capability	2,510.00
320-102J	1	ATS A2-5 2J Collet Chuck 5" Length	1,390.00
320-103J	1	ATS A2-5 3J Collet Chuck 5.75" Length	1,390.00
320-1022J	1	ATS A2-5 22J Collet Chuck 6" Length	2,190.00
320-1086	1	ATS A2-5 Warner Swasey Pull Back Style S15 utilizes #3 W & S collet pads	2,990.00
320-1088	1	ATS A2-5 Warner Swasey Pull Back Style S20 utilizes W & S #4 collet pads	4,310.00
320-1091	1	ATS A2-5 Pull Back Collet Chuck S15 (H) Hardinge utilizes standard S15 collet pads	2,990.00
320-1093	1	ATS A2-5 Pull Back Collet Chuck S20 (H) Hardinge utilizes standard S20 collet pads	3,620.00

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.

320-2015	1	ATS A2-5 5C True Length Collet Chuck for GT-10 models. Includes dead length collet chuck, adapter and drawtube	3,790.00
320-2030	1	ATS A2-5 16C Small Body True Length Collet Chuck for GT-10 models. Includes dead length collet chuck, adapter and drawtube.	4,190.00
320-2035	1	ATS A2-5 2J True Length Collet Chuck for GT-10 models. Includes dead length collet chuck, adapter and drawtube.	4,430.00

320-2050	1	ATS A2-5 3J True Length Collet Chuck for GT-10 models. Includes dead length collet chuck, adapter and drawtube.	4,390.00
320-2055	1	ATS A2-5 22J True Length Collet Chuck for GT-10 models. Includes dead length collet chuck, adapter and drawtube.	4,490.00
320-2065	1	ATS A2-5 S20 True Length Collet Chuck for GT-10 models. Includes dead length collet chuck, adapter and drawtube.	4,790.00
320-2075	1	ATS A2-5 S26 True Length Collet Chuck for GT-10 models. Includes dead length collet chuck, adapter and drawtube.	5,190.00
320-2085	1	ATS A2-5 S30 True Length Collet Chuck for GT-10 models. Includes dead length collet chuck, adapter and drawtube.	5,690.00

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.

320-3005	1	ATS A2-5 Brown & Sharpe Nose Cap True Length #21 Collet Chuck for GT-10 model. Includes dead length collet chuck, adapter and drawtube.	3,950.00
320-3020	1	ATS A2-5 Brown & Sharpe Nose Cap True Length #22 Collet Chuck for GT-10 model. Includes dead length collet chuck, adapter and drawtube.	3,950.00
320-3030	1	ATS A2-5 Nose Cap True Length Index B42 or special S10 master collets Collet Chuck for GT-10 model. Includes dead length collet chuck, adapter and drawtube.	4,430.00
320-3040	1	ATS A2-5 Nose Cap True Length Index B60 or special S16/S20 master collets Collet Chuck for GT-10 model. Includes dead length collet chuck, adapter and drawtube.	5,150.00

ATS Work Holding: Shorty Quick Change True Length:

Innovative patented design providing fixed collet position ensuring linear accuracy. Ideal for 1st and 2nd operation applications and barfeed operations. Utilizes Hardinge Quick-Change Collets, less expensive than American Standard collets. 20-second collet change over. Seals and plugs easily replaced minimizing downtime for maintenance. .0002" T.I.R. guaranteed on closing taper.

320-3050	1	ATS A2-5 Shorty Quick Change True Length Collet Chuck utilizes SQC65 quick-change collets.	3,890.00
320-3060	1	ATS A2-5 Shorty Quick Change True Length Collet Chuck utilizes SQC80 quick-change collets.	Upon Request

ATS Work Holding: Quick Change True Length:

Innovative patented design providing fixed collet position ensuring linear accuracy. Ideal for 1st and 2nd operation applications and barfeed operations. Utilizes HQC42 & HQC65 Collets. .0002" T.I.R. guaranteed on closing taper. Adjustable feature enables you to adjust for T.I.R.

320-3070	1	ATS A2-5 Quick Change True Length Collet Chuck utilizes HQC42 quick-change collets.	4,670.00
320-3080	1	ATS A2-5 Quick Change True Length Collet Chuck utilizes SQC65 quick-change collets.	5,270.00

Work Holding Options A2-6 Spindle Nose Mount

We offer a wide range of standard work holding option on the A2-6 Spindle nose of the GT-15. The standard mount would facilitate a wide range of manufactures for different work holding options. Our standard work holding options come from ATS Systems located in Orange County California. They offer a wide range of collet chucks that include Dead length, or True Length collet chucks in addition to Warner & Swasey Style Chucks S style collet chucks. The standard work options from ATS listed below.

Auto Strong 3-Jaw Chuck Options:

329-8300	1	Auto Strong N-208 8" 3-Jaw hydraulic chuck with drawtube and mounting for A2-6 spindle. Includes 3-value hydraulic station.	1,615.00
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ATS Work Holding: Pull Back Design Collet Chucks:

ATS-S is located in Southern California and offering 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 1st 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. Superior tool clearance with reduced body diameters.

320-1040	1	ATS A2-6 5C Tapered Nose 5" Length	1,290.00
320-1045	1	ATS A2-6 5C Threaded Nose 5" Length	1,390.00
320-1050	1	ATS A2-6 5C Threaded Nose 6" Length	1,390.00
320-1065	1	ATS A2-6 16C Tapered Nose 6.25" Length	1,490.00
320-1070	1	ATS A2-6 16C Collet Chuck Step Chuck Capability	2,990.00
320-1075	1	ATS A2-6 20C Collet Chuck 8" Length	2,990.00
320-1080	1	ATS A2-6 20C Collet Chuck Step Chuck Capability	3,590.00
320-1085	1	ATS A2-6 25C Collet Chuck 8.25" Length	3,710.00
320-112J	1	ATS A2-6 2J Collet Chuck 5.5 Length	1,790.00
320-113J	1	ATS A2-6 3J Collet Chuck 6" Length	1,490.00
320-1122J	1	ATS A2-6 22J Collet Chuck 6.5" Length	2,290.00
320-1087	1	ATS A2-6 Warner Swasey Pull Back Style S15 utilizes #3 W & S collet pads	3,230.00
320-1089	1	ATS A2-6 Warner Swasey Pull Back Style S20 utilizes W & S #4 collet pads	4,430.00
320-1090	1	ATS A2-6 Warner Swasey Pull Back Style S26 utilizes #5 W & S collet pads	4,670.00
320-1092	1	ATS A2-6 Pull Back Collet Chuck S15 (H) Hardinge utilizes standard S15 collet pads	3,110.00
320-1094	1	ATS A2-6 Pull Back Collet Chuck S20 (HS) Hardinge short utilizes standard S20 collet pads	3,730.00
320-1095	1	ATS A2-6 Pull Back Collet Chuck S20 (H) Hardinge utilizes standard S20 collet pads	3,390.00
320-1096	1	ATS A2-6 Pull Back Collet Chuck S22 (H) Hardinge utilizes standard S22 collet pads	4,310.00
320-1097	1	ATS A2-6 Pull Back Collet Chuck S26 (H) Hardinge utilizes standard S26 collet pads	3,690.00
320-1098	1	ATS A2-6 Pull Back Collet Chuck S30 (H) Hardinge utilizes standard S30 collet pads	4,090.00

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 angle 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.

320-2020	1	ATC A2-6 5C True Length Collet Chuck for spindle GT-15 models. 5.74" length includes dead length collet chuck, adapter and drawtube.	3,990.00
320-2025	1	ATS A2-6 16C True Length Collet Chuck for GT-15 models. 7.0" Length includes dead length collet chuck, adapter and drawtube.	4,290.00
320-2040	1	ATS A2-6 2J True Length Collet Chuck for GT-15 models. 5.5" Length includes dead length collet chuck, adapter and drawtube.	4,670.00
320-2045	1	ATS A2-6 3J True Length Collet Chuck for GT-15 models. Includes dead length collet chuck, adapter and drawtube.	4,390.00
320-2060	1	ATS A2-6 22J True Length Collet Chuck for GT-15 models. Includes dead length collet chuck, adapter and drawtube.	4,590.00
320-2070	1	ATS A2-6 S20 True Length Collet Chuck for GT-15 models. Includes dead length collet chuck, adapter and drawtube.	5,090.00
320-2080	1	ATS A2-6 S26 True Length Collet Chuck for GT-15 models. Includes dead length collet chuck, adapter and drawtube.	5,690.00
320-2090	1	ATS A2-6 S30 True Length Collet Chuck for GT-15 models. Includes dead length collet chuck, adapter and drawtube.	5,690.00
320-2095	1	ATS A2-6 S35 True Length Collet Chuck for GT-15 models. Includes dead length collet chuck, adapter and drawtube.	7,790.00

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.

320-3010	1	ATS A2-6 Brown & Sharpe Nose Cap True	4,070.00
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		Length #21 Collet Chuck for GT-15 model. Includes dead length collet chuck, adapter and drawtube.	
320-3025	1	ATS A2-6 Brown & Sharpe Nose Cap True Length #22 Collet Chuck for GT-15 model. Includes dead length collet chuck, adapter and drawtube	4,070.00
320-3035	1	ATS A2-6 Nose Cap True Length Index B42 or special S10 master collets Collet Chuck for GT-15 model. Includes dead length collet chuck, adapter and drawtube.	4,550.00
320-3042	1	ATS A2-6 Nose Cap True Length Index B60 or special S16/S20 master collets Collet Chuck for GT-15 model. Includes dead length collet chuck, adapter and drawtube.	4,390.00
320-3045	1	ATS A2-6 Nose Cap True Length DIN 90 collets or special S26 master collets Collet Chuck for GT-15 model. Includes dead length collet chuck, adapter and drawtube	7,070.00

ATS Work Holding: Shorty Quick Change True Length:

Innovative patented design providing fixed collet position ensuring linear accuracy. Ideal for 1st and 2nd operation applications and barfeed operations. Utilizes Hardinge Quick-Change Collets, less expensive than American Standard collets. 20-second collet change over. Seals and plugs easily replaced minimizing downtime for maintenance. .0002" T.I.R. guaranteed on closing taper.

320-3055	1	ATS A2-6 Shorty Quick Change True Length Collet Chuck utilizes SQC65 quick-change collets.	3,890.00
320-3065	1	ATS A2-6 Shorty Quick Change True Length Collet Chuck utilizes SQC80 quick-change collets.	4,490.00

ATS Work Holding: Quick Change True Length:

Innovative patented design providing fixed collet position ensuring linear accuracy. Ideal for 1st and 2nd operation applications and barfeed operations. Utilizes HQC42 & HQC65 Collets. .0002" T.I.R. guaranteed on closing taper. Adjustable feature enables you to adjust for T.I.R.

320-3075	1	ATS A2-6 Quick Change True Length Collet Chuck utilizes SQC42 quick-change collets.	4,790.00
320-3085	1	ATS A2-6 Quick Change True Length Collet Chuck utilizes SQC65 quick-change collets.	5,390.00

Single Bar Hydrodynamic Feeds:

CNC New 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 barfeed is safe, quiet and provides quick-change overs. This bar feeder can handle material 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 changeover. 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 a 8mm range of material. Example is the 18mm feed tube could work with material down to 10mm diameter. These are approximate estimations and will be impacted by type of material and straightness of the bars. CNC Hydrodynamic 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 quiet & 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, and 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 42 mm 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



Magazine Type Pneumatic Bar Feed Systems:

832-65MP	1	Bar Feed System 65MP is a pneumatic driven bar feed for fixed headstock machines with the range of sizes .05~.065 mm, .2~2.5" diameters, and 1200 mm lengths, 47" maximum lengths. High stability, high efficiency and low noise unit. Applicable for high-speed lathes. High feeding accuracy. Turret colliding prevention function. Operates with touch screen.	\$8,995.00
830-65LP	1	Bar Feed System 65LP is a pneumatic driven bar feed for fixed headstock machines with the range of sizes .05~.065 mm, .2~2.5" diameters, and 1500 mm lengths, 59" maximum lengths. High stability, high efficiency and low noise unit. Applicable for high-speed lathes. High feeding accuracy. Turret colliding prevention function. Operates with touch screen.	\$9,995.00

Magazine Type Servo Controlled Bar Feed Systems:

832-65MS	1	Bar Feed 65MS is a servo driven bar feed for fixed headstock machines with the range of sizes .05~.065 mm, .2~2.5" diameters, and 1200 mm lengths, 47" maximum lengths. High stability, high efficiency and low noise unit. Applicable for high-speed lathes. High feeding accuracy. Turret colliding prevention function. Operates with touch screen.	\$9,995.00
830-65LS	1	Bar Feed 65MS is a servo driven bar feed for fixed headstock machines with the range of sizes .05~.065 mm, .2~2.5" diameters, and 1200 mm lengths, 47" maximum lengths. High stability, high efficiency and low noise unit. Applicable for high-speed lathes. High feeding accuracy. Turret colliding prevention function. Operates with touch screen	\$10,495.00
832-80LS	1	Bar Feed 80LS is a servo driven bar feed for fixed headstock machines with the range of sizes .06~.080 mm, .3~3" diameters, and 1500 mm lengths, 59" maximum lengths. High stability, high efficiency and low noise unit. Applicable for high-speed lathes.	\$17,995.00



Magazine Type Hydrodynamic Bar Feeds:

832-B326	1	Bar Feed B326 is a servo driven bar feed for both sliding headstock and fixed headstock machines with the range of sizes .03~ .026 mm, .3~1" diameters, and feed lengths 1000~3200 mm lengths, 39" to 12.5' maximum lengths. High stability, high efficiency and low noise unit. This unit is a one-piece fabricated machine body, which features maximum durability and stability. The system allows for quick and convenient replacement of bar channels. Roller type anti-vibration can be adjusted according to bar sizes. Magazine capacity 010 (22) Pieces	\$13,995.00
830-B432	1	Bar Feed B432 is a servo driven bar feed for both sliding headstock and fixed headstock machines with the range of sizes .04~. 032 mm, .04~1-3/8" diameters, and feed lengths 1000~3200 mm lengths, 39" to 12.5' maximum lengths. High stability, high efficiency and low noise unit. This unit is a one-piece fabricated machine body, which	16,995.00

		features maximum durability and stability. The system allows for quick and convenient replacement of bar channels. Roller type anti-vibration can be adjusted according to bar sizes. Magazine capacity 010 (21) Pieces	
830-B542	1	Bar Feed B542 is a servo driven bar feed for both sliding headstock and fixed headstock machines with the range of sizes .05~.042 mm, .5~1-5/8" diameters, and feed lengths 1000~3200 mm lengths, 39" to 12.5' maximum lengths. High stability, high efficiency and low noise unit. This unit is a one-piece fabricated machine body, which features maximum durability and stability. The system allows for quick and convenient replacement of bar channels. Roller type anti-vibration can be adjusted according to bar sizes. Magazine capacity 010 (27) Pieces	19,995.00



Other Machine Options & Considerations:

	1	GSK RB08 6-Axis CNC Machine Loading & Unloading used for applications with CNC machines. Payload maximum of 8 kg or 17.6 pounds weight, 1,389 mm or 54" radius.	24,995.00
	1	ER-20 spindle mounted in the axial or radial direction driven by a 1kw, or 1.5hp motor with rated torque of 3.2Nm servomotor. Included with a matching AC servo driver to realize optimum servo performance. Number of spindles in any direction one, two or three. Price is for one direction static tool only.	4,995.00
	1	The Y-Axis Module includes two axial and two radial live tool spindles. Programmable Y-Axis Travel 4", Heavy cutting capability including the ability to tap with live tool spindles. Spacing of spindles can be adjusted based on the part sizing requirements. Other spindle configurations available upon request.	14,995.00
	1	Finished parts ejector, finish parts catcher, and finished parts conveyor	Upon Request
	1	Parts Catcher System	3,695.00
	1	Chip Conveyor systems installed in the rear or the side of the machine. One slot for each spindle.	3,495.00
	1	Spindle programmable air blast and separate coolant blast to rinse collet seat.	995.00
	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	Caliper Brake System for working with power spindles.	1,795.00
	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", 1", 1-1/16", 1-1/8", 1-3/16", 1-1/4", 1-5/16", 1-3/8	Upon Request
	1	Automatic Tool Presetter, manual and automatic modes. User friendly	3,995.00
	1	Work Gauging Probe	9,750.00

	1	Roller Bearings Linear System for X & Z axis standard linear rails.	4,495.00
	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 nd 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	2,995.00
	1	Enclosure Exhaust System	1,450.00
	1	Internal High-Voltage Isolated Transformer for 380-480V operation	Upon Request
	1	Export Packaging	1,295.00