

# Conventional Horizontal Lathes

## Turnado 280/2000



### SKU : 320560

The machines of the Turnado series are the modern version of the classic lathe. They are characterized by robust construction, a powerful motor and high level of versatility. With the extensive range of standard accessories and options, these machines can be adapted to many production requirements. A modern position indicator is also part of the standard equipment, as is a high-quality quick-change toolholder system. The models in this series have proven themselves many times and have been one of our best-selling conventional lathes for more than 20 years.

- Classic design with sturdy construction
- One-piece heavy cast bed for increased rigidity
- 3-axis position indicator with various turning functions
- Adjustable feed stops for longitudinal feed
- Extensive standard equipment package

## TECHNICAL SPECS

### WORKING AREA

Workpiece length (max.)	1928 mm
Turning-Ø over bed	560 mm
Turning-Ø over support	355 mm
Turning diameter over gap bridge	785 mm
Gap bridge length	170 mm
Bed width	350 mm
Center height	280 mm

### DETAILS

Equipment	with position indicator
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### TRAVELS

Travel X-axis	316 mm
Travel Z1-axis	130 mm
Swing range of top slide	± 52°

### HEADSTOCK

Spindle speeds	(12) 25 - 1.600 1/min
Spindle bore	80 mm
Spindle mount	Camlock D1-8
Spindle taper	7 MT

### FEED

Feed X-axis	0.02 mm/R - 0.573 mm/R
Feed Z-axis	0.059 mm/R - 1.646 mm/R

### THREADING

Threading, metric	0.2 mm - 14 mm
Threading, diametric	(50) 4-112 DP
Threading, module	0.1 mm - 7 mm
Threading, whitworth	(60) 2-112 TPI

### TAILSTOCK

Tailstock quill diameter	75 mm
Tailstock taper	5 MT
Tailstock quill stroke	180 mm
Tailstock traverse adjustment	± 12 mm

### DRIVE CAPACITY

Motor rating main drive	7.5 kW
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### MEASURES AND WEIGHTS

Overall dimensions (length x width x height)	3.34 m x 1.15 m x 1.46 m
Weight	2720 kg



## PRODUCT DETAILS

- The Turnado Series Universal Lathes are widely tested and proven and our definite bestsellers with a low price and lasting high value

### Machine bed

- A heavily ribbed machine bed, rigid headstock and a massive one-piece cast-iron stand form a solid machine base clamping feature for efficient machining
- Removable bridge allows machining of short workpieces with large diameters
- Guideways feature a v-block design and are hardened and ground for lasting precision

### Headstock/ feed gear

- The powerful main motor with stepped gears provides high torque and wide range of spindle speeds
- All gears and shafts are hardened and ground and run in an enclosed oil bath
- The large spindle capacity allows clamping of shafts and tubes with large diameters
- The high quality spindle support features optimum rigidity and preloading for high precision even under high radial and axial loads as well as long lasting performance
- A 3-jaw lathe chuck with hard reversible jaws, a 4-jaw independent chuck, and a face plate with large diameter are included in the machine's standard equipment
- The user-friendly control panel at the headstock facilitates rapid user familiarization and intuitive operation
- The feed gear offers a large number of thread leads for metric and Withworth tapping

### Support

- The support is designed extra-wide and can easily handle high machining forces
- The control lever for the feed switch and apron nut are designed for user safety with automatic safety interlocking
- The stop spindle features four adjustable cams to provide automatic linear feed shut-off
- This way, repetitive machining processes with different Z axis positions can be simplified by presetting the desired positions in the necessary sequence
- The micrometer bed stop can be used to set precise travel distance limits
- The slip coupling for the automatic feed is positioned centrally on the apron for easy adjustments
- The thread gauge and support allow reliable determination of the pitch after an interrupted tapping process, and also simplifies machining of multi-lead threads
- The top slide swivels and has large, easy to read scaling
- The large, swiveling safety cover at the support protects the user and keeps the work space clean
- A central lubrication system at the support supplies all guideways with lubrication and simplifies maintenance

### Tailstock

- The tailstock quill is equipped with a robust and easy to read scale
- The long quill stroke allows for complex drilling and centering jobs
- The tailstock can be adjusted laterally for machining of conical shafts

### Accessories

- The standard brake pedal is not only practical, but also a safety feature
- A large and sturdy splash guard on the rear of the machine ensures a clean machine environment
- A bright LED light is integrated in the support cover for optimum lighting throughout the work space
- The multi-functional quick-action tool changer system with tool changer cartridge is included in the standard equipment of this series
- A steady and a live rest are a must for long workpieces and also included in the standard package
- The Turnado Lathe is equipped with the latest generation of our position indicators. Ensures high work precision, lower error rate, and increased operator safety
- A coolant system and extensive operating tools complete the equipment package

## CONTROLS & SOFTWARE

### 3-axis position indicator X.Pos 3.2

- Integrating multiple functions, this new generation of 3 axis digital readouts significantly offer a much better control over the machining processes, greatly decreasing down-times and error rates
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- It features a totally sealed enclosure made of high quality polyester film which protects it against hazardous environments in shop floors, such as dust or fumes and offers excellent chemical resistance to most commonly used industry solvents
- The optical scales provide 5 micron resolution (0.005 mm) with outside cover from aluminum for protection against oil, coolant and chips.

#### **Basic Functions**

- Resolution of 0,005 mm
- Spindle control ON/OFF
- Unit measurement conversion Inch / Metric
- Setting / Resetting current position
- Coordinate display switching ABS / INC
- Radius / Diameter display
- Z1/Z2 Axes summing
- Pocket calculator functions

#### **Extended Functions**

- Axis position is maintained when display is turned off
- Hole circle pattern calculation
- Radius / diameter toggle
- Reference function for tool gauging
- Taper turning function

#### **Constant cutting speed**

- Allows you to have constant cutting speed during - the spindle speed automatically adjusts based on the turning diameter

### **STANDARD EQUIPMENT**

3-axis position indicator X.Pos 3.2  
 Quick tool changer head WC  
 Quick change tool holder WCD 32150  
 Adjustable feed stops  
 3-jaw chuck Ø 315 mm  
 4-jaw face chuck Ø 350 mm  
 Face plate Ø 450 mm  
 Follow and steady rests  
 Coolant system  
 Micrometer longitudinal stop  
 Thread gauge  
 Reducing sleeve  
 Dead center  
 Protective shield for the toolpost  
 Chuck guard  
 Foot brake pedal  
 Fixed splash guard (wall)  
 Work light  
 Toolbox with operating tools  
 Operator instructions



## KNUTH on YouTube

### Information to the point

On our YouTube channel you can find videos for nearly all machines from our program. We show the machines from current deliveries and you get an impression of the handling, the processing quality and the machining performance.

**Are you interested in a machine for which you cannot find a current video?  
Please feel free to contact us!**