

1.2. TECHNICAL DATA

Units	TPK90 TPK80A	TPK90 TPK90A
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Swing

Over bed	mm	800	930
Over the saddle	mm	530	630
In the bridge-gap	mm	1080	1200

Distance

Between centres	mm	2000-14000
In the bridge-gap, from the spindle front face	mm	430
Upper-slide travel	mm	300

Spindle

Hole diameter	mm	95
Diameter in the front bearing	mm	140
Spindle nose-according to Polish standard PN/M-55052 being in compliance with DIN-55022	size	C11
Front-end taper socket	metre	105
Maximum torque	Nm	8500

Spindle speed

For two-speed motor of TPK80/90 lathe

- speed steps	number	21
- standard range	rpm	3 to 800
- optional range /only for 50cps/	rpm	6,3 to 630

For single-speed motor of TPK80/90A lathe

- speed steps	number	18
- range	rpm	16 to 800
Exponent of progression	value	1,25

Main drive

Two-speed motor /for TPK80/90 only/

- power output	kW	15/22
- motor speeds	number	2

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Unit	TPK80 TPK80A	TPK90 TPK90A
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Motor /for TPK80/90A only/

- power output	kW	22
- motor speeds	number	1

Feeds

Feed settings

- standard /1:1/	number	80
- optional, combined /1:2/and/2:1/	number	120

Range of longitudinal feed values

- standard /1:1/	mm per rev.	0,1 to 12,8
- optional, combined /1:1/and/2:1/	mm per rev.	0,05 to 25,6

Range of cross feed values

- standard /1:1/	mm per rev.	0,05 to 6,4
- optional, combined /1:1/and/2:1/	mm per rev.	0,025 to 12,8

Threads

Standard version

- 62 metric thread pitches	mm	1 to 120
- 42 module thread pitches	mm	0,25 to 30
- 51 British standard thread pitches		
in accordance with ISO	threads per inch	1/4 to 30

Optional version/for British units

readout only/

- 61 diametral pitch values	DP	1/2 to 60
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Feed screw pitch

- standard	mm	12
- optional	inch	1/2

Skin feed

Longitudinal:

- at 50 cps	mm per minute	4000
- at 60 cps	mm per minute	4800

Cross-feed:

- at 50 cps	mm per minute	2000
- at 60 cps	mm per minute	2400

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10

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	Unit	TPK80 TJK80A	TPK90 TJK90A
<u>Saddle</u>			
Slide length	mm		860
Cross ways width	mm		255
Maximum longitudinal force of the slide	kN		25
Distance of tool rest socket:			
- from centres axis-downwards	mm		40
- from centres axis-upwards	mm		30
Output of liquid cooling system, liters per minute			40
<u>Taper turned by combined feeds method</u>			
Maximum length of a taper	mm		1200
- Maximum taper	size		1:12
Maximum length of a taper	mm		300
- Maximum taper	size		1:1
<u>Tailstock</u>			
Crosswise displacement	mm		± 15
Tailstock spindle sleeve			
- diameter	mm		130
- travel	mm		300
- Morse taper socket	NO.		6
<u>Workpiece weight</u>			
Clamped in centres	kg		6000
- turned with the use of a single rest	kg		7500
- turned with use of two rests	kg		9000
Clamped in chuck	kg		800
<u>Lathe weight</u>			
For 2000 mm centre distance	kg	5500	5600
Weight increment for 1m of centre distance	kg		600
<u>Overall lathe dimensions</u>			
Length = centre distance + work-	mm		2500
Height	mm	1370	1435
Width	mm		1750

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	Unit	TPK80 TK80A	TPK90 TK90A
Bed width at the slide-ways	mm		585
<u>Tailstock boring attachment /optional equipment/</u>			
Tailstock spindle sleeve:			
- diameter	mm		130
- Morse taper socket	NO		6
Working feeds	number		27
- range	mm per minute		1,2 to 109
- motor power output	kW		1,1
Skip feed			
- at 50 cps	mm per minute		900
- at 60 cps	mm per minute		1080
Boring depth			
- for 2m centre distance	mm		750
- for 3m and above centre distance	mm		1000
Maximum axial force	kN		15
<u>Tracer attachment /optional equipment/</u>			
Taper length	mm		780
Taper	degrees		± 10
<u>3-jaw self-centering chuck /optional equipment/</u>			
Size 400			
- external diameter	mm		400
- range of externally clamped workpiece diameters	mm		40 to 350
- range of internally clamped workpiece diameters	mm		100 to 400
permissible speed	rpm		1000
Size 500			
- external diameter	mm		500
- range of externally clamped workpiece diameters	mm		40 to 450
- range of internally clamped workpiece diameters	mm		100 to 500
- permissible speed	rpm		800

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