

# **CYCLEMATIC**

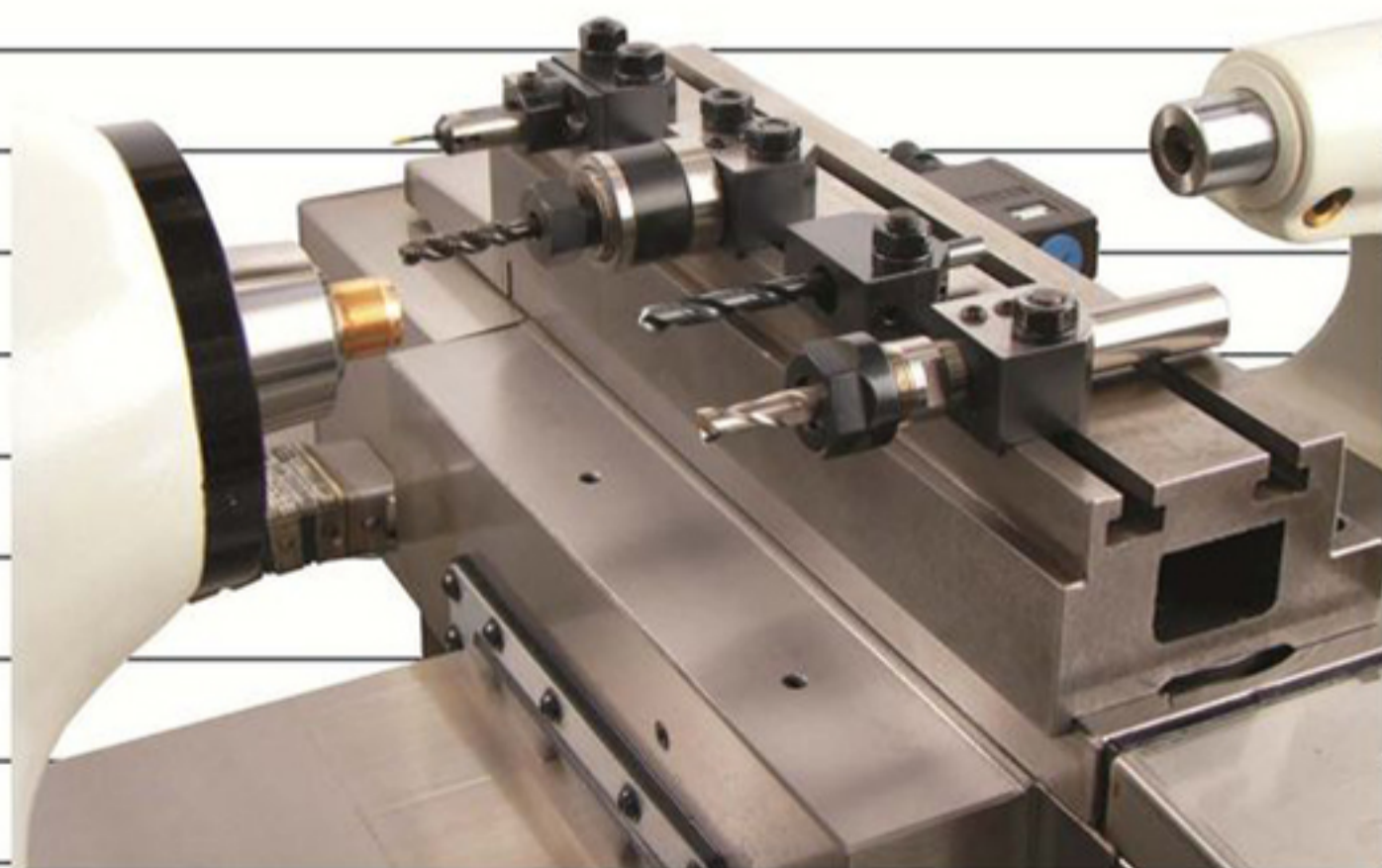
**SPINDLE TOOLING  
TOOLING, HOLDER AND  
OPTIONAL EQUIPMENT FOR  
CYCLEMATIC HIGH SPEED  
HIGH ACCURACY**

## **TOOLROOM LATHES:**

**CT-1118CNC,CT-606CNC,CP-27CNC**

**CTL-618e,CTL-618EVS,CHR-68e**

**CTL-27EVS,CTS-27EVS,CP-27EVS**



# SPINDLE TOOLING

 <p><b>STEP CHUCK CLOSER</b></p> <p><b>STEP CHUCK</b></p>	<p><b>1-1 STEP CHUCKS AND CLOSERS</b></p> <p><b>STEP CHUCKS AND CLOSERS</b> are carried in stock in 50.8mm, 76.2mm, 101.6mm, 127mm and 162mm rated sizes. All step chucks are supplied with pin holes and pins in place for precision machining.</p> <p><b>STEP CHUCKS</b> are exceptionally useful for accurately holding work up to 162mm in diameter. Castings, moldings, stampings and machined parts are held rigidly and accurately. Tubing can be held without crushing or distorting.</p> <p><b>CHUCK CLOSERS</b> fit directly to the machine spindle. A taper corresponding to that on the periphery of the step chuck places the closing pressure over the stepped area of the chuck, resulting in greater gripping power and accuracy.</p> <p>For: CT-1118CNC      CTL-618EVS, CTL-618e          CHR-68EVS, CHR-68e          CTS-27EVS, CTL-27EVS          CP-27EVS</p> <p style="text-align: right;"><b>1-1</b></p>
	<p><b>1-2 REGULAR DEPTH CAPACITY</b></p> <p><b>STEP CHUCKS</b> are 10mm larger in diameter than the rated size so the full capacity may be readily applied to a depth of 12mm.</p> <p>Tool No: T-CT-02, T-CT-03, T-CT-04,          T-CT-05, T-CT-06</p> <p><b>STEP CHUCK CLOSERS</b> are required for each rated size. A=Threaded B=Taper</p> <p>When ordering specify for taper or threaded nose spindle.</p> <p>Tool No: T-202-2B, T-202-3B, T-202-4B,          T-202-5B, T-202-6B</p> <p style="text-align: right;"><b>1-2</b></p>
	<p><b>1-3 EXTRA DEPTH CAPACITY</b></p> <p><b>EXTRA DEPTH STEP CHUCKS</b> are 10mm larger in diameter than the rated size so the full capacity may be readily applied to a depth of 32mm.</p> <p>Tool No: T-DCT-02, T-DCT-03, T-DCT-04,          T-DCT-05, T-DCT-06</p> <p><b>EXTRA DEPTH STEP CHUCK CLOSERS</b> are required for each rated size. A=Threaded B=taper</p> <p>When ordering specify for taper or threaded nose spindle.</p> <p>Tool No: T-203-2B, T-203-3B, T-203-4B,          T-203-5B, T-203-6B</p> <p style="text-align: right;"><b>1-3</b></p>



## 2-1 Threaded Positive Stops

The 5C solid, ejector, and long stops are threaded into and positively shoulder locked in the 5C collet. (Standard 5C collets have internal threads for threaded stops.) All stops are adjustable for the desired part length to the maximum depths listed below.

### Solid Stop-

For chucking parts to a depth of 80mm from the collet face.

Tool No: **T-SS1**



### Ejector Stop-

For chucking parts to a depth of 130mm from the collet face.

Tool No: **T-ES-1**



### Long Stop-

For chucking parts to a depth of 190mm from the collet face. For work to and including 22mm round, 19mm hex and 15mm square.

Tool No: **T-LS-1**

For: **CT-1118CNC**

**CTL-618EVS  
CTL-618e  
CHR-68EVS  
CHR-68e  
CTS-27EVS  
CTL-27EVS  
CP-27EVS**

**2-1**



## 2-2 Universal Collet Stop

This stop converts 5C collets into solid stop or spring ejector stop collets, without alteration of the standard collets. The application of this stop to the collet requires no machining, in other words, all collets up to and including 25.4mm capacity can be used in the regular manner or as solid stop collets or as spring ejector stop collets.

Tool No: **T-UCS-25**

For: **CT-1118CNC**

**CTL-618EVS  
CTL-618e  
CHR-68EVS  
CHR-68e  
CTS-27EVS  
CTL-27EVS  
CP-27EVS**

**2-2**



### 3-1 Plug Chuck

The collet shank section of the plug chuck is finished for direct application to your machine spindle, the nose section is 37mm in diameter and 44mm long. It can be machined in place for the greatest degree of accuracy to suit your particular requirements for special arbors.

Tool No: T-CT-01

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e  
CTS-27EVS, CTL-27EVS  
CP-27EVS

3-1



### 3-2 5C Collet Fixture Plates

5C collet fixture plates fit directly in CYCLEMATIC Lathe spindles. They can be machined for mounting of parts. Flange is 25.4mm thick and there are two diameters available, 85.7mm and 111mm.

Tool No: T-304A (85.7mm)  
T-304B (111mm)

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e  
CTS-27EVS, CTL-27EVS  
CP-27EVS

3-2



### 3-3 Fixture Plates

The Fixture plates are machined all over for direct application to the headstock spindle. Three sizes are available: 76mm, 127mm and 225.4mm diameter. The flange section is 19mm thick. The center hole is 11mm in diameter. These plates can be machined to become a fixture or for mounting fixtures to hold work or for mounting special purpose chucks. (Specify for taper nose spindle) When ordering, specify whether for taper or threaded nose spindle. A=Threaded, B=Taper

Tool No: T-FP-3B, T-FP-5B, T-FP-8B

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e  
CTS-27EVS, CTL-27EVS  
CP-27EVS

3-3



### 3-4 Face Plates

177.8mm diameter face plates are used for holding irregular shaped pieces. Holes are drilled and tapped to permit the use of standard 5/16"-18bolts.

(Specify for taper nose spindle) When ordering, specify whether for taper or threaded nose spindle.

A=Threaded, B=Taper

Tool No: T-FP-07B

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e  
CTS-27EVS, CTL-27EVS  
CP-27EVS

3-4



#### 4-1 Fixture Plates

The Fixture plate is machined all over for direct application to the headstock spindle. This plate can be machined to become a fixture or for mounting fixtures to hold work. The fixture plate is available in 76mm, 127mm or 177.8mm diameter, 19mm thick. The center hold is 54mm in diameter. When ordering, specify whether for taper or threaded nose spindle.

Tool No: T-317 (Taper)

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e  
CTS-27EVS, CTL-27EVS  
CP-27EVS

4-1



#### 4-1-1 Chuck

This Chuck should be use with fixture plate. The chuck size has 3", 4", 5" and 6".

Tool No: 3 jaw or 4 jaw

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e  
CTS-27EVS, CTL-27EVS  
CP-27EVS

4-1-1



#### 4-2 Angle Plate

The Angle plate fastens directly to the T-slot of the face plate and is used to support work at right angle to the face plate. Work clamping surface is 38mm×76mm.

Tool No: T-AP-07

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e  
CTS-27EVS, CTL-27EVS  
CP-27EVS

4-2



#### 4-3 5C Headstock center

The Headstock center is required when work is to be held between centers. This center requires LT-01-108S or LT-01-108C drive plate to drive work.

Tool No: LT-01-109

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CTL-27EVS

4-3



#### 4-4 Drive Plate

The Drive plate mounts on the spindle nose and is used in conjunction with the driving dog to drive work between centers. When ordering, specify for taper nose spindle.

Tool No: LT-01-108C

For: CT-1118CNC

CTL-618EVS, CTL-618e  
CTL-27EVS

4-4



### 5-1 Driving Dog

The Driving dog is used in conjunction with the drive plate to drive work between centers.

Tool No: LT-01-110T

For: CT-1118CNC      CTL-618EVS  
 CTL-618e  
 CTL-27EVS

5-1



### 5-2 Chuck Mounting Plate

The Mounting plate is to be machined so it accepts a 3 Jaw chuck. Six holes are provided to mount the chuck. Three adjusting screws in the outer diameter of the mounting plate are used to center the chuck. For taper spindle only.

Tool No: T-315

For: CT-1118CNC      CTL-618EVS, CTL-618e  
 CHR-68EVS, CHR-68e  
 CTS-27EVS, CTL-27EVS  
 CP-27EVS

5-2



### 5-2-1 Fine turning chuck

The Fine turning chuck has more accuracy than normal chuck. It can be fixed the accuracy any time. The Fine turning chuck should use with chuck mounting plate. It only has 6" type of chuck.

Tool No: KM-6

For: CT-1118CNC      CTL-618EVS, CTL-618e  
 CHR-68EVS, CHR-68e  
 CTS-27EVS, CTL-27EVS  
 CP-27EVS

5-2-1



### 5-3 Expanding Collet and Pads

The 5C Super-Precision Master Expanding Collet is a valuable aid for close-tolerance machining. There is no lateral movement of the Expanding Collet or Pads. The shoulder face on the machineable pads locates the work for dead length control for facing repetitive parts to the same length. No spindle nose cap is required. Collet threads are separate from collet body to operate an expander. The master collet is hardened and ground. The pads are soft for turning in the machine spindle for exacting concentricity. Depending on job application, pads may be machined for internal gripping from 6.35mm to 76mm I.D.

Tool No: S-5C

For: CT-1118CNC      CTL-618EVS, CTL-618e  
 CHR-68EVS, CHR-68e  
 CTS-27EVS, CTL-27EVS  
 CP-27EVS

5-3



### 5-4 Hydraulic Chuck (4")

Hydraulic chuck which has more power to hold the material.

**Tool No: TF-3B-4**

For: CT-1118CNC

5-4



### 5-5 Pneumatic Chuck

Max Pressure 7kg/cm<sup>2</sup>  
 Max Speed 2000rpm.  
 Gripping Range  $\varphi$  1~26mm  
 Dia of hollow  $\varphi$  26mm

**Tool No: CA5-25**

For: CT-1118CNC

5-5



### 5-6 Precision diaphragm Chuck

Gripping force is easy adjustment. Repeatability (T.I.R) 5  $\mu$ m.  
 Max Speed 3200rpm.

**Tool No: PA6-100**

For: CT-1118CNC

5-6



### 5-7 Soft Jaws

Which can use to Fine turning chuck. After put on chuck, can be turning or facing the soft jaws





**Tool No: T-3SJ**

For: CT-1118CNC

CTL-618EVS  
 CTL-618e  
 CHR-68EVS  
 CHR-68e  
 CTS-27EVS  
 CTL-27EVS

5-7

# Tooling Holder

	<p><b>6-1 Single Tool Holder</b>          The Single Tool Holder is mounted directly to the CHR-68 turret. The single tool holder takes one standard 10mm square tool bit. The tool holder body is made of hardened steel.</p> <p>Tool No: <b>TH-01</b></p> <p>For: <b>CT-1118CNC</b>      <b>CHR-68EVS</b>             <b>CHR-68e</b></p> <p style="text-align: right;"><b>6-1</b></p>
	<p><b>6-2 Double Tool Holder</b>          The Double Tool Holder is mounted directly to the CHR-68 turret. The double tool holder takes two standard 10mm square tool bits. The tool holder body is made of hardened steel.</p> <p>Tool No: <b>TH-02</b></p> <p>For: <b>CT-1118CNC</b>      <b>CHR-68EVS</b>             <b>CHR-68e</b></p> <p style="text-align: right;"><b>6-2</b></p>
	<p><b>6-3 Triple Tool Holder</b>          The triple tool holder fits directly to the turret and is used to hold three standard 10mm square tool bits or for spacing two tools. The tool holder body is made of hardened steel.</p> <p>Tool No: <b>TH-03</b></p> <p>For: <b>CT-1118CNC</b>      <b>CHR-68EVS</b>             <b>CHR-68e</b></p> <p style="text-align: right;"><b>6-3</b></p>
	<p><b>6-4 Boring Tool Holder</b>          The boring tool holder is for direct application to the eight station turret. It is used for holding 20mm diameter boring bars, turning tools or split bushings. The body of the boring tool holder is made of hardened steel. Specify 12mm or 3/8" or 1/2" tool slide center height when ordering.</p> <p>Tool No: <b>TH-04R</b>      <b>TH-04L</b></p> <p>For: <b>CT-1118CNC</b>      <b>CHR-68EVS</b>             <b>CHR-68e</b></p> <p style="text-align: right;"><b>6-4</b></p>



	<p><b>7-1 Boring Tool Holder</b> The hardened steel holders mount directly to eight station turret. Boring tools align to center line height of 90° degree slot. Specify 12mm or 3/8" or 1/2" tool slide center height when ordering.</p> <p>Tool No: <b>TH-04A</b></p> <p>For: <b>CT-1118CNC,</b>                      <b>CHR-68EVS</b>   <b>CHR-68e</b></p> <p style="text-align: right;"><b>7-1</b></p>
	<p><b>7-2 Drill and Shank Tool Holders</b> The hardened steel holders mount directly to eight station turret. They are used for holding drills directly or with split bushings, or for holding any of the 16mm round shank turret tooling. Specify 12mm or 3/8" or 1/2" tool slide center height when ordering.</p> <p>Tool No: <b>TH-05</b></p> <p>For: <b>CT-1118CNC,</b>                      <b>CHR-68EVS</b>   <b>CHR-68e</b></p> <p style="text-align: right;"><b>7-2</b></p>
	<p><b>7-3 Adjustable Tool Holder</b> The adjustable tool holder permits setting of center drills, drills, reamers and other end-working tools to the exact center of workpiece. The holder is mounted directly to the eight station turret and holds 16mm diameter tool shanks or bushings in a ground-finish hole. Specify 12mm or 3/8" or 1/2" tool slide center height when ordering.</p> <p>Tool no: <b>TH-06</b></p> <p>For: <b>CT-1118CNC,</b>                      <b>CHR-68EVS</b>   <b>CHR-68e</b></p> <p style="text-align: right;"><b>7-3</b></p>
	<p><b>7-4 Drill chuck Arbor</b> Hardened and ground drill shank arbors are available in the following sizes:</p> <p>Tool No: <b>TH-07-1(JT1#)</b> 6.5m/m Drill Chuck           <b>TH-07-2(JT2#)</b> 10 m/m Drill Chuck           <b>TH-07-3(JT6#)</b> 13 m/m Drill Chuck           <b>TH-07-4(JT3#)</b> 16 m/m Drill Chuck</p> <p>For: <b>CT-1118CNC,</b>                      <b>CTL-618e, CTL-618EVS</b>   <b>CHR-68e, CHR-68EVS</b>   <b>CTS-27EVS, CTL-27EV</b>   <b>CP-27EVS</b></p> <p style="text-align: right;"><b>7-4</b></p>
	<p><b>7-5 Drill Chuck</b></p> <p>Tool No: <b>TDC-6.5, TDC-10EL, TDC-13EL, TDC-16H</b></p> <p>For: <b>CT-1118CNC</b>                      <b>CTL-618EVS, CTL-618e</b>   <b>CHR-68e, CHR-68EV</b>   <b>CTS-27EVS</b>   <b>CTL-27EVS</b>   <b>CP-27EVS</b></p> <p style="text-align: right;"><b>7-5</b></p>



### 8-1 Square shank tool holder (Right/Left hand)

This tool holder center high is 10mm, can choose Right or Left hand tool holder.

Tool No: TH-42 TH-43

For: CT-1118CNC      CHR-68EVS  
CHR-68e

8-1



### 8-2 Square shank tool holder (Right/Left hand)

This tool holder center high is 12mm, can choose Right or Left hand tool holder.

Tool No: TH-44 TH-45

For: CT-1118CNC      CHR-68EVS  
CHR-68e

8-2



### 8-3 Quick-Change adjustable holder

This tool holder can easily change the center high. Also easy to use or change the tool holder.

Tool No: T-QC-12

For: CT-1118CNC      CHR-68EVS  
CHR-68e

8-3



### 8-4 Extension Tool Holders

Extension Tool Holders are used for turning or, with optional holders, for boring knurling or cut off. Extension Tool Holders are available in four Sizes 5mm, 75mm, 100mm, and 125mm lengths (measured from centerline of T-bolts to extension end of holder). Holders mount directly to the chucker turret and take standard 10mm square tool bits for turning operations.

Tool No: TH-48(50mm)      TH-49(75mm)  
TH-50(100mm)      TH-51(125mm)

For: CT-1118CNC      CHR-68EVS  
CHR-68e

8-4



### 9-1 Adjustable Holder

The adjustable holder is used for holding end-working tools, such as drills and reamers. The holder provides the means for adjusting the cutting edge of the tool to its proper center relation with the work. Uses standard 12mm split bushings.

Tool No: T-AH-10

For: CT-1118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

9-1



### 9-2 Tool Holder Collet (Collet Type)

To use with Releasing tap holder.

Tool No: T-RT-16-C

For: CT-1118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

CP-27EVS

9-2



### 9-3 Releasing Tap Holder (Collet Type)

The releasing tap holder has a completely enclosed releasing mechanism. Holders are furnished for right-hand tapping and easily converted for left-hand tapping. Taps are held in the holder with standard 12mm" split tap bushings.

Tool No: T-RT-16

For: CT-1118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

CP-27EVS

9-3



### 9-4 Knee Tool

The Knee Tool is of one piece, heat treated alloy steel construction. Used for turning from the turret, the knee tool can turn a single diameter with one tool, two diameters with two tools or a single diameter and chamfer. Takes 6mm tool bits.

Tool No: T-KT-16

For: CT-1118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

CP-27EVS

9-4

	<p><b>10-1</b></p> <p style="text-align: right;"><b>10-1</b></p>
	<p><b>10-2 Multiple Tool Holder</b>  This tool holder has an opening 11mmx54mm permitting the use of standard 10mm square tool bits in any multiple tool capacity. By using the under-cutting, chamfering and grooving can be done in one operation. When ordering, specify whether the holder is to be used in the front or rear position.</p> <p>Tool No: <b>T-FMH-06(Front)</b>     <b>T-RMH-06(Rear)</b></p> <p>For: <b>CHR-68EVS</b>  <b>CHR-68e</b>  <b>CTS-27EVS</b></p> <p style="text-align: right;"><b>10-2</b></p>
	<p><b>10-3 Drill and shank tool holder for 3 holds</b>  This tool holder can hold 3 different kind of Drill or shank tool. The standard tool holder inside of hole has 2 different size. Which are 16mm and 20mm. Specify 12mm or 3/8" or 1/2" tool slide center height when ordering.</p> <p>Tool No: <b>T-BT-3</b></p> <p>For: <b>CT-1118CNC</b></p> <p style="text-align: right;"><b>10-3</b></p>
	<p><b>10-4 Drill and shank tool holder for 6 holds</b>  This tool holder can hold 6 different kind of Drill or shank tool. The standard tool holder inside of hole has 2 different size. Which are 16mm and 20mm. Specify 12mm or 3/8" or 1/2" tool slide center height when ordering.</p> <p>Tool No: <b>T-BT-6</b></p> <p>For: <b>CT-1118CNC</b></p> <p style="text-align: right;"><b>10-4</b></p>



### 11-1 Centering And Facing Tool

The centering and facing tool is used in the turret. It faces the stock to the required length and, at the same time, centers the work for subsequent drill operations. Maximum drill capacity is 8mm.

Tool No: T-CFT-16

For: CT-1118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

11-1



### 11-2 Releasing Tap Holder

The releasing tap holder has a completely enclosed releasing mechanism with 12mm diameter bushing.

Tool No: T-RT-08

For: CT-1118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

11-2



### 11-3 Releasing Die Nut Holder

The releasing die nut holder is used for production threading. The holder is made for releasing quickly at the end of the turret travel.

Tool No: T-RRD-05

For: CT-1118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

11-3



### 11-4 Gang Tool Block (408mm)

This tool slide use to CT-1118CNC machine. The length of tool slide is 408mm.

Tool No: T-SL-408

For: CT-1118CNC

11-4



### 12-1 Gang Tool Block (96mm)

This tool slide use to CT-1118CNC machine. The length of tool slide is 96mm.

Tool No: **T-SL-96**

For: **CT-1118CNC**

12-1



### 12-2 Gang Tool Block (48mm)

This tool slide use to CT-1118CNC machine. The length of tool slide is 48mm.

Tool No: **T-SL-48**

For: **CT-1118CNC**

12-2



### 12-3 Knurling Holder

The knurling tool is used for knurling work from the turret. Knurls are mounted in swivel holders that can be set at any angle for straight or diamond knurling. A pair of knurls is furnished with each tool. A standard 12mm bushing can be used for spot drilling, etc.

Tool No: **T-KH-08**

For: **CT-1118CNC**

**CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e  
CTS-27EVS, CTL-27EVS  
CP-27EVS**

13-3

12-4

12-4



### 13-1 Tool Holder Extension

The tool holder extension provides a means for balancing a turret setup. It will extend short tooling to balance with the length of longer tooling. For example, it makes up the difference in length between a tap holder and a standard drill. Extension body is 40mm long.

Tool No: T-HE-16

For: CT-118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

13-1



### 13-2 Adjustable Rotary Stops

The Adjustable Revolving Stock Stop is capable of maximum length variation of maximum length variation of 19mm, from 80mm minimum to 98mm maximum overall.

Tool No: T-RS-201

For: CT-118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

13-2



### 13-3 Slide Tool

This tool is for turning and boring operations from the turret. The slide head takes 16mm diameter shank tools and has a travel of 22mm which is controlled by a fine pitch screw with a dial graduated in thousandths.

Tool No: T-ST-10

For: CT-118CNC

CHR-68EVS

CHR-68e

CTS-27EVS

13-3



### 13-4 Quick-Acting Recessing Tool

The recessing tool, shown at the left, is used to perform recessing work, back facing or chamfering operations in the same setting of the work as other turret operations. The 5.5mm travel either side of center is governed by adjustable stops.

The recessing tool head takes the 16mm diameter shank tool holders.

Tool No: T-QAR-10

For: CHR-68EVS

CHR-68e

CTS-27EVS

13-4

	<p><b>14-1 Quick Change Tool Post-Europe Style</b> The type sizes is A1</p> <p>Tool No: 540-100</p> <p>For: CT-1118CNC      CTL-618EVS                                   CTL-618e                                   CTL-27EVS                                   CP-27EVS</p> <p style="text-align: right;"><b>14-1</b></p>
	<p><b>14-2 Turning &amp; Facing Holder</b> This type size H: 16mm    L: 75mm</p> <p>Tool No: 540-111</p> <p>For: CT-1118CNC      CTL-618EVS                                   CTL-618e                                   CTL-27EVS                                   CP-27EVS</p> <p style="text-align: right;"><b>14-2</b></p>
	<p><b>14-3 Drilling &amp; Boring Bar Holder</b> This type size <math>\varnothing</math>D: 30 mm</p> <p>Tool No: 540-130</p> <p>For: CT-1118CNC      CTL-618EVS                                   CTL-618e                                   CTL-27EVS                                   CP-27EVS</p> <p style="text-align: right;"><b>14-3</b></p>
	<p><b>14-4 ER Collet Chuck Tool</b></p> <p>Tool No: C16-ER16</p> <p>For: CT-1118CNC      CTS-27EVS</p> <p style="text-align: right;"><b>14-4</b></p>



## OPTIONAL EQUIPMENT



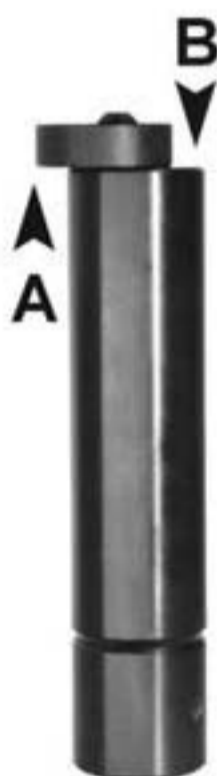
### 15-1 Tool Setting Gage

The tool setting gage for double tool cross slide is an essential aid for fast, accurate setting of tool bits to the spindle centerline of your CYCLEMATIC CTS-27EVS, CTL-27EVS machine. With the CYCLEMATIC tool setting gage slow scale measurement for setting tools on center is eliminated.

Tool No: T-301

For: CTS-27EVS  
CTL-27EVS

15-1



### 15-2 Tool Setting Gage

The tool setting gage is an essential aid for fast, accurate setting of your CYCLEMATIC CHR-68EVS and CTL-618EVS Lathes. The ground surface "A" is for setting tools cutting on front of work piece. Surface "B" is used for setting tools cutting on rear of work piece. The gage is adjustable for work piece. The gage is adjustable for its respective machine.

Tool No: T-302

For: CT-1118CNC      CHR-68EVS  
CHR-68e

Tool No: T-303

For: CTL-618EVS  
CTL-618e

15-2



### 15-3 Carriage Length Indicator

The carriage length indicator permits full carriage travel, thus allowing for "close to spindle machining".

The carriage length indicator is a needed accessory when producing parts to exact shoulder lengths or when facing to close tolerances. The fully jeweled dial indicator reads directly in .01mm increments with a range of 10mm. The long rod allows the indicator to be extended to a distance of 165mm. The carriage length indicator can be mounted to your CTL-618EVS Lathe without machining.

\* Indicator is not included.

Tool No: T-CLD-618

For: CTL-618EVS  
CTL-618e  
CHR-68EVS  
CHR-68e

15-3



### 16-2 Indicator Carriage Stop

The micrometer carriage stop is a useful accessory when producing parts with exact shoulder lengths or when facing to close tolerances. The indicator reads in 0.01mm increments. The micrometer reads in 0.01mm. Each CTL-618EVS Lathe is machined for direct application of the indicator stop.

\* Micrometer and indicator are not included.

Tool No: T-CSD-618

For: CTL-618EVS  
 CTL-618e  
 CHR-68EVS  
 CHR-68e

16-2



### 16-3 Steady Rest

Long cylindrical work held between centers requires a steady rest to prevent such work from springing away from a cutting tool. A steady rest is also used when there are machining operations to be performed on the end of work which prohibits the use of the tailstock center. The steady rest has a maximum capacity of 76mm.

Tool No: T-SR-300

For: CT-1118CNC                      CTL-618EVS  
    CTL-618e

16-3



### 16-4 Follow Rest

When you have work that is small in diameter in relation to length, it may spring away from the cutting tool. In such cases, the follow rest applied to the carriage, as shown, will assure you of accurate work.

Tool No: T-FR-300

For: CT-1118CNC                      CTL-618EVS  
    CTL-618e

16-4



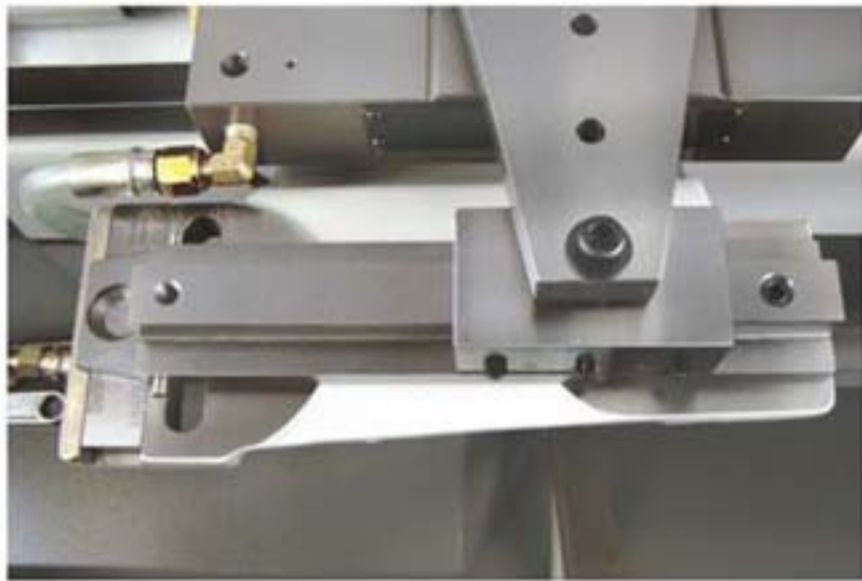
### 16-5 Six Station Turret

The turret tool holder diameter 16mm slide travel 9mm.

Tool No: L-40T

For: CTL-618EVS  
 CTL-618e  
 CTS-27EVS  
 CTL-27EVS

16-5



### 17-1 Taper Turning Attachment

The turning or boring of precision tapers is readily accomplished on the CYCLEMATIC CTL-618EVS lathe by the use of a taper turning attachment. The taper turning attachment is based on the sine bar principle—swiveling the guide bar from one end. Graduations for setting guide bar are in degrees.

The taper turning attachment mounts directly on the back of the lathe bed and is adjustable along the bed to suit the work.

Tool No: TL-T-01

For: CTL-618EVS  
CTL-618e

17-1



### 17-2 Radius Turning Attachment

The radius turning attachment is used for precision turning of concave or convex surfaces up to 38mm radius. Useful for turning punches, dies, ball shaped valve seats, and special spherical cutting tools.

The swivel slide is mounted on precision preloaded ball bearings for accuracy and rigidity. The swivel slide moves through 360°.

Hardened feed screws are mounted on preloaded ball bearings and have adjustable dials graduated in thousandths of an inch.

Tool No: T-RT-108

For: CTL-618EVS  
CTL-618e

Tool No: T-RT-208

For: CTS-27EVS  
CTL-27EVS  
CP-27EVS

17-2



### 17-3 Rear Tool Holder Slide Assembly

The Rear Tool Holder Slide Assembly for CTL-618EVS Machines, as shown with a L-3023 tool post in place, can be quickly mounted to the carriage cross slide. The top slide travel is 19mm and is controlled by an easy reading feed screw dial graduated in 0.02mm. A double locking arrangement maintains the position of the slide and tool holder. The rear tool holder slide assembly consists of the RTS-10-1 base with mounting screws and RTS-10-2 tool holder slide. Optional tool holders for rear slide assembly are the L-3023 wedge type tool post, T-RMH-06 Multiple tool holder.

Tool No: T-RTS-10

For: CTL-618EVS  
CTL-618e

17-3

18-1

18-1



### 18-2 Bed Length Indicator

This assembly can stop carriage.

Tool No: T-BLD-68

For: CTL-618EVS  
CTL-618e  
CHR-68EVS  
CHR-68e

18-2



### 18-3 Automatic Indexing Turret

The square turret is applied directly to the tool post T-slot of the compound slide. The turret takes standard 10mm square tool bits. By a simple movement of the ball-handled lever, the turret is automatically unlocked, indexed to the next tool position and relocked, ready for the next machining operation.

Tool No: T-AIT-06

For: CT-1118CNC      CTL-618EVS  
CTL-618e  
CTL-27EVS  
CP-27EVS

18-3

18-4



### **20-1 Bed Adapter for Double Tool Cross Slide**

The bed adapter is used for mounting the standard double tool cross slide normally used on Second Operation Machines. This permits the use of all double tool cross slide accessory tooling such as standard tool holders, multiple tool holders, the straight and taper turning slide and any combination of this tooling applicable to the job being run.

Tool No: **CHR-68-08**

For: **CHR-68EVS**  
**CHR-68e**

**20-1**



### **20-2 Double tool Cross Slide**

The cross slide base provides the needed rigidity when forming, cutting off, or turning with the straight and taper turning slide attachment. The cross slide is easily operated by a hand lever. Two threaded feed stops are provided for fine adjustment of each tool position.

Tool No: **CHR-68-12**

For: **CHR-68EVS**  
**CHR-68e**  
**CTS-27EVS**  
**CTL-27EVS**  
**CP-27EVS**

**20-2**



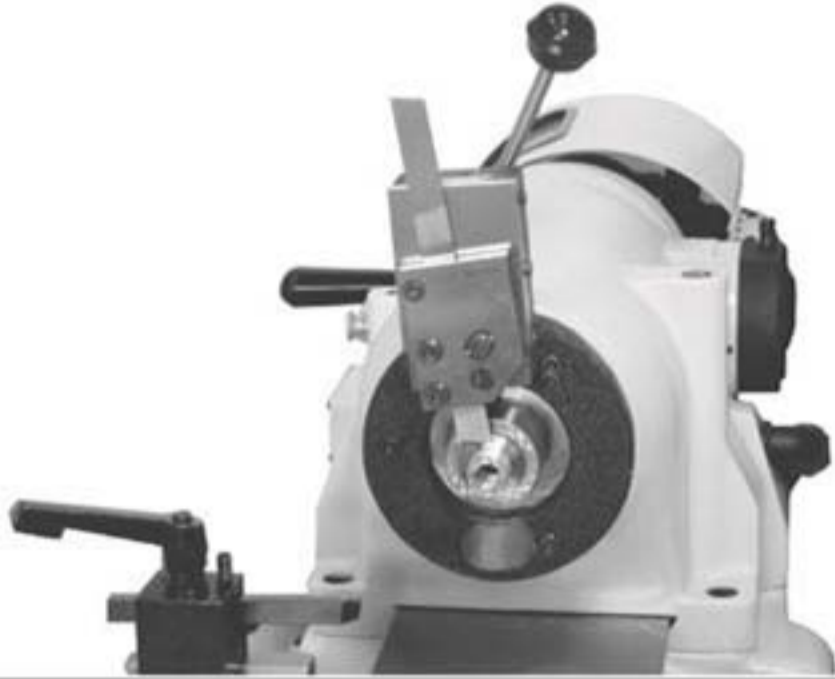
### **20-3 Straight and Taper Turning Slide for Double Tool Cross Side**

This attachment can be used on the front or rear of the double tool cross slide. It is for straight or angular turning, back facing, undercutting or for turning long slender parts that can't be readily formed by a full width tool. Two of the attachments may be mounted on the double tool cross slide for turning or boring two different angles at one setting of the work, such as valve seats or bevel gears. The swivel base is graduated in degrees and can be swiveled and locked to any angle. The lever operated rack and pinion slide travel of 44mm is controlled in either direction by adjustable stops. The tool post takes standard 8mm square tool bits.

Tool No: **CTS-27-07**

For: **CHR-68EVS**  
**CHR-68e**  
**CTS-27EVS**  
**CTL-27EVS**  
**CP-27EVS**

**20-3**



### 21-1 Vertical Cut-off Slide

The vertical cut-off slide for the CHR-68EVS, CTL-618EVS, CTS-27EVS and CTL-27EVS Lathes permits a Separate station for cut-off operations. It can be applied to the spindle nose without machining and is mounted with bolts provided.

Tool No: **LB-68-11**

For: **CT-1118CNC**

**CTL-618EVS, CTL-618e  
CHR-68EVS, CHR-68e**

Tool NO: **CTS-27-08**

For: **CTS-27EVS, CTL-27EVS  
CP-27EVS**

**21-1**



### 21-2 Compound Slide

The compound slide rest can be readily applied to the CYCLEMATIC Second Operation Machine for screw feed precision turning, facing and boring operations. The large diameter feed screws are hardened and mounted on preloaded ball bearings. The feed screw dials are 50.8mm in diameter. Both dials give direct readings in thousandths and are adjustable for Zero settings.

Tool No: **CTS-27-10**

For: **CTS-27EVS, CTL-27EVS, CP-27EVS**

**21-2**



### 21-3 Tailstock for Second Operation machines

The tailstock is applied directly to the bed ways in place of the turret. It is ordered for center work.

Tool No: **CTS-27-11**

For: **CTS-27EVS  
CTL-27EVS**

**21-3**



### 21-4 End-Working Slide

The slide is for deep hole drilling, lapping or any other operation requiring a tool travel up to 140mm.

Tool No: **CTS-27-09**

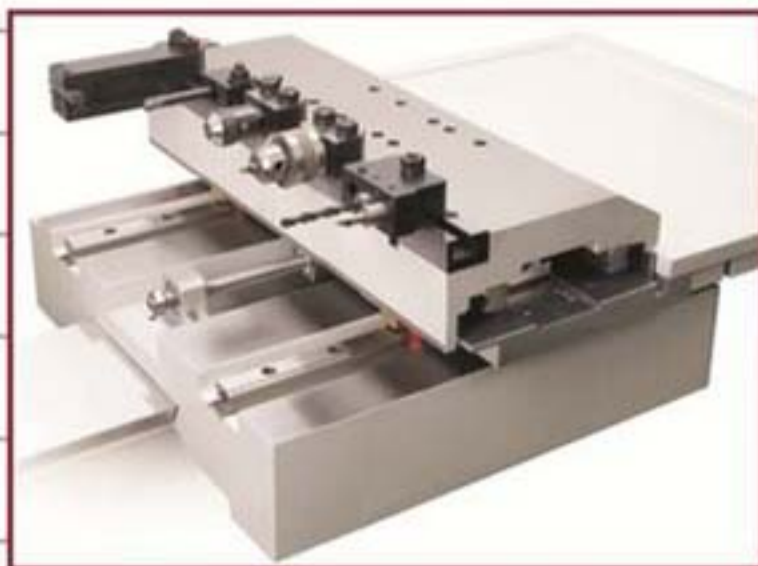
For: **CTS-27EVS  
CTL-27EVS**

**21-4**

	<p><b>22-1 Chip and Coolant Shield</b>  This transparent plastic chip and coolant shield is optional equipment on the CYCLEMATIC CTL-618EVS, CTL-27EVS, and CHR-68EVS Lathes. The hinged section is adjustable to left or right to suit work requirements. Extended sections offer additional splash prevention.</p> <p>Tool No: <b>T-CS-10</b></p> <p>For: <b>CT-1118CNC</b>      <b>CTL-618EVS, CTL-618e</b>  <b>CHR-68EVS, CHR-68e</b>  <b>CTS-27EVS, CTL-27EVS</b></p> <p style="text-align: right;"><b>22-1</b></p>
	<p><b>22-2 Male Center</b>  This male center has an 27mm head diameter and is furnished with all CYCLEMATIC tailstocks. All centers are hardened and ground.</p> <p>Tool No: <b>T-MC-2</b></p> <p>For: <b>CT-1118CNC</b>      <b>CTL-618EVS, CTL-27EVS</b></p> <p style="text-align: right;"><b>22-2</b></p>
	<p><b>22-3 Live Center</b>  This male center has an 32mm head diameter and is furnished with all CYCLEMATIC tailstocks. All centers are hardened and ground.</p> <p>Tool No: <b>T-LC-2</b></p> <p>For: <b>CT-1118CNC</b>      <b>CTL-618EVS, CTL-618e</b>  <b>CTL-27EVS</b></p> <p style="text-align: right;"><b>22-3</b></p>
	<p><b>22-4 Drill Chuck</b>  This drill chuck has 3 different kind of size. Which is 1.2-13mm, 3.0-16mm, 3.0-19mm size.</p> <p>Tool No: <b>TDC13-MT2, TDC-16-MT2, TDC19-MT2</b></p> <p>For: <b>CT-1118CNC</b>      <b>CTL-618EVS</b>  <b>CTL-618e</b>  <b>CTL-27EVS</b></p> <p style="text-align: right;"><b>22-4</b></p>
	<p><b>22-5 Electronic Magnifier Lamp</b>  The electronic magnifier lamp has 5 diopter glass. The arm unit can be move anyway.</p> <p>Tool No: <b>HQ32122-5</b></p> <p>For:  <b>CTL-618EVS, CTL-618e</b>  <b>CHR-68EVS, CHR-68e</b>  <b>CTS-27EVS, CTL-27EVS</b>  <b>CP-27EVS</b></p> <p style="text-align: right;"><b>22-5</b></p>



**CT-1118CNC**



**CT-606CNC**



**CTL-618EVS/618e**



**CHR-68e**



**CTS-27EVS**



**CP-27EVS**

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