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# **ASL-6/6B CNC LATHE**

## **Linear-Way Universal Slant-Bed Turning Center**

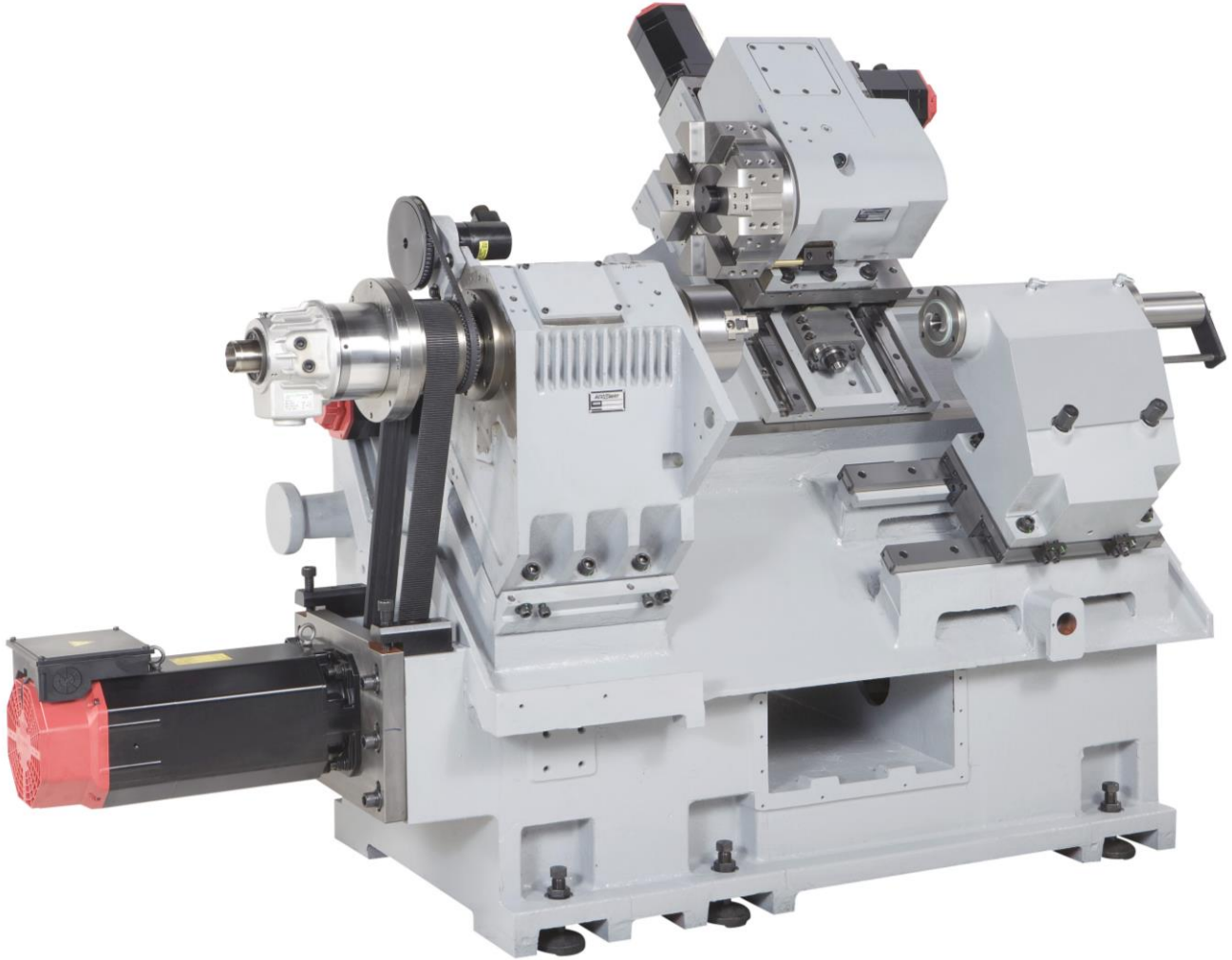
**20" Swing - Over Bedways**

**12.5" Swing - Over Saddle**



- **A2-5 Spindle w/ 1.7" Bar Diameter (2.0" Optional -ASL-6B)**
- **6" 3-Jaw Hydraulic Chuck w/ Thru-Bore (8" Optional-ASL-6B)**
- **12-Station Tool Turret**
- **6,000 RPM Spindle Speed (4,500 RPM Optional ASL-6B)**
- **Renishaw Tool Pre-Setter**
- **Parts Catcher**

## **STANDARD ASL -6 MACHINE FEATURES**



The 45° slant bed ASL-6 CNC lathe is made of premium shock-absorbing Meehanite® processed cast iron for superb interrupted cut capability. The heavy one-piece bed casting is heat-treated, annealed twice and ground to eliminate stress, thermal growth and vibration. The ball-guided linear ways provide maintenance free operation with superior stick-slip characteristics. The one-piece base and box lathe bed is an engineered torque-tube structure that demonstrates excellent stability and anti-flexing capability under severe cutting conditions. The chip and coolant pan is designed as a separate unit to keep hot chips away from the machine bed in order to control thermal distortion of the machine casting in a sustained production environment.

The robust headstock casting is mounted on the same ground way surface as the tailstock to maintain perfect alignment and center height regardless of bed temperature. The headstock is ribbed to increase surface area to better facilitate heat dissipation for optimal thermal stability. The heavy-duty spindle is supported by a double row of cylindrical roller bearing in front and rear, with duplex pair of angular thrust bearings mounted in between. The cylindrical roller bearings feature a large contact surface to ensure high rigidity for heavy cutting loads and superb surface finishes. All spindle bearings are precision class P4 and are grease lubricated for a long service life.

# **STANDARD GANESH ASL-6 MACHINE FEATURES:**

## **Renishaw Tool Setter –**

The included Renishaw removable tool-setter makes tool setting quick and easy while reducing profit sapping setup time.

## **True Slant-Bed Lathe Design –**

The one-piece 45° true slant bed design is made of premium Meehanite® processed cast iron for superb vibration dampening for superior surface finish and improved tool life.

## **Tailstock with Programmable Quill –**

The programmable tailstock quill keeps constant pressure to the workpiece to ensure that proper support is always available, even if there is a slight shift in the part location. The pressure is adjustable to meet the specific need that the application requires. The tailstock body has 11.6” of movement and is positioned manually.

## **Parts Catcher –**

The standard programmable parts catcher extracts the finished workpiece from the work area without any machine interruption for uninterrupted machining efficiency.

## **Chip Wash-Down & Chip Conveyor –**

The steep sheet metal angles and coolant flow forces chips on to the chip conveyor so that they can efficiently discharge them from the right side of the machine to simplify maintenance.

## **Coolant Tramp Oil Separator Unit –**

The included coolant tramp oil separator unit removes tramp oil off of the surface of the coolant to reduce maintenance and extend coolant life. This device reduces maintenance interruptions help increase machine productivity.

## **Auto Power Shut Off –**

The control's auto shut off feature automatically shuts down the machine once a long program is finished. This capability enhances your ability to let the machine run lights-out for extended production capability.

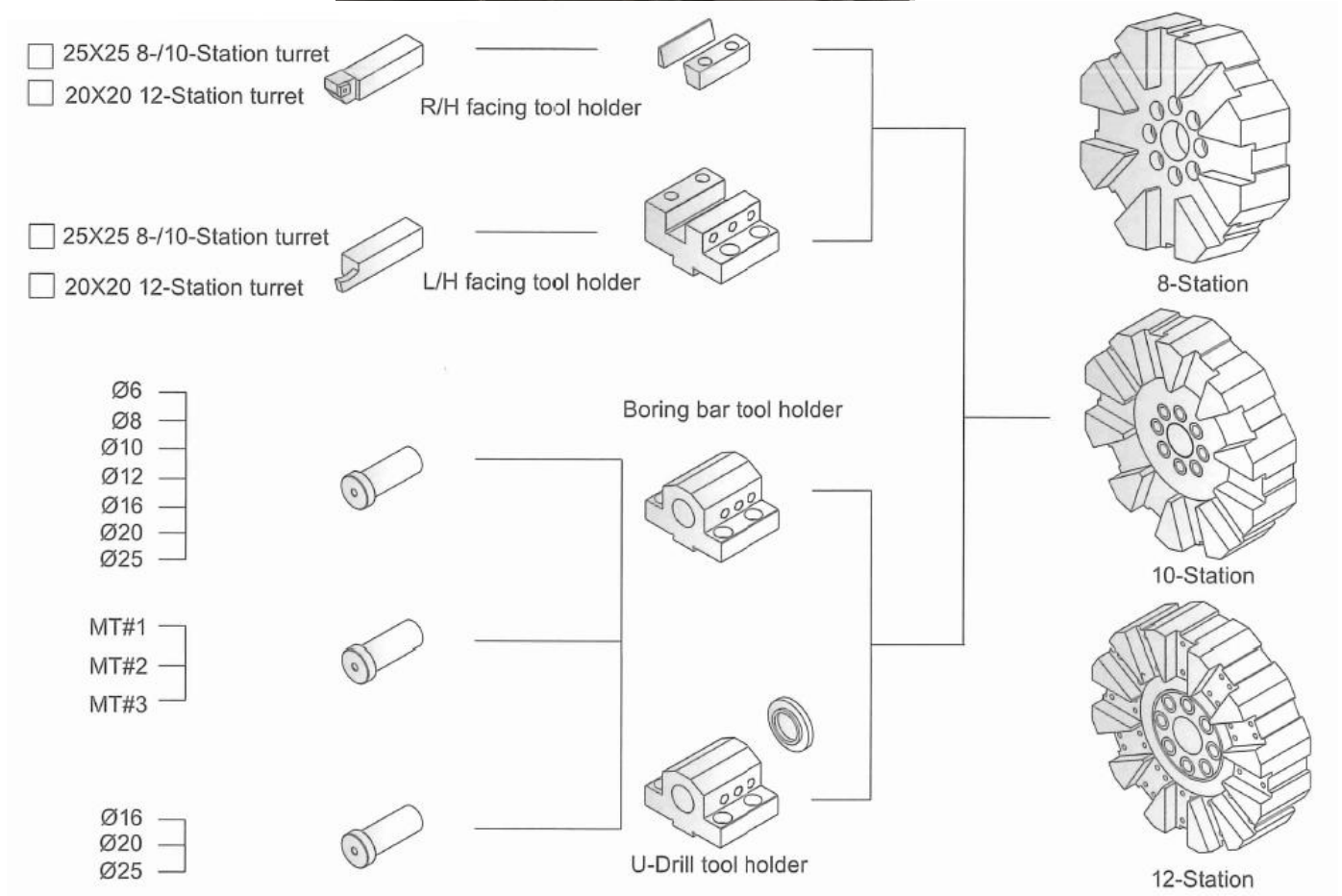
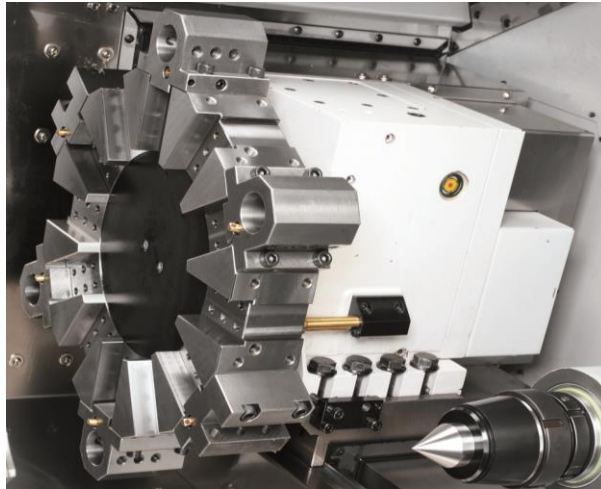
## **Ball-Bar Testing –**

The **geometric ball bar test** conducted on each machine checks for servo gain synchronization, backlash, lateral play, squareness, and straightness to ensure your machine will perform to our rigid accuracy and performance standards. **Laser inspection technology** is employed to measure linear and pitch error accuracy and repeatability to ensure high quality machine performance. The spindle is **dynamically balanced** to ensure long term production performance. Premium quality ball screws are double-anchored and pre-tensioned, and then 100% inspected for parallelism to the axis guideways. The rotational torque of each ballscrew is inspected over the entire length of travel to guarantee a true smooth non-binding alignment to ensure maximum service life and the highest possible machining accuracy.

**The Ganesh ASL-6 CNC lathe is manufactured in our  
Certified ISO 9001 Production Facility in Taiwan.**

# 12-Station Tool Turret

The 12-station tool turret uses an extra-large 10.6" 2-piece coupling for quick indexing and 22,000 lbs. of rigid clamp force to provide a stable cutting platform for high metal removal rates. The high-speed indexing system provides quick 0.19-second tool changes. Turret indexing is not-stop and bi-directional. Turret position is determined and confirmed by a rotary encoder, and clamp complete is confirmed by a proximity switch. Pictured with standard tooling below.



12-Station Tool Turret = 1-R/H & 1-L/H 3/4" facing toolholder, and 12 3/4" O.D. tool clamps  
 All turrets include 3-boring bar holders Ø1-1/4", and 1-U-Drill holder Ø1-1/4" included with machine.  
 Bore bar bushings: 1/4", 5/16", 3/8", 1/2", 5/8", 3/4", 1" supplied. U-Drill bushings: 5/8", 3/4", 1", supplied.

# **ASL- 6 CNC Lathe Machine Specifications**

## **Capacity & Dimensions-**

Swing over Bed	19.88"	(505 mm)
Swing over Saddle	12.52"	(318 mm)
Maximum Cutting Diameter	13.78"	(350 mm)
Maximum Cutting Length	12.5"	(320mm)

## **Spindle-**

Spindle Motor Horsepower – standard 7.5/11kw	20-HP Peak	15-HP 30-min. duty-rated
Spindle Motor B-Version – “Big Bore” 11kw/15kw	25-HP Peak	20-HP 30-min. duty-rated
Spindle Speed	6,000 RPM	(4,500 RPM w/ 2” bar)
Spindle Torque Maximum	75 ft. lbs.	(110 ft. lbs. opt.)
Spindle Nose	A2-5	(A2-6 in B option.)
Spindle Bore	2.2"	(56mm) / (2.4", 62mm opt.)
Bar Capacity (in draw tube)	1.73"	(44mm) / (2.0", 52mm opt.)
Chuck Diameter	6"	(8" in B option)

## **Axis-**

Axis Travel – X-axis	8.66"	(220mm)
Axis Travel – Z-axis	13.7"	(350mm)
Ballscrew Diameter / Pitch Rate – X & Z Axis	Ø32mm	10mm pitch
Ball-Guided Way Width – X Axis/ Z Axis	28mm	34mm
Axis Drive Motors - X & Z (Fanuc A8)	2.1-Horsepower (1.6kw)	
Axis Thrust – Maximum X-& Z Axis	4612 lbs.	
Rapid Traverse Feedrate X	945 IPM	(24m/min)
Rapid Traverse Feedrate Z	1181 IPM	(30m/min)
Way Type / Slant Bed Angle	Ball-Guided	45°
Minimum input unit	0.0001" (0.001mm = 40 millionths of a inch)	

## **Tool Turret-**

Tool stations – any combination of ID/OD tooling /Index time	12-stations
Tool Index Time- adjacent tool station / 180° index	0.19 sec. / 1.2 sec.
O.D. Tooling (20mm when specified for metric users)	3/4" square shank tools
I.D. Tooling (32mm when specified for metric users)	1.25" (4 I.D. holders included)
Driven Tool System / Power (optional)	5-Horsepower (3.7kw)
Driven Tool rotary speed / rotary torque (optional)	4,000 rpm / 30 Nm

## **Tailstock-**

Tailstock Body Travel	11.6"	(295mm)
Quill diameter	2.7"	(70 mm)
Quill stroke – programmable hydraulic actuation	5.9"	(150 mm)
Quill taper	MT-4	Morse Taper # 4

## **Specifications –**

Power Requirements	220vac ±5%, 32-amps
Floor Space Requirements - LxWxH	89" x 70" x 70" (+ 37" for chip conveyor)
Machine Weight	6,614 lbs. (3000kg)
Hydraulic Motor Power / Pressure / Oil	2-H.P. / 600 PSI (Mobil #24 oil)
Coolant Pump / Pressure / Capacity	3/4-HP / 60 PSI / 40-gallons

**ROBOTS AND GANTRY LOADERS AVAILABLE.**