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# **ASL-10 CNC LATHE**

## **Box-Way Universal Turning Center**

**20" Swing - Over Bedways**  
**12.5" Swing - Over Saddle**  
**22" & 39.4" Turning Lengths**



- **A2-8 Spindle w/ 3.0" Bar Diameter**
- **10" 3-Jaw Hydraulic Chuck w/ 3" Thru-Bore**
- **10-Station Tool Turret**
- **3,500 RPM Spindle Speed**
- **Renishaw Tool Pre-Setter**
- **Parts Catcher**
- **Tailstock & Programmable Quill**
- **Mitsubishi M80 CNC Control w/ Premium Drives & Motors**

# **STANDARD ASL - 10 MACHINE FEATURES**

The 45° slant bed box-way ASL-10 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 sliding surfaces are hand scraped, oil dimpled, and coated with Turcite-B for long-life maintenance free operation with excellent stick-slip characteristics. The one-piece base and box-way 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. Note: Driven tool C-axis version shown above.

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.

## **Renishaw Tool Pre-Setter –**

The included Renishaw removable tool pre-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.

## **Parts Catcher –**

The standard 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 –**

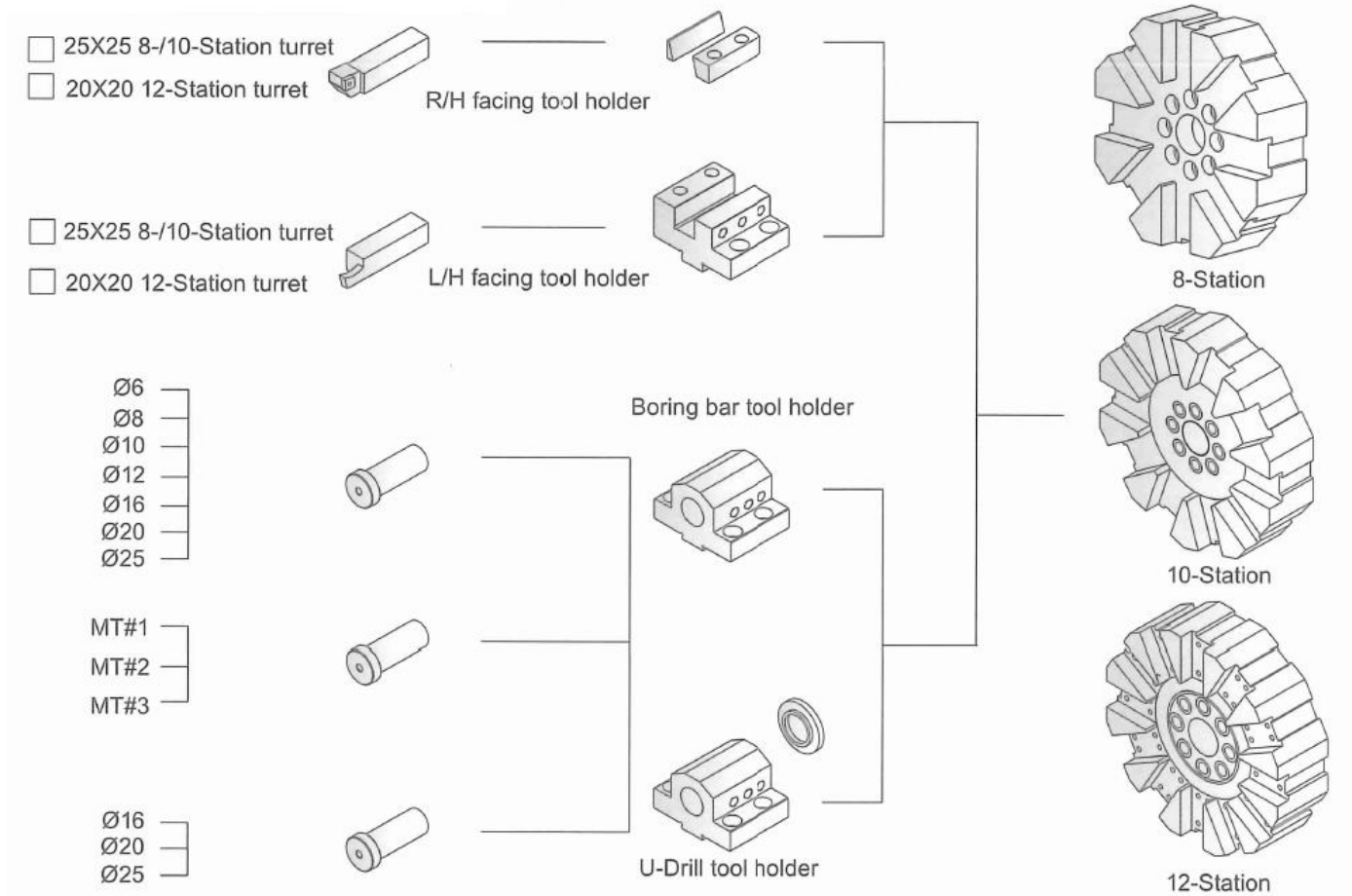
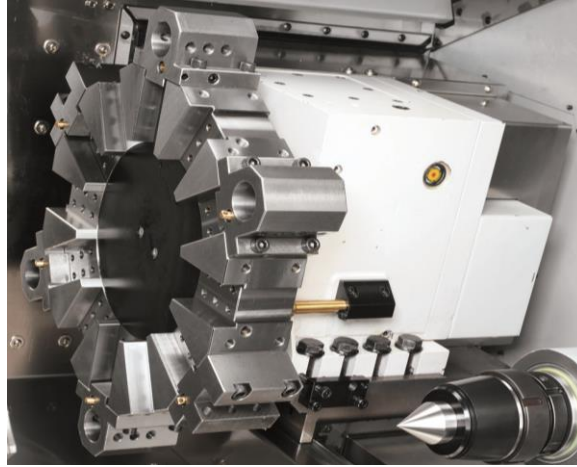
The control's auto shut off feature automatically shuts down the machine once a long program is finished. This capability enhances your ability to let the machine run lights-out for extended production capability.

## **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.

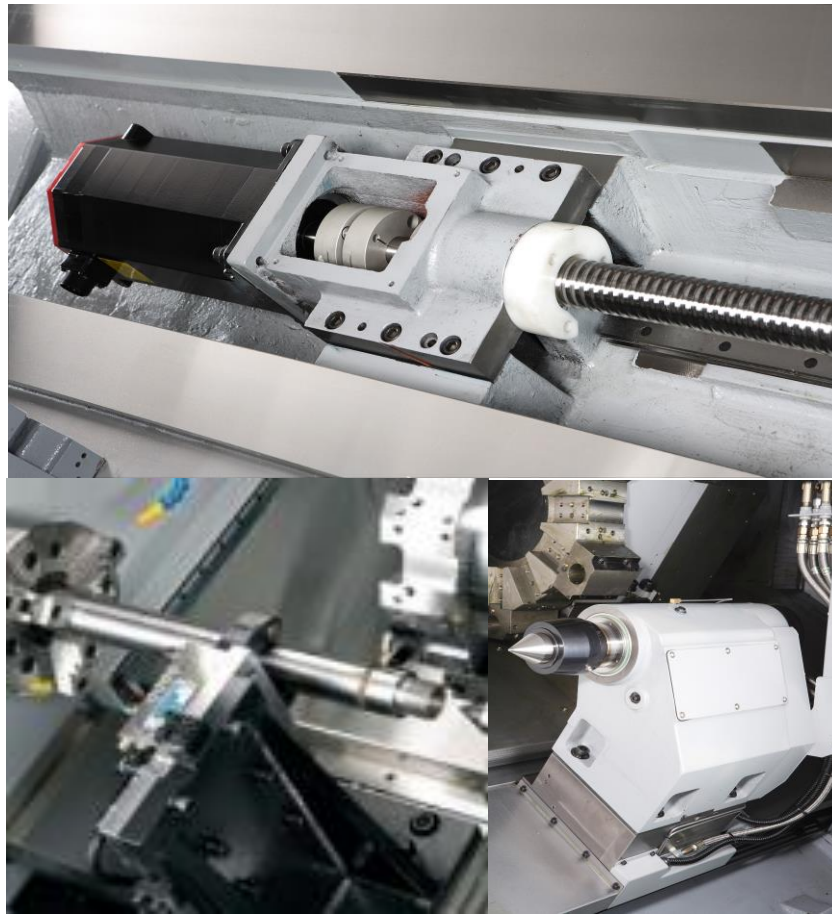
# 10-Station Indexing Tool Turret

The 10-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 bi-directional and is all controlled by a reliable high torque hydraulic indexing motor. Turret position is determined and confirmed by a rotary encoder, and clamp complete is confirmed by a proximity switch. Pictured with standard tooling below.



10-Station Tool Turret = 1-R/H & 1-L/H 1" facing toolholder, and 10 1" O.D. tool clamps  
 All turrets include 3-boring bar holders 1-1/4", 1-U-Drill holder 1-1/4" 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.

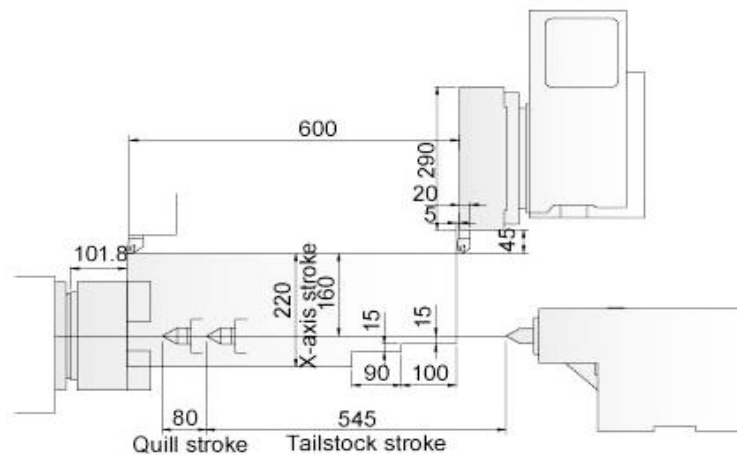
## ASL - 10 MACHINE FEATURES



SMW AUTOBLOCK SLU-1 Steady Rest ( $\varnothing.16'' - \varnothing.252''$  capacity) in photo is optional.

Ballscrews are centered between the guideways and are direct mount to the AC servo motors without the use of intermediate gears to minimize backlash. The Z-axis servo motor is mounted on the headstock end of the ball screw.

The tailstock is mounted on widely spaced guideways and the heavy-duty design ensures ample rigidity for long heavy shafts. The 3" diameter quill features 3.15" of quill stroke and is activated manually by foot pedal or automatically in the part program by M-code. The Morse Taper #4 center is suitable for heavy loads



# ASL-10 CNC Lathe Machine Specifications

## Capacity & Dimensions-

	ASL-10	ASL-10L
Swing over Bed		19.88" (505 mm)
Swing over Saddle		12.52" (318 mm)
Maximum Cutting Diameter		13.78" (350 mm)
Maximum Cutting Length	22" (560mm)	39.4" (1000 mm)

## Spindle-

Spindle Motor Horsepower – FANUC 11/15kw		25-HP Peak, 20-HP 30-minute duty-rating
Spindle Speed		3,500 RPM
Spindle Torque Maximum		135 ft. lbs.
Spindle Nose		A2-8
Bar Capacity (in draw tube)		3.1" (78mm)
Chuck Diameter(with 3.04" (77mm) through-hole)		10"

## Axis-

Axis Travel – X-axis		8.66" (220mm)	
Axis Travel – Z-axis	23.6" (600mm)		42.5" (1080mm)
Ballscrew Diameter / Pitch Rate – X Axis		Ø32mm / 8mm pitch	
Ballscrew Diameter / Pitch Rate – Z Axis		Ø32mm / 8mm pitch	
Axis Drive Motors - X & Z		3-Horsepower (2.2kw)	
Axis Thrust – Maximum - X & Z Axis		4612 lbs.	
Rapid Traverse Feedrate X		787 IPM (20m/min)	
Rapid Traverse Feedrate Z		787IPM (20m/min)	
Minimum input unit		0.0001" (0.001mm = 40 millionths of a inch)	
Guide Ways / Slant Bed Angle		Box ways / 45°	

## Tool Turret-

Tool stations – any combination of ID/OD tooling /Index time		10-stations (8 & 12-stations optional)
Tool Index Time- adjacent tool station / 180° index		0.19 sec. / 1.2 sec.
O.D. Tooling (20mm when specified for metric users)		1.0" square shank tools
I.D. Tooling (4-I.D. holders supplied with machine)		1-1/4" I.D. toolholder bore
Driven Tool Type / Power (optional)		BMT-40 (or VDI-30) / 5-Horsepower (3.7kw)
Driven Tool rotary speed / rotary torque (optional)		4,000 rpm / 30 Nm

## Tailstock-

Tailstock Body Travel by Hydraulic Piston	21.5" (545mm)		41.1" (1045mm)
Quill diameter		2.95" (75 mm)	
Quill stroke – programmable hydraulic actuation		3.15" (80 mm)	
Quill taper		MT-4 Morse Taper # 4	

## Specifications –

Power Requirements		220vac ±5%, 44-amps
Floor Space Requirements - WxH		66" x 69"
Floor Space Requirements - Length	115" (+ 25" for chip conveyor)	147"
Machine Weight	8,145 lbs.	11,464 lbs.
Hydraulic Motor Power / Pressure / Oil		2-H.P. / 600 PSI / Mobil #24 oil
Coolant Pump / Coolant Pump Pressure		3/4-HP / 60 PSI

**The Ganesh ASL-10 CNC lathe is manufactured in our  
Certified ISO 9001 Production Facility in Taiwan.**

**ROBOTS AND GANTRY LOADERS AVAILABLE.**