



**GANESH
MACHINERY**
The Edge in Cutting.

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ASL-15 CNC Lathe

24" Swing over Bedways

15" Swing over Saddle

19.6" Maximum Turning Diameter

27" / 47" / 66" / 86" / 118" Turning Lengths



- **A2-11 Spindle w/ 4" Bar Diameter in Drawtube**
- **15" 3-Jaw Hydraulic Chuck w/ 4" Thru-Bore**
- **2,500 RPM Spindle Speed**
- **12-Station Tool Turret**
- **Renishaw Tool Setter**
- **Tailstock with Programmable Quill**

STANDARD ASL-15 MACHINE FEATURES

The 30° box way slant bed ASL-15 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 to Rc53, 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 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.

Renishaw Tool Pre-Setter –

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

Programmable Tailstock Quill –

The programmable tailstock quill keeps constant pressure to the workpiece so 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.

True Slant-Bed Lathe Design –

The one-piece 30° true slant-bed design is made of premium Meehanite® processed cast iron for superb vibration dampening for superior surface finish and improved tool life.

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 –

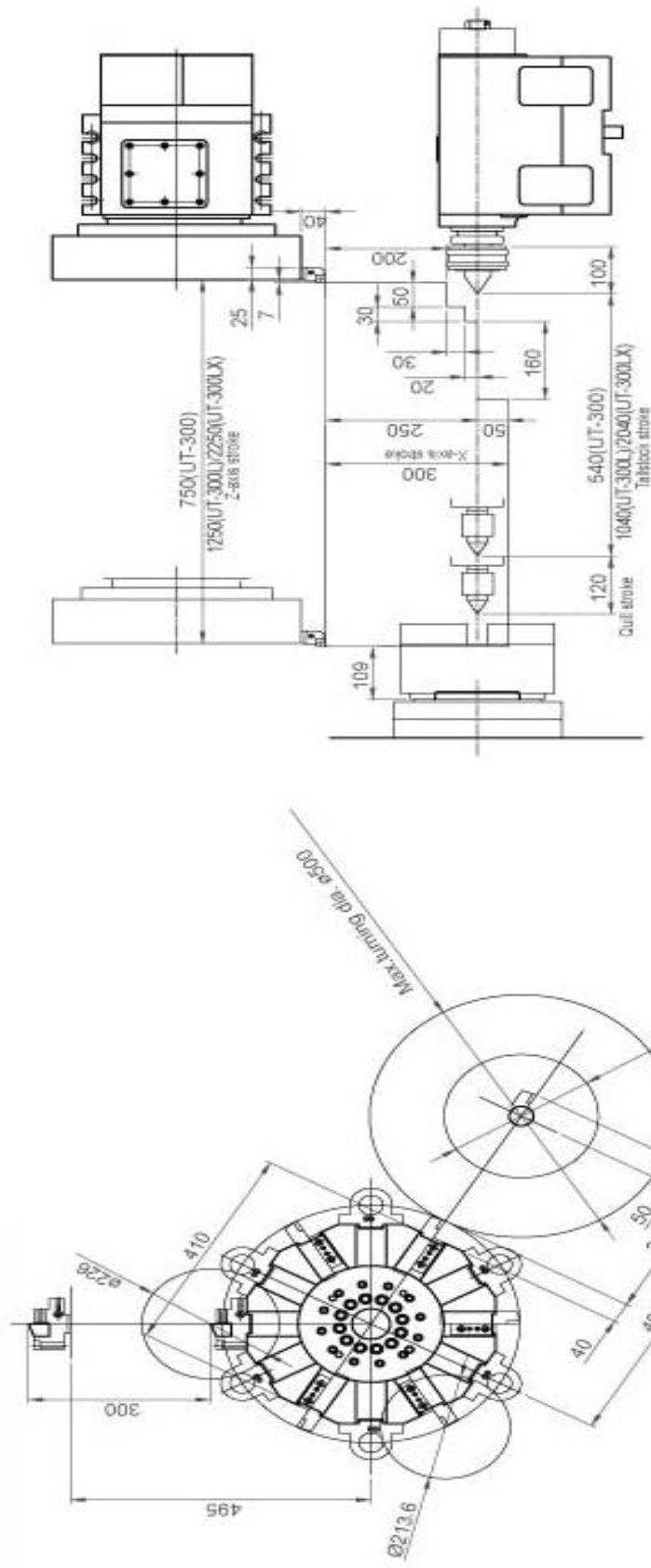
The included coolant tramp oil separator unit removes tramp oil off of the surface of the coolant to reduce maintenance and extend coolant life. This device reduces maintenance interruptions help increase machine productivity.

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 –

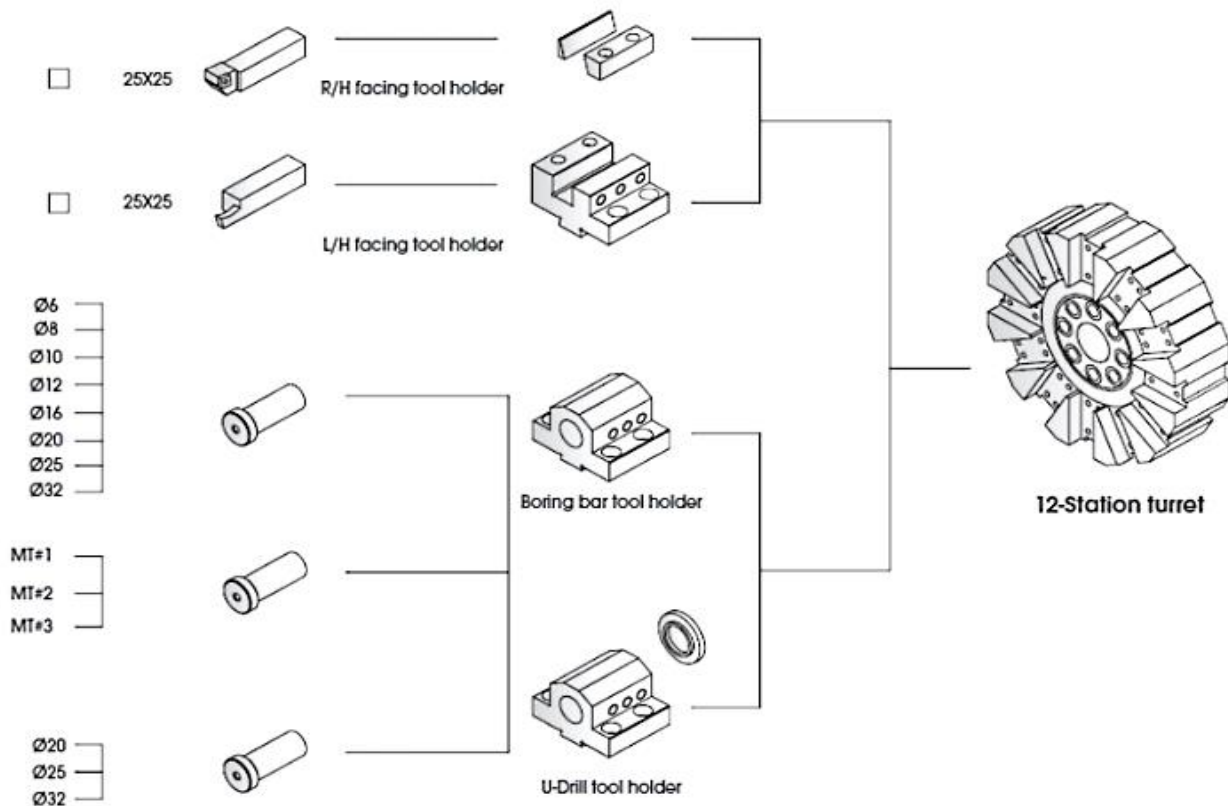
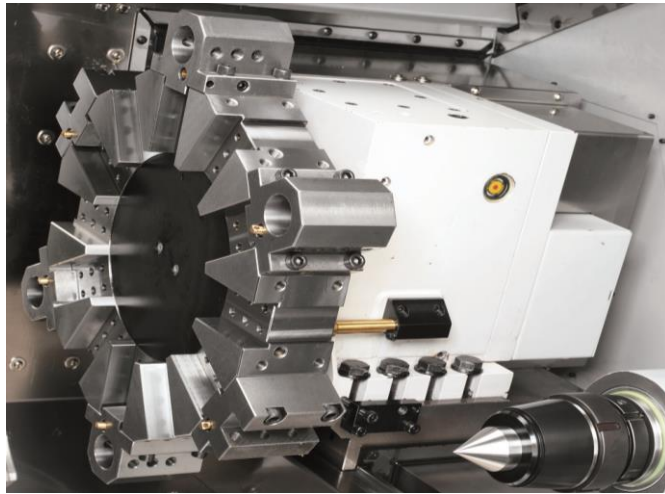
The **geometric ball bar test** conducted on each machine checks for servo gain synchronization, backlash, lateral play, squareness, and straightness to ensure your machine will perform to our rigid accuracy and performance standards. **Laser inspection technology** is employed to measure linear and 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.



■ 12-Station block turret

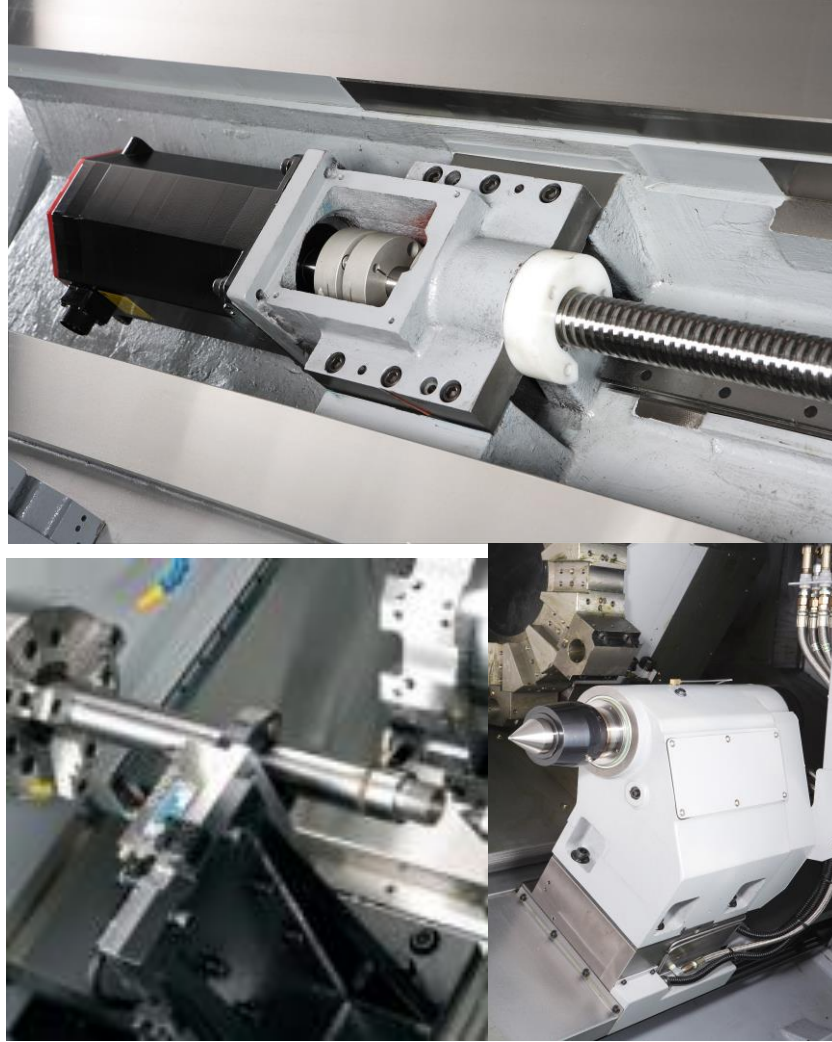
12-Station Indexing Tool Turret

The 12-station tool turret uses an extra-large 12.6" 2-piece coupling for quick indexing and 26,000 lbs. of rigid clamp force to provide a stable cutting platform for high metal removal rates. The high-speed indexing system provides quick 0.4-second tool changes. Turret indexing is not-stop bi-directional and the rotation, deceleration and clamp force are 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 package below.



1-R/H & 1-L/H 1" facing toolholder, 4-boring bar holders Ø1-1/2" included with machine.
Bore bar bushings: 1/4", 3/8", 1/2", 5/8", 3/4", 1", 1-1/4" supplied.

ASL-15 MACHINE FEATURES



SMW AUTOBLOCK SLU-4 Steady Rest (Ø 1.18" – Ø 9.64" capacity) - 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 programmable tailstock is mounted on widely spaced guideways and the heavy-duty design ensures ample rigidity for long heavy shafts. The 3.3" diameter quill features 4.7" of quill stroke and is activated by manually by foot pedal or automatically in the part program by M-code. The large Morse Taper #5 center is suitable for heavy loads. The tailstock body is position by a hydraulic motor driving against a toothed rack with a positioning rate of 400 IPM.

ASL-15 CNC Lathe Machine Specifications

Capacity & Dimensions-

Swing over Bed	24.09"	(612 mm)
Swing over Saddle	15.27"	(388 mm)
Maximum Turning Diameter	19.68"	(500 mm)
Maximum Turning Length (in each of 5 bed lengths)	25" / 43" / 62" / 84" / 114"	

Spindle

Spindle Motor Horsepower (15/18.5kw spindle motor) (20-HP Constant duty, 25-HP 30-minute rating, 30 HP Peak)	35-HP Peak Power	
Spindle Speed	2,500 RPM	
Spindle Nose	A2-11	
Bar Capacity (in draw tube)	4.1"	(105 mm)
Chuck Diameter (with 4" through-hole)	15"	

Axis-

Axis Travel – X-axis 11.81" overall (spec shows travel past centerline)	9.84+1.96"	(250+50mm)
Axis Travel – Z-axis (all 5 travel lengths shown)	29" / 49" / 69" / 88" / 122"	
Ballscrew Diameter / Pitch Rate – X Axis	Ø32mm / 8mm pitch	
Ballscrew Diameter / Pitch Rate – Z Axis	Ø40mm / 10mm pitch	
Axis Drive Motors - X & Z	4-Horsepower	(3kw)
Maximum Feed Thrust – X / Z	4452 lbs. / 5565 lbs.	
Rapid Traverse Feedrate X	787 IPM	(20m/min)
Rapid Traverse Feedrate Z	945 IPM	(24m/min)
Minimum input unit	0.0001" (0.001mm = 40 millionths")	
Guide Ways / Slant Bed Angle	Box ways / 30°	

Tool Turret-

Tool stations – any combination of ID/OD tooling /Index time	12-stations	
Tool Index Time- adjacent tool station / 180° index	0.4 sec. / 2.4 sec.	
O.D. Tooling (25mm when specified for metric users)	1" square shank tools	
I.D. Tooling (40mm when specified for metric users)	1.5" (4 I.D. holders included)	
Driven Tool System / Power (optional)	BMT-50 / 5-Horsepower (3.7kw)	
Driven Tool rotary speed / rotary torque (optional)	4,000 rpm / 30 Nm	

Tailstock-

Tailstock Body Travel (dependent on bed length)	21" / 40" / 63" / 80" / 120"	
Tailstock Body Programmable Positioning	Hydraulic Motor Driven	
Quill diameter	3.3"	(85 mm)
Quill stroke – Programmable hydraulic actuation	4.7"	(120 mm)
Quill taper	MT-5	Morse Taper # 5

Specifications –

Power Requirements –	208-220vac ±5%, 50-amps	
Floor Space Requirements – L = 120" / 148" / 177" / 219" / 256"	W x H = 71" x 71" (1.8 x 1.8m)	
Hydraulic Motor Power / Pressure / Oil	2-H.P. / 600 PSI / Mobil #24 oil	
Coolant Pump / Coolant Pressure	3/4-HP / 60 PSI	

**The Ganesh ASL-15 CNC lathe is manufactured in our
Certified ISO-9001 Production Facility in Taiwan.**