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JARNG YEONG ENTERPRISE CO., LTD.

**GREENWAY**®



# ***PRECISION CNC LATHE***

JOA-252 & JYN-42

**精密刀塔式數控車床**

Precision Turret Type CNC Lathe

# JOA-252

## TURRET TYPE CNC LATHE 刀塔式數控車床

45度斜背式結構，X/Z軸方形硬軌設計，搭配10位油壓刀塔或12位伺服動力刀塔，低震動、低噪音、高穩定，更耐用。

45° Slant angle of bed, box guideway designed of X/Z-axis with 10 position hydraulic turret or 12 position servo power turret. Less vibration and noise, stable and longer machine life.

### 產品說明 / DESCRIPTION

- ▶ 高剛性的底座，耐用的軌道，穩定性高的刀塔，讓機台具有重切削能力，以滿足各種加工之需求。  
High rigidity body base, durable box guideway, and high stable turret, they make machines are equipped with heavy cutting capability to fulfill various processing demand.



- ▶ 真正的45°斜背式床台，從Z軸滾珠螺桿到刀尖的最小距離，具有絕佳的排屑能力。  
Genuine 45° slant bed for minimum distance from Z-axis ball screw to the tool tip, makes excellent chip evacuation capacity.
- ▶ 軸向皆採用雙螺帽預拉式螺桿設計。  
Axes adopt double nut pre-pull ballscrew.

# JYN-42

## TURRET TYPE CNC LATHE 刀塔式數控車床

主軸軸承採用滾柱式軸承，提供更穩定的切削能力，斜背式護蓋，將馬達隔離於機台外，延長馬達使用壽命。

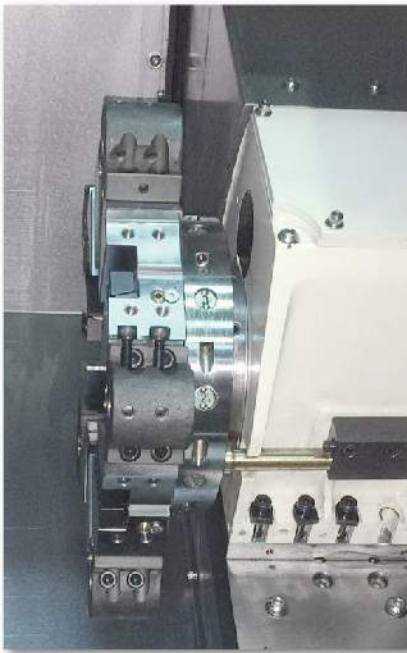
The spindle bearing that adopts roller type can provide more stable turning capability. Slant cover, separating motor from machine itself, can contribute to extend the usage lifetime.

### 產品說明 / DESCRIPTION

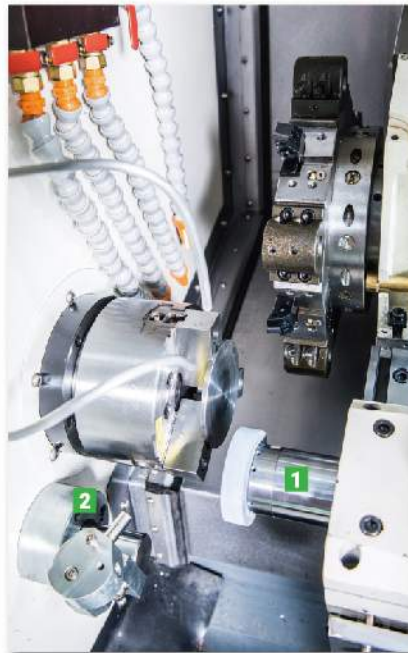
- ▶ 可選配尾座，適合進行長工件加工。  
Optional tailstock, suitable for processing long workpiece.



- ▶ 可選購配件：研磨裝置 & 自動修砂裝置，可接續車床上的研磨工程，提高生產率與生產精度。  
Optional Accessories: Grinding device & Automatic sand-rubbed finish device, to follow next grinding process to improve productivity and high precision production.



▲ 10位油壓刀塔  
10 position hydraulic turret



▲ 1 研磨裝置(選配)  
Grinding device(opt)  
2 自動修砂裝置(選配)  
Automatic sand-rubbed finish device(opt)



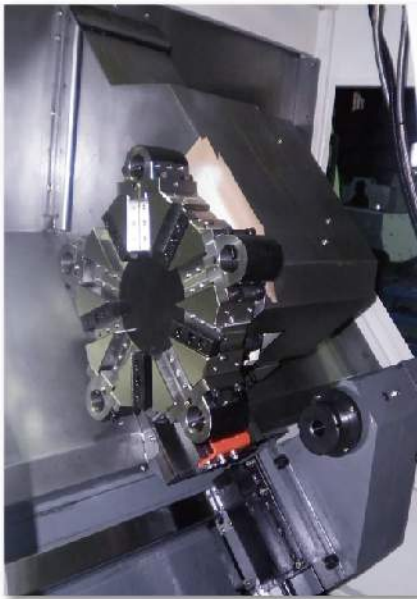
▲ 油壓尾座(手動)  
Hydraulic tailstock(manual)

## 標準配件 Standard Accessories

工具及工具箱 Tools and tools box	1 SET	LED工作燈 Lighting device	1 SET	刀具板 Tool plate	1 SET
腳踏開關 Pedal switch	1 SET	主軸插銷裝置 Spindle pin location device	1 SET	無料異常警示燈 No-material alarm indicating lamp	1 SET
熱交換器(用於電器箱) Heat exchanger for electric box	1 SET	機械墊塊 Base leveling block	6 PCS	自動潤滑系統 Auto lubrication system	1 SET
三爪油壓夾頭含軟爪 3-jaw hydraulic chuck with soft jaws	1 SET	切削水設備含1HP強力冷卻幫浦 Cutting coolant system with 1HP powerful coolant pump	1 SET	內孔刀座(I.D.Ø20) Tool base for inner hole(I.D.Ø20)	5 PCS
內孔套筒(I.D.Ø6, 8, 10, 12, 16 / O.D.Ø20) 各1只 Tool holder bush(I.D.Ø6, 8, 10, 12, 16 / O.D.Ø20) per pc		內孔刀架(I.D.Ø20)(若選配尾座·則無此配件·) Tool holder for inner hole(I.D.Ø20)(This accessory is NOT available if tailstock is installed.)		車刀上/下墊片(口20) Tool spacer(up/down)(□20)	4 SETS
					1 SET
					2 SETS

## 選購配件 Optional Accessories

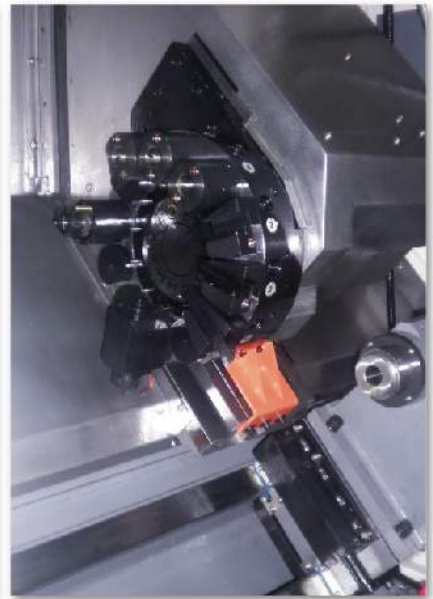
變壓器 Transformer	穩壓器 Voltage stabilizer	CE規格 CE specification
電動鏈板式排屑機 Electrical steel belt type chip conveyor	油霧回收機 Oil mist collector	油水分離機 Oil skimmer
密閉式空調冷卻機(用於電器箱) Air-Condition unit for electric box	成品取料裝置 Parts catcher	成品取料裝置含輸送帶 Parts catcher and conveyor
油壓尾座(手動) Hydraulic tailstock(manual)	油壓缸檢知 Hydraulic cylinder detection device	研磨裝置 Grinding device
自動修砂裝置 Automatic sand-rubbed finish device		



▲ 10位油壓刀塔  
10 position hydraulic turret



▲ 自動刀具量測(選配)  
Automatic tool measurement(opt)



▲ 12位伺服動力刀塔  
12 position servo power turret

### 標準配件 Standard Accessories

#### JOA-252 油壓/動力 共同標準配件 Hydraulic / Servo Power Turret Shared Standard Accessories

工具及工具箱 Tools and tools box	1 SET	LED工作燈 Lighting device	1 SET	腳踏開關 Pedal switch	1 SET
三爪油壓夾頭含軟爪 3-jaw hydraulic chuck with soft jaws	1 SET	油壓尾座(手動) Hydraulic tailstock(manual)	1 SET	無料異警警示燈 No-material alarm indicating lamp	1 SET
電動鏈板式鐵屑排出機 Electrical steel belt type chip conveyor	1 SET			機械墊塊 Base leveling block	6 PCS
切削水設備含1HP強力冷卻幫浦 Cutting coolant system with 1HP powerful coolant pump	1 SET			自動潤滑系統 Auto lubrication system	1 SET

#### JOA-252 油壓標準配件 Hydraulic Standard Accessories

內孔刀座(I.D.Ø40) Tool base for inner hole(I.D.Ø40)	5 SETS	車刀上/下墊片(□25) Tool spacer(up/down)(□25)	5 SETS
內孔套筒(I.D.Ø8, 10, 12, 16, 20, 25, 32 / O.D.Ø40) 各1只 Tool holder bush(I.D.Ø8, 10, 12, 16, 20, 25, 32 / O.D.Ø40) per pc	1 SET	10位油壓刀塔 10 position hydraulic turret	1 SET

#### JOA-252 動力標準配件 Servo Power Standard Accessories

外徑刀座(O.D.□20) Tool base for(O.D.□20)	3 SETS	內徑刀座(I.D.Ø32) Tool base for(I.D.Ø32)	3 SETS	保護套 Protective cap	7 PCS
內孔套筒(I.D.Ø6,8,10,12,16,20,25 / O.D.Ø32) 各1只 Tool holder bush(I.D.Ø6,8,10,12,16,20,25 / O.D.Ø32) per pc	1 SET	12位伺服動力刀塔 12 position servo power turret	1 SET		

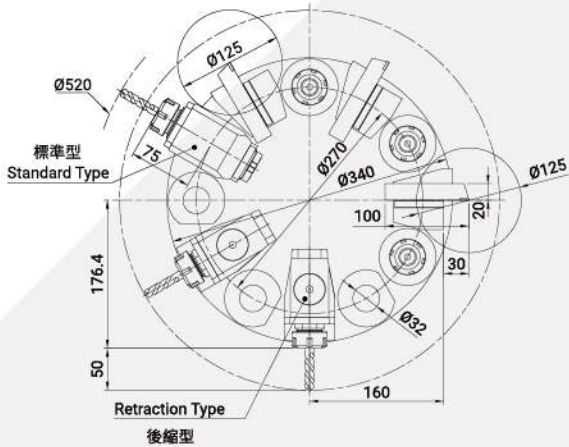
### 選購配件 Optional Accessories

變壓器 Transformer	穩壓器 Voltage stabilizer	CE規格 CE specification
CR60筒夾套(A2-6) CR60 collet chuck(A2-6)	油霧回收機 Oil mist collector	油水分離機 Oil skimmer
10"三爪油壓夾頭(A2-8) 10" 3-jaw hydraulic chuck(A2-8)	自動刀具量測 Automatic tool measurement	手動刀具量測 Manual tool measurement
PLC可程式控制尾座 Programmable tailstock	成品取料裝置及輸送帶 Parts catcher and conveyor	
12位雙向油壓刀塔(搭配副主軸) 12 position bi-directional hydraulic turret(with sub-spindle)		

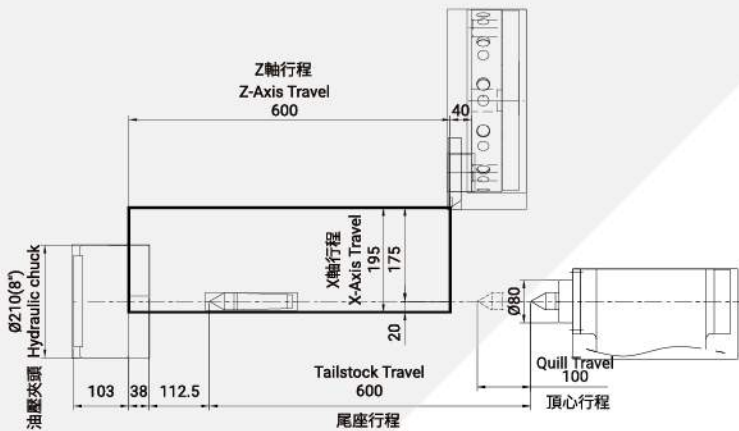
# JOA-252

單位 Unit : mm

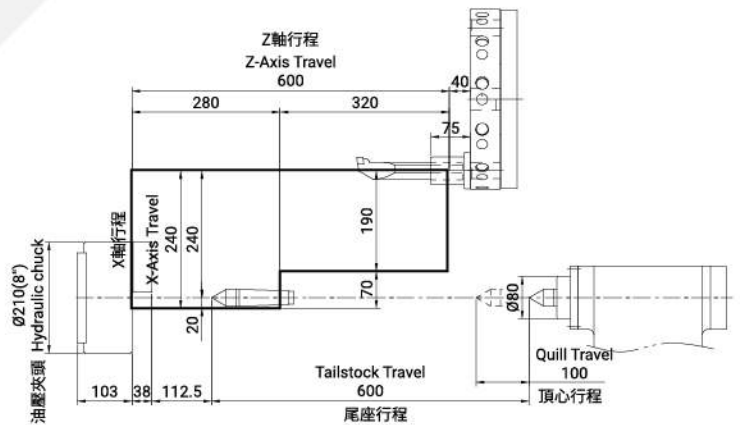
## ▶ 12位伺服動力刀塔 12 position servo power turret



▲ 刀具干涉圖(X軸)  
Tool Interference Diagram(X axis)

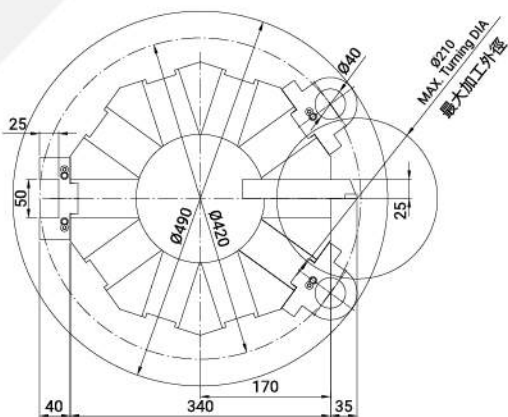


▲ 外徑刀具干涉圖(Z軸)  
O.D. Tool Interference Diagram(Z axis)

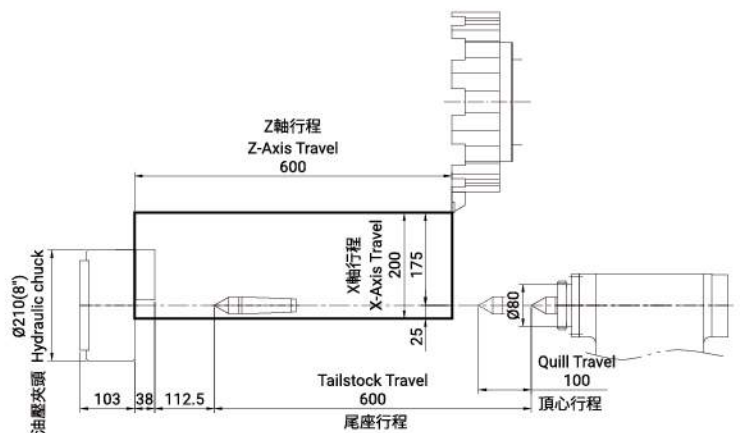


▲ 內徑刀具干涉圖(Z軸)  
I.D. Tool Interference Diagram (Z axis)

## ▶ 10位油壓刀塔 10 position hydraulic turret



▲ 刀具干涉圖(X軸)  
Tool Interference Diagram(X axis)



▲ 刀具干涉圖(Z軸)  
Tool Interference Diagram(Z axis)

# 機械規格 / MACHINE SPECIFICATION

機型 MODEL		單位	JOA-252	JOA-252	JYN-42
刀塔型式	Turret type	-	油壓 Hydraulic	動力 Servo power	油壓 Hydraulic
床面上旋徑	Swing over cross bed	mm	600	600	400
最大加工外徑	Max turning dia	mm	Ø350	Ø350	Ø320
最大加工長度	Max turning length	mm	600	600	310 (選配尾座) 310 (Optional tailstock)
主軸迴轉速	Spindle rotating speed	rpm	4,000	4,000	4,500
主軸貫穿孔徑	Bore of spindle	mm	Ø62	Ø62	Ø45
主軸馬達	Spindle motor	KW	11/15	11/15	5.5/7.5(opt)
X軸移動量	X-axis travel	mm	200	260	250
Z軸移動量	Z-axis travel	mm	600/900(opt)/1200(opt)	600/900(opt)/1200(opt)	400
X/Z軸馬達	X/Z-axis motor	KW	1.8	2.5	1
X/Z軸快速移動	X/Z-axis rapid travel speed	m/min	20	20	20
主軸鼻端	Spindle nose	-	A2-6	A2-6	A2-5
油壓夾頭	Hydraulic chuck	inch	8"	8"	6"
外徑刀尺寸	O.D. turning tool size	mm	□25	VDI 30 □20	□20
內徑刀尺寸	I.D. turning tool size	mm	Ø40	VDI 30 Ø32	Ø20
尾座心軸直徑	Quill dia. of tailstock	mm	80	80	80(opt)
尾座心軸行程	Quill stroke of tailstock	mm	100	100	100(opt)
尾座錐度	Quill taper of tailstock	-	MT#4	MT#4	MT#4(opt)
切削液幫浦	Cutting coolant pump	HP	1	1	1
切削液容量	Coolant tank volume	L	190	190	120
軌道型式	Guideway type	-	硬軌 Box guideway	硬軌 Box guideway	硬軌 Box guideway
刀塔刀具數量	Number of turret tools	-	10T	12T	10T
刀塔換刀時間 (相鄰刀)	Rotating time of turret (tool-to-tool)	sec	0.55	0.4	0.5
動力刀座轉速	Max. live tooling speed	rpm	-	5,000	-
動力刀塔馬達	Servo power turret motor	KW	-	2.2/3.7	-
機器尺寸(大約值)	Approx. machine size	mm (LxWxH)	3900 x 1900 x 2050	3900 x 1900 x 2050	2300 x 1500 x 1700
機器淨重(大約值)	Approx. net weight	KGS	4100	4150	2500

本公司產品規格/設計/特性，均不斷研究改進，如有變更，不再另行通知。

All specifications, dimensions and design characteristics shown in this catalogue are subject to change without notice.

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