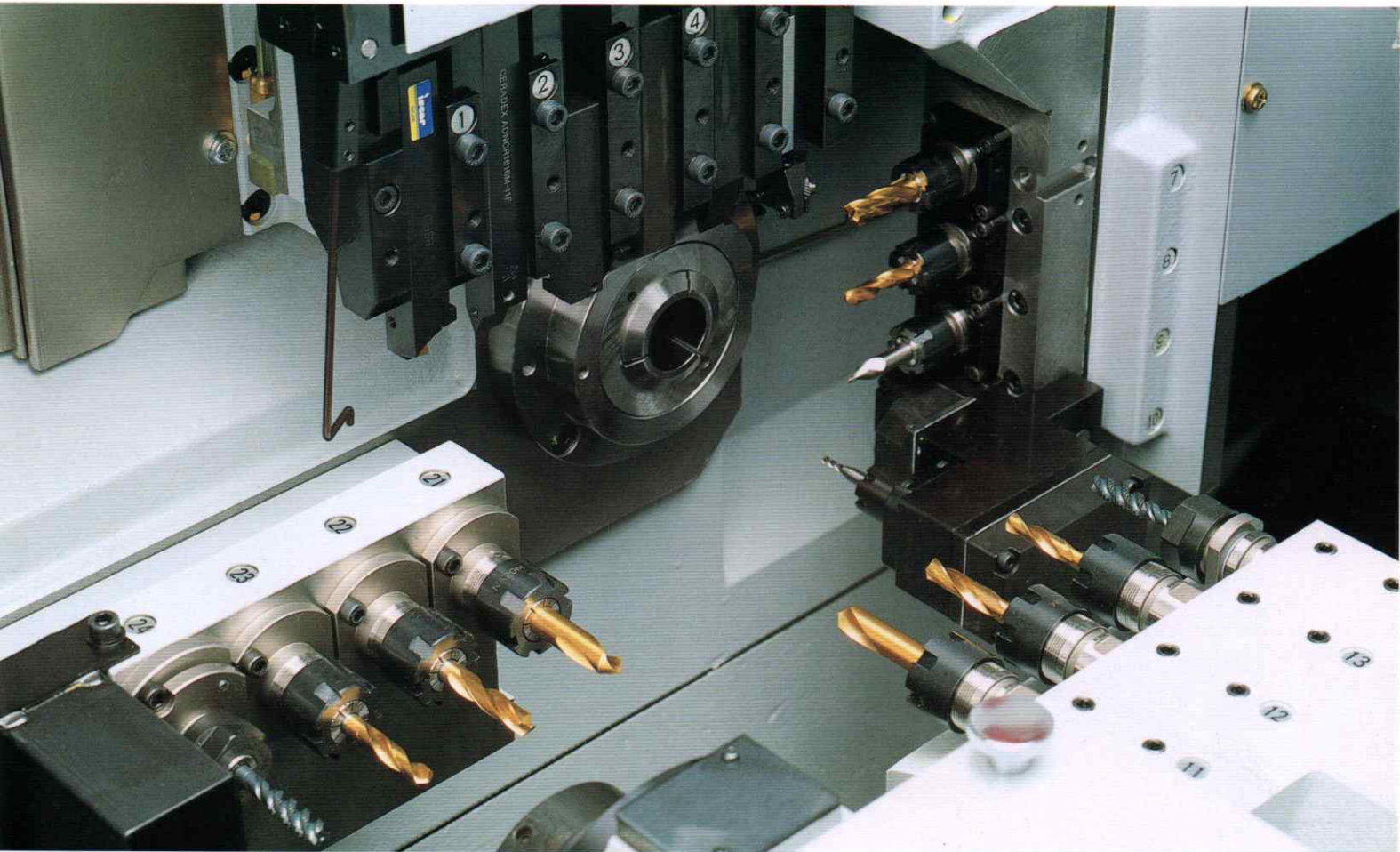


star



CNC Swiss Type Automatic Lathe

SR-32

CE marked

CNC SWISS TYPE AUTOMATIC LATHE

SR-32 CE marked

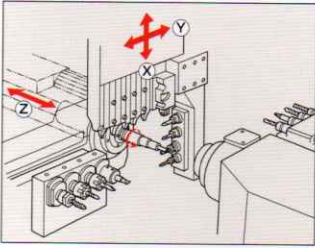
Star has the philosophy that its design machine tools should meet the needs of the users and utilise the most advanced technology available in order to continue its long history of producing superior CNC automatic lathes.

So it is that the SR series has proved to be such a popular choice.



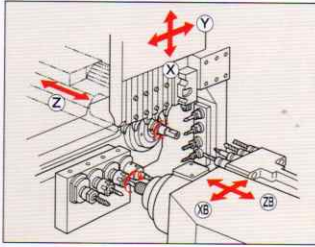
■ The SR-32 is a fast producer. High rapid traverse rates, fast control response, simple tool setting and overlapped operations all contribute to its productivity. ■ It has the power and the rigidity to work with 32mm dia. steels. 5.5/7.5kw (main) and 2.2/3.7kw (sub) spindle motors generate the power. Water-based coolant removes the heat. ■ It has space for a lot of cutting tools. 6-turning, 4-front and 4-rear-end working, plus 4-cross-working tools are equal to most requirements. ■ It has as standard what some consider optional. The main spindle has 1° indexing, the main and sub-spindles can be precisely synchronized both in rotation and traverse and material can be fed while the spindle rotates.

Turning-Main Spindle



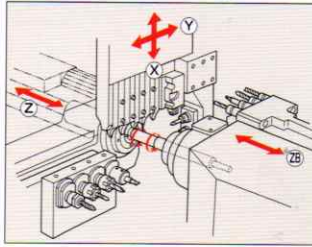
The tool-change time is reduced to the minimum by using the gang tool post design. Heavy cuts can be absorbed by the 16mm shank tools.

Turning-Sub Spindle



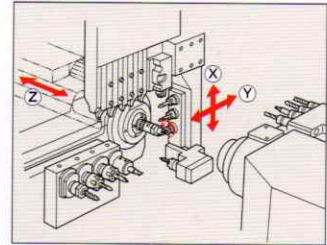
The sub-spindle accommodates all needs. Its forward position is just 17mm from the guide bush for short parts; parts up to 125mm can be forward ejected and longer parts can be fed through.

Long Shaft Machining



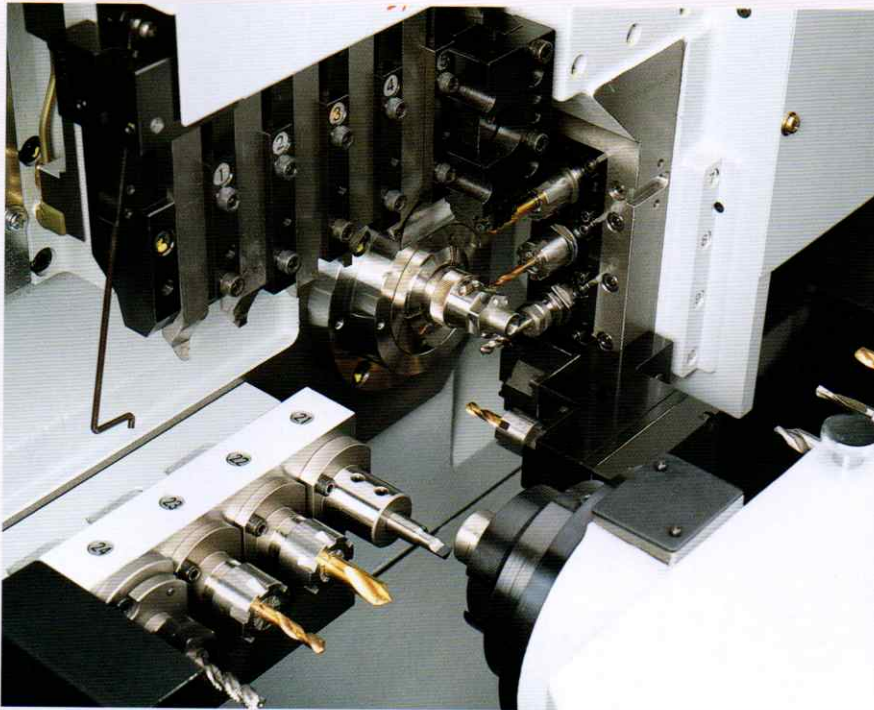
With material held in the headstock collet, supported by the guide bush and with the sub-spindle collet, long shafts can be machined very accurately.

In Process "2nd-op" Working

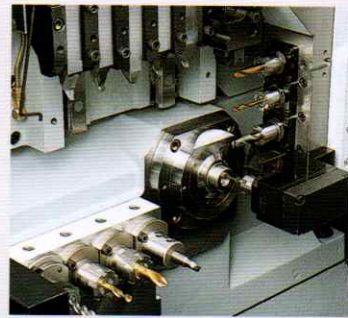


Having 4 cross-working spindles increases machining versatility, combining the possibility for drilling, tapping, milling, even to fitting a front-end working toolholder.

Star's user-friendly SR-32 makes producing turned parts easy yet efficient and environmentally friendly yet cost effective. It is packed with real user advantages.



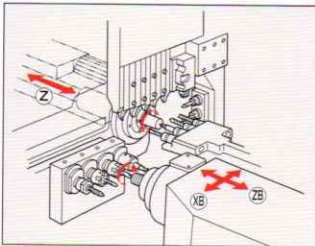
● **The front-end off-center drilling option provides extra capability.**



● **C-Axis Control is equipped as a standard function.**

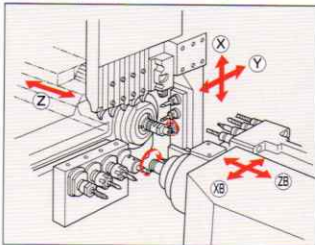


Simultaneous Front and Back End Machining



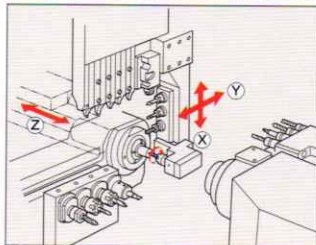
By having the capability to simultaneously perform front and back end on-center drilling, tapping and boring operations, even using different feed rates, the production time is optimized.

Overlapping Flexibility



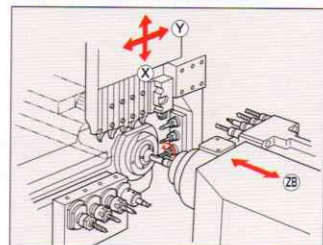
The design features of the SR-32 make it possible to carry out certain machining operations on the main spindle while doing something entirely different on the sub-spindle, for example, cross-milling with back end threading. Another time saver.

Main & Sub-Spindle Functions



Secondary machining operations on the surface of parts are facilitated by the possibility to precisely coordinate the rotation, indexing and motion of the main and sub-spindles.

Perfect Synchronization



Because phase control is perfect, the sub-spindle can clamp onto the workpiece without reducing its speed of rotation, once again giving a saving in production time.

Standard Machine Specifications

OP : Option

Item	Specifications	
Max. turning diameter	φ 32mm (1-1/4in)	
Max. headstock stroke	Standard	310mm (12-13/64in)
	With gripping unit	295mm (11-39/64in)
Max. drilling capacity	Stationary tool	φ 14mm (35/64in)
	Power-driven tool	φ 8mm (5/16in)
Max. tapping capacity	Stationary tool	M12×P1.75
	Power-driven tool	M6×P1.0
Max. milling capacity	φ 10mm (25/64in)	
Max. die cutting capacity	M10×P1.5	
Max. slotting capacity	2mm(W)×3.5mm(D) (Max. woodruff slotter dia : φ 24)	
Main spindle speed	7,000min ⁻¹	
Main spindle min. indexing angle	0.01° (C-axis control)	
Main spindle motor	5.5kw (Continuous)/7.5kw (30min.)	
Number of tools	6 Tools + 4 Power-driven tools	
Tool shank	□16×100~135mm (□5/8×4~5-5/16in)	
Power-driven attachment	Speed	5,000min ⁻¹
	Motor	0.75kw (Inverter motor)
Dimension (L×W×H)	2,515×1,505×1,870mm (Except for leveling pad)	
Main spindle center height	1,070mm (Except for leveling pad)	
Weight	2,800kg	
4-Spindle endworking attachment	Number of tools	4 Tools
	Max. drilling capacity	φ 14mm
	Max. tapping capacity	M12×P1.75
	Max. die cutting capacity	M10×P1.5
		Max. chucking diameter
		ER11 : φ 7, ER16 : φ 10
		ER20 : φ 13, T7 : φ 7
		Max. die dia : φ 30
Coolant tank capacity	120 ℓ	
Coolant motor	0.25kw	
Coolant used	Oil-based coolant, Water-based coolant	
Hydraulic tank capacity	30 ℓ	
Hydraulic pump motor	1.5kw	
Power consumption	7.0 KVA	

Backworking Specifications

OP : Option

Item	Specifications	
Max. chucking diameter	φ 32mm (1-1/4in)	
Max. length for front ejection	125mm (4-29/32in)	
Max. parts projection length	45mm (1-49/64in) Distance from collet end	
4-Spindle unit for backworking	Number of tools	4 Tools
	Max. drilling capacity	φ 13mm Max. chucking dia. ER20 : φ 13
	Max. tapping capacity	M10×P1.5 Max. chucking dia. ER16 : φ 10
Sub-spindle motor	2.2kw/3.7kw (15min.)	
Sub-spindle min. indexing angle	1° (360 divisions) : OP/15° (24 divisions) : OP	
Sub-spindle speed	7,000min ⁻¹	

Note)
The above machining capacities apply to S45C (AISI 1045, DIN c45) material.
The machining capacities may differ from listed values depending on the machining conditions, such as the material to be machined or the tools to be used.
※ Design feature, specifications and technical execution are subject to change without prior notice.
※ This machine is controlled under foreign exchange and foreign trade control law.

Standard Accessories and Functions

- Hydraulic unit
- Separate type coolant tank
- Coolant oil level detector
- Auto. centralized lubrication unit (with oil level detector)
- Revolving guide bushing
- Door interlock
- C-axis control function
- Parts ejection detector
- Main spindle inner tube 11.7mm
- Backworking attachment
- Tool holder (1 set)
- Leveling bolts and leveling pads
- Work light (Fluorescent bulb 100V/15W)

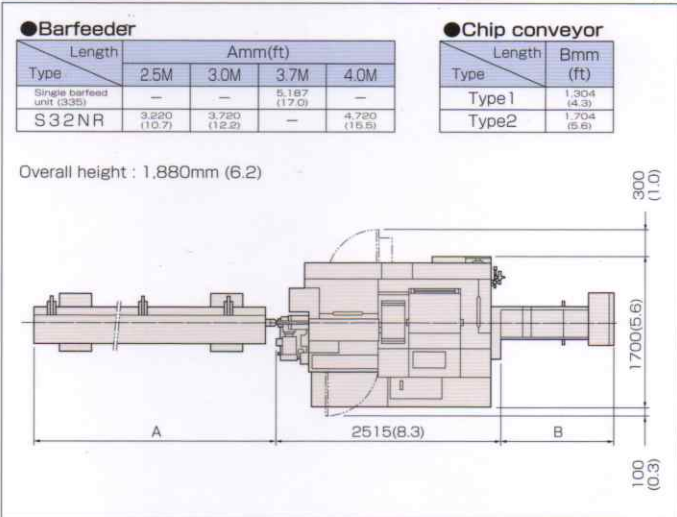
Optional Accessories and Functions

- Warning light
- Air unit
- Main spindle 15° indexing
- Sub-spindle 15° indexing
- Sub-spindle 1° indexing
- Sub-spindle indexing unit
- Long part ejector with guide tube
- Air blow version A
- Air blow version B
- Single barfeeder
- Broken cut-off tool detector
- Parts separator
- Barstock gripping unit
- Parts conveyor
- Parts stocker base
- Tool setter
- Leakage breaker
- Chip conveyor

Note) When sub-spindle 1° or 15° indexing is used, sub-spindle indexing unit is required.

External Dimensions and Floor Space

Unit : mm(ft)



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