

NEW model

star

**CNC SWISS TYPE AUTOMATIC LATHE
CNC AUTOMATIC LATHE [Non-Guide-Bush Type] Type N**

SR-32J

Type J Never Stops Advancing.



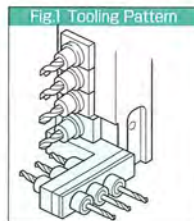
More Flexible Machining Performance and User-Friendly Operation

An advanced power machine suited to a large-diameter machining that answers the needs of the age

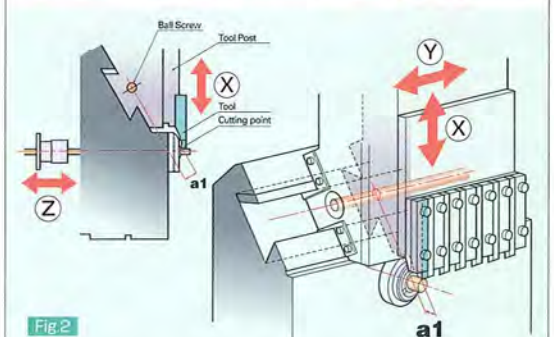
A newly designed 5-spindle cross drill unit with added cartridge positions SR-32J, newly developed, with a movable operation panel and other innovative functions.

- The lower 2 spindles out of 5 spindles of the cross drill unit are cartridge type to obtain a flexible tooling method (Fig.1). Together with increased power of the motor for cross drill unit power driven-tools, complex machining capability is further enhanced.
- A newly mounted movable operation panel enables the operator to operate the machine at the best position at all times.
- The tool post (Fig.1), with a slanted sliding guideway and a high-power spindle motor, allow rigid and powerful performance for machining large-diameter components.
- Type N, with no guide bush for minimizing the remaining material length to 70mm, is included in the product line. (The minimum remaining material length is 40mm when the used bar feeder discharges remaining materials in the forward direction.)

● Points that are more advanced than the conventional type.



Rigid tool post with "Slanted dovetail slideway structure"
The tool post with Star's original "Slanted dovetail slideway structure" improves the lifespan of cutting tools and maintains dimensional accuracy during continuous machining for long-periods.



The Y-axis slideway of the tool post incorporates a slanted dovetail structure. The X and Y-axis slideways can be arranged in a pattern close to the cutting point, which improves machine rigidity. In addition, a straight line, passing through the ball screw center which is parallel to the Y-axis slideway and the cutting point are close to each other (a1), reducing the moment load caused by cutting resistance and thereby improving rigidity.

■ Standard Machine Specifications

OP : Option

Item	SR-32J	SR-32J type N	
Max. machining diameter	φ32mm(1-1/4in)		
Max. headstock stroke	310mm(12-13/64in)	Bar diameter×2.5	
Tool	280mm(11-1/32in)	(Max.80mm)(Max.3.5/32mm)	
Tool	Number of tools	6 tools	
	Tool shank	□16mm×95~155mm, □5/8inch×95~155mm	
4-Spindle sleeve holder	Number of tools	Front 4 tools : OP Rear 2 tools(Max.4 tools) : OP	
	Max. drilling capability	φ13mm(33/64in)	
	Max. tapping capability	M12×P1.75	
	Max. die cutting capability	M10×P1.5	
Power driven att.	Number of tools	4~15 tools : including OP	
	Max. drilling capability	φ8mm(5/16in)	
	Max. tapping capability	M6×P1.0	
	Max. milling capability	φ10mm(25/64in)	
Main spindle indexing angle	C-axis control (15° : OP)		
Main spindle speed	Max.7,000min ⁻¹		
Main spindle motor	5.5kw(continuous)/7.5kw(15min./60%ED)		
Rapid feed rate	24m/min (X, Y, Z, ZB, XB)		
Power-driven att. spindle speed	Max.5,000min ⁻¹		
Power-driven att. drive motor	1.2kw		
Coolant tank capacity	174ℓ		
Dimensions (W×D×H)	2,711×1,275×1,705mm		
Weight	3,100kg		
Power consumption	6.0KVA		
A-weighted sound pressure : note-1	Max. 71dB (A)		

■ Standard Accessories and Functions

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|--|--|
| 1. CNC unit FANUC 32i-B | 12. Door interlock system |
| 2. Operation panel 10.4-inch movable color LCD display | 13. Coolant level detector (lower limit) |
| 3. Collet (Main/Sub) | 14. Broken cutoff tool detector |
| 4. Revolving guide bush unit ※ | 15. Parts ejection detector |
| 5. 6-station tool holder | 16. Leakage breaker |
| 6. C-axis control unit (Main/Sub) | 17. Pneumatic unit |
| 7. Spindle clamp unit (Main/Sub) | 18. Air purge for revolving guide bush ※ |
| 8. Drive system for power-driven attachment (including the 3-spindle cross-milling unit) | 19. Main spindle air purge unit ※※ |
| 9. 4-Spindle sleeve holder | 20. Sub spindle air blow unit |
| 10. Back 4-Spindle unit | 21. Sub spindle air purge unit |
| 11. Automatic centralized lubrication unit | 22. Work light |
| | 23. Parts conveyor |

■ Optional Accessories and Functions

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|---|--|
| 1. Spindle 15° indexing unit | 9. Coolant unit 1.5MPa |
| 2. Stopper ※※ | 10. Coolant unit 6.9MPa |
| 3. Parts ejector (A) (Air cylinder type) | 11. Coolant pipings |
| 4. Parts ejector B (Spring type) | 12. Main spindle inner tube ※※ |
| 5. Parts separator unit A | 13. Coolant flow detector |
| 6. Parts ejector with guide tube ※ | 14. Beacon |
| 7. Parts stopper unit ※ | 15. Automatic bar feeder interface |
| 8. Drive system for power-driven attachment B | 16. Water removal unit |
| | 17. Compliant with the RS-232C interface |

※ SWISS type only ※※ type N only

■ Standard Machine Specifications

OP : Option

Item	Specifications	
Max. chucking diameter	φ32mm(1-1/4in)	
Max. length for front ejection	125mm(4-59/64in)	
Max. parts projection length	45mm(1-49/64in)	
Number of tools	4 tools : OP	
Back 4-Spindle unit note-2	Max. drilling Stationary tool capability	φ13mm(33/64in)
	Power driven tool	φ6mm(15/64in)
	Max. tapping Stationary tool capability	M10×P1.5
	Power driven tool	M5×P0.8
Sub spindle indexing angle	C-axis control (15° : OP)	
Sub spindle speed	Max.7,000min ⁻¹	
Sub spindle motor	2.2kw(continuous)/3.7kw(15min./60%ED)	

Note)

The machining capacities apply to SUS303 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.

note-1 : ● Measures conforming to EN standard.

● A-weighted sound pressure is a general assessment standard characteristic that corrected the sound level to human acoustic sense.

note-2 : ● In order to use the rotary tool, the driven system for power-driven tool type B is needed.

※Design features, specifications and technical execution are subject to change without prior notice.

※This product is an export control item subject to the foreign exchange and foreign trade laws. Thus, before exporting this product, or taking it overseas, contact your STAR MICRONICS dealer.

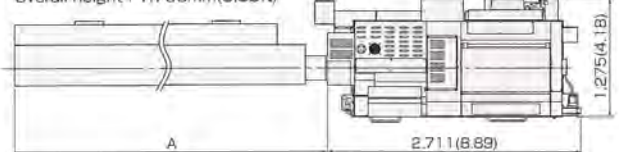
■ External Dimensions and Floor Space

unit : mm(ft)

● Bar Feeder

Type	Length A(mm)		
	2.5M	3.0M	4.0M
OS325E	3,600(11.81)	4,100(13.45)	5,100(16.73)
ASR X-32P	3,630(11.91)	4,130(13.55)	5,130(16.83)

Overall height : 1,705mm(5.59ft)



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