



VICTOR 618e

DIGITAL THREADING CONTROL

SUPER PRECISION TOOLROOM LATHE

Features

- Digital threading operations are microprocessor controlled and carried out by synchronized spindle speed and servo motor driven leadscrew
- LCD touchscreen to select thread pitch (TPI or mm) with no gears to change
- DRO functions integrated into LCD panel features linear scales on X & Z axis
- Infinitely variable spindle speeds from 50 ~ 4,000 rpm
- The spindle is mounted in high precision preloaded angular contact ball bearings
- Hardened and ground alloy tool steel bed ways
- Full bearing carriage with Turcite-B slideway bearing material between carriage & bed
- Fast lever collet chucking with a single movement
- Independent infinitely variable feeds control on carriage and cross slide
- Auto thread length control with fine adjustable stops for accurate threading
- Quick-action tool post slide for threading is instantly cleared from work
- 3 HP frequency controlled motor (Inverter Drive)



Machine may be shown with optional accessories.

SPECIFICATIONS		618e
SPINDLE CAPACITY	With jaw chucks	6" (150 mm)
	With expanding collets	3" (76 mm)
	With round 5C collets	1-1/16" (27 mm)
	With hexagon 5C collets	7/8" (22 mm)
	With square 5C collets	3/4" (19 mm)
	With step chucks	1-1/16" to 6" (27 ~152 mm)
Spindle nose diameter		Ø2.189" (Ø 55.5 mm)
Spindle nose I.D. / O.D.		5C / 4° Taper
Variable spindle speeds		50 ~ 4,000 rpm (5C Collet) 50 ~ 3,000 rpm (with 6" 3-Jaw Chuck)
Hole through spindle		1-1/4" (31.75 mm)
Distance between center		18" (457 mm)
Swing over bed		11" (280 mm)
Swing over carriage		9" (228.6 mm)
Swing over cross slide		6" (152 mm)
Carriage power feed range		5/16" ~ 7" (8 ~ 178 mm)
Cross slide power feed range		3/16" ~ 4" (5 ~ 102 mm)
Cross slide travel		6" (152 mm)
Quick-action compound slide travel		0.1" (2.5 mm)
Compound slide travel		3" (76 mm)
Tailstock spindle diameter		Ø 1.358" (Ø 34.5 mm)
Tailstock spindle taper		M.T. #2
Tailstock spindle travel		3-3/4" (95 mm)
Threads range		3.175 ~ 500 TPI (0.55 ~ 6.55 mm)
Coolant pump		1/8 HP, 220V, 3PH
Feed inverter motor		1/2 HP
Main motor		3 HP, 220V / 3PH
D.C. feed motor		110V, 70W
Net / Gross weight		2,420 / 2,640 lb. (1,100 / 1,200 kg)
Machine packing dimension		74" x 34" x 74" (1,880 x 864 x 1,880 mm)

• Specifications are subject to change without notice for further design improvements.

STANDARD ACCESSORIES

1. LCD touchscreen w/ digital threading system	2. DRO functions integrated into the LCD screen	3. Variable frequency drive
4. 5C lever type collet closer	5. Tool holder	6. Tailstock
7. Coolant system	8. Leveling screws and pads	9. Manual and parts list

OPTIONAL ACCESSORIES

1. Tool setting gage	2. 5C collet fixture plate	3. Chip and coolant shield
4. Vertical cut-off slide without cut-off blade	5. Steady rest	6. Follow rest
7. Face plate	8. Taper turning attachment	9. 6" zero-set 3-jaw chuck w/ back plate
10. 6" 4-jaw chuck w/ back plate	11. Four station turret	12. Micro carriage stop with indicator
13. 5C step chuck and closer	14. Halogen work light	15. 440V Frequency inverter conversion
16. MT #2 live center	17. Digital readout	



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