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INFORMATION REPORT INFORMATION REPORT

CENTRAL INTELLIGENCE AGENCY

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C-O-N-F-I-D-E-N-T-I-A-L

COUNTRY China

REPORT

25X1

SUBJECT Chinese Communist Export
Catalogs: Lathes

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REFERENCES

ENCLOSURE ATTACHED
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25X1

The following descriptive pamphlets published by the China National Machinery Export Corporation and describing lathes produced in Communist China

- Turret lathe, model C365L (in English, illustrated, 4 pages)
- Multi-cutter semi-automatic lathe, models C 720 and C 730 (in English, illustrated, 4 pages) (2 copies)
- Geared head lathe, model C616 (in English, illustrated, 2 pages)

Attachments, unclassified when detached from this report

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C-O-N-F-I-D-E-N-T-I-A-L

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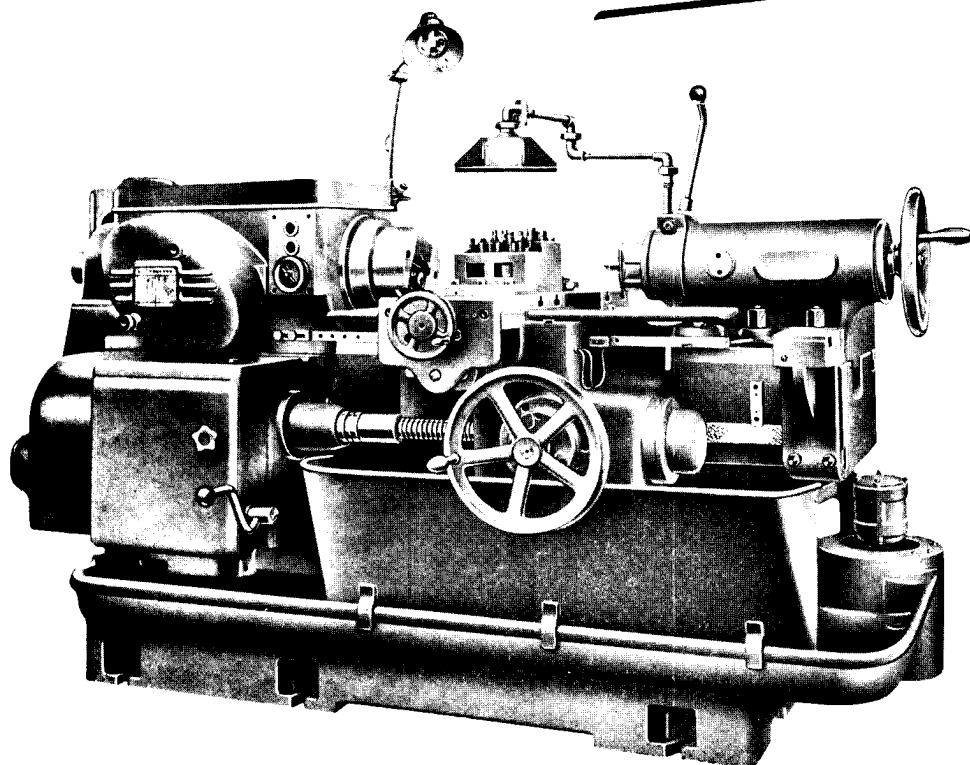
INFORMATION REPORT INFORMATION REPORT

多刀半自動車床

Multi-Cutter

Semi-Automatic Lathe

Model: C 720
C 730



中國機械進口公司

CHINA NATIONAL MACHINERY IMPORT CORPORATION

(IMPORT — EXPORT)

ER-LI-KOW, HSI-CHIAO, PEKING, CHINA

CABLE ADDRESS: "MACHIMPORT" PEKING

Technical drawing of a mechanical component, likely a pump or motor housing, showing dimensions and labels.

Labels:

- CONTROL BOX
- 5 GROOVES 25 MM (IN OIL GROOVES)

Dimensions (mm):

- Overall width: 800
- Overall height: 422
- Top left section height: 300
- Top left section width: 213
- Top right section width: 185
- Left side section height: 362
- Left side section width: 30
- Central section height: 740
- Central section width: 210
- Right side section height: 532
- Right side section width: 360
- Bottom right section height: 30
- Bottom right section width: 365
- Bottom left section height: 100
- Bottom left section width: 285
- Bottom center section width: 635
- Bottom center section height: 132
- Bottom right section width: 265
- Bottom right section height: 430
- Overall width (MAX): 1800
- Overall height (MAX): 575
- Overall height (MAX): 775
- Overall height (MAX): 1200

MULTI-CUTTER SEMI-AUTOMATIC LATHE

Model C720

The machine is suitable for machining external and end surfaces of workpieces such as stepped sleeves, pistons, gear blanks, etc., in lot and mass production.

Profile and taper turning may be effected by utilizing templates.

The machine is equipped with a front tool post (for longitudinal feed) and a rear tool post (for cross feed).

Changes of spindle speeds, longitudinal feeds of front tool post, and cross feeds of rear tool post are obtained through the change gears.

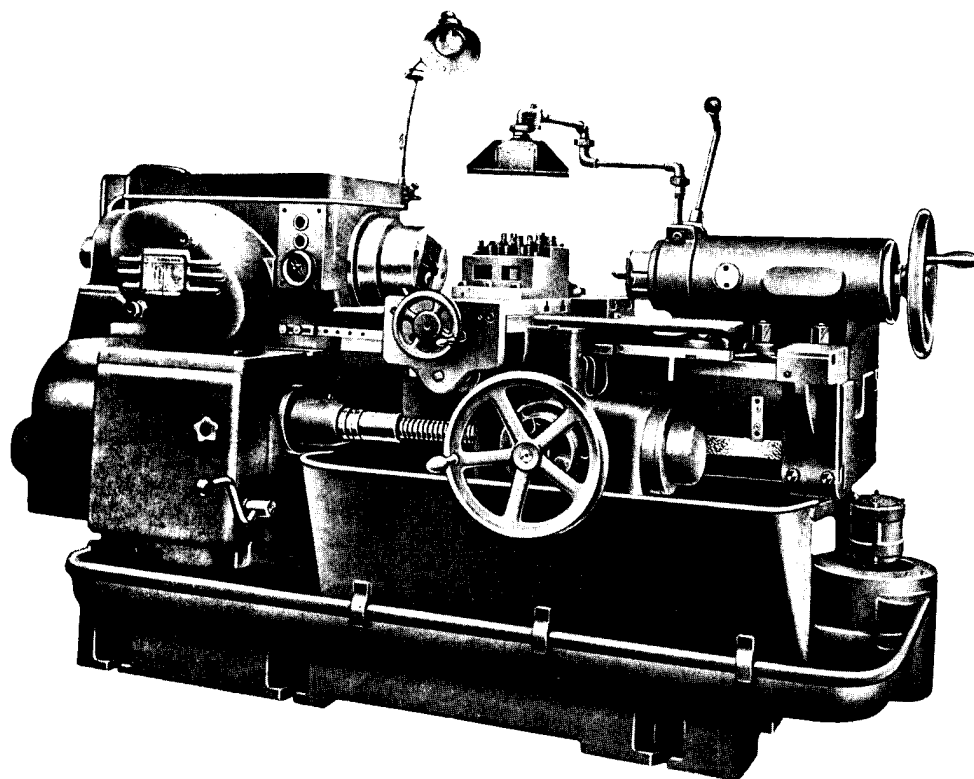
The machine is provided with an interlocking arrangement, which stops the machine automatically at the end of working cycle.

Workpieces are loaded and unloaded by hand.

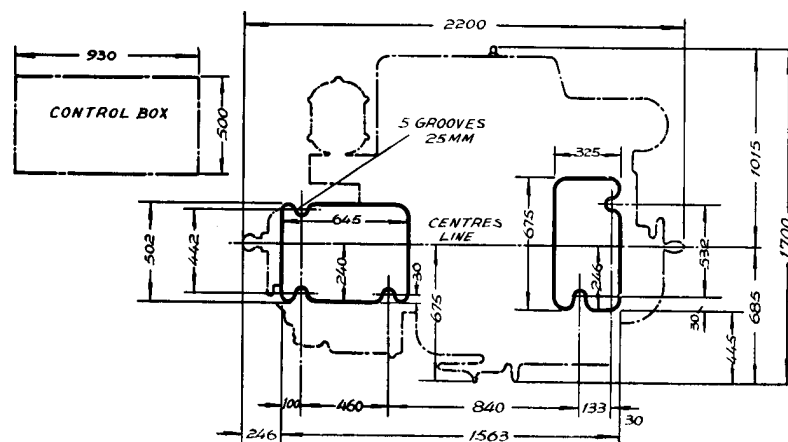
The machine is operated by a single level control.

SPECIFICATION

Centre height	150 mm.
Distance between centres:	
Minimum	0 mm.
Maximum	300 mm.
Max. distance, spindle nose (ϕ 120 mm) to tailstock centre	325 mm.
Max. diameter to be turned:	
Bar material	32 mm.
Swing over carriage	200 mm.
Swing over bed	300 mm.
Max. length to be turned (with 2 pcs. of cutters):	
Using compound tool post	250 mm.
Using single tool post	260 mm.
Max. longitudinal travel of front tool post:	
Compound cutting: Power (working)	100 mm.
Manual (adjusting)	200 mm.
Single cutting: Power (working)	150 mm.
Manual (adjusting)	250 mm.
Max. cross travel of rear tool post:	
Power (working)	90 mm.
Manual (adjusting)	155 mm.
Max. travel of centre sleeve in tailstock	120 mm.
Spindle speeds	105; 131; 154; 196; 236; 296; 354; 442; 532; 680; 794; 1000; rpm.
Longitudinal feeds of front tool post per revolution of spindle	0.07; 0.10; 0.16; 0.23; 0.32; 0.48; 0.72; 1.02 mm.
No. of cross feeds per longitudinal feed	12
Range of cross feeds of rear tool post per revolution of spindle	0.019-2.51 mm.
Motors: 3-phase, A. C.	
for main drive:	Power ... 5.8 KW. Speed ... 1450 rpm.
for coolant pump:	Power ... 0.25 KW. Speed ... 2800 rpm.
Overall dimension (L \times W \times H)	1800 \times 1290 \times 1340 mm.
Net weight	1800 kg. approx.



Model C730



MULTI-CUTTER SEMI-AUTOMATIC LATHE

Model C730

This machine is suitable for turning plain and external cylindrical surfaces of workpieces (such as stepped sleeves, pistons, gear blanks, etc.), clamped either between centres or by chuck in large scale as well as in mass production.

When equipped with template, it can also be used for profile and taper turning.

The machine is provided with a front tool slide (for longitudinal feed) and a rear tool slide (for cross feed).

The longitudinal feed of front tool slide, the cross feed of rear tool slide, and the spindle speed are controlled by means of the change gears.

The machine is equipped with an automatic interlock. It stops automatically after the working cycle is completed.

Workpieces are loaded and unloaded manually.

The machine is operated by means of a single hand lever.

SPECIFICATION

Height of centres	200 mm.
Distance between centres:	
Max.	500 mm.
Min.	200 mm.
Max. distance between spindle nose (dia. 185 mm.) and centre of tailstock	580 mm.
Max. diameter to be turned:	
Dia. of bar material	48 mm.
Over tool post	300 mm.
Over bed	410 mm.
Max. length of workpiece to be turned (with two pieces of tools)	460 mm.
Max. longitudinal travel of front tool slide:	
Power (working)	250 mm.
Manual (adjusting)	325 mm.
Max. cross travel of rear tool slide:	
Power (working)	135 mm.
Manual (adjusting)	225 mm.
Max. travel of centre sleeve of tailstock	165 mm.
Spindle speed	40; 52; 65; 84; 107; 129; 155; 187; 240; 310; 388; 500 rpm.
Longitudinal feed of front tool slide	0.12; 0.17; 0.23; 0.34; 0.49; 0.71; 0.97 1.38 mm/rev.
Number of cross feeds per longitudinal feed	12
Range of cross feed by rear tool slide	0.16-2.37 mm/rev.
Motors, A.C., 3 phase	
for Main drive:	Power 10 KW. Speed 1455 rpm.
for Rapid traverse of tool slide:	Power 1 KW. Speed 1425 rpm.
for Coolant pump:	Power 0.15 KW. Speed 2800 rpm.
Overall dimension (L×W×H)	2200×1700×1420 mm.
Net weight	3000 kg. approx.

BRANCHES

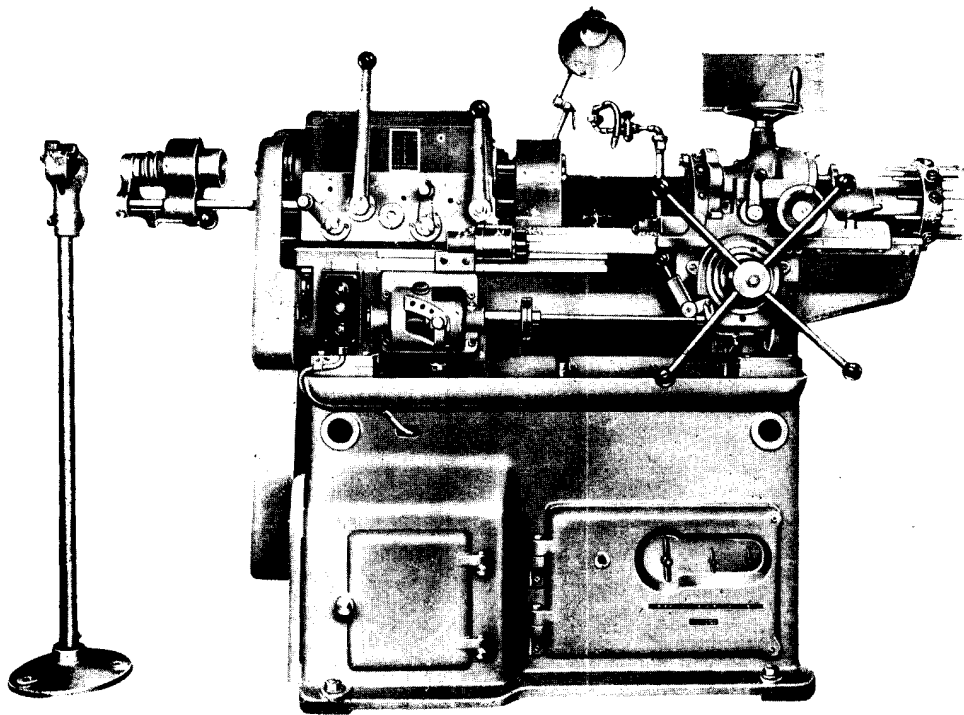
TIENTSIN OFFICE: 171 Chien Shien Road (Ho Si District)
Cable Address: MACHIMPORT Tientsin

SHANGHAI OFFICE: 27 Chung Shan Road E I
Cable Address: MACHIMPORT Shanghai

CANTON OFFICE: No. 2, West Bund Road, Canton
Cable Address: MACHINERY Canton

Twiner Lathes

六角車床



中國機械進口公司

CHINA NATIONAL MACHINERY IMPORT CORPORATION

(IMPORT — EXPORT)

ER-LI-KOW, HSI-CHIAO, PEKING, CHINA

CABLE ADDRESS: "MACHIMPORT" PEKING

Technical drawing of a mechanical part, likely a bracket or support, showing dimensions in millimeters. The drawing includes a top view and a side view. Key dimensions include overall width 3200, overall height 1780, and various internal features like holes (φ22, φ24) and fillets (R10, R25).

TURRET LATHE

Model C365L

This machine is suitable for turning workpieces which require a series of successive operations such as cylindrical turning, thread cutting, etc. The workpiece is held either in a three-jaw chuck or other work-holding fixtures. The necessary tools are held by collets inside the 6 holes of turret or set on a 4-way tool holder of cross slide. The machine is driven by an individual motor.

The spindle speed is controlled by headstock gears, and the feeds of turret and cross slide by feed gear box underneath the apron.

The rotation of spindle is reversible.

The turret saddle is provided with reversible power feed, hand travel and power rapid traverse with automatic disengagement at the end of the back stroke. It is also provided with automatic limit stops for stopping feeds. The feed mechanism is provided with automatic overload release. Turret saddle, cross slide, and stop-drum can be simultaneously adjusted by hand to the required positions.

The cross slide is capable of longitudinal and cross feeds, and can be automatically disengaged by means of the limit stops. It is provided with stop-drum, on which 6 stops are intended for stopping longitudinal feeds and one for stopping the cross feeds.

By means of work-holding fixtures, tapers, grooves, and threads can also be machined on this lathe.

S P E C I F I C A T I O N

Height of centres	210 mm.
Distance between end of spindle and turret face:	
Min.	260 mm.
Max.	1177 mm.
Maximum swing (for chucking work):	
Over bed ways	440 mm.
Over cross slide	350 mm.
Over carriage	420 mm.
Maximum longitudinal travel of turret (by manual or power)	917 mm.
Maximum travel of cross slide (by manual or power):	
Longitudinal	1012 mm.
Cross	259 mm.
No. of spindle speeds	12
Range of spindle speed:	
Forward	44-1000 rpm.
Reverse	48-1094 rpm.
Nos. of cross and longitudinal feeds	16
Range of feeds of turret and cross slide per revolution of spindle:	
Longitudinal	0.07-2.29 mm.
Cross	0.03-1.00 mm.
Motor (3-phase, A.C.):	
Power	10 KW.
Speed	1500 rpm.
Overall dimension (L x W x H)	3200 x 1780 x 1450 mm.
Net weight	2980 kg. approx.

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TURRET LATHE

Model C325

This machine is suitable for turning all kinds of rods fixed on the spring collet or in the chuck. Cutters are secured at the 12 holes on the turret.

This machine is driven by an electric motor.

By means of the templates, profile turning can be carried out when the longitudinal feed of turret and the cross feed are taking place simultaneously.

The spindle speed is controlled by headstock gear box and the longitudinal feed by feed gear box.

The longitudinal feed can be automatically disengaged by means of the adjustable limit stop.

SPECIFICATION

Height of centers	115 mm.
Distance between end of spindle and turret face	90-400 mm.
Diameter of hole in spindle	26 mm.
Max. size of bar material:	
Round (diameter)	25 mm.
Square (side)	18 mm.
Hexagonal (side)	21 mm.
Max. turning length	150 mm.
Max. diameter of work held in chuck:	
Over turret slide	250 mm.
Over bed ways	300 mm.
Max. longitudinal travel of turret	330 mm.
No. of spindle speeds	6
Range of spindle speed	140-1380 rpm.
No. of longitudinal feeds of turret	4
Range of feed per revolution of spindle	0.06-0.25 mm.
Motor (3-phase, A.C.):	
Power	2.2 KW.
Speed	1450 rpm.
Overall dimension (L x W x H)	1815 x 740 x 1290 mm.
Net weight	900 kg. approx

N.B.—*For improvement of the machine, we reserve the right to alter either the design or the specification.*

BRANCHES

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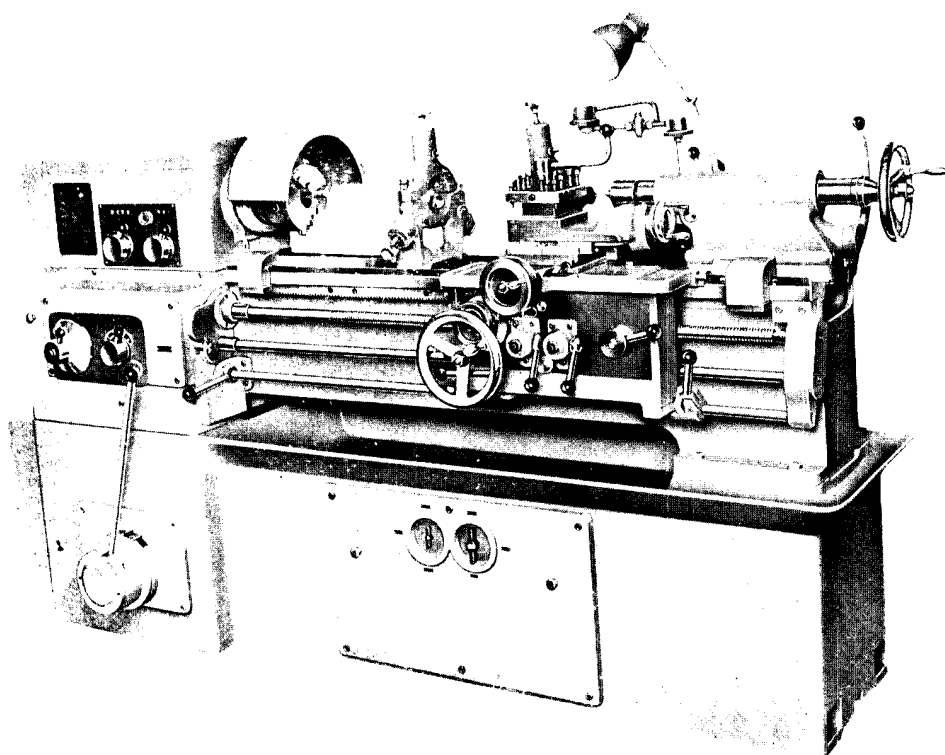
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普通車床

GEARED HEAD LATHE

Model C616

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中國機械進口公司
CHINA NATIONAL MACHINERY IMPORT CORPORATION
(IMPORT — EXPORT)
ER-LI-KOW, SHIH-CHIAO, PEKING, CHINA
CABLE ADDRESS: "MACHIMPORT" PEKING

GEARED HEAD LATHE

Model C616

This machine is suitable for general lathe work and thread-cutting of different types of threads in Metric, Whitworth, Module, and Diametral pitches. It is also suitable for turning different kinds of workpieces held between centres and by chuck.

The outstanding features of this machine are its rugged construction, higher spindle speed, and simple operation.

The speed of spindle is controlled by means of the headstock gears housed in the machine base and the backgears of headstock; feeding and thread-cutting are adjusted by means of the feed gear box and change gears.

An interlock is provided to prevent simultaneous engagement of lead screw and feed rod.

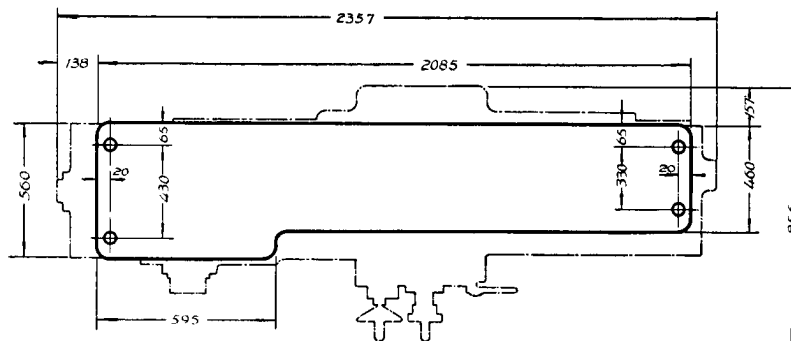
The machine is fitted with protective unit for safety during high speed operation.

Accessories attached with the machine:—face plate, 3-jaw chuck, centre rest, follow rest, centres, etc.

SPECIFICATION

Centre height	160 mm.
Distance between centres	750 mm.
Max. diameter to be turned:	
Swing over cross slide	175 mm.
Swing over bed ways	320 mm.
Thread cutting:	
Metric, pitch	0.5-9 mm.
Whitworth threads	38-2 t.p.i.
Module	0.5-9
Max. travel of carriage	
(by power and manual):	
Longitudinal	850 mm.
Cross	210 mm.

Distance from tool bottom to centre line of spindle	20 mm.
Max. distance, face of tool holder to centre line	185 mm.
Max. size of tool (W x H)	25 x 20 mm.
Dia. of hole in spindle	30 mm.
Taper hole in spindle	Morse No. 5
Taper hole of centre sleeve in tailstock	Morse No. 4
Max. traverse of centre sleeve in tailstock	95 mm.
Max. cross traverse of tailstock	± 10 mm.
No. of spindle speeds (forward and reverse)	12
Range of spindle speed	44-1980 rpm.
No. of feeds of carriage, longitudinal and cross	140
Range of feed of carriage per revolution of spindle:	
Longitudinal	0.06-3.36 mm.
Cross	0.044-2.46 mm.
Motors, A.C., 3 phase.	
For main drive:	
Power	4.3 KW.
Speed	1450 rpm.
For coolant pump:	
Power	0.1 KW.
Speed	2800 rpm.
Overall dimension (L x W x H)	2357 x 856 x 1275 mm.
Net weight	1950 kg.



N.B.—For improvement of the machine, we reserve the right to alter either the design or the specification.

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