

BAOJI



1 Machine specifications and features

1.1 Machine basic specifications

Items	BJ1640G BJ1640A BJ1640GD	BJ1840G BJ1840A BJ1840GD BJ1840D/B	BJ50
Max. swing over bed mm	φ410(16")	φ458(18")	φ510(20")
Max. swing over cross slide mm	φ240(9 7/16)	φ288(11 5/16)	φ305(12")
Max. swing in gap mm	φ595(23 7/16)	φ640(25 3/16)	φ745(29 3/8)
Available length in gap mm	155 (6 1/8)		320(12 9/16)
Max. distance between centers mm	750/1000/1500 (30"/40"/60")		1500/2000(60"/80")
Max. machining length mm	650/900/1400(26"/35"/55")		1400/1900(55"/75")
Max. machining length (with taper attachment) mm	530/780/1280(20"/30"/50")		1280/1780(50"/70")
Center height	1085(42 3/4)	1110(43 3/4)	1150(45 1/4)
Spindle bore mm	φ52(2 1/16)	BJ1840D/B:φ77(3")	φ82(3 1/4)
Spindle nose	ISO702/II No.6 cam lock type: BJ1840D/B;BJ50:ISO702/III No.8 cam lock type		
Spindle taper	Morse No.6; BJ1840D/B; BJ50: φ90mm 1:20 (3 35/64,1:20)		
Spindle speeds r/min	BJ1 _{640G} :8-step; BJ1 _{640A} :16 or 12-step; BJ1 _{640GD} :12-step; BJ1840D/BJ50:12-step		
Travel distance of compound rest mm	120(4 3/4)	200(7 7/8)	
Travel distance of cross slide mm	230(9")	315(12 7/16)	
Longitudinal lead screw pitch mm	4TPI or 6		
Max. section of cutting tool mm×mm	25×25(1" ×1")		
Longitudinal lead screw pitch	40 kinds, 0.0012" ~ 0.0352" /r	50 kinds	
Cross feeds half longitudinal values.			50 kinds
Pitch type and range			
Metric threads	53 kinds 0.4 ~ 14	24 kinds	
Inch threads	40 kinds 2 ~ 56TPI	50 kinds	
Diametral pitch threads	32 kinds 4 ~ 56D.P	50 kinds	
Module pitch threads	44 kinds 0.4 ~ 7M.P	34 kinds	
Diameter of tailstock quill mm	φ55(2 1/8)	φ75(2 15/16)	
Travel distance of tailstock quill mm	120(4 3/4)	180(7 5/16)	
Taper of tailstock quill	Morse No.4	Morse No.5	
Main motor	Y112M-4.4kW; YD132M-8/4, 3kW/4.5kW	7.5kW	
Coolant pump	90W or 1/8 HP		