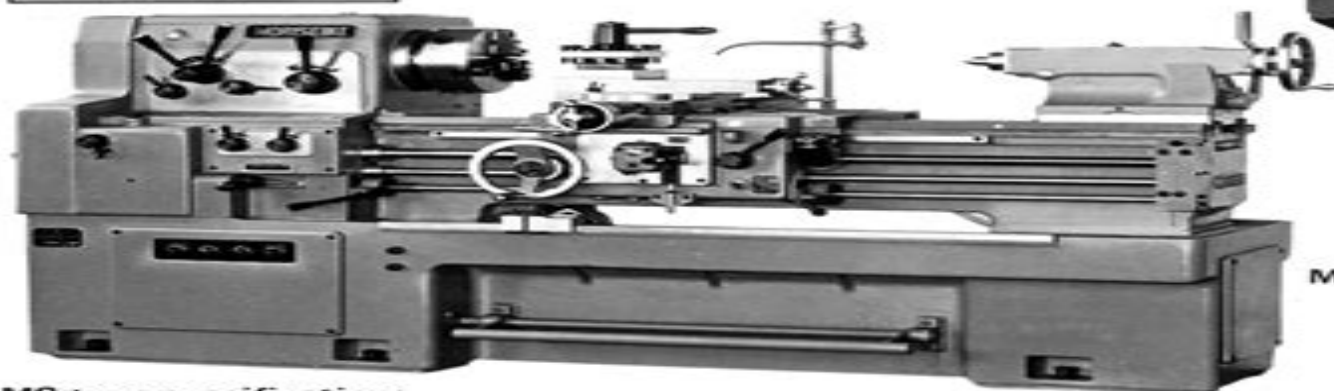
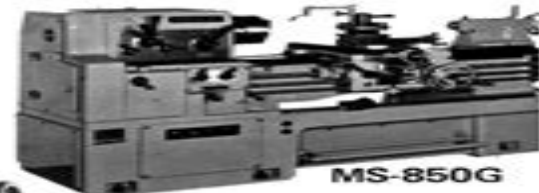


MS type

On lathes with cutoff devices, the apron handle is located in a different position.



MS-850



MS-850G

MS type specifications

Unit: Inch (mm)

	MS-650	MS-850	MS-1250	MS-850G	MS-1250G
Swing			17.13" (435mm)		
Swing Over Bed			19.29" (490mm)		
Swing Over Bed from Face Plate up to 7" (180mm)			9.84" (250mm)		
Swing Over Cross Slide				25.59" (650mm)	
Swing Over Gap					
Distance					
Width of Gap (from Face Plate)			8.46" (215mm)		
Distance from Bed to Spindle Center			42.32" (1075mm)		
Distance from Floor to Spindle Center			49.21" (1250mm)		
Between Centers (A)	25.59" (650mm)	33.46" (850mm)		33.46" (850mm)	49.21" (1250mm)
Spindle					
Spindle Nose			ASA A1-6 or D1-6		
Hole Thru Spindle			2-3/64" (52mm)		
Spindle Sleeve Taper			M.T. No. 6		
Spindle Center Taper			M.T. No. 4		
Number of Spindle Speeds			12		
Spindle Speed Range (RPM)			32, 62, 82, 112, 160, 200, 285, 395, 510, 710, 1010, 1800		
Feeds					
Number of Feed Changes (both longitudinal and cross feeds)			40		
Range of Longitudinal Feeds			0.0017 ~ 0.0246" (0.045 ~ 0.627mm)/rev. & 0.0035 ~ 0.0493" (0.090 ~ 1.254mm)/rev.		
Range of Cross Feeds			0.0017 ~ 0.0246" (0.045 ~ 0.627mm)/rev. & 0.0035 ~ 0.0493" (0.090 ~ 1.254mm)/rev.		
Threads					
Lead Screw			1.25" (31.75mm) dia. x Acme thread 4 T.P.I. or 6mm pitch		
Inch Threads			80 ~ 4 T.P.I.		
Metric Threads			0.25 ~ 7mm pitch		
D.P. Threads			112 ~ 8		
Module Threads			0.5 ~ 3.5		
Tool Post					
Cross Slide Travel			10" (255mm)		
Compound Rest Travel			5.90" (150mm)		
Max. Cutting Tool Size (X x Y)			0.98" x 0.98" (25 x 25mm)		
Tail Stock					
Tail Stock Spindle Stroke			6" (150mm)		
Spindle Center Taper			M.T. No. 4		
Bed					
Bed Width			13.85" (352mm)		
Bed Length	66.14" (1680mm)	74.01" (1880mm)	89.76" (2280mm)	74.01" (1880mm)	89.76" (2280mm)
Motor					
Main Motor			5 HP (3.7 kw) 4P		
Motor for Coolant System			75W (1/10 HP) 2P or 7.5 HP (5.5 kw) 4P (Optional)		
Floor Space (B)					
	78x36" (1990x930mm)	86x36" (2190x930mm)	102x36" (2590x930mm)	86x36" (2190x930mm)	102x36" (2590x930mm)
Net Weight	3927 lbs (1785 kg)	4257 lbs (1935 kg)	4917 lbs (2235 kg)	4257 lbs (1935 kg)	4917 lbs (2235 kg)

Standard Accessories

- 4 jaw independent chuck (12") & handle
- Driving plate 240φ
- Center sleeve (M.T. No. 6)
- Center (high speed steel) M.T. No. 4
- Center (carbide tip) M.T. No. 4
- Coolant pump (MS-650, option)

- Change gears 72 teeth
- Installation blocks
- Grease pump
- Box handle
- Single-ended wrench
- Screwdriver
- Hex. handles

Optional Accessories

- 3 jaw chuck (8")
- Face plate 400φ
- 500φ (G type only)
- Inverse tool post
- Taper cutting attachment; 300 type
- Max. taper angle 20°
- Max. taper length 300mm
- Turret stopper

- Bed stopper
- Steady rest (30φ ~ 125φmm)
- Steady rest with rolls (90φ ~ 210φmm)
- Follow rest
- Copying attachment
- Chuck cover (9")
- D.P./Module change gears
- Coolant pump (MS-650)
- Worm gear (22T, 13T)
- Drill attachment

Mori Seiki Lathe Training Manual

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Mori Seiki Lathe Training Manual:

Easy CNC Turning Programming English Hand Book By Sanjay Sharma Sanjay Sharma, 2025-04-15 This book is a comprehensive guide to CNC basic programming which has been written for the use of students of ITI Diploma B Tech etc Technical courses ATS Scheme CNC Programmer Cum Operator DGT Nimi course and machine operators machine setters and supervisors working in other types of industries Nowadays the increasing use of CNC in industries has given rise to its need Only those people who know about it and are capable of preparing part programs can guide the machine tools Using which parts are prepared with the required size and accuracy Keeping this in mind I have prepared this textbook in Hindi to bring out the mystery of CNC programming It has been put in a logical order and written in a very simple language which everyone can understand very easily To create a program the step by step process has been explained in this book with useful examples which will greatly benefit the students associated with this field In this book I have used the method created by me to write the program in which I have described each G and M code in detail in this book Coordinate systems have been explained in detail in simple language For this space has been left to practice all the coordinate systems This will help in understanding this chapter easily In this most of the machining centers functions of machines working method of the machine and the main parts of the machine control panel buttons related to the operator panel have been described in detail Simple method of making programs has been explained with examples An attempt has been made to cover most of the machining processes in this Different types of materials and detailed pictures have been included to help in understanding it My feeling is that anyone who wants to make their future in CNC programming will benefit from this book and they will emerge as a successful CNC programmer Many readers who may need some other different kind of programmer will benefit from these references with additional information On the other hand those who do not need further information about CNC programming can ignore those few pages and only explore the topics covered in this book I sincerely hope that this book will help you transform from a better CNC operator to a programmer by understanding not only the HOW but also the WHY of many programming techniques

Job Shop Lean Shahrukh A. Irani, 2020-05-04 In the 1950 s the design and implementation of the Toyota Production System TPS within Toyota had begun In the 1960 s Group Technology GT and Cellular Manufacturing CM were used by Serck Audco Valves a high mix low volume HMLV manufacturer in the United Kingdom to guide enterprise wide transformation In 1996 the publication of the book Lean Thinking introduced the entire world to Lean Job Shop Lean integrates Lean with GT and CM by using the five Principles of Lean to guide its implementation 1 identify value 2 map the value stream 3 create flow 4 establish pull and 5 seek perfection Unfortunately the tools typically used to implement the Principles of Lean are incapable of solving the three Industrial Engineering problems that HMLV manufacturers face when implementing Lean 1 finding the product families in a product mix with hundreds of different products 2 designing a flexible factory layout that fits hundreds of different product routings and 3 scheduling a multi

product multi machine production system subject to finite capacity constraints Based on the Author s 20 years of learning teaching researching and implementing Job Shop Lean since 1999 this book Describes the concepts tools software implementation methodology and barriers to successful implementation of Lean in HMLV production systems Utilizes Production Flow Analysis instead of Value Stream Mapping to eliminate waste in different levels of any HMLV manufacturing enterprise Solves the three Industrial Engineering problems that were mentioned earlier using software like PFAST Production Flow Analysis and Simplification Toolkit Sgetti and Schedlyzer Explains how the one at a time implementation of manufacturing cells constitutes a long term strategy for Continuous Improvement Explains how product families and manufacturing cells are the basis for implementing flexible automation machine monitoring virtual cells Manufacturing Execution Systems and other elements of Industry 4 0 Teaches a new method Value Network Mapping to visualize large multi product multi machine production systems whose Value Streams share many processes Includes real success stories of Job Shop Lean implementation in a variety of production systems such as a forge shop a machine shop a fabrication facility and a shipping department Encourages any HMLV manufacturer planning to implement Job Shop Lean to leverage the co curricular and extracurricular programs of an Industrial Engineering department *The Foundry Trade Journal* ,1981

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