



VICTOR 1800S SERIES

PRECISION HEAVY-DUTY LATHE

Features

- One piece heavy-duty cast iron base with special exit for chips removal
- Full Meehanite casting bed
- Oversized rigid compound rest for heavy cutting
- Hardened and precision ground gears and bedways
- Hardened and ground spindle nose
- Headstock transmission gears driven by spline shafts
- Spindle is supported by 3-point bearings
- Safety overload device
- Inch/metric threading without changing gears
- 7.5 HP main motor delivers full power at all 12 speeds



Machine may be shown with optional accessories.

SPECIFICATIONS		1840S	1860S
CAPACITY	Max. swing over bed	18" (458 mm)	
	Max. swing over cross-slide	11-5/16" (288 mm)	
	Max. swing in gap	25-3/16" (640 mm)	
	Width of bed	11-13/16" (300 mm)	
	Max. distance between centers	40" (1,000 mm)	60" (1,500 mm)
HEADSTOCK	Spindle bore diameter	2-3/8" (60 mm)	
	Spindle bore taper	M.T. No. 6	
	Taper of center in sleeve	M.T. No. 4	
	Spindle nose	D1-6	
	Number of spindle speeds	12 steps	
	Range of spindle speeds	30 ~ 2,000 rpm	
THREADS AND FEEDS	Number of cross and longitudinal feeds	40	
	Range of longitudinal feeds	0.0012" ~ 0.0252"/ rev. (0.032 ~ 0.898 mm/ rev.)	
	Range of cross feeds	0.0006" ~ 0.0126"/ rev. (0.032 ~ 0.449 mm/ rev.)	
	Whitworth threads per inch	2 ~ 56 TPI x 40 Kinds	
	Metric Thread	0.4~14 mm x 52 Kinds	
	Diametral threads	4 ~ 32 D.P. x 32 Kinds	
	Module threads	0.4 ~ 7 M.P. x 44 Kinds	
TAILSTOCK	Tailstock spindle diameter	2-3/8" (60 mm)	
	Max. tailstock spindle travel	5-9/10" (150 mm)	
	Tailstock spindle bore taper	M.T. No. 4	
POWER	Main Motor	7-1/2 HP 3 PH	
	Coolant Pump	1/8 HP 3PH	
MACHINE DIMENSIONS	Gross machine weight (approx.)	4,400 lb. (2,000 kg)	5,060 lb. (2,300 kg)
	Packing measurement (approx.)	89" x 40" x 61" (2,260 x 1,020 x 1,550 mm)	110" x 40" x 61" (2,800 x 1,1020 x 1,550 mm)

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

STANDARD MACHINE ACCESSORIES

1. Center sleeve	1 pc	7. Thread dial indicator	1 set	13. Lever change inch/metric box gear	1 pc
2. Tool top wrench	1 pc	8. M.T. No 4 dead center	2 pcs	14. Inch/Metric dual dials	1 set
3. Hex wrenches	1 set	9. 7-/12HP 3PH motor(voltage optional)	1 pc	15. Safety pin	2pcs
4. Gun oiler	1 pc	10. ⊖ and ⊕ screw driver	1 ea.	16. Safety fuses	3pcs
5. D.P. / M.P. change gear	1 pc	11. Operation manual & parts	1 pc	17. Tool box & tool kits	1 set
6. Leveling screws & pads	6 ea	12. Coolant system	1 set	18. Repair paint	1can

OPTIONAL MACHINE ACCESSORIES

1. 4-way tool post	7. 4-jaw independent chuck	13. Micro saddle stop
2. Quick change tool post	8. Chuck back plate	14. 4-position saddle cover stop
3. American tool post	9. Face plate	15. Work light
4. Rear tool post	10. Steady rest 1" ~ 6"	16. Fast lever 5C collet closer
5. 3-jaw scroll chuck	11. Follow rest	17. Live center with replaceable tips
6. Chuck cover (or with micro switch)	12. Taper turning attachment	18. Full length splash guard



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