

## Preface

In order to make you select spare parts well, maintain the lathes and ensure normal operation of the lathes, conveniently, we have compiled the list of spare parts, and the simple construction.

The list consists mainly of driving gears, shafts, bushes, worm, worm gears, split nuts, leadscrews, racks, feed rods, driving forks, slide blocks, control cams, levers setting gibs and seal rings etc.

The types and quantities of the bearings and the electrical elements can be found in the ball and roller bearing diagram and the electrical circuit diagram which are shown in the "INSTRUCTION BOOK" for models CA6140, CA6240, CA6150 and CA6250. From these diagrams you may select the bearings and the electrical elements which are by you required.

Excepting spare parts in relation to beds, other spare parts are applicable respectively to models CA6140, CA6240, CA6150 and CA6250, therefore we have also put them in this list. The Works' part number and the quantities of the rack, leadscrew and feed rod in bed units are determined according to the model and size (distance between the centres) of each lathe indicated in the "Remarks" column of the list.

We recommend; You may select the spare parts as you need with reference to the list. And it is necessary to indicate the manufacturer, the model of the lathe, the yielding date (serial number), designation, work's part number, quantity of the required spare, part so that we can supply the spare parts correctly.

# 维 修 配 件 目 录

## LIST OF SPARE PARTS

序号 oN.	件号 (规格和型号) Works' part Number (Size & Type)	配 件 名 称 Designation	每台件数 Qty./set	备 注 Remarks
1	01013 (全长140mm) (Full length: 140 mm)	齿 条 Rack	1	CA6240 CA6250
2	01014 (全长604mm) (Full length: 604mm)	齿 条 Rack	1	CA6140 CA6240 CA6150 CA6250
3	01015 (全长502mm) (Full length: 502mm)	齿 条 Racks	1	CA6140/1000 CA6150/1000 CA6240/1500 CA6250/1500
			2	CA1640/1500 CA6150/1500
			3	CA6140/2000 CA6250/2000
4	01039/750 (全长251mm) (Full length: 251mm)	齿 条 Rack	1	CA6140/750 CA6150/750 CA6240/1000 CA6250/1000 CA6240/1500 CA6250/1500
5	01016/750	丝 杠 Leadscrew	1	CA6140/750 CA6240/750 CA6150/750 CA6250/750
6	01016/1000	丝 杠 Leadscrew	1	CA6140/1000 CA6240/1000 CA6150/1000 CA6250/1000

序号 No.	件号(规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
7	01016/1500	丝杠 Leadscrew	1	CA6140/1500 CA6240/1500 CA6150/1500 CA6250/1500
8	01016/2000	丝杠 Leadscrew	1	CA6140/2000 CA6150/2000
9	01017/750	光杠 Feed rod	1	CA6140/750 CA6240/750 CA6150/750 CA6250/750
10	01017/1000	杠杠 Feed rod	1	CA6140/1000 CA6240/1000 CA6150/1000 CA6250/1000
11	01017/1500	光杠 Feed rod	1	CA6140/1500 CA6240/1500 CA6150/1500 CA6250/1500
12	01017/2000	光杠 Feed rod	1	CA6140/2000 CA6150/2000
13	01019	后托架 Rear support	1	
14	02013	I 轴 Shaft I	1	
15	02015	皮带轮座 Pulley support	1	
16	02020	齿轮 Gear	1	
17	02023	摩擦片 Friction clutch discs	12	

序号 No.	件号(规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
18	02024	摩擦片 Friction clutch discs	14	
19	02028	齿 轮 Gear	1	
20	02029	拉 杆 Pull rod	1	
21	02030	杠 杆 Lever	1	
22	02031	压 环 Compressing ring	1	
23	02032	II 轴 Shaft II	1	
24	02035	齿 轮 Gear	1	
25	02037	齿 轮 Gear	1	
26	02038	齿 轮 Gear	1	
27	02039	齿 轮 Gear	1	
28	02041	III 轴 Shaft III	1	
29	02042	齿 轮 Gear	1	
30	02043	齿 轮 Gear	1	
31	02045	齿 轮 Gear	1	
32	02046	齿 轮 Gear	1	
33	02047	IV 轴 Shaft IV	1	
34	02049	齿 轮 Gears	2	
35	02050	齿 轮 Gear	1	
36	02052	齿 轮 Gear	1	

序号 No.	件号(规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
37	02054	V 轴 Shaft V	1	
38	02057	齿 轮 Gear	1	
39	02058	齿 轮 Gear	1	
40	02059	齿 轮 Gear	1	
41	0189030L	主 轴 Spindle	1	
42	02065A	密 封 圈 Seal ring	1	
43	02069	套 Bush	1	
44	02070	斜 齿 轮 Bevel gear	1	
45	02071	齿 轮 Gear	1	
46	02073	齿 轮 Gear	1	
47	02079	齿 轮 Gear	1	
48	02082	拨 叉 Driving fork	1	
49	02083	齿 轮 Gear	1	
50	02084	齿 轮 Gear	1	
51	02085	齿 轮 Gear	1	
52	02086	Ⅱ 轴 Shaft Ⅱ	1	
53	02087	齿 轮 Gear	1	
54	02089	X 轴 Shaft X	1	
55	02092	齿 轮 Gear	1	

序号 No.	件号 (规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
56	02094	齿 轮 Gear	1	
57	02097	拨 叉 Driving fork	1	
58	02099	X II 轴 Shaft X II	1	
59	02100	拨 叉 Driving foik	1	
60	02102	齿 条 轴 Rack rod	1	
61	02103	拨 叉 Driving fosk	1	
62	02107	拨 叉 Driving fork	1	
63	02113	杠 杆 Lever	1	
64	02114	拨 杆 Driving lever	1	
65	02115	凸 轮 Cam	2	
66	02125	杠 杆 Lever	1	
67	02126	拨 块 Driving blcok	1	
68	02129	杠 杆 Lever	1	
69	02139	凸 轮 Cam	1	
70	02141	凸 轮 Cam	1	
71	02142	杠 杆 Lever	1	
72	02143	杠 杆 Lever	1	
73	02145	杠 杆 Lever	1	
74	02146	刹 车 钢 带 Brake steel band	1	

序号 No.	件号 (规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
75	0 2 1 4 7	刹 车 带 Brake band lining	1	
76	0 2 1 4 9	调 整 螺 钉 Adjusting screw	1	
77	0 2 1 5 0	杠 杆 Lever	1	
78	0 2 1 5 7	扇 形 齿 轮 Sector gear	1	
79	0 2 1 6 7	调 整 螺 钉 Asjusting screws	2	
80	0 2 1 9 3	滑 块 Slide blocks	13	
81	20; G51-2	密 封 环 Seal rings	3	
82	30; G51-2	密 封 环 Seal ring	1	
83	32; G51-2	密 封 环 Seal ring	1	
84	36; G51-2	密 封 环 Seal ring	1	
85	35 × 55; G51-4	密 封 环 Seal ring	1套 set	
86	25 × 32ga × 40; Q41-1	轴 套 Bush	1	
87	B铜25 × 32ga × 32; Q41-1 B,copper	轴 套 Bush	2	
88	16; Q99-1	滑 块 Slide block	3	
89	6/5; S25-10	顶 尖 套 Centre sleeve	1	
90	0 3 0 1 4	丝 杆 Leadscrew	1	
91	0 3 0 1 5	螺 母 Nut	1	
92	H.5; S25-2	顶 尖 Centre	1	
93	0 4 0 1 2	镶 条 Gib	1	

序号 No.	件号(规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
94	04023	销 Locating Pin	1	
95	04024	套 Bushes	4	
96	04028	刀架螺杆 Tool post screw	1	
97	04029	螺母 Nut	1	
98	M16×50;GB83—66	方头螺钉 Square tool post screws	8	
99	05017	齿轮 Gear	1	
100	05018	套 Bush	1	
101	05019	进刀螺杆 Feed screw	1	
102	05021	螺母 Nut	1	
103	05022	楔块 Wedge	1	
104	05023	螺母 Nut	1	
105	05038	银条 Gib	1	
106	06012A	齿轮轴 Gear shaft	1	
107	06013	齿轮 Gear	1	
108	06014	齿轮 Gear	1	
109	06015A	套 Bush	1	
110	06023	齿轮 Gear	1	
111	06024	齿轮 Gear	1	
112	06025B	套 Bush	1	



序号 No.	件号(规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
113	06028	轴 Shaft	1	
114	06029	齿 轮 Gear	1	
115	06030	齿 轮 Gear	1	
116	06031	轴 Shaft	1	
117	06032	齿 轮 Gear	1	
118	06033A	蜗 轮 Worm Wheel	1	
119	06034	齿 轮 Gear	1	
120	06035	齿 轮 Gear	1	
121	06039	齿 轮 Gear	1	
122	06040	齿 轮 Gear	1	
123	06041	齿 轮 Gear	1	
124	06042	轴 Shaft	1	
125	06043	齿 轮 Gear	1	
126	06044	齿 轮 Gear	1	
127	06045	结 合 子 Clutches	2	
128	06050	凸 轮 Cam	1	
129	06051	镶 条 Gib	1	
130	06062	套 Bush	1	
131	06063	套 Bush	1	

序号 No.	件号(规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
132	06068	凸 轮 Cam	1	
133	06069	拨 叉 Driving fork	1	
134	06082A	杠 杆 Lever	1	
135	06086	对 开 螺 母 Split nut	1	
136	06090	齿 轮 Geat	1	
137	06091	套 Bush	1	
138	06092	齿 轮 Geat	1	
139	06101	齿 轮 Gear	1	
140	06102A	星 形 体 Astral body	1	
141	06107A	蜗 杆 Worm	1	
142	06108A	轴 Shaft	1	
143	06109	齿 轮 Gear	1	
144	06110	套 Bush	1	
145	06111A	齿 轮 Geat	1	
146	06117	拨 叉 Driving fork	1	
147	06119	拨 叉 Driving fork	1	
148	06123A	齿 轮 Gear	1	
149	06124	凸 轮 Cam	1	
150	06143A	套 Bush	1	

序号 No.	件号(规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
151	16×22ga×16; Q41-1	轴套 Sleeve	1	
152	20×28ga×25; Q41-1	轴套 Sleeves	2	
153	C22×30ga×20; Q41-1	轴套 Sleeve	1	
154	B22×30ga×28; Q41-1	轴套 Sleeve	1	
155	B22×30ga×22; Q41-1	轴套 Sleeve	2	
156	28×35ga×30; Q41-1	轴套 Sleeve	1	
157	18×25ga×30; Q41-1	轴套 Sleeve	1	
158	8; C31-1-34	滚子 Rollers	3	
159	4; C31-1-35	销 Locating Pins	3	
160	07014	轴 Shaft	1	
161	07015	齿轮 Gear	1	
162	07017	齿轮 Gear	1	
163	07018	轴 Shaft	1	
164	07020	凸轮 Cam	1	
165	07021	轴 Shaft	1	
166	07022	齿轮 Gear	1	
167	07026	齿轮轴 Gear Shaft	1	
168	07027	齿轮 Gear	1	
169	07028	齿轮轴 Gear Shaft	1	

序号 No,	件号(规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
170	07029	齿 轮 Gear	1	
171	07030	齿 轮 Gear	1	
172	07031	齿 轮 Gear	1	
173	07032	齿 轮 Gear	1	
174	07033	套 Bush	1	
175	07035	齿 轮 Gear	1	
176	07036	轴 Shaft	1	
177	07037	轴 Shaft	1	
178	07038	齿 轮 Gear	1	
179	07039	滑 块 Slide blocks	2	
180	07041	杠 杆 Lever	1	
181	07047	联 杆 Connecting	1	
182	07049	拨 块 Driving block	1	
183	07052	杠 杆 Lever	1	
184	07053	杠 杆 Lever	1	
185	07054	拨 块 Driving block	1	
186	07061	偏 心 轮 Eccentric	1	
187	07063	凸 轮 板 Cam plate	1	
188	07064	滑 块 Slide block	1	

序号 No.	件号 (规格和型号) Works' Part Number (Size & Type)	配件名称 Designation	每台件数 Qty./set	备注 Remarks
189	07071	齿 轮 Gear	1	
190	07072	齿 轮 Gear	1	
191	07073	齿 轮 Gear	1	
192	07074	齿 轮 Gear	1	
193	07075	齿 轮 Gear	1	
194	07076	齿 轮 Gear	1	
195	07077	齿 轮 Gear	1	
196	07078	齿 轮 Gear	1	
197	07081	齿 轮 Gear	1	
198	07082	齿 轮 Gear	1	
199	07083	齿 轮 Gear	1	
200	07084	齿 轮 Gear	1	
201	07095A	杠 杆 Lever	1	
202	07096A	杠 杆 Lever	1	
203	07097A	杠 杆 Lever	1	
204	07098A	杠 杆 Lever	1	
205	07113	滑 块 Slide block	4	
206	30×50; G51—4	密 封 圈 Seal ring	2套 2sets	
207	B12; Q99—1	滑 块 Slide block	1	



# 床身装配图

Assembly Drawing of Bed

各规格齿  
条件号见目录

各规格丝  
杠件号见目录

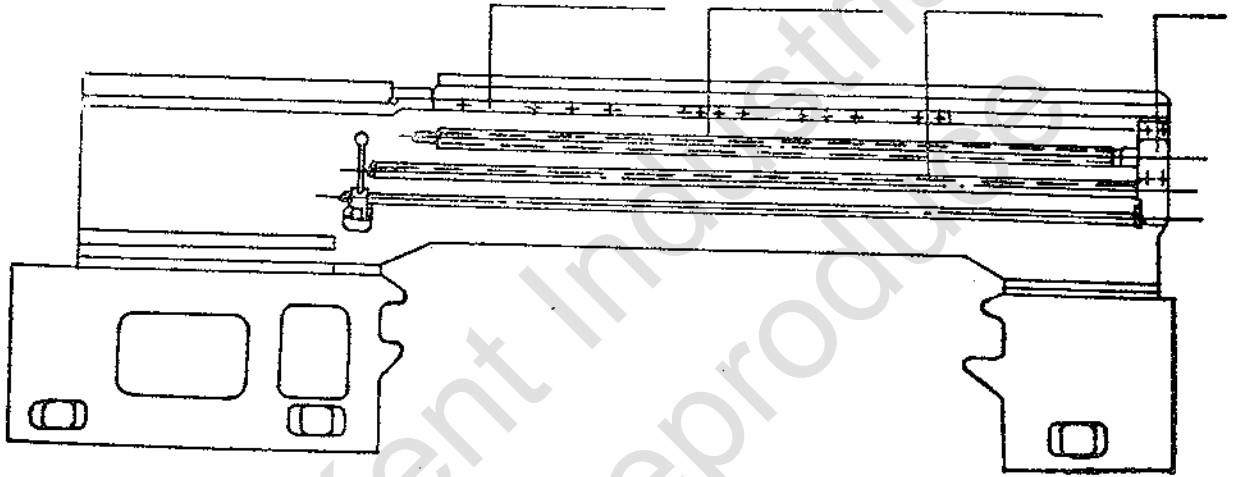
各规格光  
杠件号见目录

Works' part numbers of all sizes of the racks are shown in the list.

Works' part numbers of all sizes of the lead screws are shown in the list.

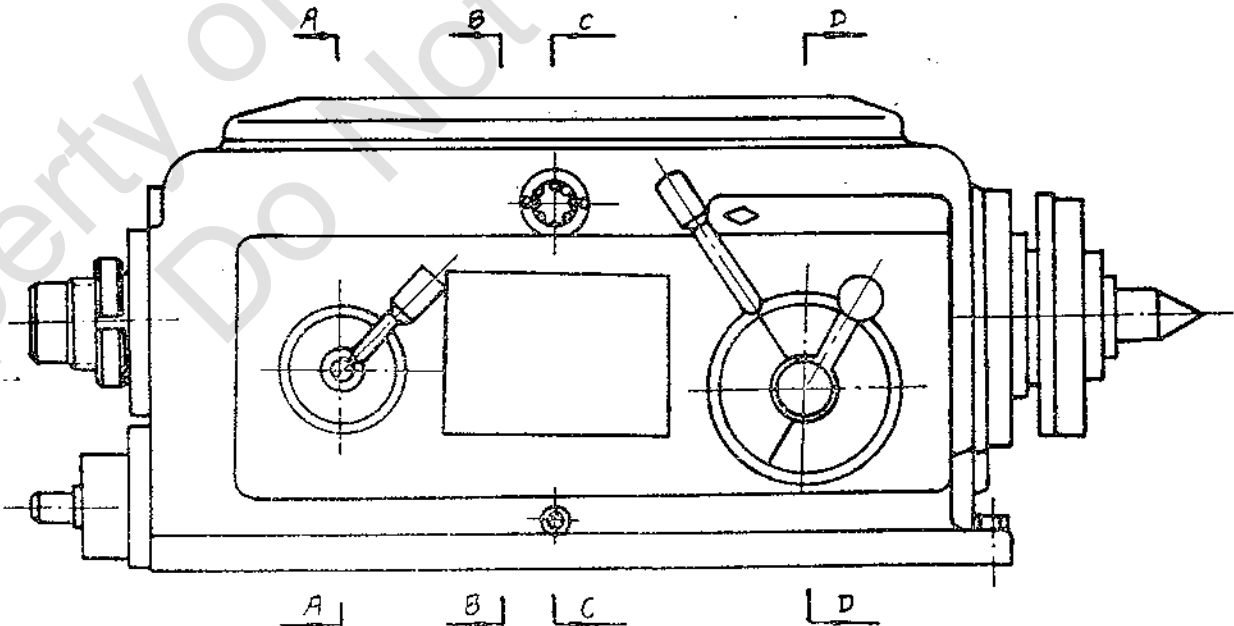
Works' part numbers of all sizes of the feed rods are shown in the list.

01019



## 床头箱外观图

External view of Headstock

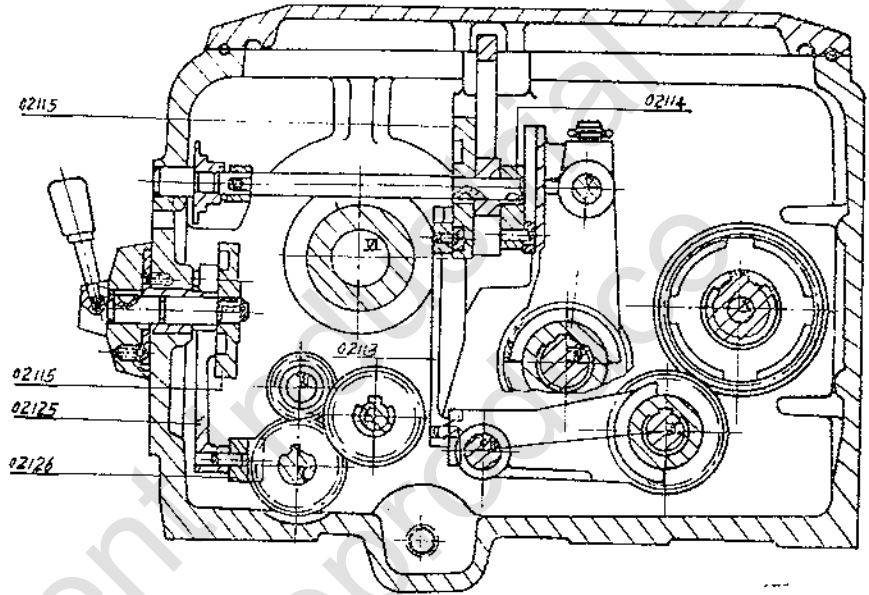






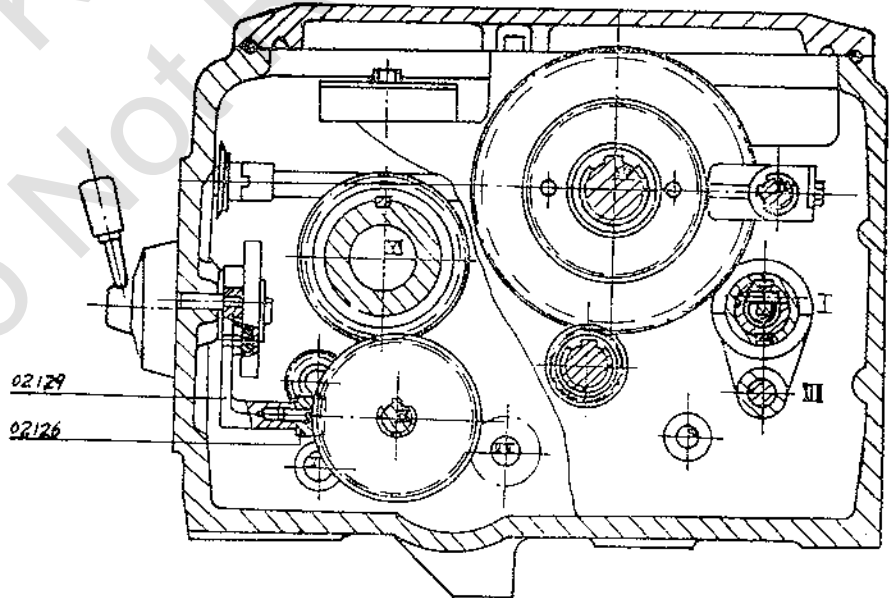
A—A 床头箱操纵机构

A—A Control Mechanism of Headstock



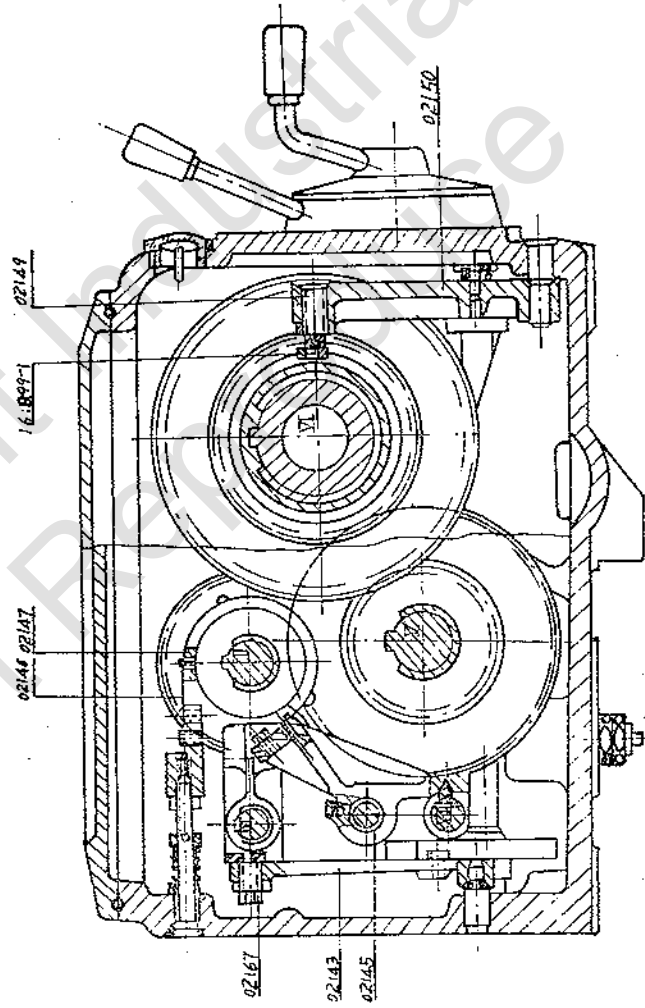
B—B 床头箱操纵机构

B—B Control Mechanism of Headstock



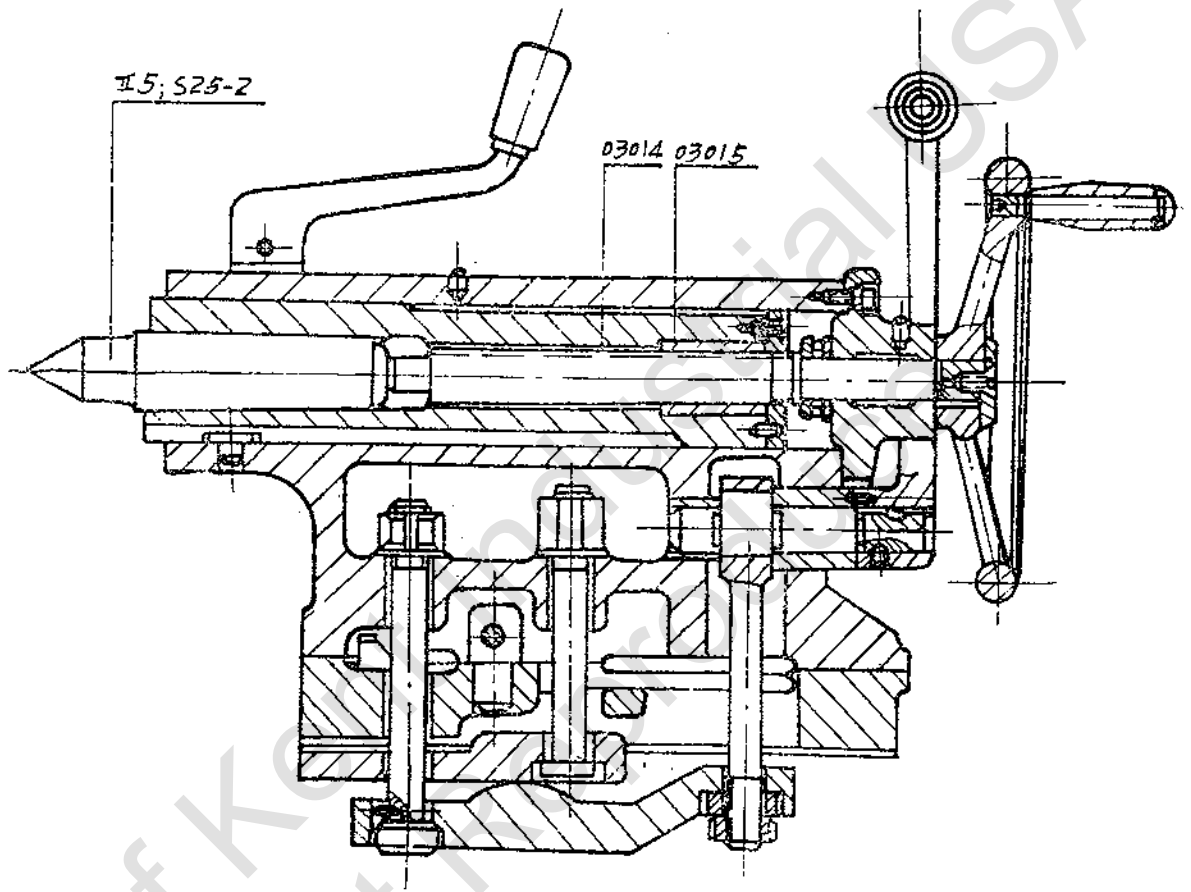
# C—C 床头箱操纵机构

C—C Control Mechanism of Headstock



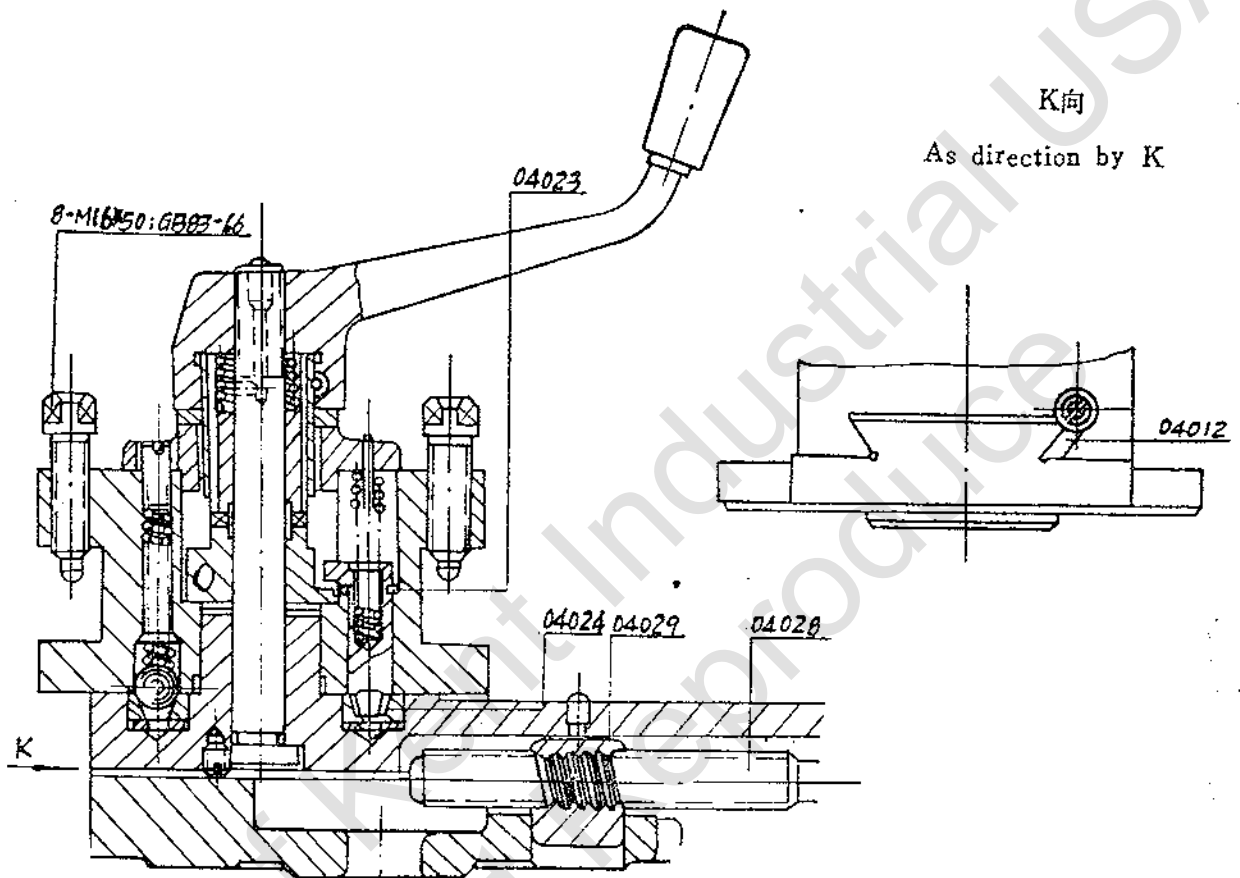


台尾装配图  
Assembly Drawing of Tailstock

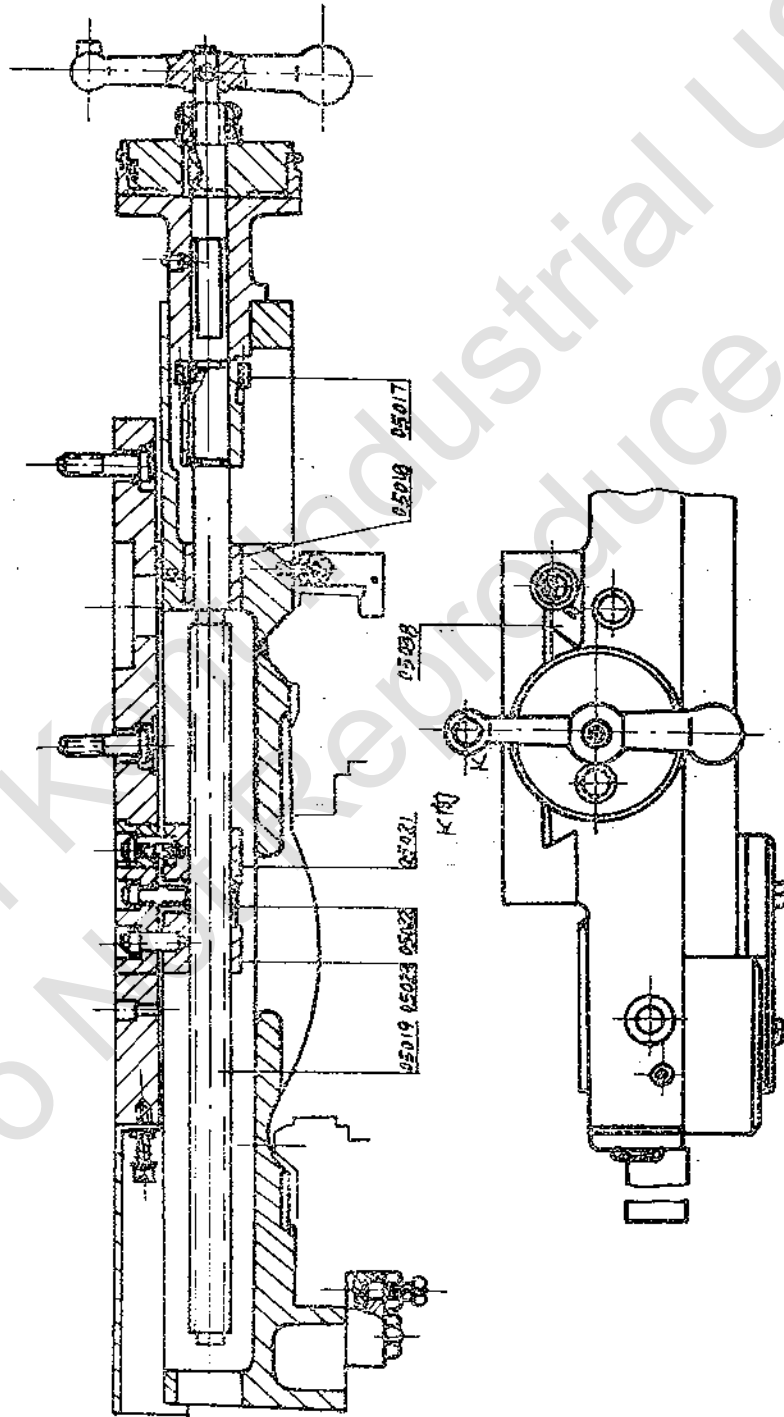


# 刀架装配图

Assembly Drawing of Tool post



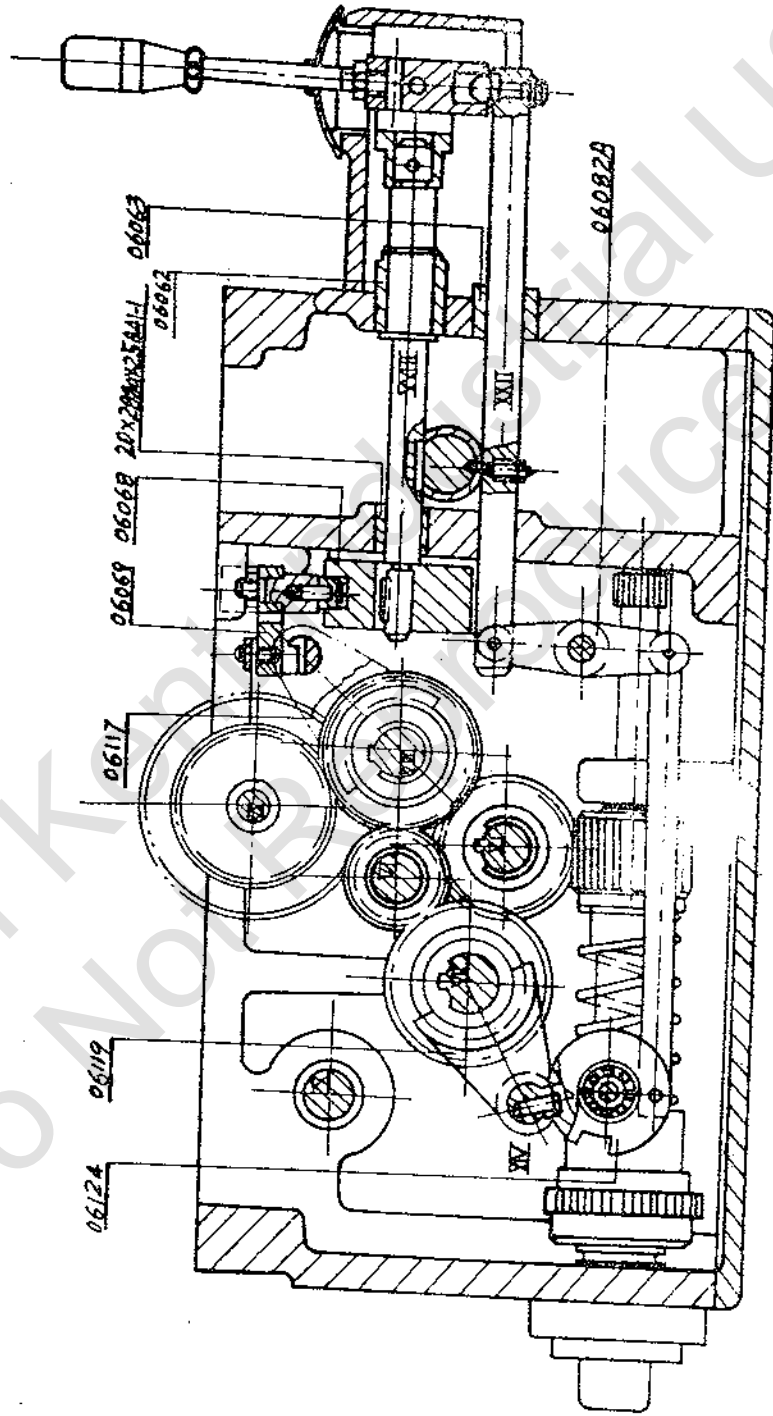
床鞍装配图  
Assembly Drawing of Saddle





# 溜板箱操纵机构

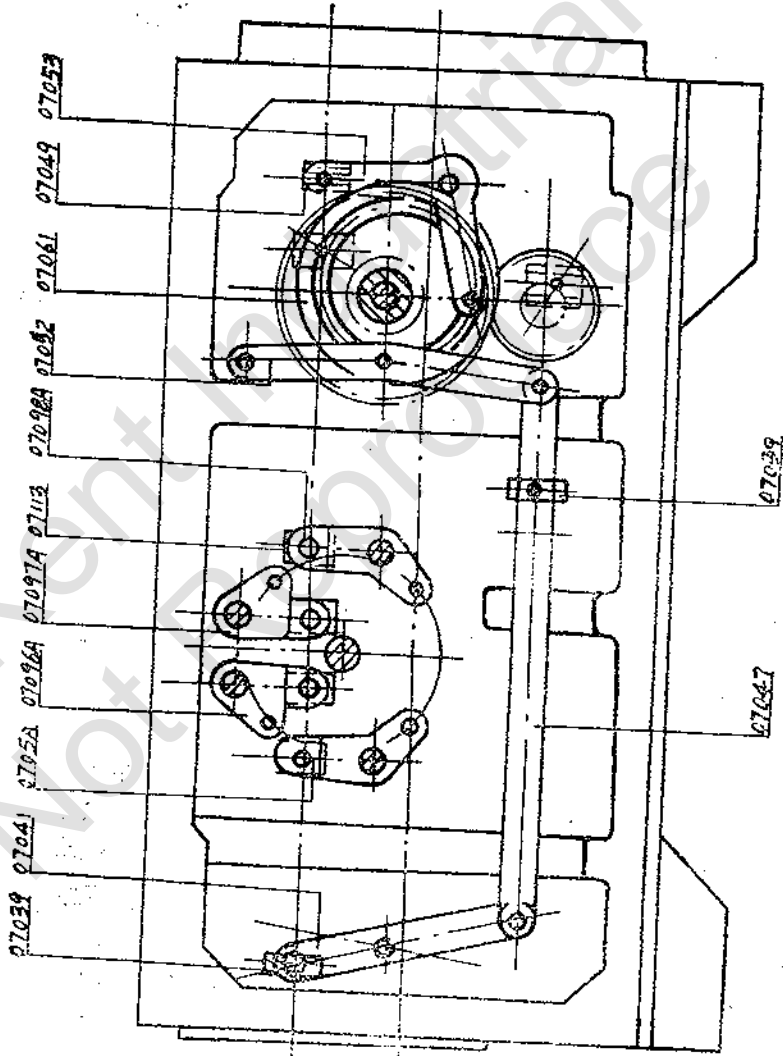
Control Mechanism of Apron





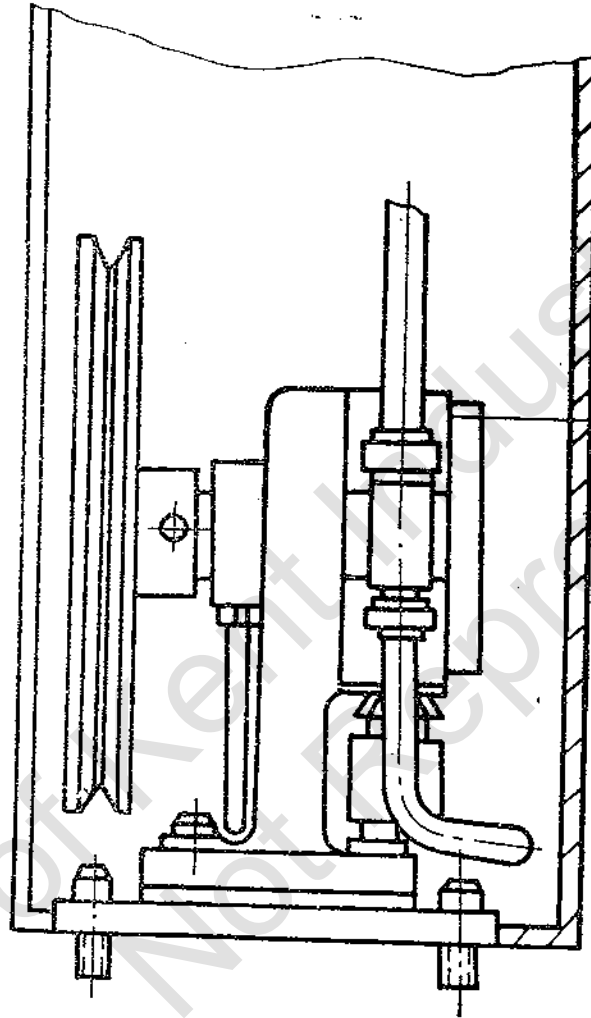


进给箱操纵纵图  
Control Mechanism of Feed Box





润滑泵安装图  
Installation Diagram of Lubricating Pump



叶片润滑泵 R12—1  
Vane lubricating pump  
R12—1