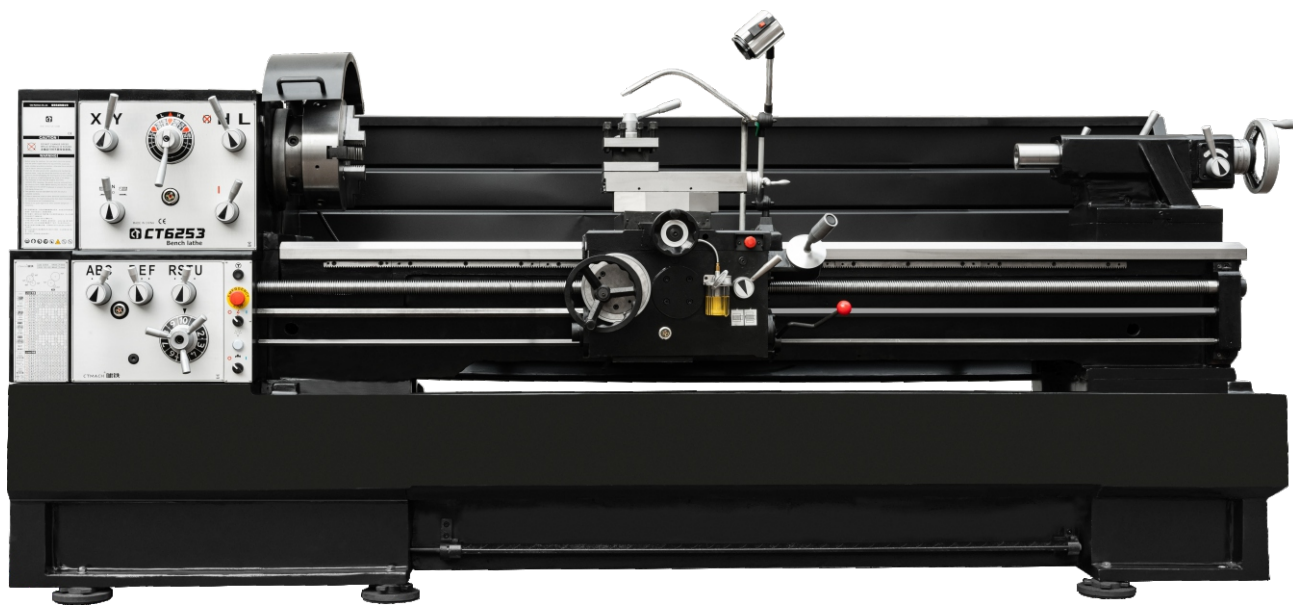




# CT6253

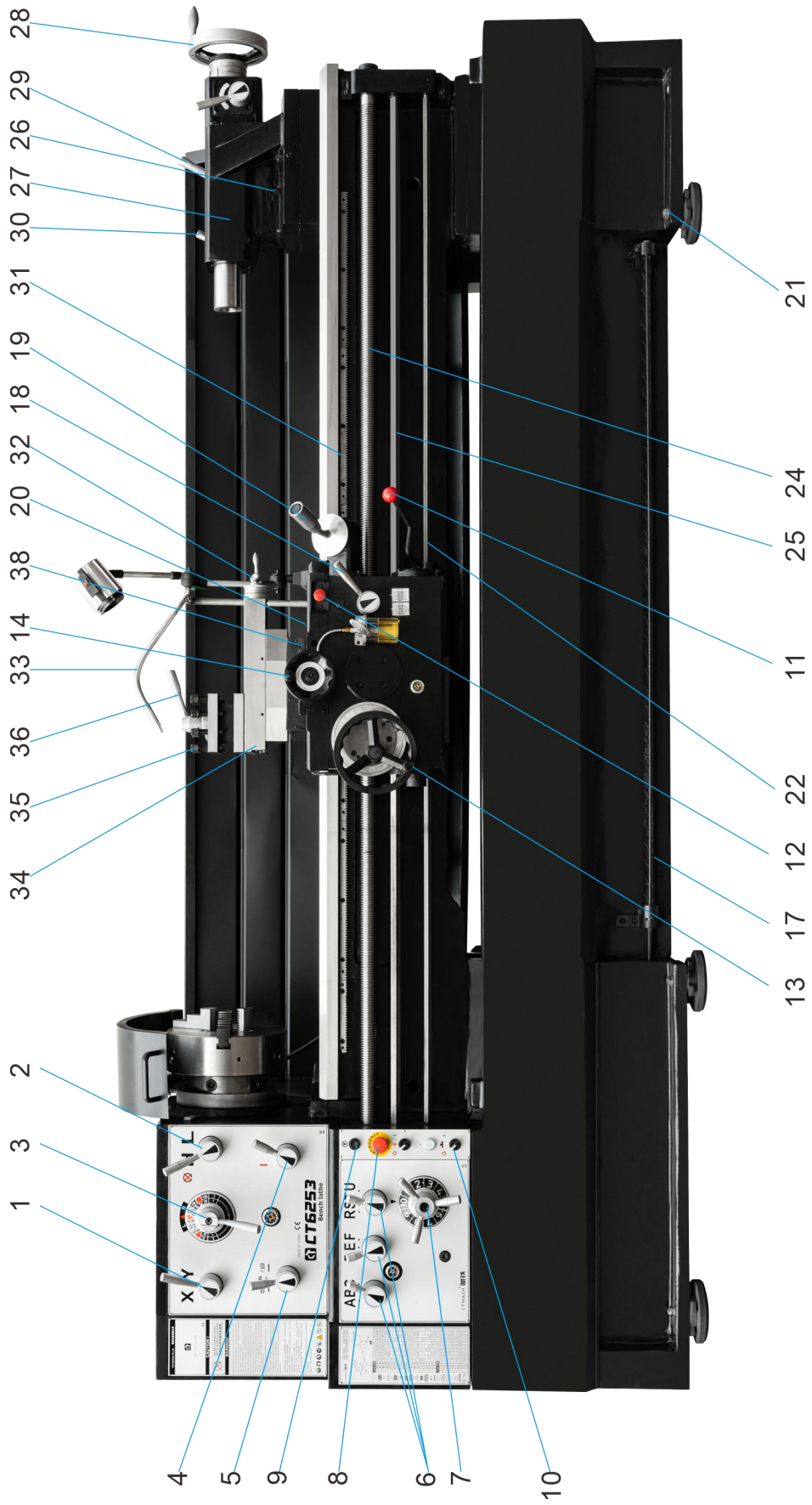
工业级车床  
Industrial Lathe



使用手册  
Operation Manual

## 技术参数

型号	CT6253
床身上回转直径	Φ530mm
中拖板上回转直径	Φ329mm
马鞍上回转直径	Φ765x218mm
高度中心	265mm
中心间距	2000
床身宽度	400mm
刀具最大截面	30 x30mm
横向行程	320mm
小刀架行程	200mm
<b>主轴</b>	
孔径	Φ82mm
主轴鼻端	D8
主轴锥度	Φ90(1:20) x 4
主轴转速级数	12
主轴转速范围	25—1600 R.P.M
螺纹和进给	
丝杆	Φ40mmx4T.P.I or Φ40x6mm
公制螺纹	0.25—7 mm (24 kinds)
英制螺纹	4—112T.P.I (50 kinds)
模数螺纹	0.25—14 M.P(34 kinds)
径节螺纹	4-112 D.P (50 kinds)
纵向进给量	0.031—0.85mm /r.e.v (50 kinds)
	0.0011"—0.0316" inches/r.e.v (50 kinds)
横向进给量	0.01—0.286mm /r.e.v (50 kinds)
	0.00024"—0.0068" inches/r.e.v (50 kinds)
尾座	
套筒行程	180mm
套筒孔径	Φ75mm
套筒锥度	M.T 5
电动机	
主电机功率	7.5KW (10 HP)
冷却剂泵的功率	0.1KW (1/8HP)
重量和尺寸	
机器尺寸(LxWxH)	3450x1200x1350
包装尺寸(LxWxH)	3550x1250x1800
净重	3250kg
毛重	3600kg



车床操作件名称			
NO.	名称	NO.	名称
1	主轴变速杆	20	床鞍座固定螺钉
2	高、低变速杆	21	基座调整螺栓
3	主轴转速选择杆	22	主轴正反转启动杆
4	正反螺纹（丝杆正反转）选择杆	24	丝杆
5	螺纹、进给选择杆	25	光杆/自动进给杆
6	螺纹、进给选择杆	26	尾架调整螺钉
7	螺纹、进给选择杆	27	尾架
8	急停按钮	28	尾架手轮
9	间隙开关	29	尾架限位锁紧杆
10	冷却液泵开关	30	尾架套筒限位锁紧杆
11	主轴正反转、停止选择杆	31	支架
12	床鞍自动进给急停按钮	32	刀架进给手轮
13	纵向进给手轮	33	冷却剂控制阀
14	横向进给手轮	34	刀架托板
17	脚踏制动踏板	35	四工位刀架
18	开合螺母选择杆	36	四工位刀架旋转锁紧把手
19	纵横向进给或纵向快速进给选择杆	38	调整锥形刹铁间隙螺丝

## 拆箱与安装

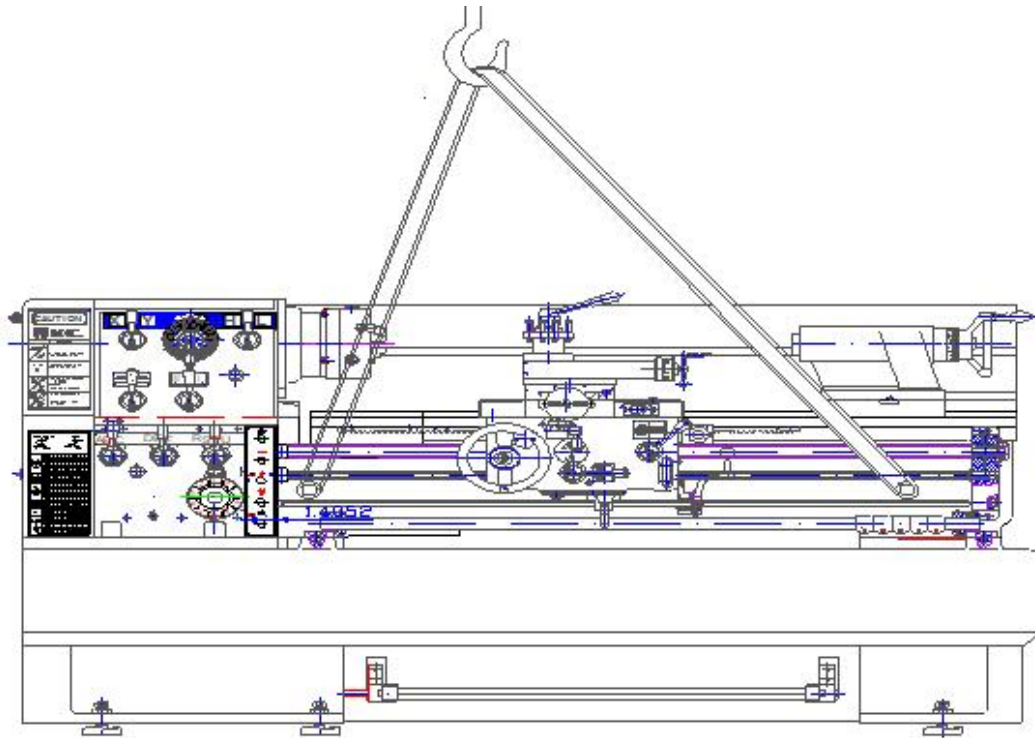
### 2.1 拆箱

本机短距离运输时用麻绳固定在卡车上，长途运输时用木箱包装或集装箱运输。到货时请先检查一下包装箱是否有破损。开箱后，应仔细检查是否存在或不足。如有任何问题，请立即与我们联系，妥善解决，否则您将得不到任何赔偿。

### 2.2 卸机

当机器从车上卸下或需要移动时，请按照以下步骤进行操作(如图 2-2 所示)。

1. 准备两根圆钢棒(长约 830mm，直径 22mm)插入到车床上保留的孔中。
  2. 用起重机吊起机器。
  3. 升降前，调整车床床鞍和尾架的位置，以保持机器的平衡。
  4. 当机器转移到目的地时，一定要小心放下。不要撞击地面，否则会影响机器的精度。
- 注：机器重量见规格表。
5. 为了方便对机床电气控制的调整，保持机器与墙壁之间的距离不小于 600mm。



### 2.3 地基

归于超高硬度的材料应用。合金钢刀具，与以前的钢制刀具相比，它无疑提高了重切削的速度。但同时也容易引起机器的振动。为了保证更好的切割效果，需要非常坚固和稳定的地面施工。

(请参考右图的地面施工)

### 2.4 准备

在将机器安装到预定位置之前，请仔细清洗机器上的保护油。各自的机器表面应用纯石脑油或汽油清洗。

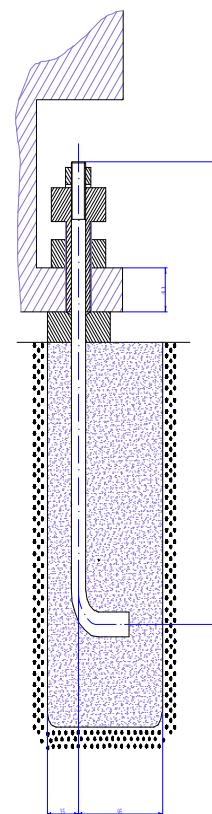
这种保护油不能被硬物或溶剂除去，以免损坏机器的金属表面或油漆。清洁干净的表面在干线的帮助下干燥，并涂上纯机械油。拆卸末端齿轮盖。清洁所有的端齿轮组件，并给所有的齿轮涂上厚重的、不脱垂的润滑脂。

### 2.5 水平调整

拆包机按规定方法用吊车吊起，地脚、找平螺栓到位后，降低基础，使地脚螺栓进入相应的孔内。调平板(垫片)置于调平螺栓下方。导轨水平通过水平仪对机床轴线进行纵向和横向检查，精度分别为 $\pm 0.02/1000\text{mm}$  和  $\pm 0.04/1000\text{mm}$ 。本次机器调平完成后，用水泥腻子浇筑地脚螺栓孔和机器腿的空隙，水泥与砂的比例为 1:3

水泥沉降好后（3-4 天），仔细均匀地拧紧地脚螺栓的螺母。

再次检查机器水平，如有必要，借助水平螺栓进行校正。



## 电路控制

### 3.1 供电输出电压与机床输入电压是否一直

检查 e1 上的数据是否与信息铭牌（电源的电压和频率）对应于可用的。

控制水平应保持在中间，并按下开关以保持机器电源关闭。

确保车床正确接地。

### 3.2 电气设备

1. 配电盘设有断电装置和电磁接触器，避免电机过载损坏。
2. 翻转开关已连接。
3. 脚刹接微动开关，手动启动前缩径。每当松开脚刹，需重新操作主轴控制杆，才能恢复主轴运转。
4. 设有“间隙”按键，用于主轴间歇运转。

### 3.3 重要说明

接线后检查主轴旋转方向：





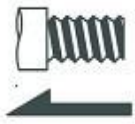
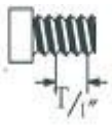

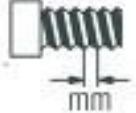
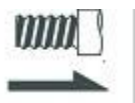











1. 打开电源开关，轻压“间隙”按键，观察主轴卡盘旋转方向。如果它是逆时针的，你的接线是正确的。如果相反，则将“R”、“S”、“T”端子中的任意两根线互换。
2. 如果电源指示灯亮，但不能启动电机。因此，它是过载的。如果发生电流超限，切断装置会立即启动。此时请先关闭电源，然后慢慢按下控制箱内靠近切断装置的回收板。它会再次工作。

### 3.4 卡盘盖操作

1. 夹头盖可避免铁屑飞溅造成事故或伤害。
2. 带限位开关的卡盘盖，与主电机开关串联。
3. 掀起卡盘盖，主电机断电。
4. 放下卡盘盖，机器通电，即可启动电机。
5. 切勿将夹头盖作为主电机的开关，否则会导致事故。

# 试运行

## 4.1 操作符号

1		高速	11		无级调速
2		低速	12		电气控制箱
3		正转	13		英制螺纹
4		中性的	14		公制螺纹
5		反转	15		自动进给 mm/每转
6		照明灯	16		泵
7		间歇按钮	17		接通电源
8		横向进给	18		关闭电源
9		纵向进给	19		注油口
10		锥形离合器	20		停止



## 4.2 主轴的传动与停止

当您按照手册中说明的步骤进行操作时，就可以开始运行测试了。高/低速杆（2）置于“L”位，主轴变速杆（3）置于最左边位置，正/反转杆（4）置于“N”位中间位置。将启动杆（11）向左拨动向上，使主轴向前旋转，向下推，使主轴反向旋转。在紧急情况下使用脚刹车。使用脚制动器停止主轴后，将启动杆提升到中间位置。

打开泵开关（10）开始泵送，调节阀（33）用于获得所需的冷却水量。



### 4.3 选择主轴转速

主轴转速由变速杆（1）、高/低速杆（2）和主轴变速杆（3）等 3 个变速杆组成，实现 12 挡变速。当您将高/低速杆（2）移到“H”和“L”之间的空挡位置时，仅用手即可旋转主轴。为安全起见，不伤害齿轮，每次变速必须在电机停止时进行。如果齿轮齿不能正常啮合，按下“间歇”按钮（9），然后换档变速杆(1)(2)或(3)，改变转速。



#### 4.4 主轴传动间歇式运转

为方便更换主轴转速、确定进给速度和定心对象，机床在齿轮箱右侧设有“间歇”按钮(9)。按下后主轴立即旋转，松开后主轴停止转动。注意，间歇功能不能反向旋转。

#### 4.5 齿轮箱的传动与停止

打开主轴箱端盖，你会发现一组齿轮从主轴箱传递到齿轮箱。将丝杠正转/反转(4)移到右侧，丝杠正向运行，或向左，反向运行，或者如果将其移到中间位置则停止。机器运行时绝不改变速度。

#### 4.6 齿轮箱操作

1、螺纹车削：采用特殊设计的齿轮箱，无需更换任何齿轮即可进行螺纹加工。请参考车削进给表，并对照相应的螺纹进给，分别选择杠杆(5)(6)(7)，即可获得所需规格。

2、自动进给：自动进给的选择应与切削速度和进给速度相协调。请参考切削工作台，选择合适的进给速度，按照指示移动螺纹进给选择杆(5)(6)(7)。



#### 4.7 手动操作

首先将开合螺母啮合杆(18)和丝杠正反杆(4)移至“N”位置，然后可以任意操作纵向进给手轮(13)、横向进给手轮(14)和刀架手轮(32)。纵向进给手轮刻度盘每格刻度为 1mm，横向进给手轮刻度盘每格刻度为 0.05mm，每转一圈为 8mm 和小刀架进给手轮上的刻度盘每格刻度为 0.02mm，每转一圈为 4mm。

松开刀架夹杆(36)，逆时针旋转刀架即可固定。为锁紧挡板，只需拧紧鞍座紧定螺钉(20)即可。如中拖板与刀架托板之间有间隙，只需拧紧斜板两端的紧定螺钉即可。

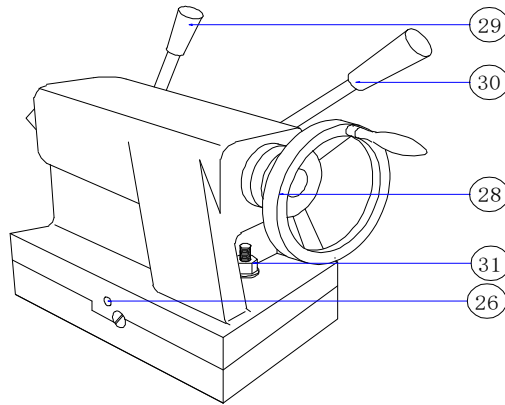
#### 4.8 自动进给操作

**纵横向进给或纵向快速进给选择杆(19)：**为了解决机床床身长，此操作杆可代替纵向手动进给手轮频繁操作带来的不便，操作杆上有快速进给按钮，触碰按钮，可快速纵向进给；此操作杆配合开合螺母，可横/纵向自动进给。

1. 移动主轴箱上的丝杠正/反转选择杆(4)来决定进给方向。
2. 通过变速齿轮箱进给杆选择合适的进给速度。

3. 按下开合螺母啮合杆(18)，进行螺纹加工
4. 当需要横向进给刀具时，将“纵横向进给或纵向快速进给选择杆(19)”向上提。
5. 当需要纵向进给时，将“纵横向进给或纵向快速进给选择杆(19)”向下。

#### 4.9 尾架操作



1. 尾架手轮刻度环每格是 0.02mm。尾架手轮(28)顺时针旋转一圈，尾架套筒进给为 5mm。如果逆时针旋转，则向后运行； 当它运行到最后时，顶尖将自动脱离。
2. 向前推动尾架套筒锁紧杆(29)，可使尾架套筒进给锁紧。如果你想稳定尾架在车床床上，你只需要推动尾架锁紧杠杆(30)向前螺母(31)。
3. 尾座对中心，松开尾座调节螺钉（26），再调节另一侧，调节好后拧紧两侧螺钉。

## 车螺纹

### 5.1 丝杆传动

转动正反螺纹（丝杆正反转）选择杆 (4) 至右侧，丝杆(24)反向向左移动，移动正反螺纹（丝杆正反转）选择杆 (4) 至“N”位，丝杆不转动。

### 5.2 切削螺纹

1. 为了加工指定的螺纹，参考螺纹表，选择杠杆（5）（6）（7）的位置。
2. 接通电源，直接驱动丝杆。
3. 扳动开合螺母啮合杆(18)，开始螺纹车削。

### 5.3 螺纹和进给表

#### CT6253 公制

LEAD SCREW CROSS FEED ROD		P=6mm P=4mm									
<p>(v)</p>		<p>(w)</p>									
<p>(v)</p>	LEVER	1	2	3	4	5	6	7	8	9	10
	II AER	64	72	76	80	88	92	96	104	108	112
	II AFR	32	36	38	40	44	46	48	52	54	56
	II BFR	16	18	19	20	22	23	24	26	27	28
	I AFR	8	9	9½	10	11	11½	12	13	13½	14
<p>(v)</p>	II CFU	0.25									
	II CDS	0.5					0.75				
	II CDU	1			1.25		1.5				1.75
	I CDS	2	2.25		2.5	2.75		3	3.25		3.5
	I CDV	4	4.5	4.75	5	5.5	5.75	6	6.5	6.75	7
<p>(V V)</p>	II ADR	64	72	76	80	88	92	96	104	108	112
	II AER	32	36	38	40	44	46	48	52	54	56
	II AFR	16	18	19	20	22	23	24	26	27	28
	II BFR	8	9	9½	10	11	11½	12	13	13½	14
	I AFR	4	4½	4¾	5	5½	5¾	6	6½	6¾	7
<p>(V V)</p>	II CFS	0.25									
	II CES	0.5					0.75				
	II CDS	1			1.25		1.5				1.75
	II CDU	2	2.25		2.5	2.75		3	3.25		3.5
	I CDS	4	4.5	4.75	5	5.5	5.75	6	6.5	6.75	7
<p>(v)</p>	LEVER	1	2	3	4	5	6	7	8	9	10
	II CFT	.030	.034	.036	.038	.042	.043	.046	.049	.051	.053
	II CET	.061	.068	.072	.076	.084	.087	.091	.099	.102	.106
	I CFT	.121	.136	.144	.152	.167	.175	.182	.197	.205	.213
	I CET	.243	.273	.289	.304	.334	.349	.364	.395	.410	.425
<p>(v)</p>	I CDT	.486	.547	.577	.607	.668	.698	.729	.790	.820	.850
	II CFT	.010	.011	.012	.013	.013	.014	.015	.017	.017	.018
	II CET	.020	.023	.024	.025	.028	.029	.030	.033	.034	.036
	II CDT	.041	.046	.049	.051	.056	.060	.061	.066	.069	.072
	I CET	.082	.093	.097	.103	.113	.118	.123	.133	.138	.143
I CDT	.163	.184	.194	.197	.225	.235	.246	.266	.276	.286	

CT6253 英制

LEAD SCREW												
CROSS FEED ROD												
<p>(V)</p>		<p>(W)</p>										
		<b>LEVER</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>
<p>(V)</p>	II AER	64	72	76	80	88	92	96	104	108	112	
	II AFR	32	36	38	40	44	46	48	52	54	56	
	II BFR	16	18	19	20	22	23	24	26	27	28	
	I AFR	8	9	9½	10	11	11½	12	13	13½	14	
	I BFR	4	4½	4¾	5	5½	5¾	6	6½	6¾	7	
<p>(V)</p>	II CFU	0.25										
	II CDS	0.5						0.75				
	II CDU	1			1.25			1.5			1.75	
	I CDS	2	2.25		2.5	2.75		3	3.25		3.5	
	I CDV	4	4.5	4.75	5	5.5	5.75	6	6.5	6.75	7	
<p>(VV)</p> <p>DP</p>	II ADR	64	72	76	80	88	92	96	104	108	112	
	II AER	32	36	38	40	44	46	48	52	54	56	
	II AFR	16	18	19	20	22	23	24	26	27	28	
	II BFR	8	9	9½	10	11	11½	12	13	13½	14	
	I AFR	4	4½	4¾	5	5½	5¾	6	6½	6¾	7	
<p>(VV)</p> <p>MP</p>	II CFS	0.25										
	II CES	0.5						0.75				
	II CDS	1			1.25			1.5			1.75	
	II CDU	2	2.25		2.5	2.75		3	3.25		3.5	
	I CDS	4	4.5	4.75	5	5.5	5.75	6	6.5	6.75	7	
	I CDU	8	9	9.5	10	11	11.5	12	13	13.5	14	
<p>(V)</p> <p>mm</p>	<b>LEVER</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>	
	II CFT	.0011	.0012	.0013	.0014	.0015	.0016	.0017	.0018	.0019	.0020	
	II CET	.0023	.0025	.0027	.0028	.0031	.0032	.0034	.0037	.0038	.0040	
	I CFT	.0045	.0051	.0054	.0056	.0062	.0065	.0068	.0073	.0076	.0079	
	I CET	.0090	.0102	.0107	.0113	.0124	.0130	.0135	.0147	.0153	.0158	
	I CDT	.0181	.0203	.0215	.0226	.0249	.0260	.0271	.0294	.0305	.0316	
<p>(V)</p> <p>mm</p>	II CFT	.00024	.00027	.00021	.00030	.00033	.00035	.00036	.00039	.00041	.00042	
	II CET	.00048	.00055	.00057	.00060	.00067	.00069	.00073	.00079	.00082	.00085	
	II CDT	.00970	.00108	.00114	.00121	.00133	.00139	.00145	.00157	.00163	.00167	
	I CET	.00183	.00218	.00240	.00242	.00266	.00278	.00290	.00315	.00326	.00338	
	I CDT	.00337	.00435	.00459	.00434	.00531	.00536	.00580	.00638	.00653	.00680	

## 润滑

### 6.1 主轴箱润滑

主轴箱的润滑系统采用喷油方式。主轴箱顶部有环绕的凹槽，使润滑油沿着凹槽流入主轴轴承，最后流到箱体底部。加润滑油时，取下车头旁边的油塞盖，从油孔加注至前视镜底部。排放废油，车头右侧下方有一个放油孔。

请您在购买机器时注意检查主轴箱是否加注了润滑油。如果不是，请使用如图（6-4）所示的润滑油示意图。我们要求您从第一时间开始更换润滑油一个月，然后每两个月进行一次，以确保齿轮在最佳状态下工作。

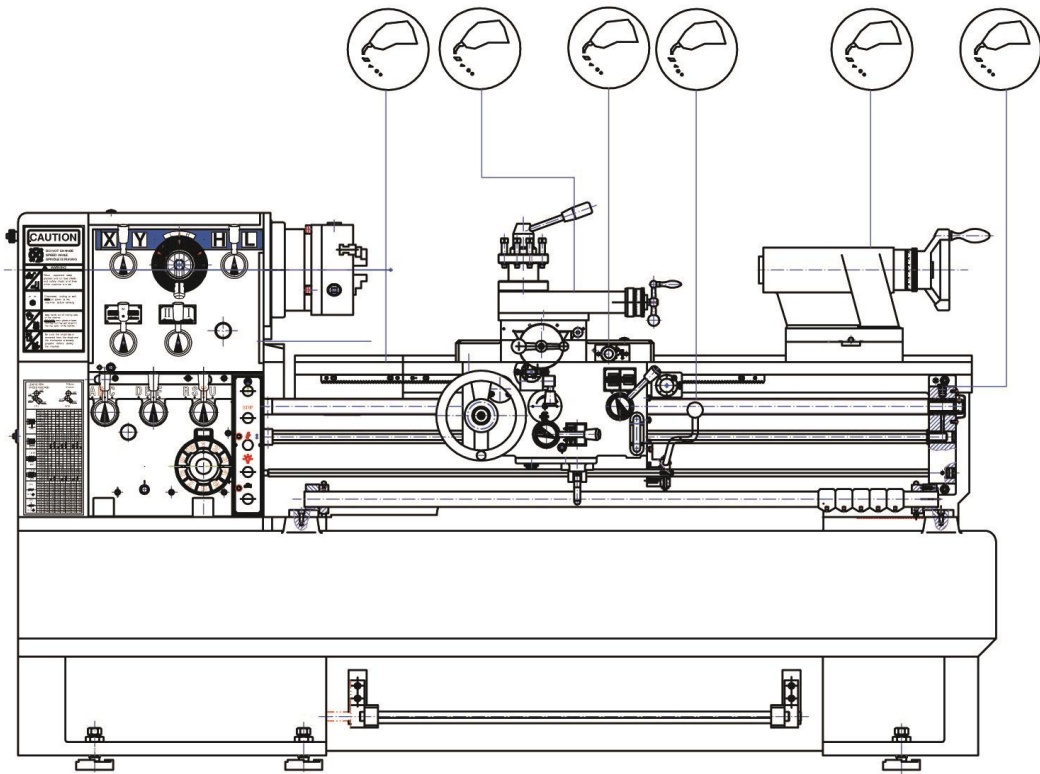
### 6.2 齿轮箱和挡板润滑

1. 齿轮箱采用油浴润滑，确保齿轮和轴承的使用寿命。建议每六个月更换一次润滑油。
2. 床鞍也是油浸过的。如床鞍中的油量低于油位视镜的中心水平，则应加注一些油以保持油位。

### 6.3 其它机构的润滑表

No.	位置	方式	油量	换油时间
1	主轴承	拆下左侧向上的加油孔螺丝	L	一个月，然后每两个月一次
2	齿轮箱	打开顶盖取下加油孔螺丝	L	每月加一次，半年换一次
3	床鞍	取下加油孔螺丝	L	每天一次，不换油
4	小刀架	通过油罐	适量	每天一次，不换油
5	自动进给杆	通过油罐	适量	每天一次，不换油
6	尾座	通过油罐	适量	每天一次，不换油
7	丝杠	通过油罐	适量	每天一次，不换油
8	三杆支架	拆下填充孔螺钉	适量	每天一次，不换油
9	床身导轨	按下手动油泵	适量	每天一次，不换油

## 6.4 一天加一次油

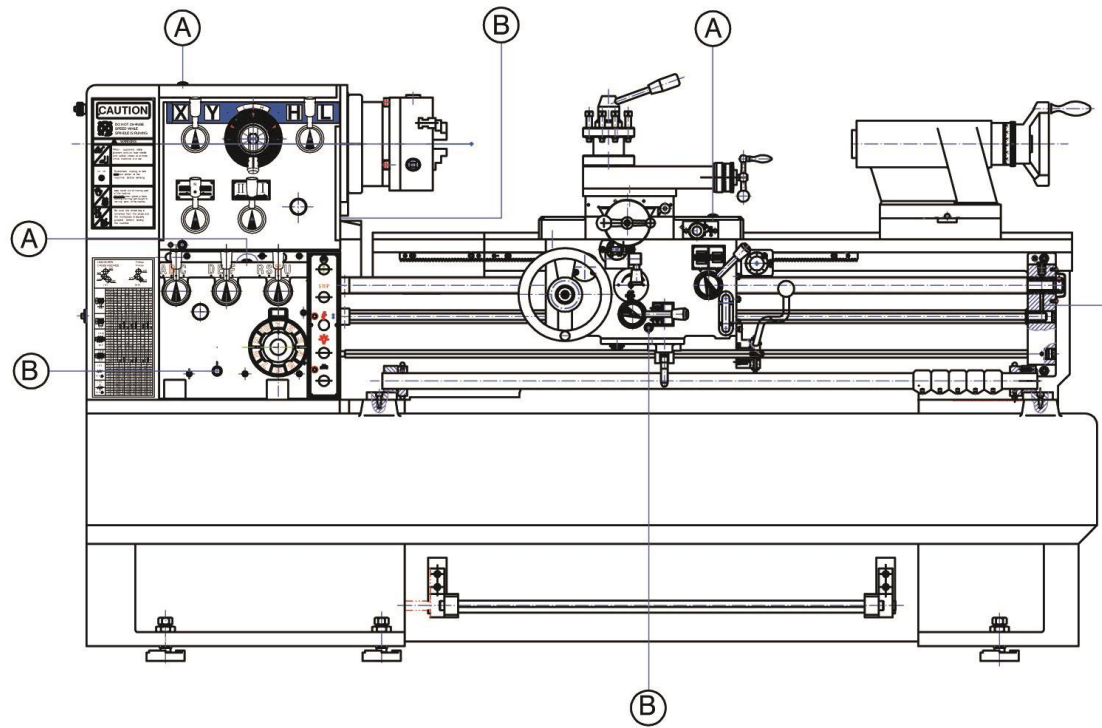




## 6.5 潤滑位置

A 注油孔

B 排油孔



## 维护和调整

为了更好地确认这台车床，无论是在操作中还是一些简单的故障排除或维修方法，以使机器发挥最大功能，我们现在开始一些重要的事情如下：

### 7.1 主轴箱

#### 1. 防止主轴箱顶盖漏油：

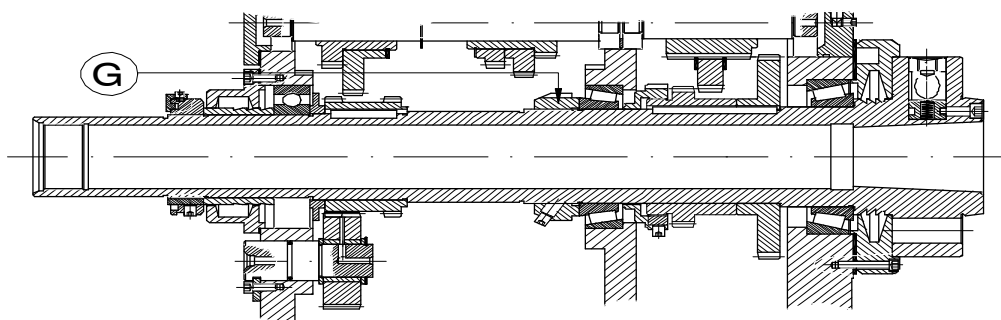
在盖上主轴箱顶盖之前，每次拆下时，请擦拭干净接触面并涂上一些油脂。确保用固定螺丝将其牢固固定。

#### 2. 防止堵塞油路：

前主轴箱盖漏油多是由于机油加注过多或油路堵塞所致。此时，先拆下主轴箱盖，然后将气嘴吹入前主轴轴承上下两个注油孔，同时转动主轴，使其重新工作。

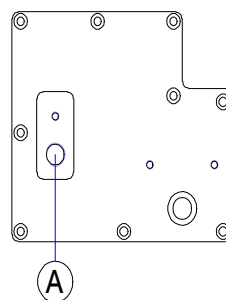
#### 3. 主轴轴承调整：

主轴滚子轴承的前、中间部分。为了提高精度和满足操作功能的要求，可以要求您调整轴承上的适当压力。经过长时间的操作，“G”可能会松动，导致切割表面出现“波迹”。你现在需要调整一下。用内六角套筒扳手拧下固定螺钉，用固定螺母重新安装到位。只有适当的压力才足够。不要过紧，否则会导致轴承过热或损坏轴承的滚动表面，降低其动力。如图所示调整完毕后，确保固定螺钉完全固定。



## 7.2 床鞍和溜板座

1. 床鞍注油孔位置: 在溜板座的右侧顶部。注油表已插入, 指示“OIL”。
2. 溜板座油孔位置: 在溜板座底盖上, 如图左图所示, 位置为“A” (也可在停机坪正面向下看到)
3. 床鞍润滑油型号及更换周期: ISO V968, 建议期每半年一次。



## 7.3 进给箱

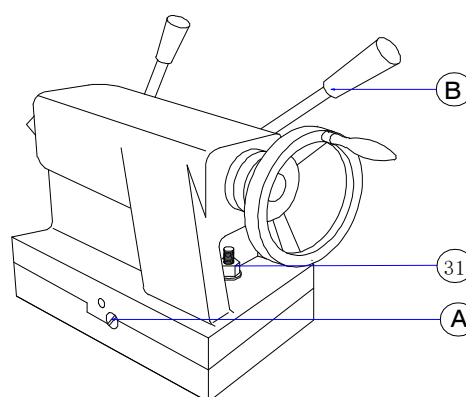
1. 齿轮箱注油孔位置:  
在进给箱的上方, 拆下上盖, 有一个油塞, 指示“OIL”, 根据插图“A”注油孔。
2. 进给箱排油孔位置:  
在数字进给手柄的左侧, 排油孔在带有内六角螺母的螺丝上, 如图“B”箭头指向所示。
3. 油的品牌和换油时间:



我们建议(如图所示)每半年更换一次。

## 7.4 尾座定心调整

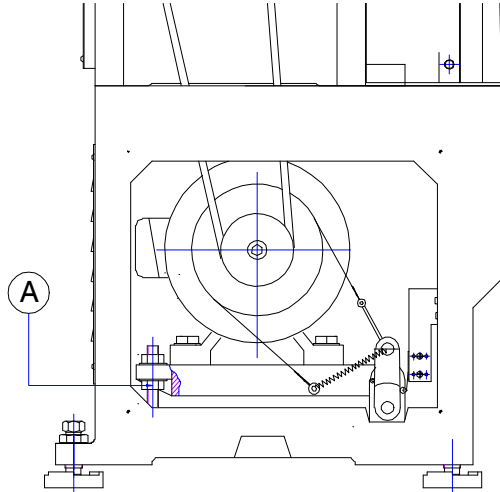
1. 调整尾座精度, 松开尾座主体和底板连接的两个内六角螺钉, 调整方向取决于您的期望: 如需前倾, 必须先松开调节螺丝, 然后将其精确校正到要求的精度, 然后装上内六角螺丝和调节螺丝。永远不要太紧, 否则夹紧杆会变得更重, 如图所示“A”。
2. 尾座套筒已固定, 但仍感觉释放手轮偏重。这是因为夹紧块不能自由松开。您必须将夹紧杆向前推一点, 它会再次恢复正常。



## 7.5 皮带张力的调整

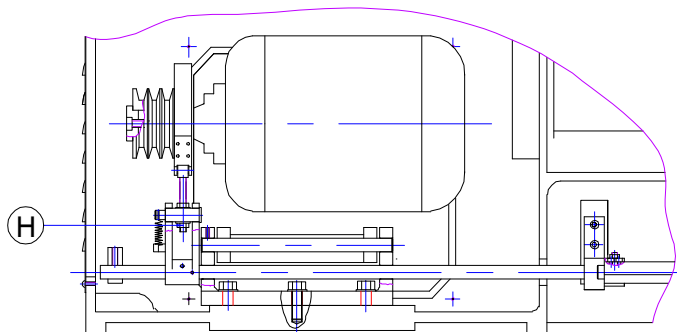
皮带工作一段时间后需要调整，步骤如下：

1. 打开车床左后侧的盖子
2. 松开调节螺母“**A**”，将电机降低到适当的高度，使皮带达到一定的张力。
3. 紧固螺母。



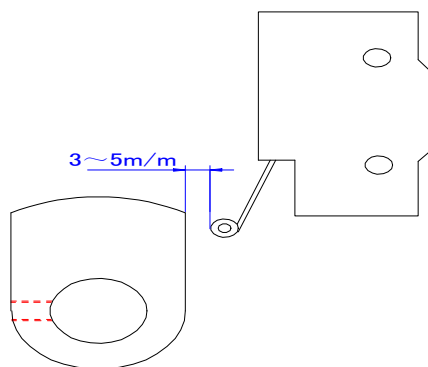
## 7.6 刹车带的调整

如果刹车皮磨损，刹车太松，那么我们需要调整刹车螺母 **H**，打开侧护板后，先松开上面的螺母，将下面的螺丝拧紧到合适的长度，然后拧紧两侧螺母，即完成调整，最后将保护盖锁回。



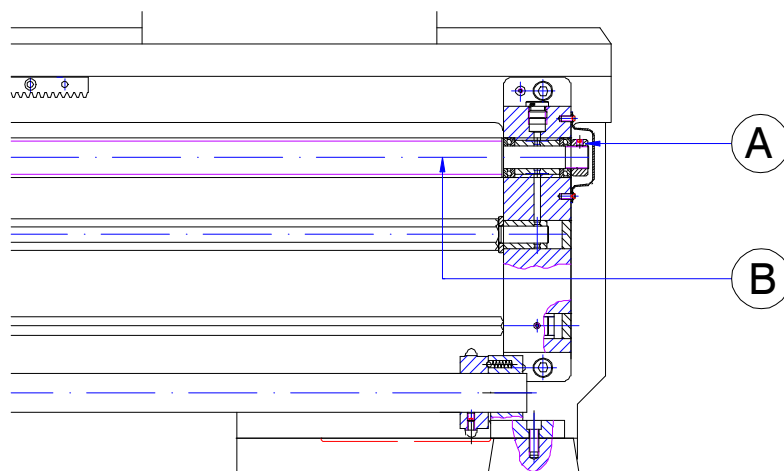
## 7.7 刹车和微动开关的调整

脚踏制动器与微动开关相连。它需要从制动凸轮到微动开关的触摸头保持 3-5mm 的间隙。刹车时一定要断开电源，否则会导致刹车片褪色。踩下脚制动器后，需要重新操作主轴控制杆，使主轴再次旋转。



## 7.8 调整丝杠防护装置的背隙

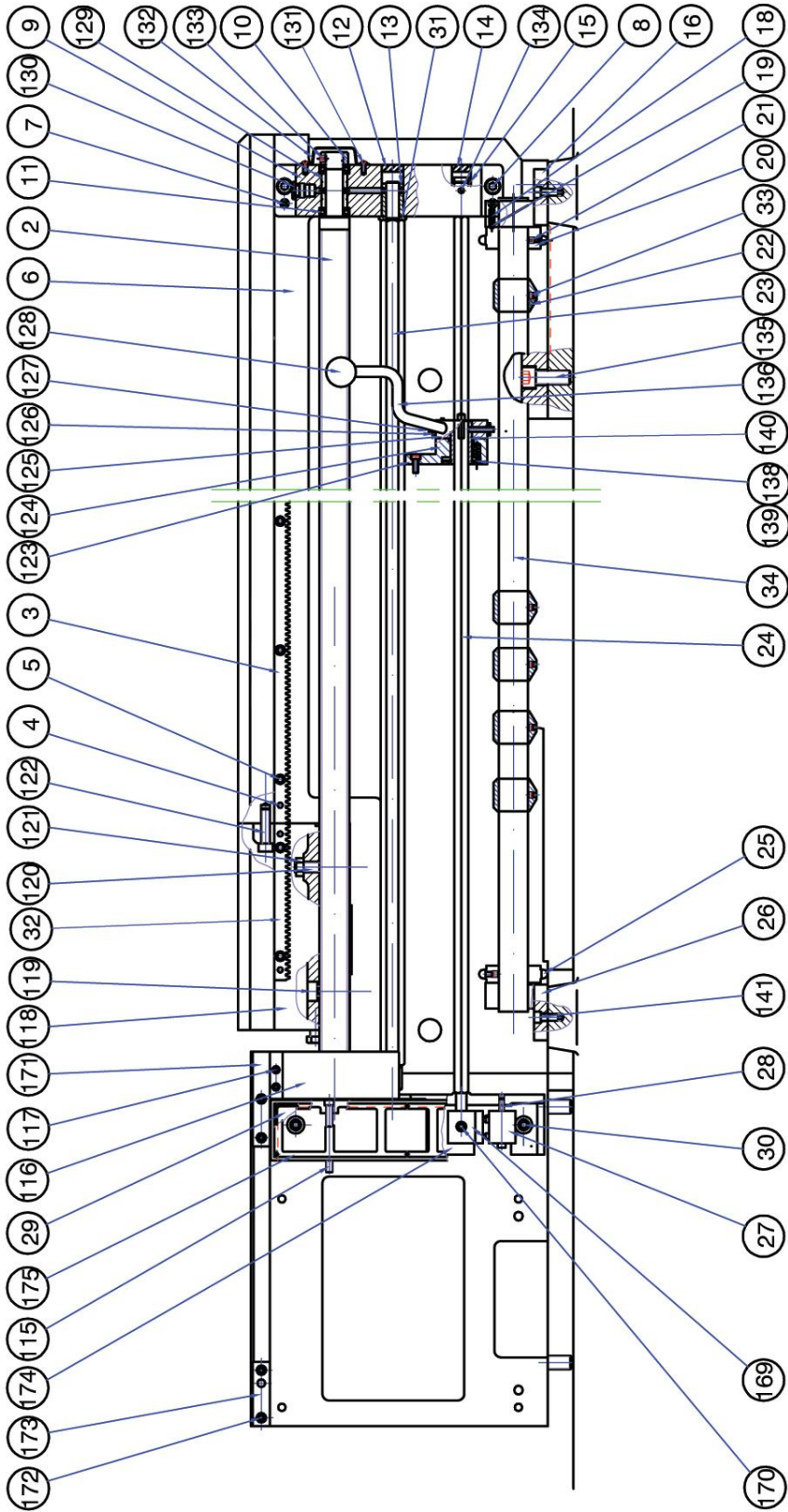
当在加工过程中出现一些螺纹堆积时，这是由于丝杠上的反冲造成的。适当调整丝杠后侧的密封螺母。打开丝杠支架后侧的盖子，将螺母“A”拧得很紧，不要留下任何间隙。



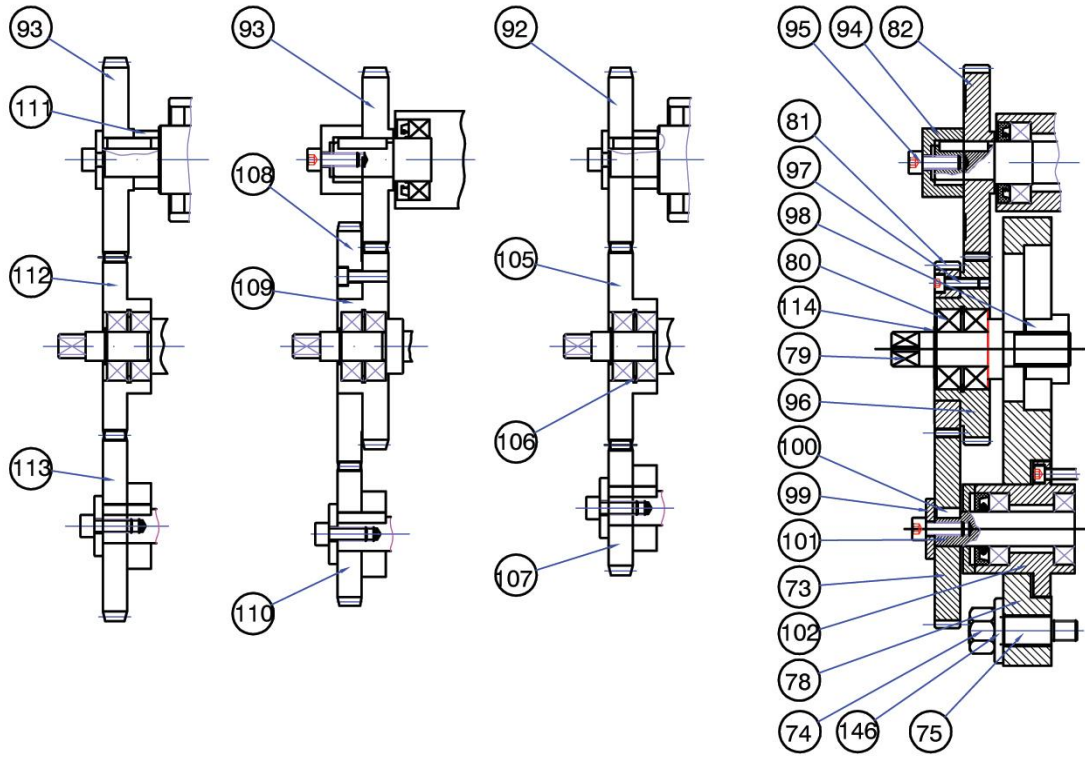
## 7.9 切削液冷却泵的维护

如果在启动电机开关时，切削液没有流出，首先要检查电机是否已启动，其次要检查油箱内的切削液是否超过液位。如果没有，则需要添加更多的液体。重新启动泵时，若仍看不见有液体排出，则一定是泵内有堵塞或有泄漏，应拆开检查或清洗。

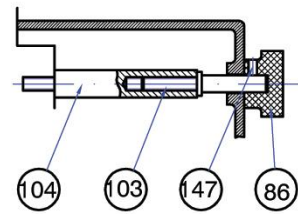
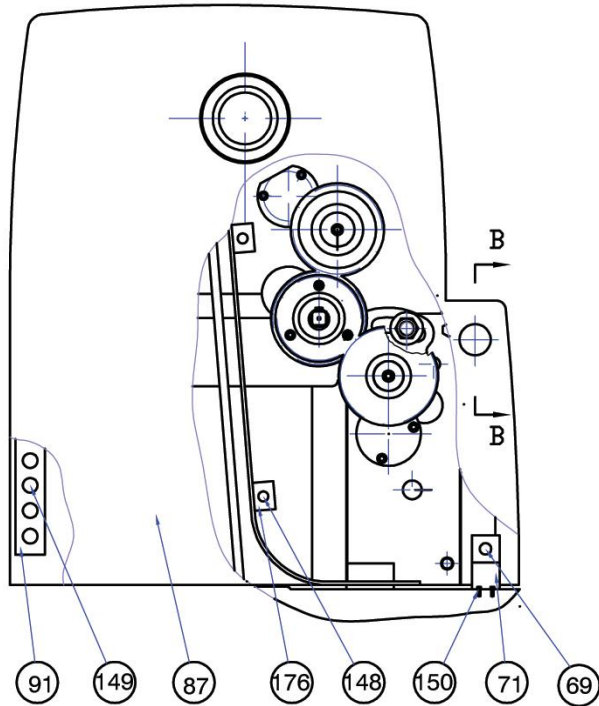
### BED ASSEMBLY (1)



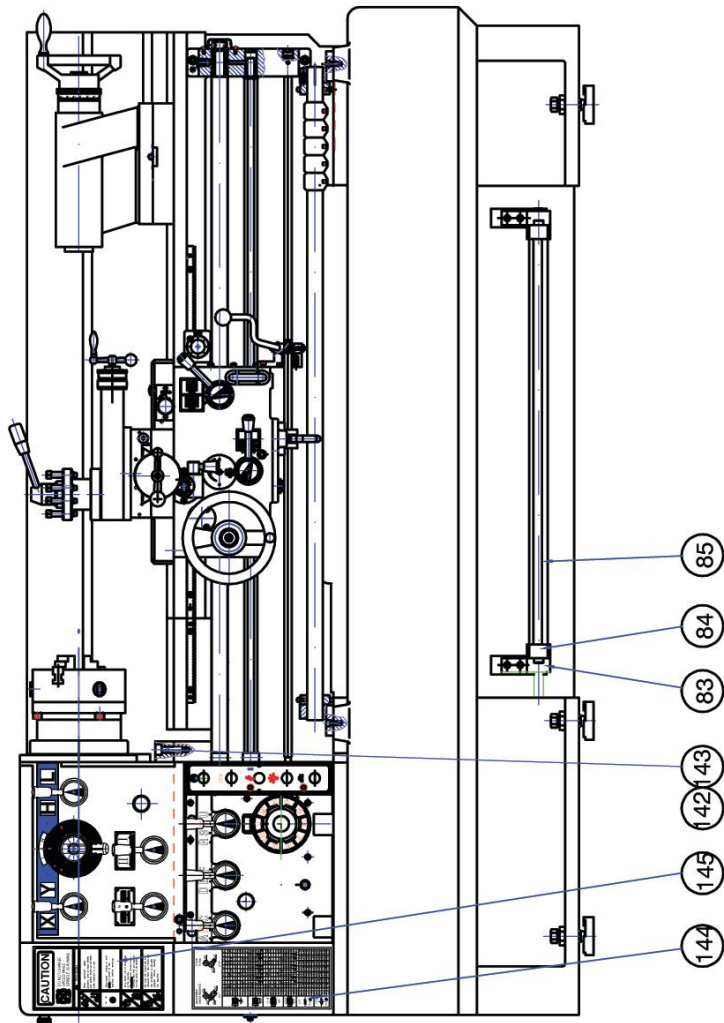
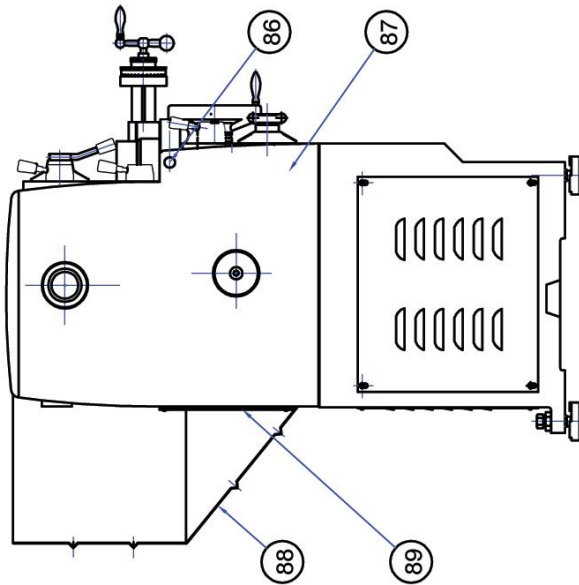
### BED ASSEMBLY (2)



### B-B

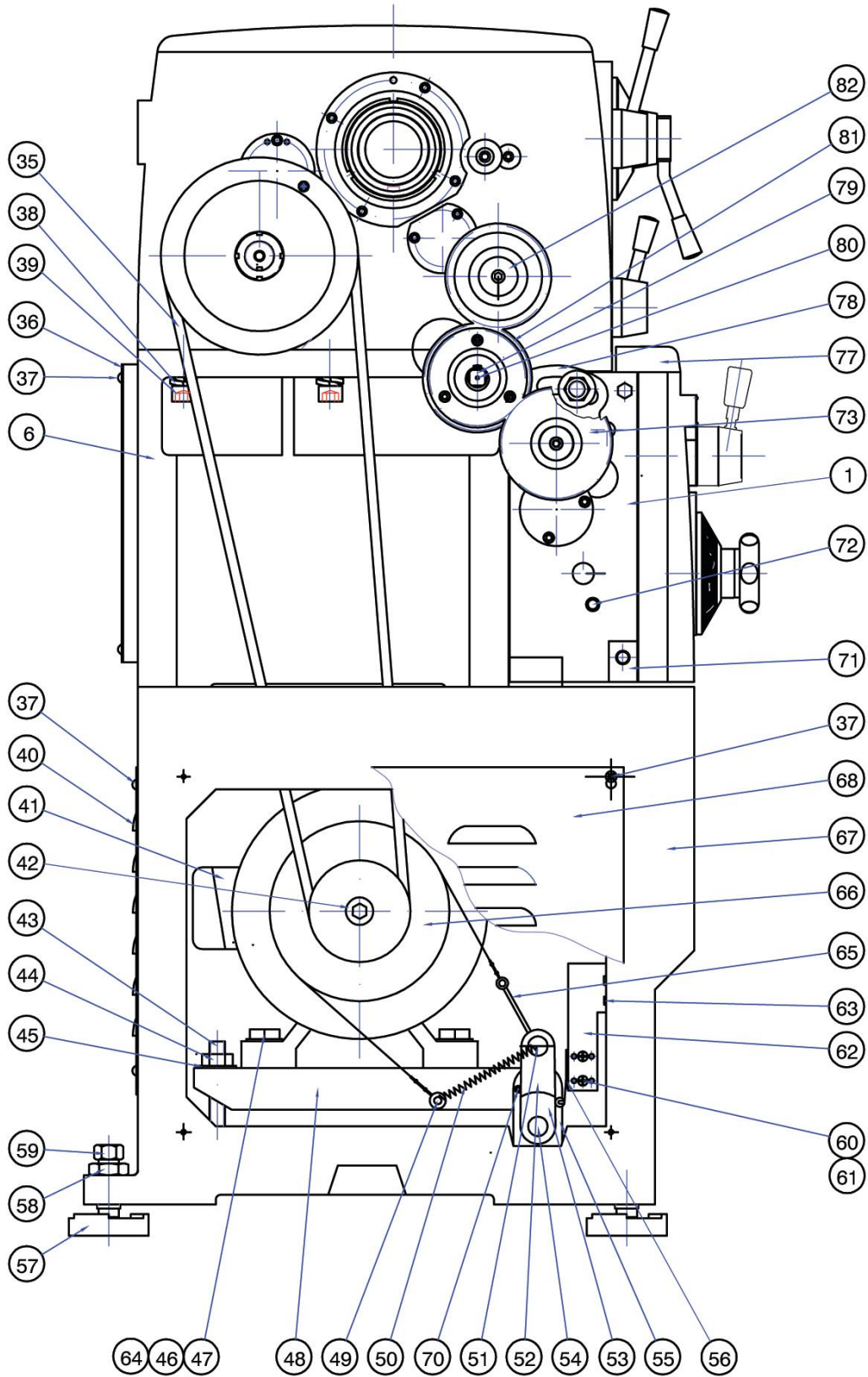


### BED ASSEMBLY (3)

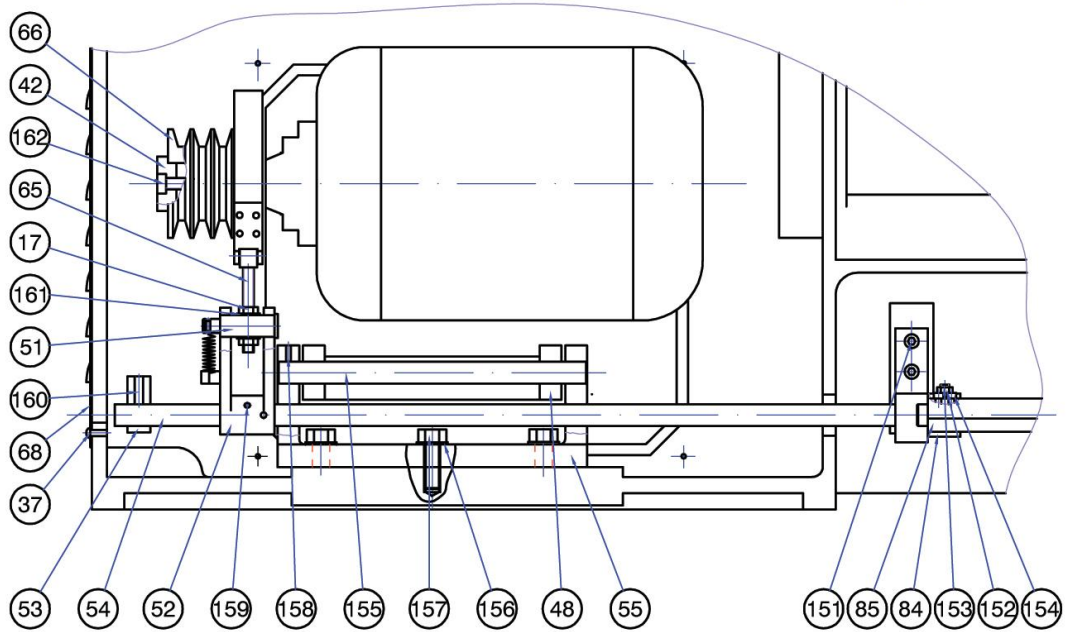
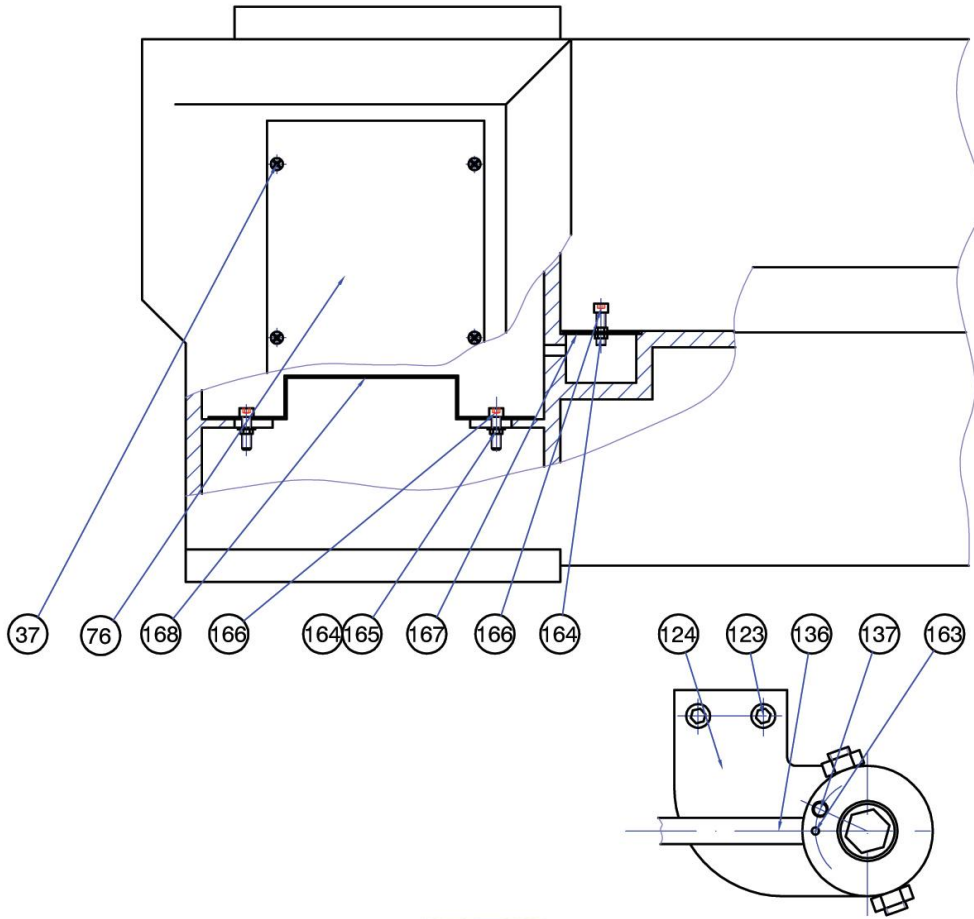




### BED ASSEMBLY (4)



### BED ASSEMBLY (5)



### CT6253 Bed Assembly Parts list

No.	Part No.	Name	Specification	Qty	Remarks
1	CT6253-3001	Feeding Box	HT200	1	
2	CT6253-1021	Leadscrew	40Cr	1	Thread pitch=6
3	CT6253-1049	rack gear	45	1	
4	GB879-86	Spring Pin	6×30	11	Reference number
5	GB70.1-2000	Screw	M6×25	10	Reference number
6	CT6253-1001	Bedway	HT300	1	41.46.53.60 type
7	GB118-86	Pin	10×45	2	
8	GB70.1-2000	Screw	M10×40	2	
9	CT6253-1004	Bracket	HT200	1	
10	CT6253-1032	Nut	45	1	
11	GB301-84	ball bearing	8014	2	
12	CT6253-1008	Plug	45	1	
13	CT6253-1007	Bush	ZAlSn6Cu1NI1	1	Material or use ZQSn6-6-3
14	CT6253-1008	Plug	45	1	
15	CT6253-1006	Bush	ZAlSn6Cu1NI1	1	Material or use ZQSn6-6-3
16	CT6253-1035	Bracket	HT200	1	
17	GB6170-86	Screw	M10	2	
18	GB/2089	Spring	65Mn	1	1*5*25
19	GB/308	steel ball	φ5	1	
20	CT6253-1038	Star Type Ring	HT150	1	
21	GB80-85	Screw	M6×8	2	
22	CT6253-1039	cover	HT200	5	
23	CT6253-1022	Feed Rod	45	1	
24	CT6253-1023	Started rod	45	1	
25	CT6253-1037	Star Type Ring	HT150	1	
26	CT6253-1034	Bracket	HT200	1	
27	KM1	Switch	CJX2-2501	1	
28	GB70.1-2000	Screw	M4×40	2	
29	CT6253-3079	Plate	Al	1	δ=1.5
30	GB70.1-2000	Screw	M8×25	2	
31	CT6253-1030	Spacer	45	1	
32	CT6253-1050	Rack	45	1	M2 Z29
33	GB70.1-2000	Screw	M6×6	5	
34	CT6253-1036	Auto stopping rod	45	1	
35	GB/894.1	belt	B1833	3	
36	CT6253-1048	cover	cold rolled sheet (A3)	1	δ=1
37	GB818-85	Screw	M6×10	16	
38	GB93-87	Spacer	16	3	
39	GB70.1-2000	Screw	M16×55	3	
40	CT6253-1045	Cover motor seat	cold rolled sheet (A3)	1	δ=1

No.	Part No.	Name	Specification	Qty	Remarks
41	YC	Motor	5.5kw	1	
42	CT6253-1052	Washer	45	1	
43	CT6253-1020	Screw	45	2	
44	GB6170-86	Nut	M16	6	
45	GB95-85	Spacer	16	6	
46	GB97.1-85	Spacer	10	4	
47	GB5782-86	Screw	M10×35	4	
48	CT6253-1017	Motor Seat	HT200	1	
49	CT6253-1108	Shaft	45	1	
50	GB/T1239.6-III	Spring	65Mn	1	3*18*75
51	CT6253-1109	Shaft	45	1	
52	CT6253-1104	Lever	HT200	1	
53	CT6253-1105	Cam	HT150	1	
54	CT6253-1101	Shaft	45	1	
55	CT6253-1018	Motor Seat	HT200	1	
56	SQ5	Switch		1	Electrical components
57	CT6253-1015	Block-leveling	HT200	6	
58	GB6173-86	Nut	M24×2	6	
59	CT6253-1014	Bolt	45	6	
60	GB818-85	Screw	M4×20	2	
61	GB6170-86	Nut	M4	2	
62	CT6253-1110	Switch bracket	A3	1	δ=3
63	GB70.1-2000	Screw	M5×8	2	
64	GB93-87	Spring Washer	10	4	
65	CT6253-1102	Belt-Brake	(assembly parts)	1	
66	CT6253-1051	Belt Pulley	HT150	1	
67	CT6253-1002	Stand	HT150	1	
68	CT6253-1046	Cover Motor Seat	cold rolled sheet (A3)	1	δ=1
69	SQ	Stopper		1	Electrical components
70	GB70.1-2000	Screw	M5×8	1	
71	CT6253-1043	Switch bracket	Q235	1	δ=3.5
72	GB/T7037	Nut	ZG3/8"	1	
73	CT6253-3086	Gear	45	1	T56 M2
74	GB6170-86	Nut	M16	1	
75	CT6253-3002	Bolt	45	1	
76	CT6253-1047	cover	cold rolled sheet (A3)	1	δ=1
77	CT6253-3077	cover	HT200	1	
78	CT6253-3081	Bracket	HT-200	1	
79	CT6253-3082	Shaft	45	1	
80	GB276-93	Ball bearing	180204	2	
81	CT6253-3085	Gear	45	1	T49 M2
82	CT6253-3088	Gear	45	1	T55 M2

No.	Part No.	Name	Specification	Qty	Remarks
83	CT6253-1103	Bracket	HT200	2	
84	CT6253-1107	Arm	HT150	2	
85	CT6253-1106	Pedal-bracket	( assembly parts )	1	
86	CT6253-1033	Nut	45	1	
87	CT6253-1011	Cover of headstock	Fiber Reinforced Plastics	÷	
88	CT6253-1010	Splash guard	A3	1	δ=1.5
89	CT6253-1047	pump Hole Cover	A3	1	δ=1
90	CT6253-1073	Wiper	Q235	1	
91	GB7277-87	chain	100	2	
92	CT6253-3086	Gear	45	1	T56 M2
93	CT6253-2103	Gear	45	1	T48 M2
94	CT6253-2067	cover	45	1	
95	GB70.1-2000	Screw	M8×20	2	
96	CT6253-3084	Gear	45	1	T54 M2
97	GB70.1-2000	Screw	M6×20	3	
98	CT6253-3083	Nut	45	1	
99	CT6253-3045	Spacer	45	1	
100	GB1096-79	Key	6×10	1	
101	CT6253-3009	I Shaft	45	1	
102	CT6253-3007	I Shaft stand	HT200	1	
103	CT6253-1042	Shaft	45	1	
104	CT6253-3024	Shaft	16×14 hexagonal	1	
105	CT6253-3102 A	Gear	45	1	T57 M2
106	GB893.1-86	Snap Ring	47	2	
107	CT6253-3087	Gear	45	1	T40 M2
108	CT6253-3101	Gear	45	1	T66 M2
109	CT6253-3089	Gear	45	1	T57 M2
110	CT6253-3103	Gear	45	1	T42 M2
111	CT6253-3104	Gear	45	1	
112	CT6253-3102 A	Gear	45	1	T57 M2
113	CT6253-3102	Gear	45	1	T57 M2
114	GB894.1-86	Snap Ring	20	1	
115	GB70.1-2000	Screw	M6×70	2	
116	CT6253-1065	Small splash guard	A3	1	δ=1.2
117	GB818-85	Screw	M5×8	2	
118	CT6253-1003	Saddle	HT300	1	
119	GB70.1-2000	Screw	M12×50	4	
120	GB881-86	Pin	10×75	2	
121	GB6170-86	Nut	M8	2	
122	GB70.1-2000	Screw	M10×40	2	

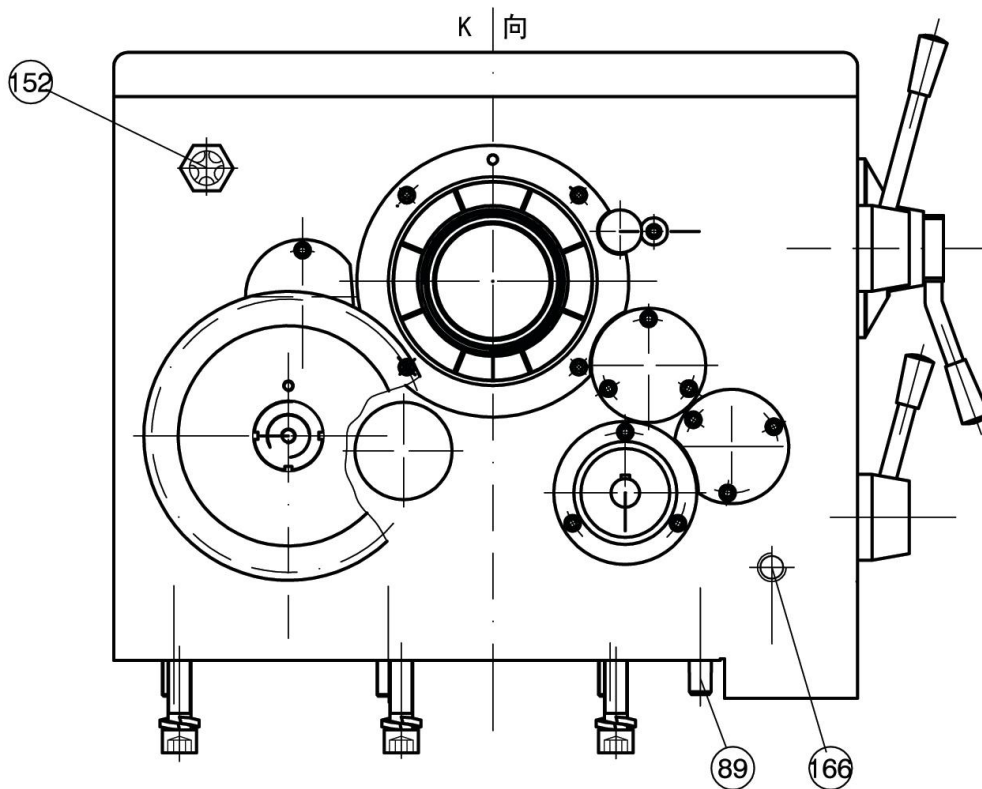
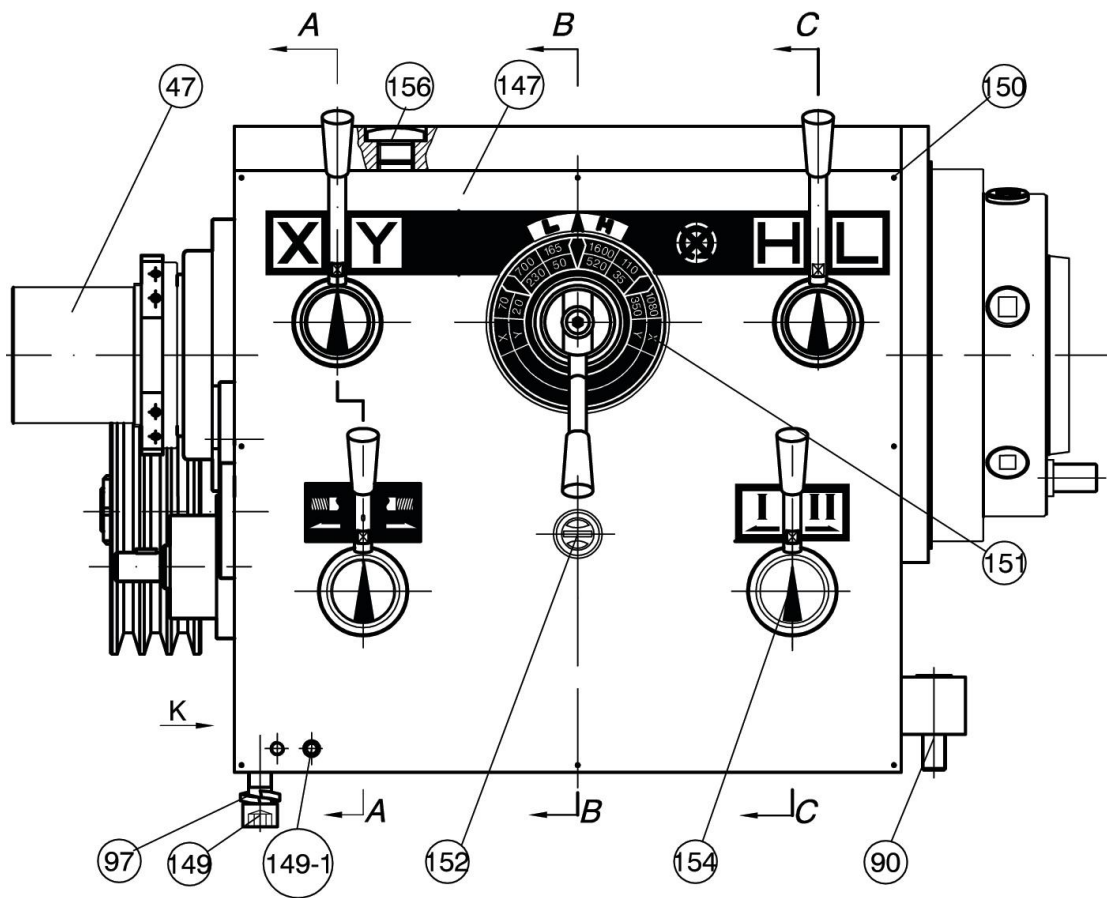
123	GB70.1-2000	Screw	M6×16	2	
124	CT6253-1025	Switch Bracket	HT200	1	
<b>No.</b>	<b>Part No.</b>	<b>Name</b>	<b>Specification</b>	<b>Qty</b>	<b>Remarks</b>
125	CT6253-1026	Lever	45	1	
126	GB75-85	Screw	M8×30	2	
127	GB6172-86	Nut	M8	2	
128	Z16-1	Lever-Bush	M12×40	1	
129	CT6253-1005	Sleeve	ZQSn6-6-3	1	
130	G31-4	Plug-oil inlet	M16×2	1	
131	GB818-85	Screw	M5×10	3	
132	CT6253-1009	cover	cold rolled sheet (A3)	1	δ=1
133	GB80-85	Screw	M6×6	1	
134	GB80-85	Screw	M6×6	1	
135	GB70.1-2000	Screw	M16×40	4	
136	CT6253-1029	Lever	45	1	
137	CT6253-1027	Pin	45	1	
138	CT6253-1028	Washer	A3	1	δ=1.5
139	GB/2089	Spring	65Mn	2	1*6*20
140	CT6253-1024	Shaft Sleeve	45	1	
141	GB70.1-2000	Screw	M8×20	2	
142	GB70.1-2000	Screw	M16×45	3	
143	GB120-86	Pin	16	1	
144	CT6253-1056	Plate	Ly12	1	δ=0.5
145	CT6253-3091	Plate	Al	1	δ=0.5
146	CT6253-3057	Washer	45	1	
147	GB79-85	Screw	M6×8	1	
148	GB70.1-2000	Screw	M6×12	2	
149	GB68-85	Screw	M5×10	16	
150	GB70.1-2000	Screw	M6×16	2	
151	GB70.1-2000	Screw	M8×20	4	
152	GB6170-86	Nut	M10	2	
153	GB79-85	Screw	M10×25	2	
154	GB70.1-2000	Screw	M6×16	8	
155	CT6253-1019	Shaft	45	1	
156	GB97.1-85	Spacer	10	3	
157	GB70.1-2000	Screw	M10×40	3	
158	GB80-85	Screw	M6×8	2	
159	GB879-86	Pin	5×40	1	
160	GB78-85	Screw	M6×8	2	
161	GB97.1-85	Washer	10	2	
162	GB70.1-2000	Screw	M8×30	1	
163	GB879-86	Pin	3×20	1	
164	GB6170-86	Nut	M8	4	
165	GB96-85	Spacer	8	2	

---

166	GB70.1-2000	Screw	M8×30	3
-----	-------------	-------	-------	---

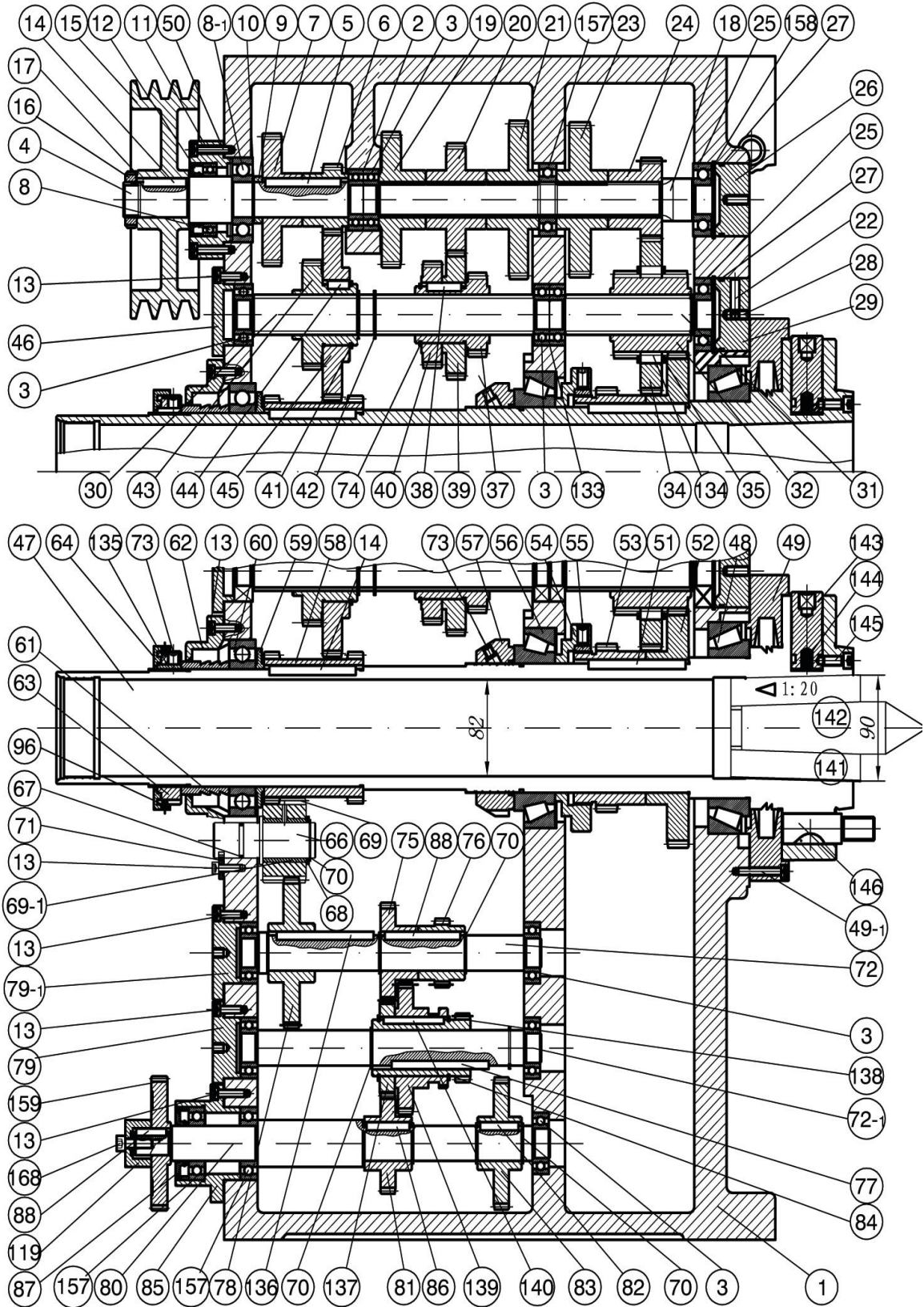
<b>No.</b>	<b>Part No.</b>	<b>Name</b>	<b>Specification</b>	<b>Qty</b>	<b>Remarks</b>
167	CT6253-1040	Crane	cold rolled sheet (A3)	1	δ=2
168	CT6253-1012	Pump stand	Q235	1	δ=2
169	CT6253-1031	Bracket	HT200	1	
170	GB70.1-2000	Screw	M6×12	1	
171	CT6253-1054	Block	45	1	
172	GB70.1-2000	Screw	M6×16	4	
173	CT6253-1053	Block	45	1	
174	CT6253-3080	electrical box	HT200	1	
175	CT6253-3078	Electrical box	ZL	1	

# CT6253 HEADSTOCK

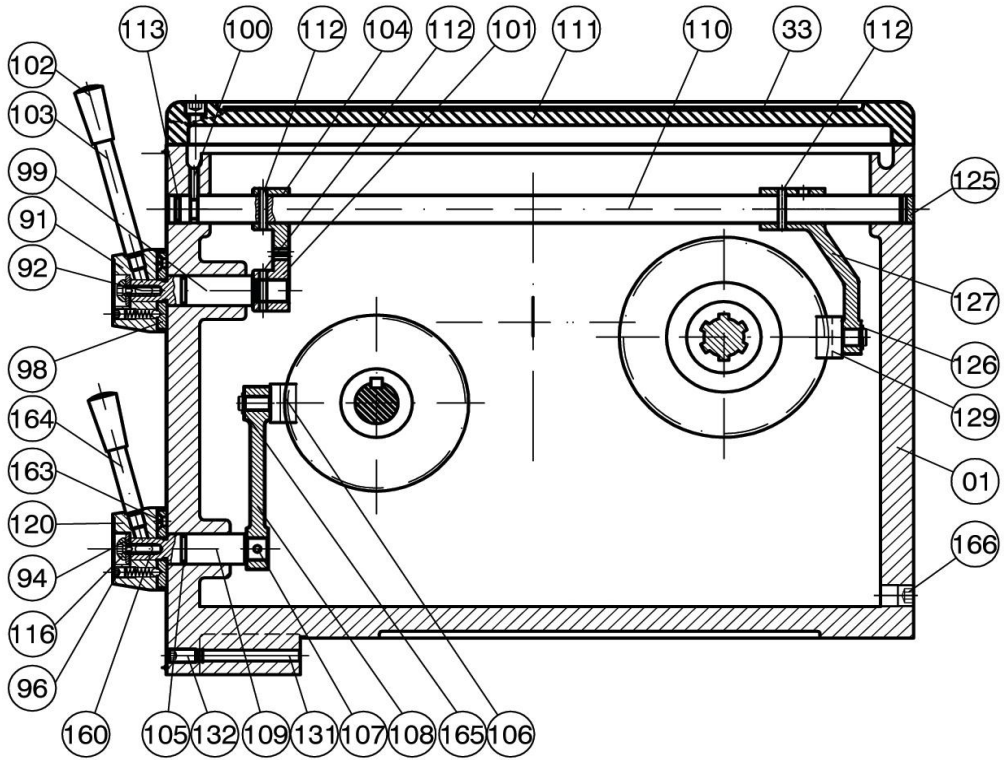




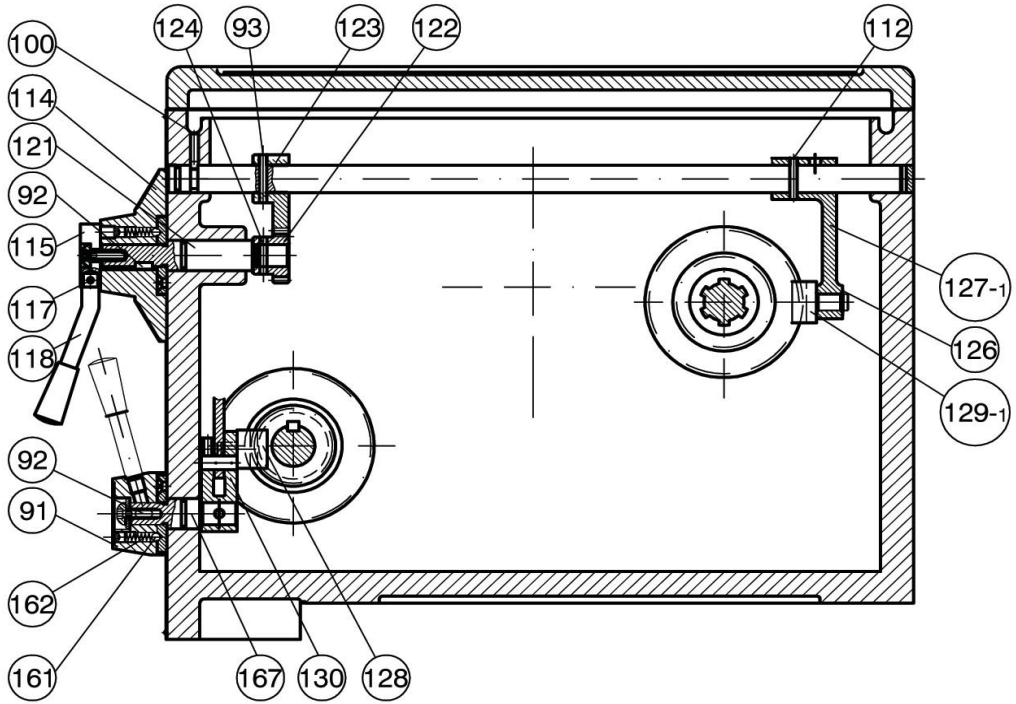
CT6253 HEADSTOCK PARTS LIST ASSEMBLY

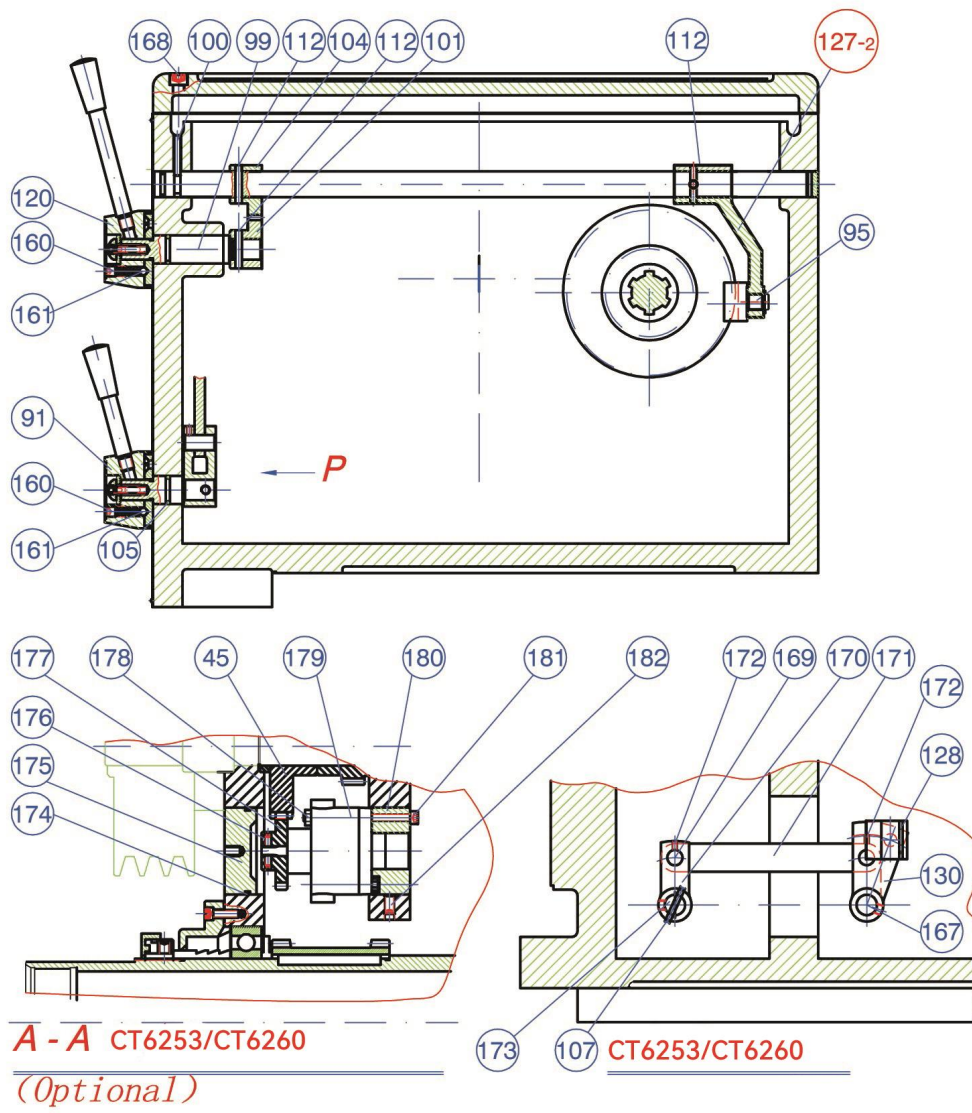


A-A



B-B





### CT6253 HEADSTOCK PARTS LIST

No.	Part No.	Name	Specification	Qty
1	CT6253/60-2001	Headstock Carsting		1
2	CT6260-2011	Spacer		1
3	GB276-94	Ball Bearing	6205	10
4	CT6260-2004	I shaft		1
5	GB/1096-2003	Key	8X7X70	1
6	CT6260-2010	Gear	20TXM2.75	1
7	CT6253-2009	Gear	39TXM2.75	1
8	GB276-94	Ball Bearing	61908	1
8-1	GB276-94	Ball Bearing	6306	1
9	CT6260-2004-1	Spacer		1
10	GB/T894.1-86	O-ring	30	1
11	CT6260-2006	I shaft flange cover		1
12	GB13871-92	Spacer	FB40X62X12	1
13	GB/T70.1-2000	Hexagon socket head cap screws	M6X25	17
14	GB/1096-2003	Key	8X7X45	1
15	CT6260-2005	pulley		1
16	GB/T 812-88	Nut	M30X1.5	1
17	GB/T 858-88	toothed lock washer	30	1
18	CT6260-2020	III shaft		1
19	CT6260-2021	Gear	40TXM2.75	1
20	CT6260-2022	Gear	33TXM2.75	1
21	CT6260-2023	Gear	47TXM2.75	1
22	CT6253-2032	Pin		1
23	CT6260-2024	Gear	46TXM2.75	1
24	CT6260-2025	Gear	23TXM2.75	1
25	GB276-94	Ball Bearing	6305	2
26	CT6260-2026	Plug		1
27	GB3452.1-92	O-ring	58X2.65	2
28	GB/T78-2000	Screw	M8X10	1
29	CT6260-2031	Plug		1
30	CT6260-2014	II Shaft		1
31	CT6260-2028	IV Shaft		1
32	CT6260-2029	Gear	25TXM2.75	1
33	CT6260-2002-1	Spacer		1
34	CT6260-2030	Gear	48TXM2.75	1
35	GB/T894.1-86	Snap Ring	75	2
36	GB/T70.1-2000	Ball Bearing	M6X40	5
37	CT6260-2019	Gear	24TXM2.75	1
38	GB/1096-2003	Key	8X7X32	1
39	CT6260-2018	Gear	38TXM2.75	1
40	CT6260-2017	Gear	31TXM2.75	1

No.	Part No.	Name	Specification	Qty
41	GB/T894.1-86	Snap Ring	52	1
42	GB/T894.1-86	snap Ring	34	2
43	CT6260-2015	Gear	31TXM2.75	1
44	GB/1096-2003	key	8X7X20	1
45	CT6260-2016	Gear	51TXM2.75	1
46	CT6260-2012	II shaft cover		1
47	CT6260-2033	spindle	D6M6	1
48	GB/T297-94	bearing	32024/P5	1
49	CT6260-2035	Front Bearing Cover		1
49-1	GB/T70.1-2000	Hexagon socket head cap screws	M6X40	5
50	GB/T70.1-2000	Hexagon socket head cap screws	M6X30	4
51	GB/1096-2003	key	10X8X90	1
52	CT6260-2037	Gear	72TXM2.75	1
53	CT6260-2038	Gear	49TXM2.75	1
54	CT6260-2039	Set Nut		1
55	GB/T77-2000	Hexagon screws with flat point	M10X16	1
56	GB/T297-94	Bearing	32022/P5	1
57	CT6260-2040	Nut		1
58	CT6260-2041	Gear	55TXM2.25	1
59	CT6260-2042	Oil ring		1
60	GB276-94	Ball Bearing	6020	1
61	CT6260-2043	Cycle oil ring		1
62	CT6260-2044	Back Bearing Cover		1
63	CT6260-2046	Nut		1
64	CT6260-2047	Balance piece		1
65	GB/T79-2000	Hexagon screws with dog point	M6X8	4
66	CT6260-2048	Shaft		1
67	GB3452.1-92	O-ring	30X2.65	1
68	CT6260-2050	Spacer		2
69	CT6260-2049	Gear	30TXM2.25	1
69-1	CT6260-2049-1	cover		1
70	GB/T894.1-86	Snap Ring	30	8
71	CT6253-2051	Washer		1
72	CT6260-2054-C	C-shaft		1
72-1	CT6260-2054-F	F-shaft		
73	GB/T77-2000	Hexagon screws with flat point	M10X10	4
74	GB/T894.1-86	Snap Ring	48	1
75	CT6260-2059	Gear	36TXM2.25	1
76	CT6260-2056	Gear	24TXM2.25	1
77	GB/1096-2003	Key	8X7X90	2
78	CT6260-2055	Gear	55TXM2.25	1
79	CT6260-2052-F	F-cover		1
79-1	CT6260-2052-C	C-cover		1

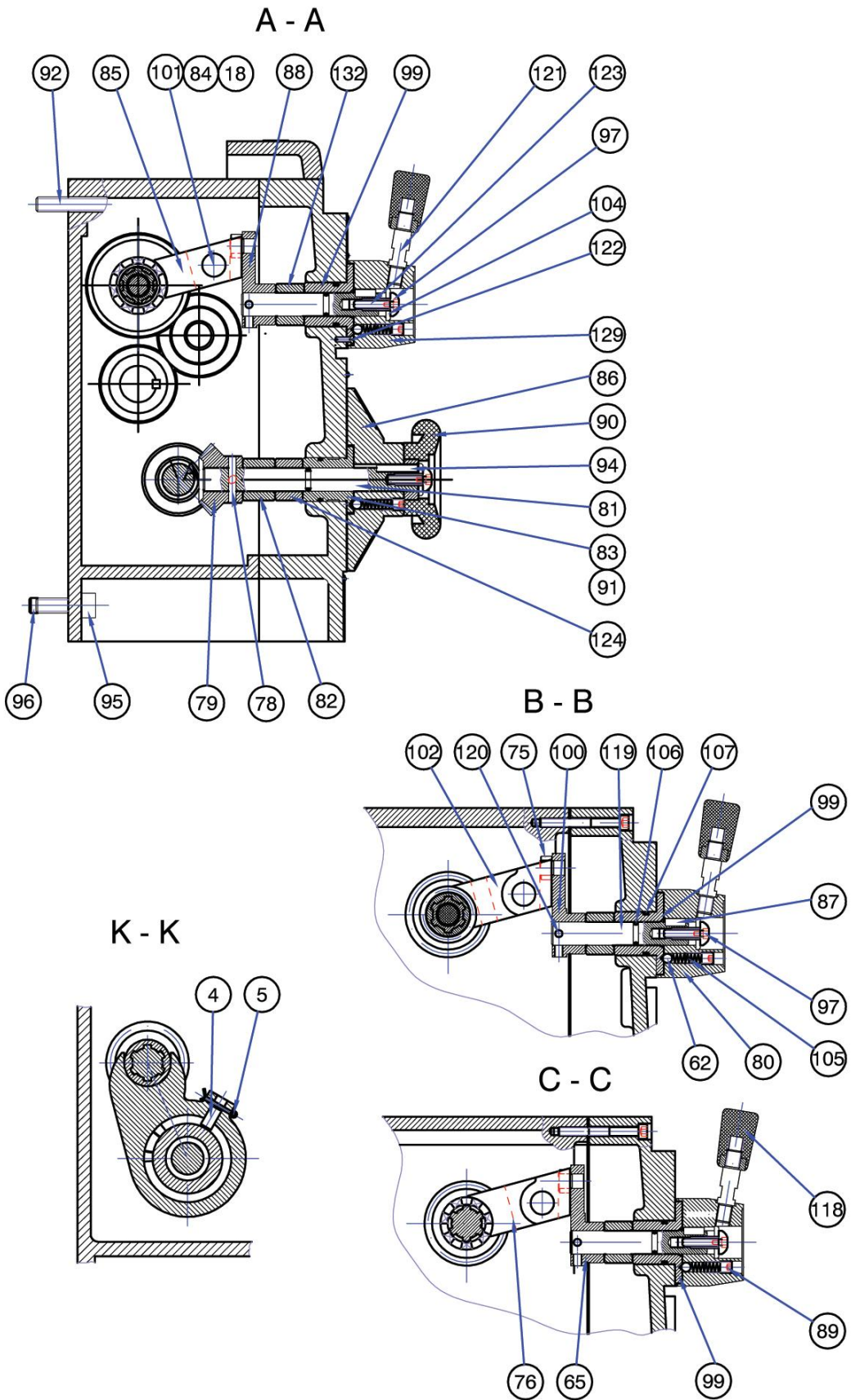
No.	Part No.	Name	Specification	Qty
80	CT6260-2066	Shaft		1
81	CT6260-2062	Gear	36TXM2.25	1
82	GB/1096-2003	Key	8X7X36	1
83	CT6260-2061	Gear	48TXM2.25	1
85	CT6260-2065	Cover		1
86	GB/1096-2003	Key	8X7X40	1
87	GB13871-92	Skeleton oil seal	FB30X62X12	1
88	GB/1096-2003	Key	8X7X70	1
89	GB/T120-2000	Pin	16X55	1
90	GB/T70.1-2000	Hexagon socket head cap screws	M16X60	3
90-1	GB/T93-87	Spring Spacer	16	3
91	CT6253-2077	lever hand		2
92	GB/1096-2003	Key	5X5X12	5
93	GB/T879.2-2000	Pin	5X35	1
94	CT6253-2078	Spacer		4
95	CT6260-2071	Fork		1
96	GB/T77-2000	Hexagon socket set screws with flat point	M8X8	12
97	GB/T93-87	Spring Spacer	16	3
98	CT6253-2076	Fix Black		5
99	CT6260-2075	Shaft		2
100	GB/T79-2000	Hexagon socket set screws with dog point	M8X40	3
101	CT6260-2074	Gear	25TXM2	2
102	JB/7271.3-94	Knob	BM10X40	5
103	JB/7271.6-94	Handle	BM10X45	2
104	CT6260-2073	Gear	29TXM2	2
105	GB3452.1-92	O-ring	17X2.65	6
106	CT6260-2088	Fork		1
107	GB/T879.2-2000	Pin	4X30	2
108	CT6260-2089	Lever		1
109	CT6260-2090	Shaft		1
110	CT6260-2068	Shaft		3
111	CT6260-2002	Headstock cover		1
112	GB/T879.2-2000	Pin	5X30	7
113	GB3452.1-92	O-ring	15X2.65	3
114	CT6253-2083	Handle		1
115	CT6253-2084	Fix Bracket		1
116	CT6253-4048	Screw	M8X20	5
117	GB/T879.2-2000	Pin	4X20	1
118	CT6253-2085	Lever		1
119	CT6253-2067	Cover		1
120	CT6253-2092	Handle		1

No.	Part No.	Name	Specification	Qty
121	CT6260-2082	Shaft		1
122	CT6253-2081	Gear	16TXM2	1
123	CT6253-2080	Gear	44TXM2	1
124	GB/T879.2-2000	Pin	5X25	1
125	CT6253-2069	Plug		3
126	GB/T894.1-86	Snap Ring	12	3
127	C6260-2070	The left fork arm		1
127-1	CT6260-2070-1	The middle fork arm		1
128	CT6260-2095	Double fork		1
129	CT6260-2072	The left fork		1
130	CT6260-2093	Double fork arm		1
131	CT6253-2098	Pin		1
132	GB/T79-2000	Hexagon socket set screws with dog point	M10X20	1
133	CT6260-2027	Spacer		1
134	CT6260-2097	Pin		2
135	CT6253-2046-1	Brass		1
136	GB/1096-2003	Key	6X6X65	1
137	CT6260-2057-1	Gear	36TXM2.25	1
138	CT6260-2057	Gear	24TXM2.25	1
139	CT6260-2057-2	Gear	48TXM2.25	1
140	GB/1096-2003	Key	6X6X56	1
141	JB/T9940.1-99	Cover	R5490X4	1
142	GB/T9204-2008	Center	DG4	1
143	CT6260-2034	Cam lock		6
144	GB/T2089-94	Spring	1.2X7X25	6
145	CT6260-2033-1	Screw	M8X20	6
146	CT6260-2099	Cam lever		6
147	CT6260-2087	Plate		1
149-1	GB/T70.1-2000	Hexagon socket head cap screws	M10X90	1
149	GB/T70.1-2000	Hexagon socket head cap screws	M16X55	3
150	GB/T70.1-2000	Hexagon socket head cap screws	M3X6	19
151	CT6253-2086	Plate		1
152	JB/T7941.1	Oil Level	A20	1
127-2	CT6260-2070-2	The right fork arm		1
154	CT6253-2079	Indication sign		4
129-1	CT6260-2072-1	The middle fork arm		1
156	CT6253-3100	Cover		1
157	GB276-94	Ball Bearing	6206	3
158	GB/T893.1-86	O-ring	62	1
159	CT6253-2103	Gear	35TXM2.25	1
	CT6260-2103	Gear	35TXM2.5	1
160	GB/T80-2000	hexagon screws with cup point	M5X25	6

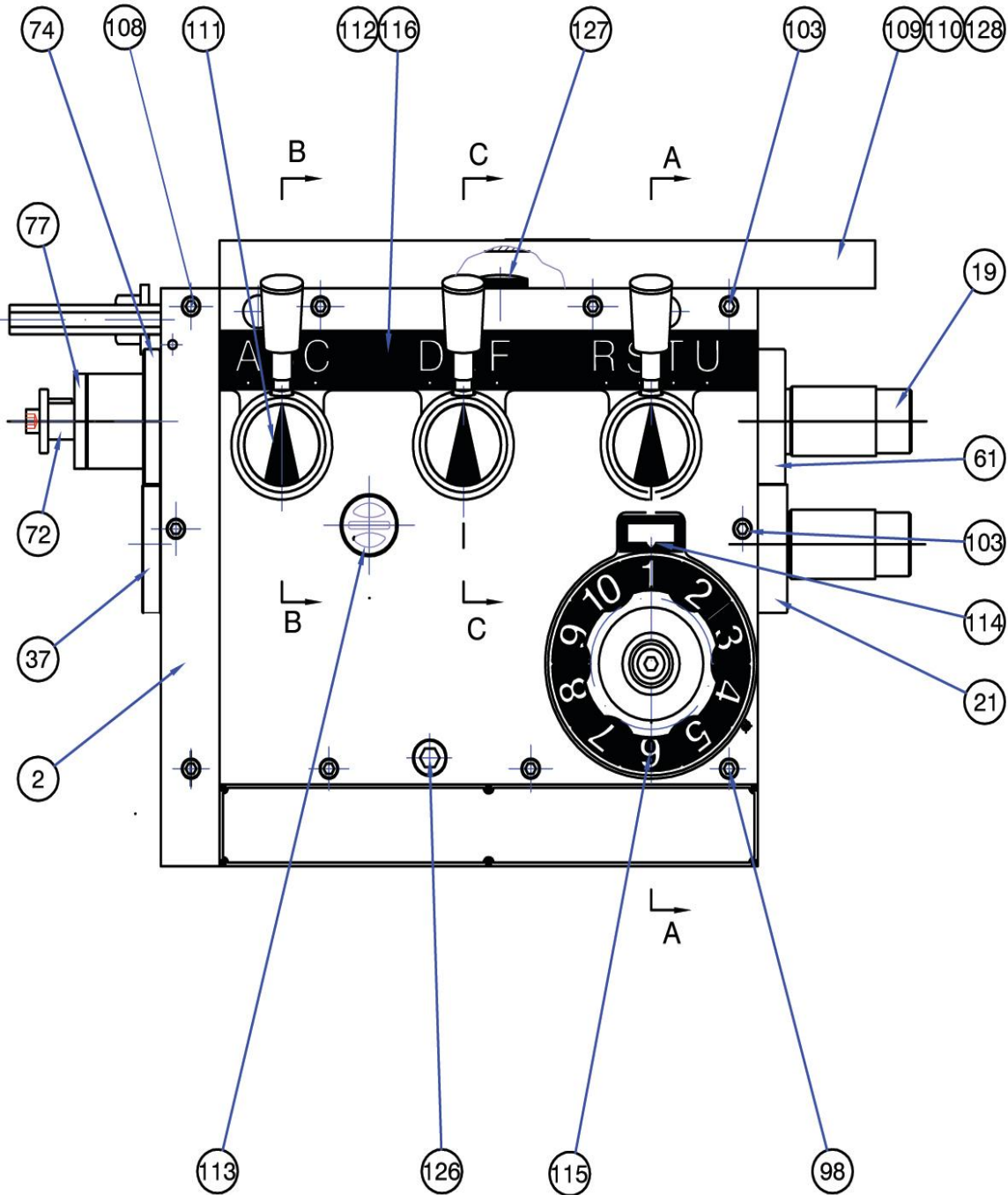
No.	Part No.	Name	Specification	Qty
161	GB308-89	Steel Ball	φ5	6
162	GB/T2089-94	Spring	1X5X25	6
163	GB/T68-2000	Screw	M6X20	10
164	JB/7271.6-94	Lever	BM10X25	2
165	GB/T894.1-86	Snap Ring	10	2
166	JB/T1001-77	Nut	M16X1.5	1
167	CT6253-2094	Double fork shaft		1
168	GB/T70.1-2000	Hexagon socket head cap screws	M8X25	4
169	GB/T119-2000	Pin	12X25	1
170	CT6260-2104	Lever		1
171	CT6260-2105	connector		1
172	GB/T77-2000	Hexagon socket set screws with flat point	M6X10	2
173	CT6260-2106	Doubling transition fork arm		1
174	GB3452.1-92	O-ring	63X2.65	1
175	CT6260-2107	Cover		1
176	GB/T77-2000	Hexagon socket set screws with flat point	M5X10	2
177	CT6260-2108	Lubricating gear pump	T20M2.75	1
178	GB/T6170-2000	hexagon nut	M6	2
179	IRA-2FS	Pump		1
180	CT6260-2108	Pump Stand		1
181	GB/T70.1-2000	Hexagon socket head cap screws	M6X85	2
182	GB/T77-2000	Hexagon socket set screws with flat point	M8X115	2



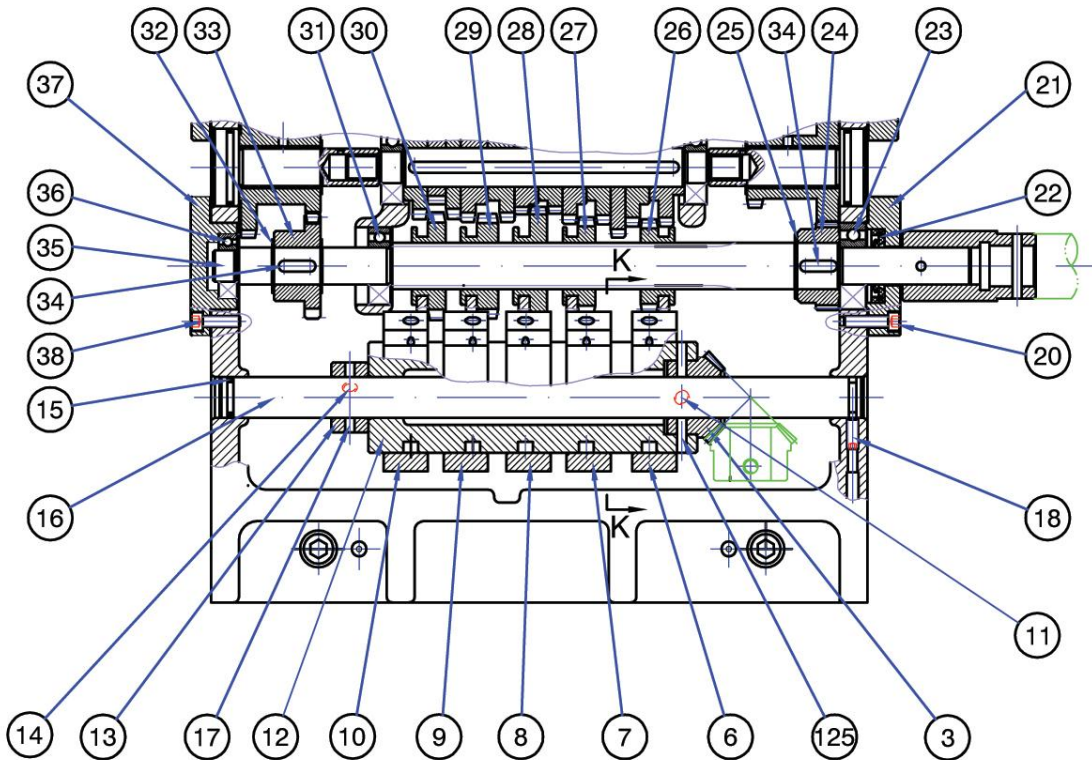
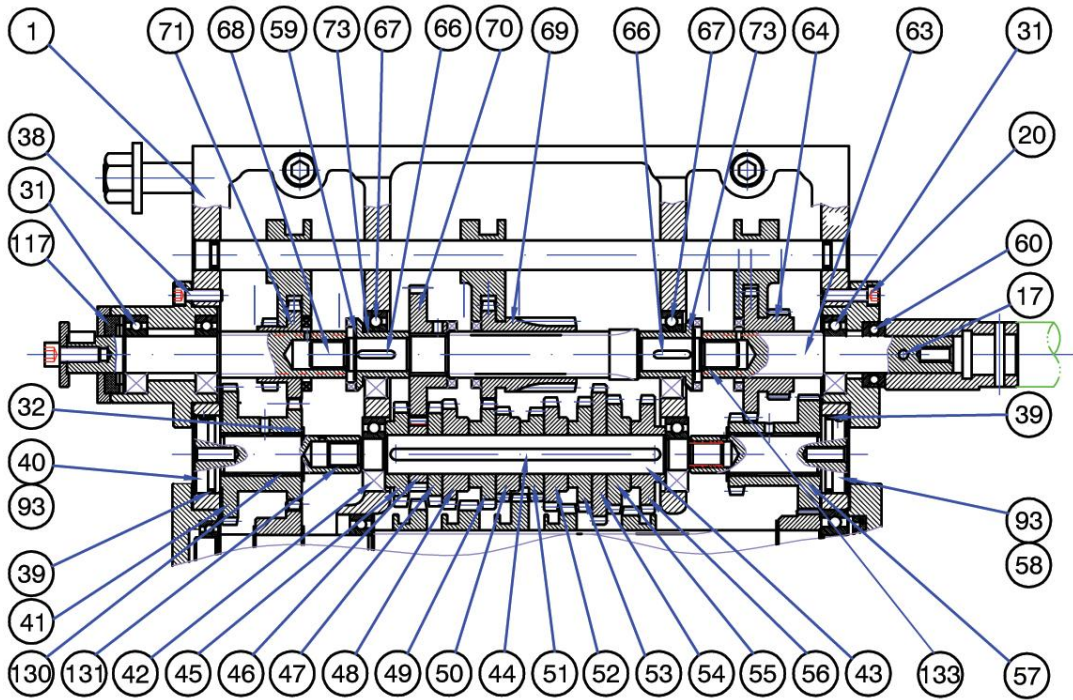
# C6253 GEAR BOX (1)



C6253 GEAR BOX (2)



### C6253 GEAR BOX (3)



### C6253 GEAR BOX PARTS LIST

No.	Part No.	Name	Specification	Qty	Remarks
1	CT6253-3001	Gear box	HT200	1	
2	CT6253-3058	Front cover	HT200	1	
3	CT6246-3056	Bevel gear	45	1	M1.58 Z30
4	GB119-86	Pin	h7×8×20	5	
5	GB91-86	Pin	2.5×30	5	
6	CT6253-3053	9-10 Claw Shifter	HT250	1	
7	CT6253-3052	7-8 Claw Shifter	HT250	1	
8	CT6253-3049	1-2 Claw Shifter	HT250	1	
9	CT6253-3051	5-6 Claw Shifter	HT250	1	
10	CT6253-3050	3-4 Claw Shifter	HT250	1	
11	GB78-85	Screw	M8×10	1	
12	CT6253-3054	Cam Shifter	HT300	1	
13	CT6253-3055	IX Shaft	45	1	
14	GB78-85	Screw		1	
15	GB3452.1-99	O-ring	17×2.65	2	
16	CT6253-3048	IX Shaft	45	1	
17	GB/T879.2-2000	Pin	5×38	1	
18	GB79-85	Screw	M6×16	2	
19	CT6253-3023	Collar-Linkage	45	2	
20	GB70.1-2000	Screw	M6×24	6	
21	CT6253-3022	III cap-right	HT200	1	
22	GB9877.1-88	keleton oil seal	FG20×40×7	1	ACM
23	GB/T276-94	Ball Bearing	6024-2RS	1	
24	CT6253-3021	U-3 Gear	45	1	M1.25 Z36
25	GB894.1-86	Ball Bearing	25	1	
26	CT6253-3020	9-10 Gear	45	1	M12D.P Z22
27	CT6253-3019	7-8 Gear	45	1	M2.25 Z22
28	CT6253-3016	1-2 Gear	45	1	M14D.P Z33
29	CT6253-3018	5-6 Gear	45	1	M11D.P Z22
30	CT6253-3017	3-4 Gear	45	1	M10D.P Z22
31	GB/T276-94	Ball Bearing	6004-2RS	4	
32	GB894-86	Snap ring	20	4	
33	CT6253-3015	B-3 Gear	45	1	M10D.P Z22
34	GB1096-79	Key	6×20	2	
35	CT6253-3014	III Shaft	45	1	
36	GB/T276-94	Ball Bearing	6003-2RSG	1	
37	CT6253-3013	III Shaft seat	HT200	1	
38	GB70.1-2000	Screw	M6×20	6	
39	GB3452.1-92	O ring	37.5×2.65	2	
40	CT6253-3011	II Shaft	45	1	

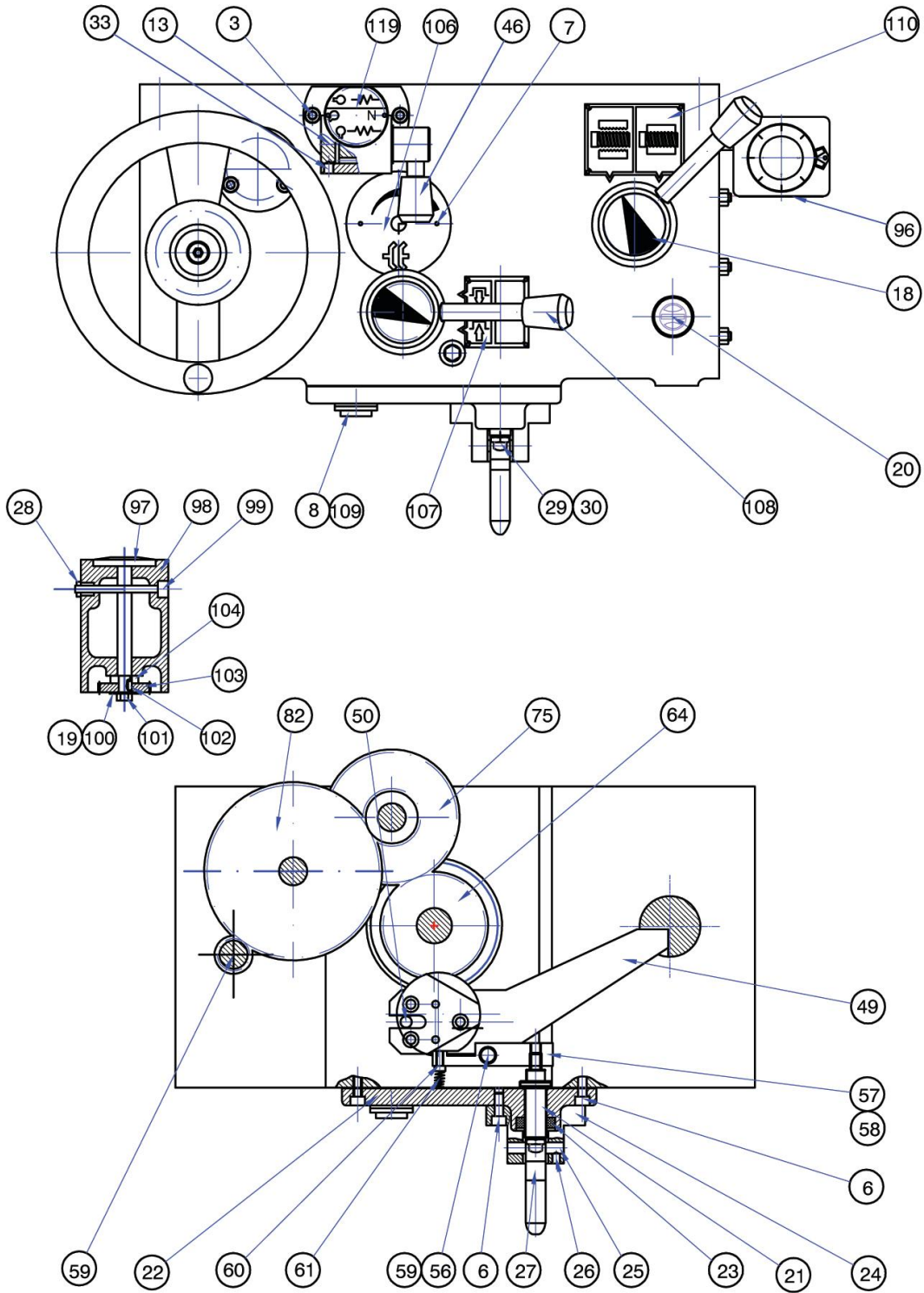
No.	Part No.	Name	Specification	Qty	Remarks
41	CT6253-3012	B-2 Gear	45	1	14D.P 10D.P Z40 20
42	GB/T276-94	Ball Bearing	6023-RS	2	
43	CT6253-3025	IV Shaft	45	1	
44	GTB1096-79	Key	6×146	1	
45	CT6253-3028	3 Gear	45	1	M10D.P Z19
46	CT6253-3029	D-Gear	45	1	M2 Z18
47	CT6253-3030	4-Gear	45	1	M10D.P Z20
48	CT6253-3031	5-Gear	45	1	M11D.P Z22
49	CT6253-3032	6-Gear	45	1	M11D.P Z23
50	CT6253-3026	1-Gear	45	1	M14D.P Z24
51	CT6253-3027	2-Gear	45	1	M14D.P Z27
52	CT6253-3033	7-Gear	45	1	M2.25 Z24
53	CT6253-3034	8-Gear	45	1	M2.25 Z36
54	CT6253-3035	F-2 Gear	45	1	M2 Z36
55	CT6253-3036	9-Gear	45	1	M12D.P Z27
56	CT6253-3037	10-Gear	45	1	M12D.P Z28
57	CT6253-3047	U-2 Gear	45	1	M2 1.25 Z20 50
58	CT6253-3046	VII Shaft	45	1	
59	GB894.1-86	Snap ring	18	1	
60	GB/T301-95	Ball Bearing	51104	1	
61	CT6253-3044	VI Shaft seat	HT200	1	
62	GB308-77	Steel Ball	φ6.5	5	
63	CT6253-3042	VI Shaft	45	1	
64	CT6253-3043	R-U Gear	45	1	M2 1.25 Z35 35
65	CT6253-3074	D-F Lever	HT200	1	
66	GB1096-79	Key	4×20	2	
67	GB/T276-94	Ball Bearing	6005-2RS	2	
68	CT6253-3038	V Shaft	45	1	
69	CT6253-3041	D-F Gear	45	1	11D.P M2 Z23 18
70	CT6253-3040	Gear	45	1	M2 Z36
71	CT6253-3010	A-C Gear	45	1	14D.P 10D.P Z19 19
72	CT6253-3009	I Shaft	45	1	
73	CT6253-3039		45	2	
74	CT6253-3007	I Shaft Seat	HT200	1	
75	CT6253-3067	Block	45	1	
76	CT6253-3005	D-F Fork	HT200	1	
77	CT6253-3008	Spacer	HT200	1	
78	GB879-86	Pin	5×32	1	
79	CT6253-3059	Gear	45	1	M1.58 Z30
80	CT6253-3073-2	Lever	45	2	

No.	Part No.	Name	Specification	Qty	Remarks
81	CT6253-3060	Shaft	45	1	
82	CT6253-3061	Spacer	45	1	
83	CT6253-3063	1-10 Shaft sleeve	45	1	
84	GB3452.1-92	O ring	11.2×2.65	2	
85	CT6253-3006	R-U Fork	HT200	1	
86	CT6253-3064	Selecting Dial	HT200	1	
87	GB1096-79	Key	5×14	3	
88	CT6253-3075	R-U Lever	HT200	1	
89	GB77-85	Screw	M8×8	1	
90	CT6253-3076	Handle	45、bakelite	1	Synthesis of parts
91	GB78-85	Screw	M8×35	1	
92	GB70.1-2000	Screw	M10×65	2	
93	GB78-85	Screw	M6×16	2	
94	GB1096-79	Key	C5×30	1	
95	GB70.1-2000	Screw	M10×40	2	
96	GB118-86	Pin	10×45	2	
97	CT6253-4048	Screw	45	4	
98	GB70.1-2000	Screw	M6×60	3	
99	CT6253-3070	A-C Sleeve	45	3	
100	CT6253-3066	A-C lever	HT200	1	
101	CT6253-3003	VIII Shaft	45	1	
102	CT6253-3004	A-C Fork	HT200	1	
103	GB70.1-2000	Screw	M6×55	4	
104	CT6253-3065	Washer	45	4	
105	GB/T2089-94	Spring	65Mn	5	1*5*1.83*25
106	GB3452.1-92	O ring	11.2×2.65	4	
107	GB3452.1-92	O ring	25×2.65	4	
108	GB70.1-2000	Screw	M6×35	3	
109	CT6253-3095	Plate	Al	1	δ=0.5
110	GB70.1-2000	Screw	M6×30	2	
111	CT6253-3094	Plate	Al	3	δ=0.5
112	CT6253-3093	Plate	Al	1	δ=0.5
113	GB1160.1-89	Oil Plate	A32	1	
114	CT6253-3090	Plate	Al	1	δ=0.5
115	CT6253-3092	Plate	Al	1	δ=0.5
116	GB827-86	Screw	2×5	10	
117	TTO-D213-TC	washer	20×42×8-1	1	
118	CT6253-3071	Handle Sleeve	45、bakelite	1	Synthesis of parts
119	CT6253-3069	Shaft	45	1	
120	GB879-86	Pin	5×20	1	
121	CT6253-3072	Lever	45	1	

---

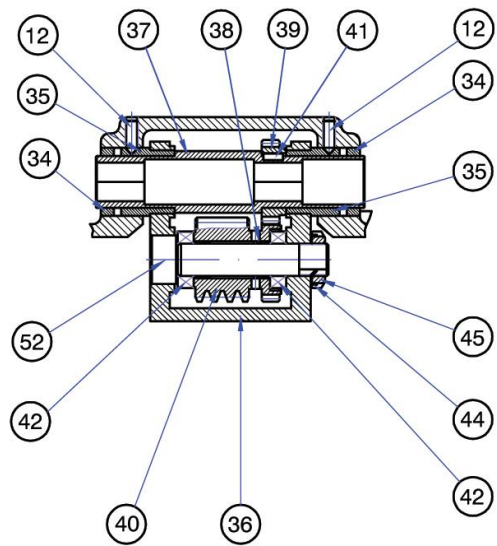
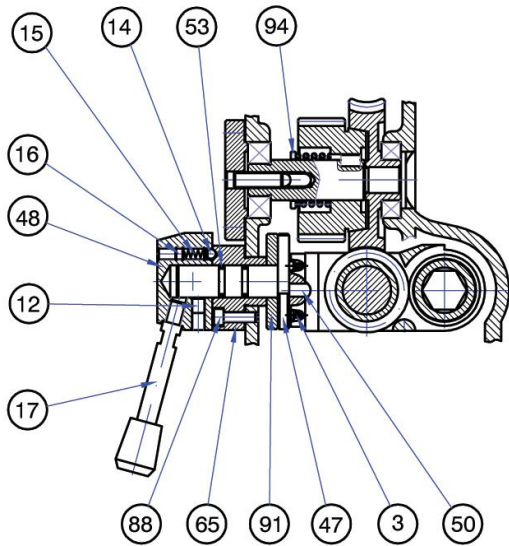
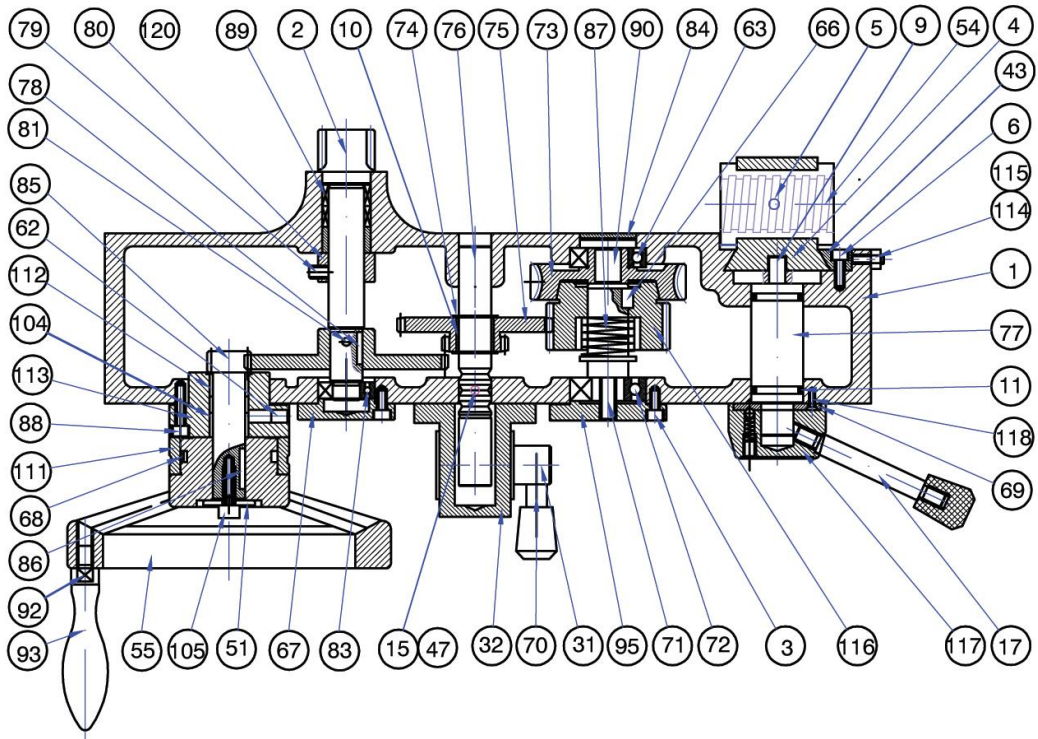
No.	Part No.	Name	Specification	Qty	Remarks
122	GB819-85	Screw	M5×15	6	
123	GB80-85	Screw	M5×25	4	
124	CT6253-3062	Spacer	45	1	
125	GB879-86	Pin	5×20	2	
126	GB/T7037	Nut	ZG3/8"	1	19*12.5
127	CT6253-3100	cover	Plastic	1	
128	CT6253-3077	cover	HT200	1	
129	CT6253-3073-1	Handle	45	1	
130	GB/T18234-2001	Sleeve	C20×23×15	2	
131	GB/T18234-2001	Sleeve	C12×14×18	2	
132	CT6253-3068	Spacer	45	1	
133	GB/T18234-2001	Sleeve	C14×16×10	2	

# SLIDE BOX ASSEMBLY (1)





## SLIDE BOX ASSEMBLY (2)



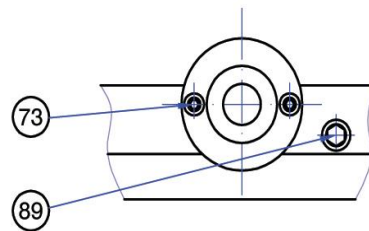
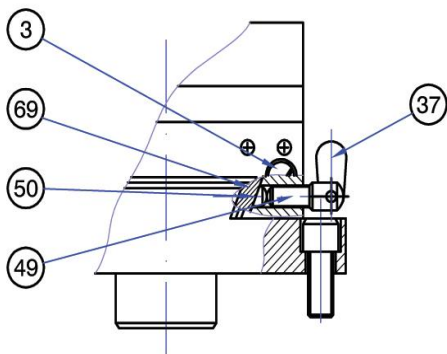
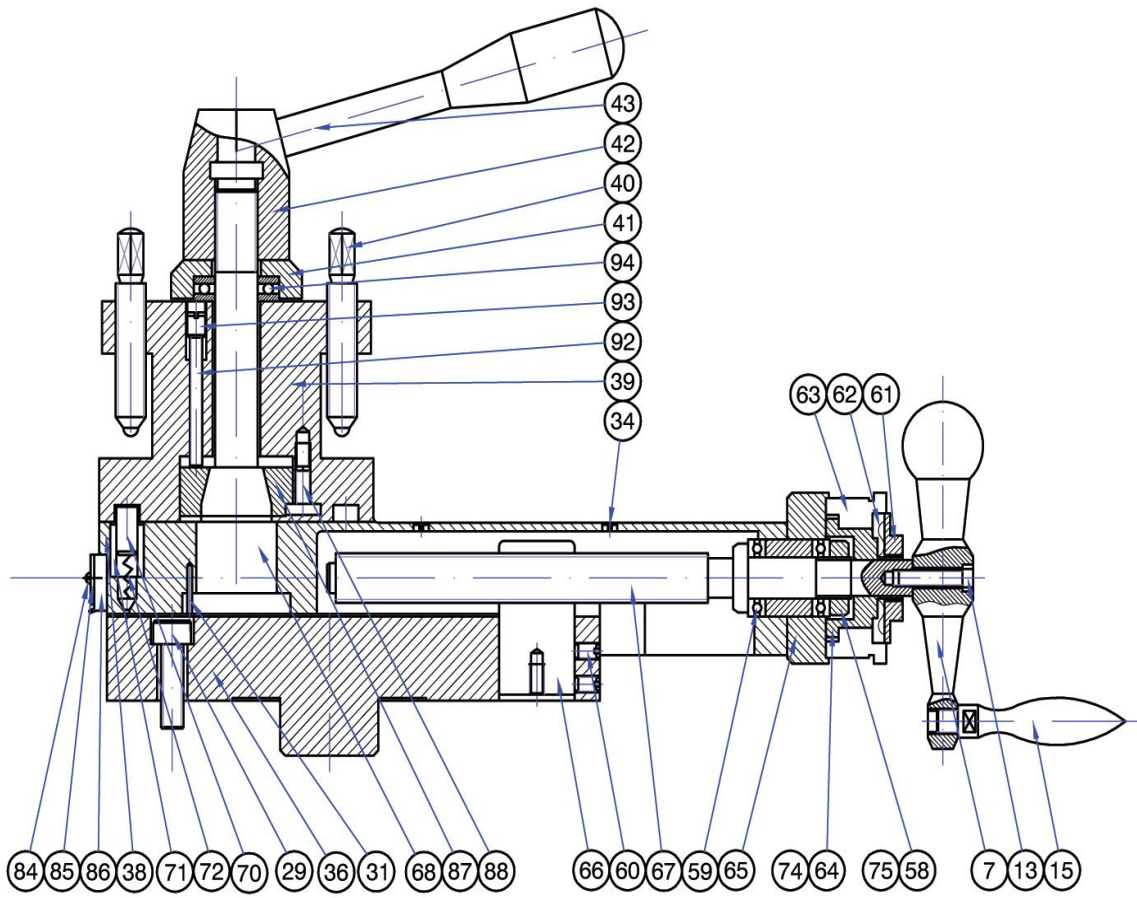
### CT6253 SLIDE BOX PARTS LIST

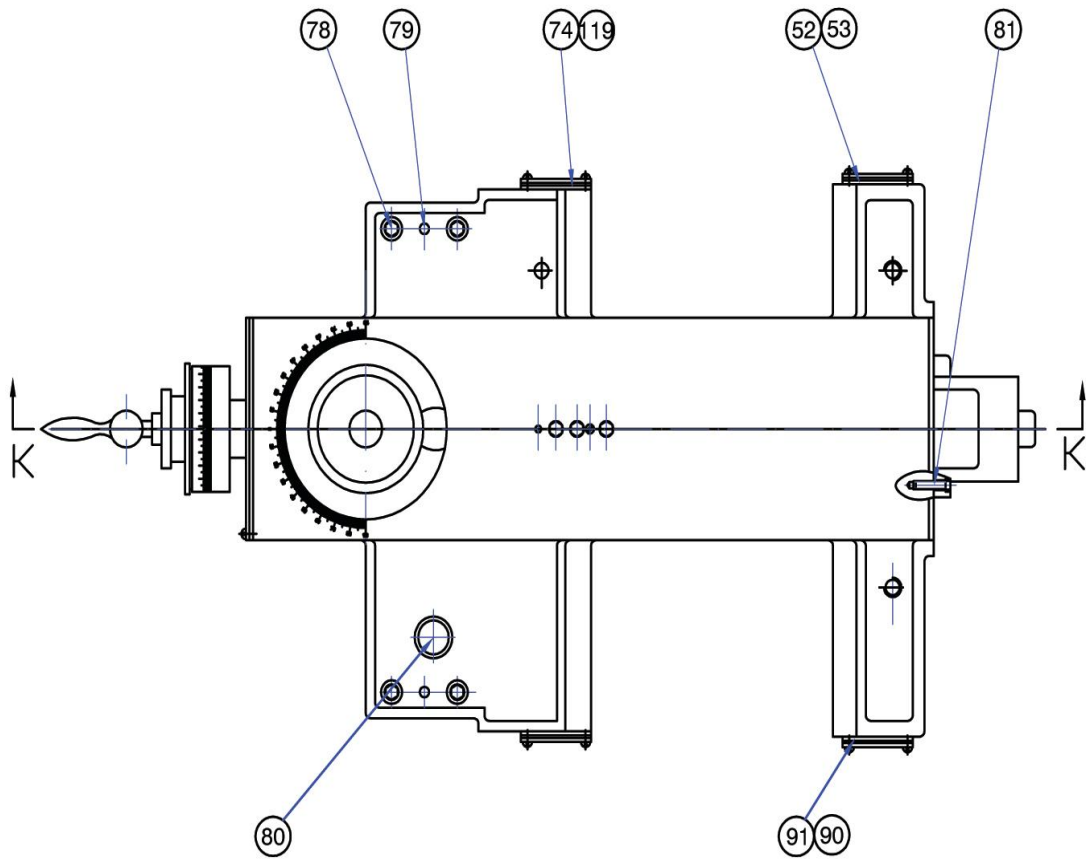
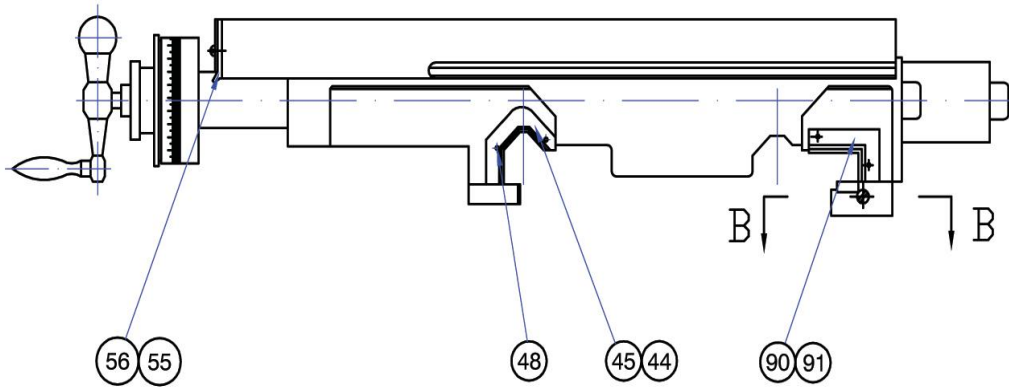
No.	Part No.	Name	Specification	Qty
1	CT6253-4001A	Apron	HT250	1
2	CT6253-4047	Gear-Shaft	45	1
3	GB70.1-2000	Screw	M6×12	11
4	CT6253-4015	Half nut	HT200	1
5	GB70.1-2000	Screw	M6×16	2
6	GB70.1-2000	Screw	M6×16	16
7	GB27-86	Rivet	2×5	6
8	GB38-4A	Nut	M16×1.5	1
9	CT6253-4019	Shaft	45	2
10	CT6256-4015	cover	ZCuSn6-6-3	1
11	GB3452.1	O-ring	26×3.55	2
12	GB80-85	Screw	M8×10	8
13	CT6253-4006	Plate	HT200	1
14	GB6308-89	steel ball	φ6	2
15	GB/T2089	Spring	65Mn	3
16	GB77-85	Screw	M8×10	2
17	JB/T7271.6-94	Lever	35	2
18	CT6253-4016	Plate	Al	1
19	GB93-87	Spring	10	1
20	HY8316.4	Oil level	31×97	1
21	CT6253-4030	Shaft	45	1
22	CT6253-4028	Cover	HT200	1
23	GB13871	Skeleton oil seal	(FB) 15×26×7	1
24	CT6253-4031	Stand	HT200	1
25	GB119-86	Pin	8×40	1
26	GB78-85	Screw	M6×10	1
27	CT6253-4032	Lever	HT200	1
28	CT6256-4008	Spacer	45	1
29	GB77-85	Screw	M8×25	1
30	GB6170-86	Nut	M8	1
31	CT6253-4004	Gear-Shaft	45	1
32	CT6253-4002	Gear	HT200	1
33	GB78-85	Screw	M5×8	2
34	GB13871	Skeleton oil seal	(FB) 32×42×8	2
35	CT6253-4058	Shaft cover	ZCuSn6-6-3	2
36	CT6253-4057	Sleeve feed rod	HT250	1
37	CT6253-4059	Sleeve	45	1
38	GB/T12949	Sleeve	23×20×10	2
39	CT6253-4053	Gear	45	1
40	CT6253-4055	Seat-worm	45	1

No.	Part No.	Name	Specification	Qty
41	GB/T1567	Key	6×12	1
42	GB/T301	Bearing	51104	2
43	CT6253-4062	Block	HT200	1
44	GB/T858-88	Spacer	20	1
45	GB812-88	Nut	M20×1.5	1
46	JB/T7271.3-1994	Handle wheel	BM10×32	3
47	CT6253-4010	Knob	45	1
48	CT6253-4008	Lever stand	45	1
49	CT6253-4061	Plate	HT200	1
50	GB119-86	Pin	8×25	1
51	CT6253-4049	Spacer	45	1
52	CT6253-4054	Shaft	45	1
53	GB3452.1	O ring	15×2.65	2
54	CT6253-4051	half nut	ZCuSn6-6-3	1
55	CT6253-4050	handle wheel	HT200	2
56	GB894.1-86	Snap Ring	10	1
57	CT6253-4060	Block	45	1
58	GB70.1-2000	Screw	M8×12	1
59	CT6253-4027	Shaft	45	1
60	GB70.1-2000	Screw	M5×8	1
61	GB/T2089	Spring	65Mn	1
62	GB13871	Oil cup	FBTC15×1=26×7	1
63	GB276-94	Ball bearing	6005	1
64	CT6253-4023	Gear	45	1
65	CT6253-4009	Flange	HT200	1
66	GB1096-79	Key	8×12	1
67	CT6253-4041	Flange Cover	HT200	1
68	CT6253-4036	Spiring	65Mn	1
69	CT6253-4017	Sleeve	45	1
70	CT6253-4005	Lever	45	1
71	GB77-85	Screw	M10×30	1
72	GB276-94	Ball bearing	6204	1
73	CT6253-4022	Rod	ZCuSn6-6-3	1
74	GB894.1-86	Snap Ring	20	2
75	CT6253-4043	Gear	45	1
76	CT6253-4003	Gear-Shaft	45	1
77	CT6253-4018	pinon	45	1
78	GB1096-79	Key	6×20	1
79	GB78-85	Screw	M8×10	1
80	CT6253-4044	Sleeve	45	1
81	GB/T879.2	Pin	5×35	1

82	CT6253-4042	Gear	45	1
83	GB276-94	Ball bearing	6003	1
<b>No.</b>	<b>Part No.</b>	<b>Name</b>	<b>Specification</b>	<b>Qty</b>
84	CT6253-4021	Cover	45	1
85	CT6253-4045	Shaft	45	1
86	GB1096-79	Key	6×25	1
87	CT6253-4024	Spring	50CrVA	1
88	GB70.1-2000	Screw	M6×25	4
89	GB5801-86	Bearing	NA4903	2
90	CT6253-4020	Shaft	45	1
91	CT6253-4011	Plate	45	1
92	GB4141.6	Lever	M10×80	1
93	GB4141.6	Sleeve	M10×80	1
94	CT6253-4025	Spacer	45	1
95	CT6253-4033	Cover	HT200	1
96	CT6253-4070	Plate	Al	1
97	CT6253-4065	Gib	45	1
98	CT6253-4064	Seat	HT200	1
99	GB70.1-2000	Screw	M8×80	1
100	GB97.2-85	Washer	10	1
101	GB6170-86	Nut	M10	1
102	GB1096-79	Key	4×8	1
103	CT6253-4069A	Gear	45	5
104	GB/T18324	Sleeve	C20×26×10	1
105	CT6253-4048	Screw	45	1
106	CT6253-4035	Plate	Al	1
107	CT6253-4012	Plate	Al	1
108	GB4141.14	Lever	B-M10×40	3
109	GB97.1-16	Spacer	Copper	1
110	CT6253-4014	Plate	Al	1
111	CT6253-4037	Dial	45	1
112	CT6253-4071	Cover	ZCuSn6-6-3	1
113	CT6253-4038	Flange	HT200	1
114	GB77-85	Screw	M6×20	4
115	GB/T41	Nut	M6	4
116	CT6253-4023	Gear	45	1
117	CT6253-4015	lever hand	45	1
118	GB68-85	Screw	M4×10	2
119	CT6253-4007	Plate	Al	1
120	CT6253-4046	Cover	ZCuSn6-6-3	1

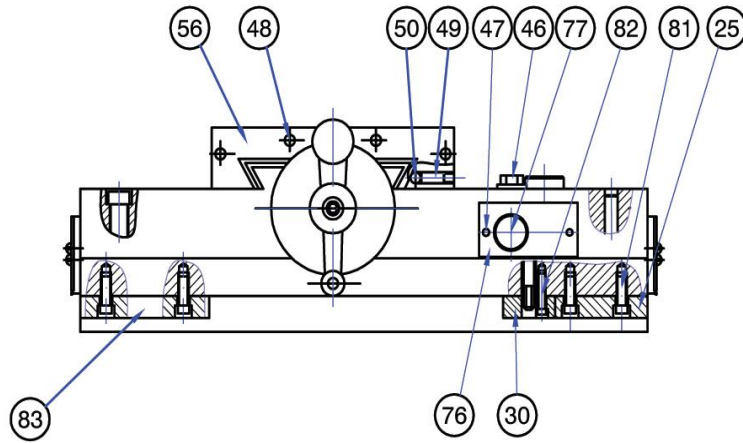
# TOOL CARRIER



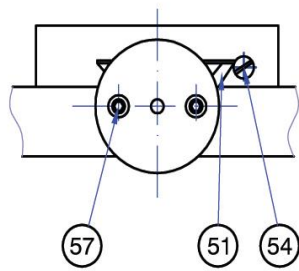


# BED SADDLE (2)

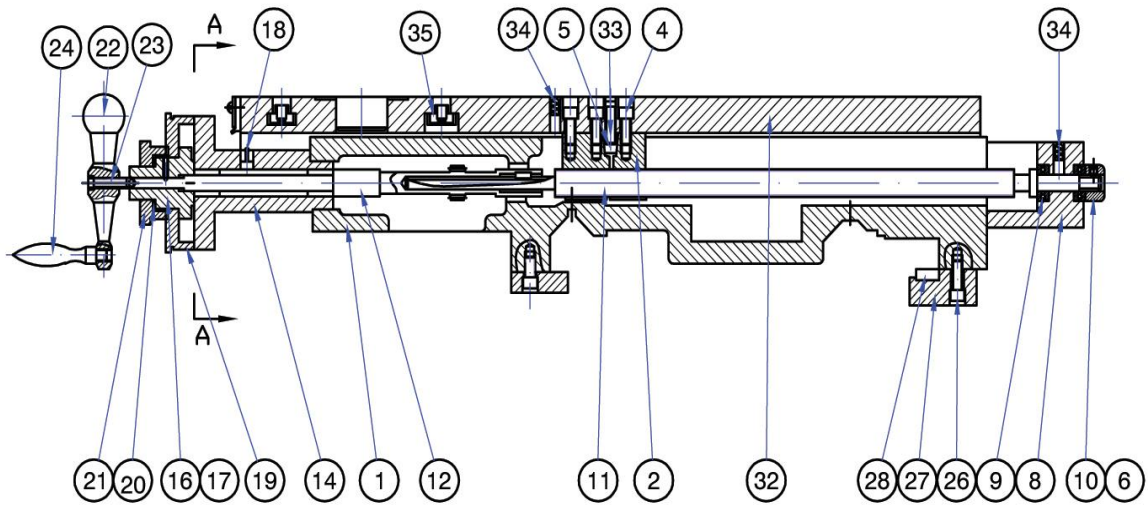
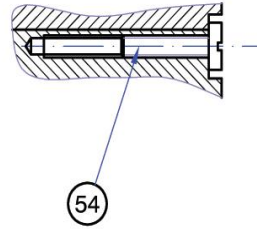
K-K



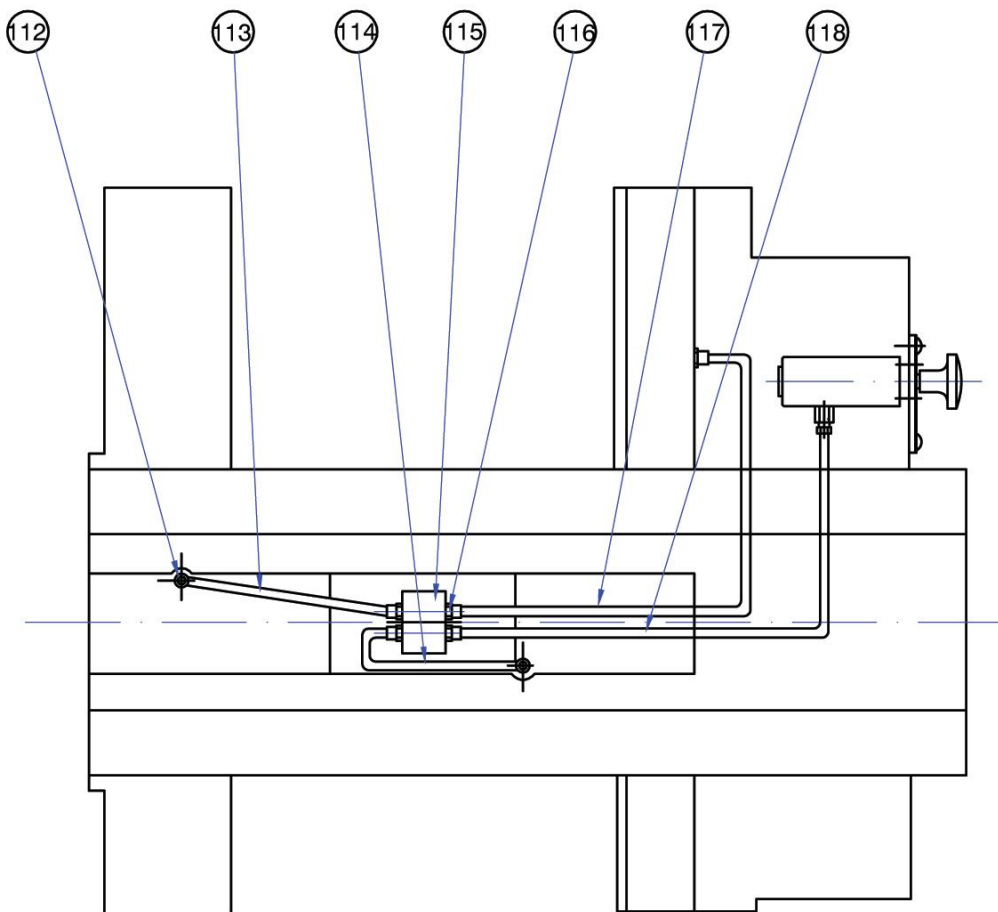
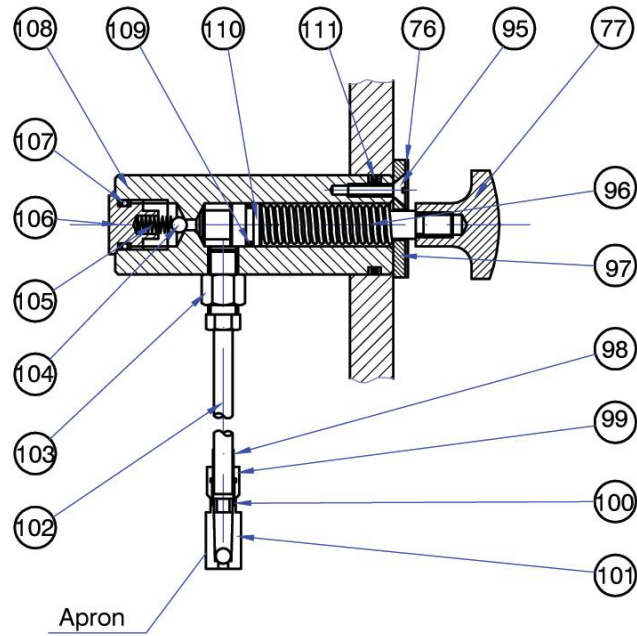
A-A



B-B



### BED SADDLE (3)





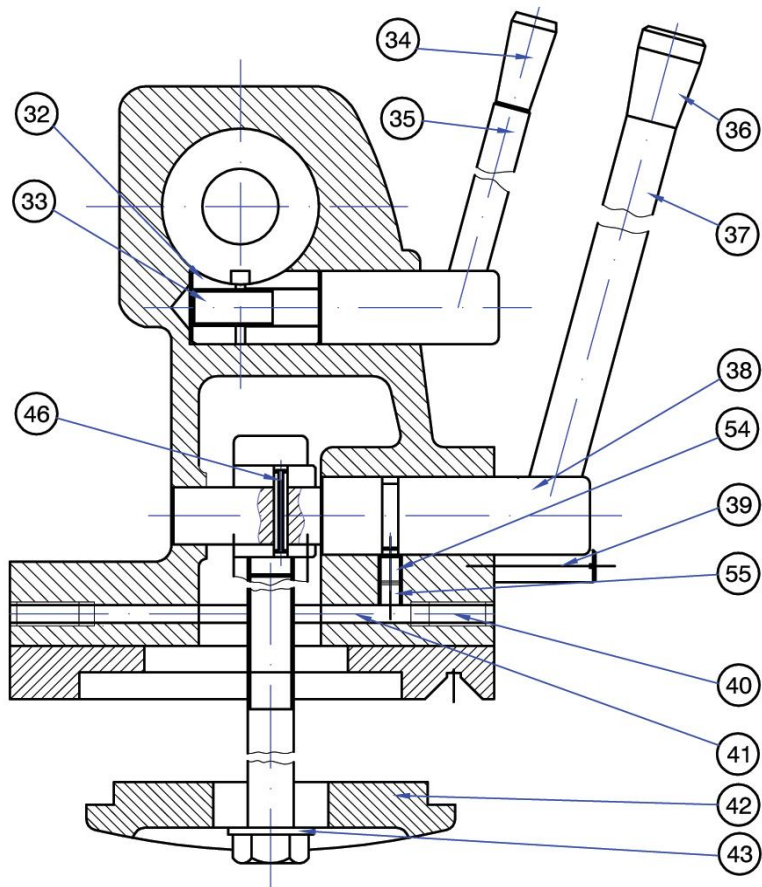
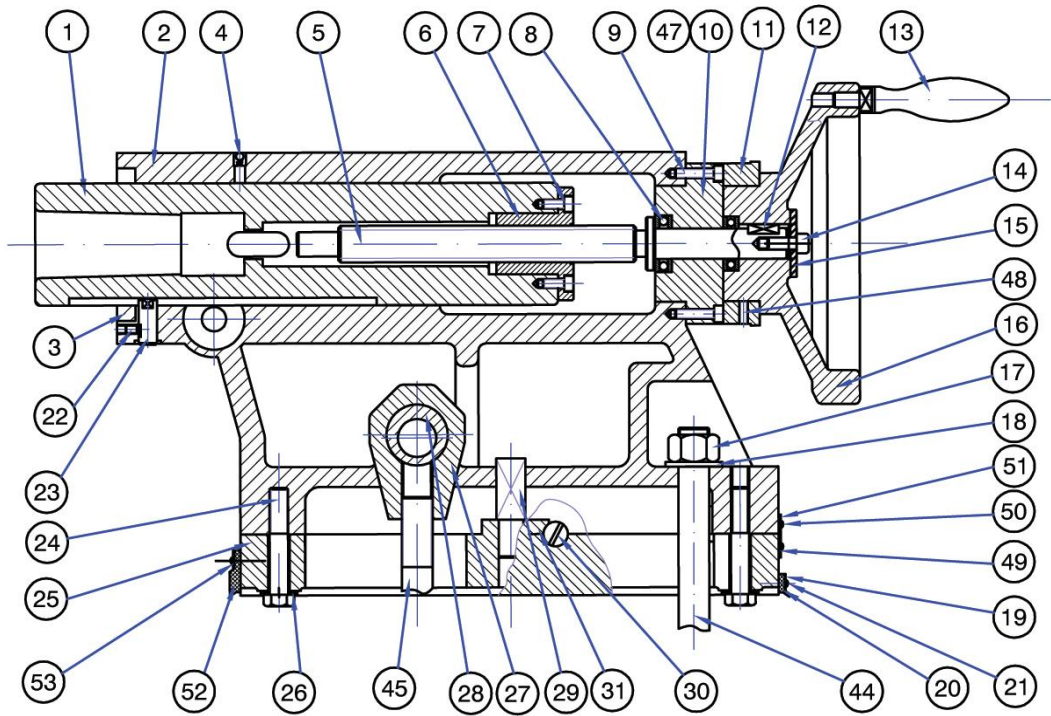
### CT6253 SADDLE PARTS LIST

No.	Part No.	Name	Specification	Qty	Remarks
1	CT6253-5101	Saddle	HT200	1	
2	CT6253-5128	nut	ZQSn6-6-3	1	
3	CT6253-5010	Screw	45	1	
4	GB70.1-2000	Hexagon socket head cap screws	M6×30	3	
5	CT6253-5129	Gib	45	1	
6	GB80-85	hexagon socket set screws with cup point	M6×8	1	
7	GB4141.9	Handle	B-8×37	1	
8	CT6253-5130	Bracket	HT200	1	
9	GB301-84	Thrust Bearing	51101	2	
10	CT6253-5135	Nut	45	1	
11	CT6253-5131	Cross Feed Screw	45	1	
12	CT6253-5126	Cross Feed Pinion	45	1	
13	GB70.1-2000	Hexagon socket head cap screws	M6×15	1	
14	CT6253-5124	In the front seat	HT200	1	
15	GB4141.9	Handle		1	
16	GB80-85	hexagon socket set screws with cup point	M6×8	1	
17	CT6253-5121	Clutch-Dial	45	1	
18	GB1155-89	Oil cup	8	1	
19	CT6253-5122	Cross feed Dial	45	1	
20	TH	Spring		1	0.5*41*51*2.5
21	CT6253-5120	Nut	45	1	
22	CT6253-5140	Handle	35	1	
23	GB70.1-2000	Hexagon socket head cap screws	M8×16	1	
24	CT6253-5142	Handle	35	1	
25	CT6253-5119	Gib-right-front	HT200	1	
26	GB70.1-2000	Hexagon socket head cap screws	M8×30	4	
27	CT6253-5114	Holder Gib	HT200	1	
28	CT6253-5115	Gib	45	1	
29	GB70.1-2000	Hexagon socket head cap screws	M10×20	1	M10*45 for 46
30	CT6253-5118	Clamp-carriage	HT200	1	
31	GB879-86	Pin	6×16	1	
32	CT6253-5102	Cover-Cross Sliding	HT200	1	
33	GB80-85	hexagon socket set screws with cup point	M8×25	1	
34	GB1155-89	Oil cup	6	6	
35	CT6253-5125	T nut	45	3	
36	CT6253-5002	Swivel Table	HT200	1	
37	CT6253-5138	Plate	A3	1	δ=2
38	CT6253-5001	Compound post	HT200	1	
39	CT6253-5013	tool post	45	1	
40	GB85-88	Square set screws with long dog point	M12×55	12	

No.	Part No.	Name	Specification	Qty	Remarks
41	CT6253-5014	Spacer	45	1	
42	GB4141.6	Handle	M20×45	1	
43	GB4141.6	Handle	B-M12×140	1	
44	CT6253-5105-1	Wiper	Oil resistant rubber	1	
45	CT6253-5105-2	Wiper	A3	1	δ=1.5
46	CT6253-5106	Shaft	45	1	
47	GB818-85	Screw	M6×16	2	
48	GB818-85	Screw	M4×12	12	
49	CT6253-5137	Screw	M8×20	2	
50	CT6253-5104	Pin	35	2	
51	CT6253-5132	Gib	45	1	
52	CT6253-5133-1	wiper	Oil resistant rubber	1	
53	CT6253-5133-2	wiper	A3	1	δ=1.5
54	CT6253-5116	Screw	45	4	
55	CT6253-5123-1	wiper	Oil resistant rubber	1	
56	CT6253-5023-2	wiper	A3	1	δ=2
57	GB70.1-2000	Screw	M8×60	2	
58	GB6173-86	Nut	M14×1.5	1	
59	GB/T301	Ball bearing	51102	2	
60	GB80-85	Screw	M6×8	2	
61	CT6253-5008	Nut	45	1	
62	TH	Spring		1	0.5*38*45*2.5
63	CT6253-5006	Dial compound post	45	1	
64	CT6253-5007	Collar	45	1	
65	CT6253-5005	seat-compound rest	45	1	
66	CT6253-5003	Nut	ZQSn6-6-3	1	
67	CT6253-5004	Screw-compound rest	45	1	
68	CT6253-5011	Tool post shaft	45	1	
69	CT6253-5009	Gib	45	1	
70	GB119-86	Pin	8×18	1	
71	CT6253-5015	Sleeve	45	1	
72	GB2089-80	Spring	65Mn	1	0.6*4*20
73	GB70.1-2000	Screw	M6×20	2	
74	CT6253-5134-1	Wiper	Oil resistant rubber	1	
75	GB80-85	Screw	M6×5	1	
76	CT6253-5108	Plate	Ly	1	δ=0.8
77	CT6253-5109	Plug	45	1	
78	GB70.1-2000	Screw	M10×60	4	
79	GB118-86	Pin	8×60	2	
80	QB-OIL	Nut	M20	1	
81	GB70.1-2000	Screw	M8×18	6	
82	GB70.1-2000	Screw	M6×16	1	

No.	Part No.	Name	Specification	Qty	Remarks
83	CT6253-5117	Gib front	HT200	1	
84	GB818-85	Screw	M4×12	4	
85	CT6253-5016-2	Wiper	A3	1	δ=1.5
86	CT6253-5016-1	Wiper	Oil resistant rubber	1	
87	CT6253-5012	Sleeve	45	1	
88		Screw	M8×14	3	
89	GB80-85	Screw	M6×20	1	
90	CT6253-5103-1	wiper	Oil resistant rubber	1	
91	CT6253-5103-2	wiper	A3	1	δ=1.5
92	GB119-86	Pin	6×50	3	
93	GB80-85	Screw	M8×10	3	
94	GB/T301	Ball bearing	51104	1	
95	GB819-85	Screw	5×12	2	
96	GB2089-1994	Spring	1.4×11×55	1	
97	CT6253-5107	Button Board	Q235	1	δ=4
98	CT6253-5143-1	Brass Tube		1	
99	CT6253-5143-2	Nut	45	1	
100	CT6253-5143-3	Sleeve	45	1	
101	CT6253-4080		45	1	
102	G5111	Brass Tube	φ6×160	1	
103	CT6253-5143	Value ass	22587-2 copper	1	
104	GB308-84	Steel ball	5	1	
105	GB2089-1994	Spring	0.5×4.5×16	1	
106	6T241-5110	Oil plug	19/Q235	1	Six angle steel
107	GB3542.1-92	O-ring	12.5×1.8	1	
108	CT6253-5111	Body pump	HT200	1	
109	GB3542.1-92	O-ring	9×1.8	1	
110	CT6253-5112	Piston rod	45	1	
111	GB3542.1-92	O-ring	25×2.65	1	
112		Tube Fitting	22617	3	Z1/8"×φ6
113	G5111	Brass Tube	φ4×150	1	
114	G5111	Brass Tube	φ4×140	1	
115	CT6253-5139	Manifold	45	1	
116	B1064、1524	Sleeve and Fitting	45	1	
117	G5111	Brass Tube	φ4×380	1	
118	G5111	Brass Tube	φ4×400	1	
119	CT6253-5134-2	Wiper	A3	1	δ=1.5

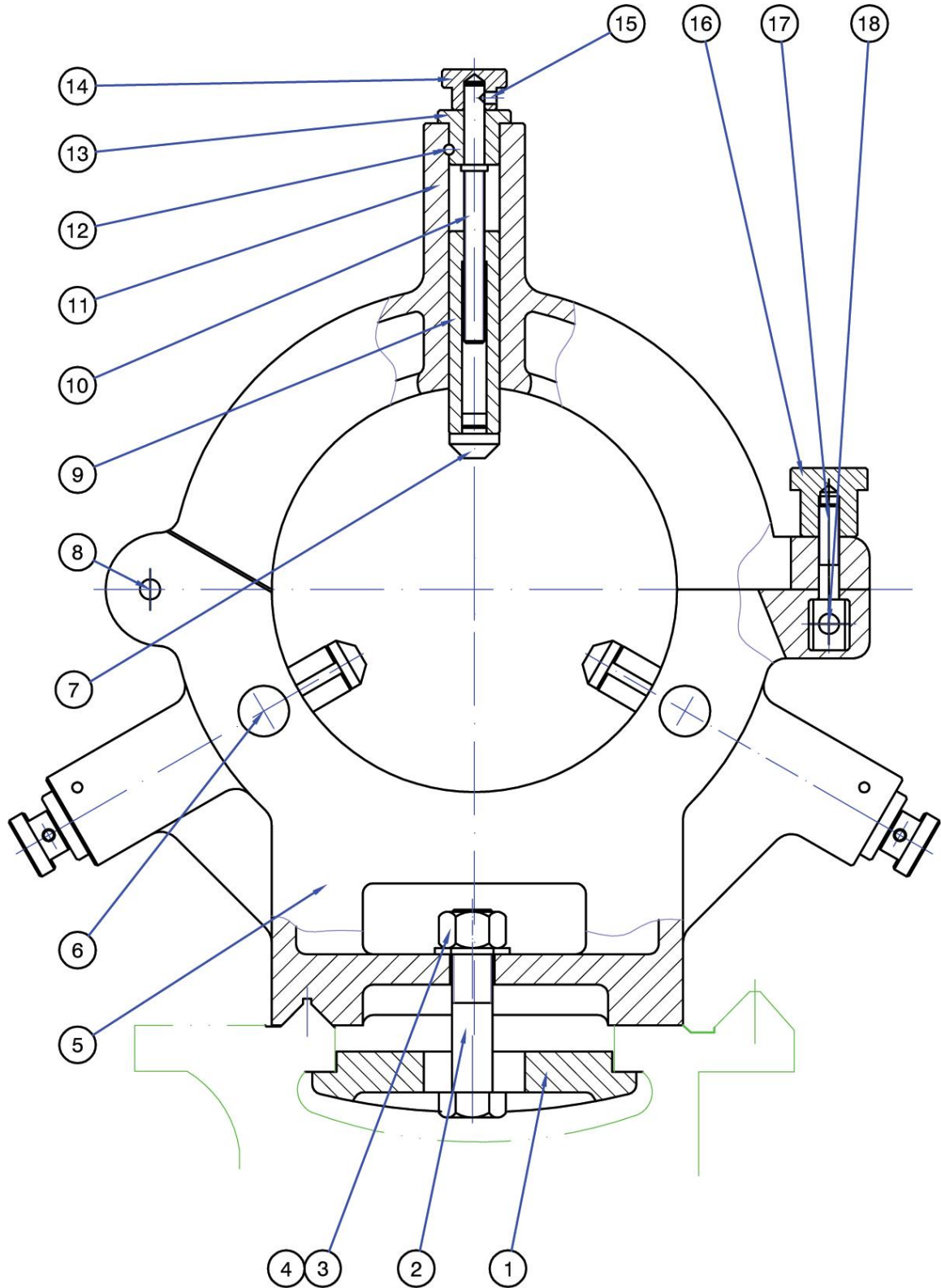
# TAILSTOCK



No.	Part No.	Name	Specification	Qty	Remarks
1	CT6253-6003	Spindle tang Slot	45	1	
2	CT6253-6001	Tailstock Body	HT200	1	
3	GB9877.1-88	Beleton oil seal	60×75×9	1	
4	GB1155-89	Oil cup	10	2	
5	CT6253-6004	Screw-Spindle	45	1	
6	CT6253-6005	Nut	ZQSn6-6-3	1	
7	GB70.1-2000	Screw	M6×18	3	
8	GB301-84	Thrust Bearing	8105	2	
9	GB70.1-2000	Screw	M6×30	3	
10	CT6253-6006	Cap-Body End	HT200	1	
11	CT6253-6007	Dial-Feed	45	1	
12	GB1096-79	Key	6×25	1	
13	GB4141.6	Handle	M10×60	1	
14	GB80-85	Screw	M6×25	1	
15	CT6253-6009	Screw	45	1	
16	CT6253-6008	Handle wheel	HT200	1	
17	GB551-88	Nut	M20	1	
18	GB97.1-85	Washer	20	1	
19	CT6253-6024	Case-Wiper	A3	2	δ=1
20	CT6253-6023	Wiper	polyurethane	2	
21	GB818-85	Screw	M4×12	8	
22	GB77-85	Screw	M6×14	1	
23	CT6253-6010	Key	45	1	
24	GB5780-86		M20×60	2	
25	CT6253-6002	Bottom Tailstock	HT200	1	
26	GB97.1-85	wiper	12	2	
27	CT6253-6016	Bracket	HT200	1	
28	CT6253-6015	Block	45	1	
29	CT6253-6018	Block-adjustting	HT200	1	
30	CT6253-6021	Screw	45	2	
31	CT6253-6020	Gib	45	1	
32	CT6253-6011	Shaft Lock Sleeve	H62	1	
33	CT6253-6012	Lock Bolt	45	1	
34	JB7271.3	Handle Sleeve	M10×40	1	
35	CT6253-6013	Lever	45	1	
36	JB7271.3	Handle sleeve	M12×40	1	
37	CT6253-6017	Lever	45	1	
38	CT 6253-6014	Shaft	45	1	
39	CT6253-6022	Screw	45	2	
40	GB80-85	Screw	M12×16	2	

No.	Part No.	Name	Specification	Qty	Remarks
41	GB119-86	Pin	10×70	2	
42	CT6253-6019	Clamp	HT200	2	
43	GB96-85	Washer	20	2	
44	GB5780-86	Shaft	M20×150	1	
45	GB5782-2002	Shaft	M20×90	1	
46	GB879.2-86	Pin	6×40	1	
47	GB1155-89	Oil cup	6	1	
48	GB80-85	Screw	M5×20	1	
49	CT6253-6027	Plate	Ly12	1	δ=0.5
50	GB867	Screw	2×6	4	
51	CT6253-6028	Plate	Ly12	1	δ=0.5
52	CT6253-6025	wiper	polyurethane	2	
53	CT6253-6026	Case-Wiper	A3	2	δ=1
54	GB79-85	Screw	M10×12	1	
55	GB77-85	Screw	M10×8	1	

# STEADY ASSEMBLY

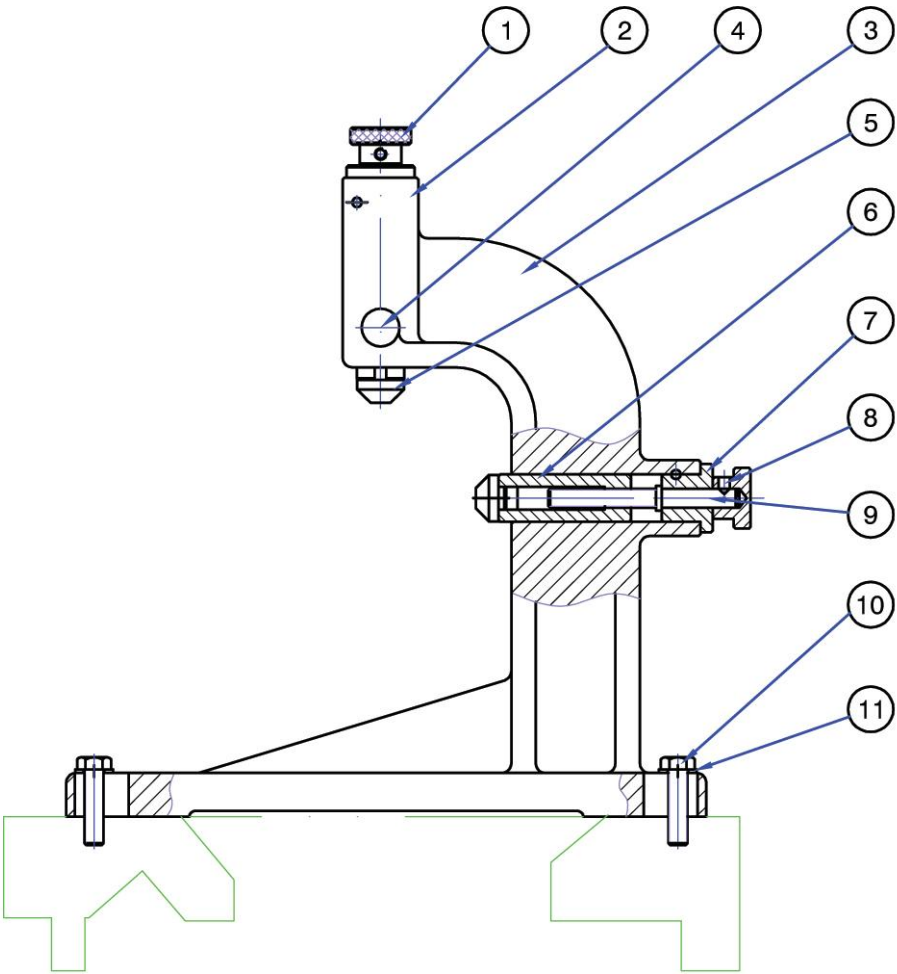


### CT6253 STEADY PARTS LIST

No.	Part No.	Name	Specification	Qty
1	CT6253-6019	Clamp	HT200	1
2	GB5780-86	Shaft	M20×95	1
3	GB6170-86	Nut	M20	1
4	GB97.1-85	Spacer	20	1
5	CT6253-8201	Downside of Steady rest	HT200	1
6	CT6253-8208	Limited Screw	45	3
7	CT6253-8207	Bracket	40-2Brass	3
8	GB119-86	Pin	10×40	1
9	CT6253-8206	Sleeve	45	3
10	CT6253-8205	Screw Shaft	45	3
11	CT6253-8202	Upside of Steady Rest	HT200	1
12	GB879-86	Pin	5×32	3
13	CT6253-8204	Bush	HT200	3
14	CT6253-8203	Rotate	45	3
15	GB78-85	Screw	M6×8	3
16	CT6253-8209	Screw	45	1
17	CT6253-8210	Screw	45	1
18	GB119-86	Pin	10×40	1



**FOLLOW REST ASSEMBLY**



### C6253 FOLLOW REST PARTS LIST

No.	Part No.	Name	Specification	Qty
1	CT6253-8203	Knurling sleeve	45	2
2	GB879-86	The elastic cylindrical pin	5×26	2
3	CT6253-8301	follow rest	HT200	1
4	CT6253-8208	Locating bolt	45	2
5	CT6253-8207	Copper pad	40-2	2
6	CT6253-8302	Cover	45	2
7	CT6253-8204	bush	HT200	2
8	GB78-85	Hexagon socket set screws with cone point	M6×8	2
9	CT6253-8303	Screw	45	2
10	GB5782-86	Six hexagon-head bolts	M10×40	2
11	GB97.1-85	Flat washer	10	2