



Rene Swiss Corporation

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Product Catalog

Tornos AS 14

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Tornos AS 14 - Collets

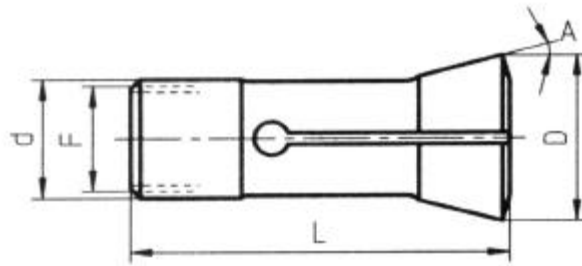


Fig. 1

Clamping

Maximum Capacity

Reference	Machine	Fig.	d	D	L	A	F	●	⬡	■
9001 E	AS 14	1	25	35	75	16°	M22x100	18	15	

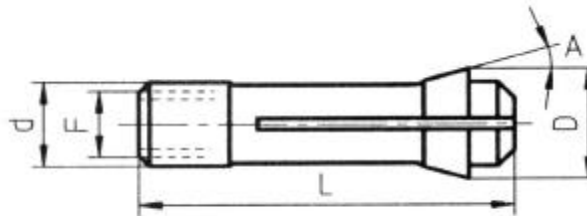


Fig. 1

Pick-up

Maximum Capacity

Reference	Machine	Fig.	d	D	L	A	F	●	⬡	■
9001 PU	AS 14	1	16	21	66	16°	M14x75	16		

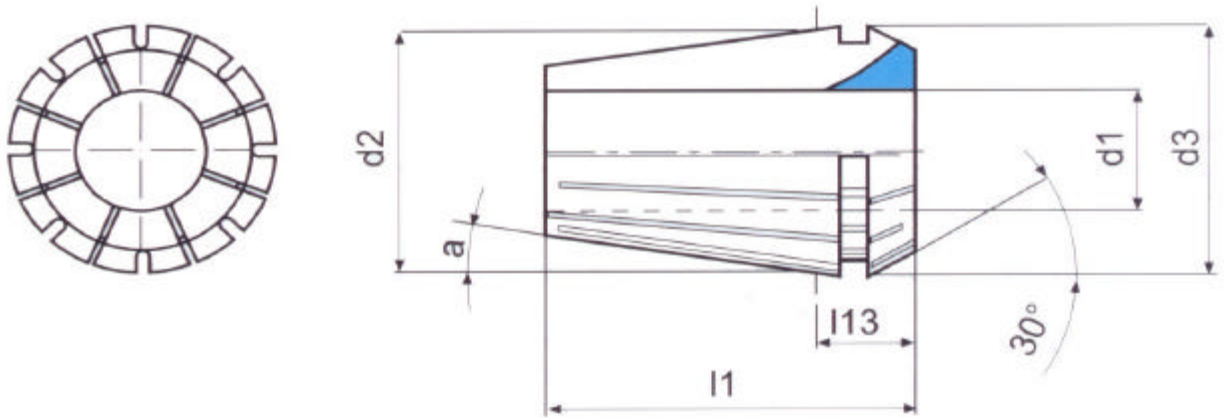


shown with extractor



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Tornos AS 14 - Collets



Type	d1 mm min - max	Gripping Range	d2	d3	a	l1	l13 max
ERC8	1 ÷ 5	0.5 mm	8	8.5	8°	13.5	4.5
ERC11	1 ÷ 7	0.5 mm	11	11.5	8°	18	6.6
ERC12	1 ÷ 7	0.5 mm ÷ 1 mm	12	12	8°	19.5	9
ERC16	1 ÷ 10	0.5 mm ÷ 1 mm	16	17	8°	27.5	10.5
ERC20	1 ÷ 13	0.5 mm ÷ 1 mm	20	21	8°	31.5	11.5
ERC25	1 ÷ 16	0.5 mm ÷ 1 mm	25	26	8°	34	12
ERC32	2 ÷ 20	0.5 mm ÷ 1 mm	32	33	8°	40	13

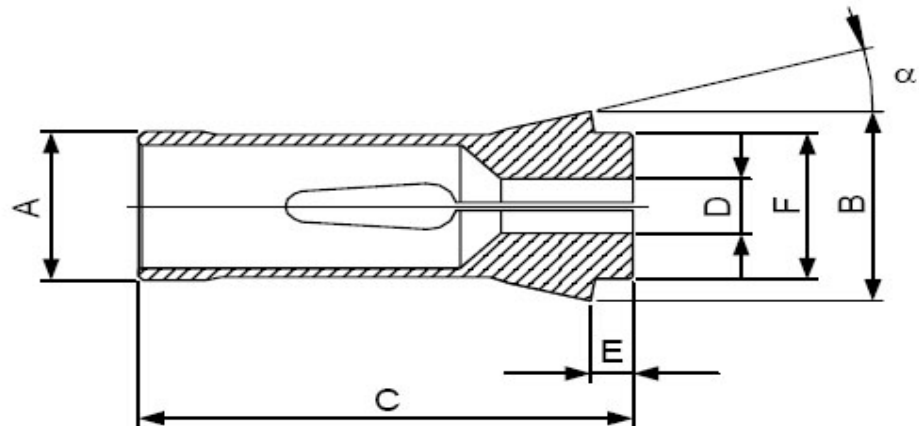
Type	d1 mm min - max	Gripping Range	d2	d3	a	l1	l13 max
ESX8	1 ÷ 5	0.5 mm	8	8.5	8°	13.5	4.5
ESX11	1 ÷ 7	0.5 mm	11	11.5	8°	18	6.6
ESX12	1 ÷ 7	0.5 mm ÷ 1 mm	12	12	8°	19.5	9
ESX16	1 ÷ 10	0.5 mm ÷ 1 mm	16	17	8°	27.5	10.5
ESX20	1 ÷ 13	0.5 mm ÷ 1 mm	20	21	8°	31.5	11.5
ESX25	1 ÷ 16	0.5 mm ÷ 1 mm	25	26	8°	34	12
ESX32	2 ÷ 20	0.5 mm ÷ 1 mm	32	33	8°	40	13



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Tornos AS 14 - Collets

Fig. 1

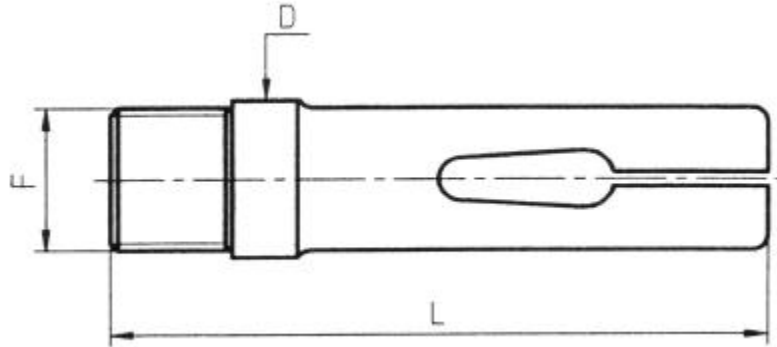


Type	A	B	C	E	F	a	D min - max
F8	8	12	42	4.5	8	16°	0.3 - 6.35
F8	8	11	19	2	8	15°	0.3 - 6.50



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Tornos AS 14 - Feed Finger



Maximum Capacity

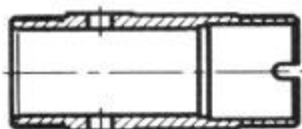
Reference	Machine	D	L	F	●	⬡	■
9251 E	AS 14	17.9	70	M16x75	14	12	
9251 ER	AS 14	18.3	70	M17x75	15	13	



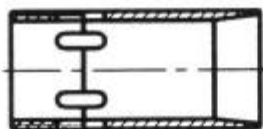
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Tornos AS 14 - Feed Finger

Avanstar Feed Fingers



Body No. 1



Adjusting Sleeve No. 2



Guide No. 4



Feed Pads No. 3

Spring No. 5



Spring No. 6

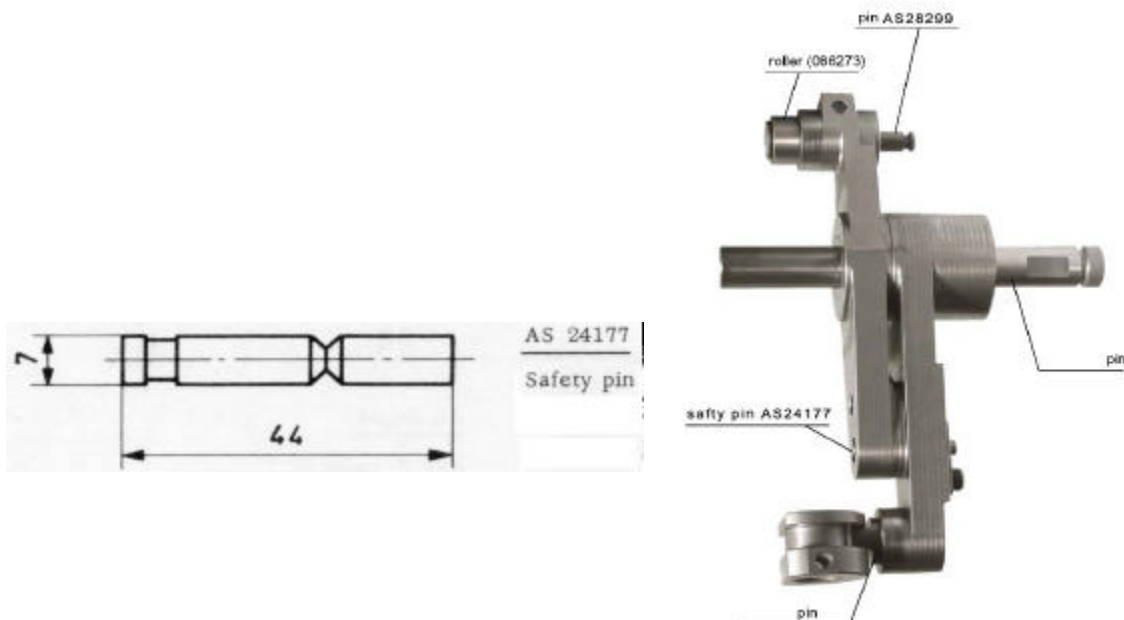
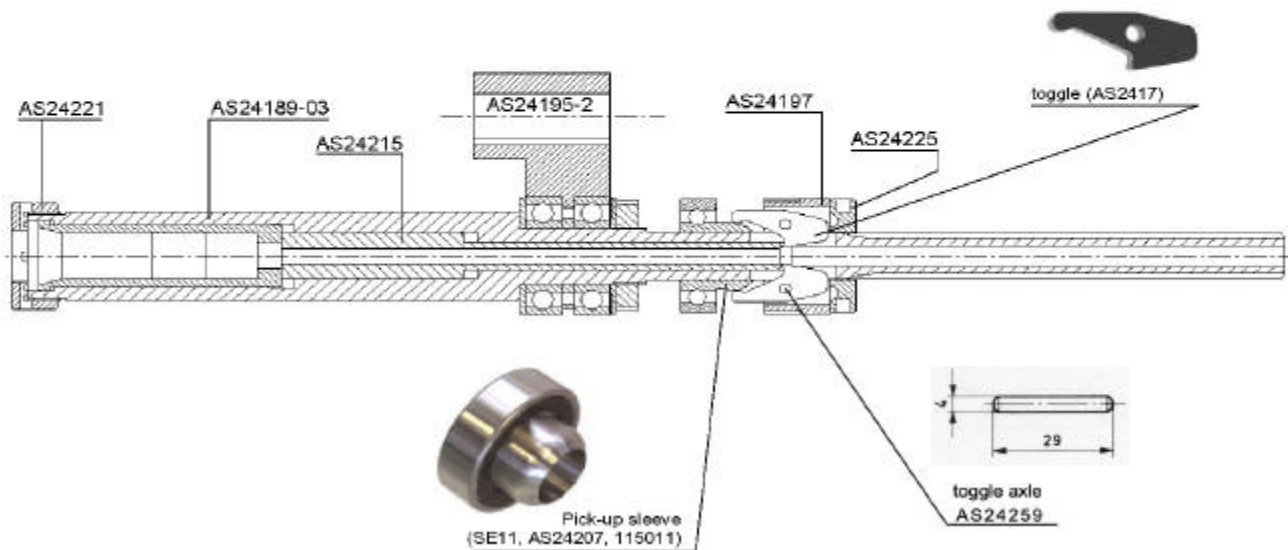


Reference	Machine	Location	●	⬠	■
9251STNG...	AS14	Complete Assembly	10	8	7
9251STNGC...		Body No. 1			
9251STNGB...		Adjusting Sleeve No. 2			
9251STNGD...		Feed Pad No. 3			
9251STNGO...		Guide No. 4			
9251STNGR5...		Leaf Spring No. 5			
9251STNGR6...		Leaf Spring No. 6			



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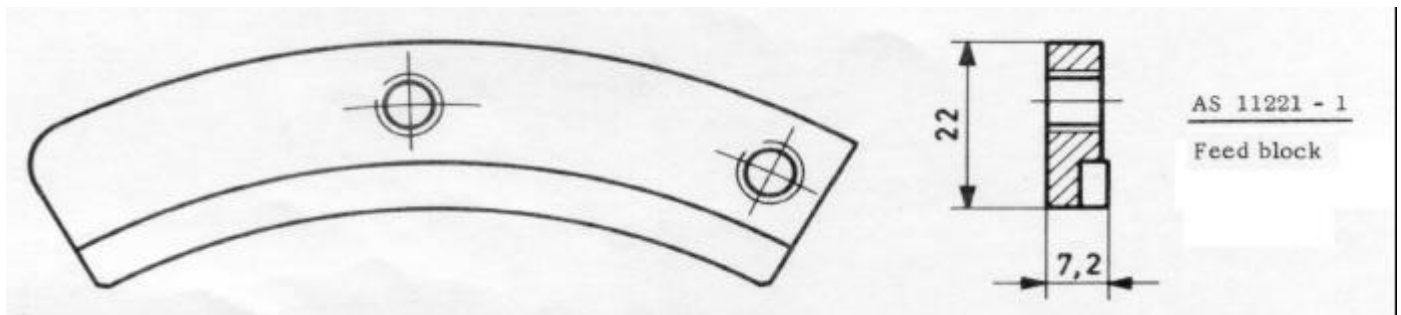
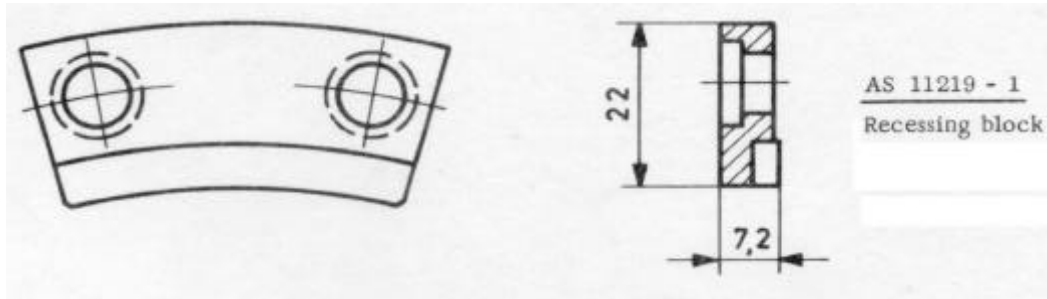
Tornos AS 14 - Pick off Attachment





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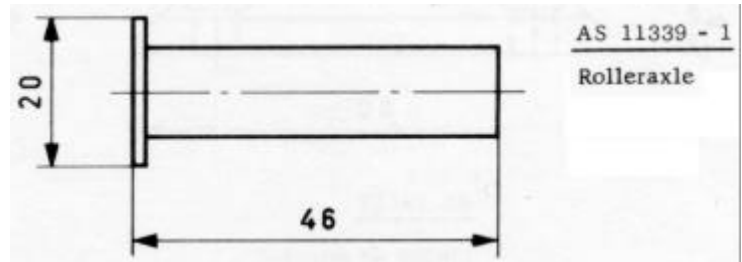
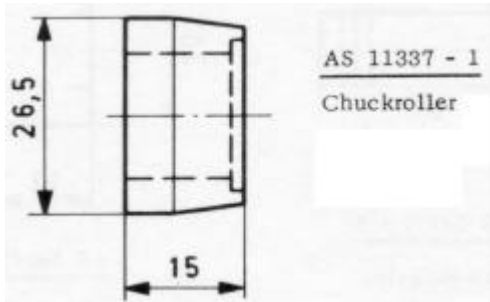
Tornos AS 14 - Feed



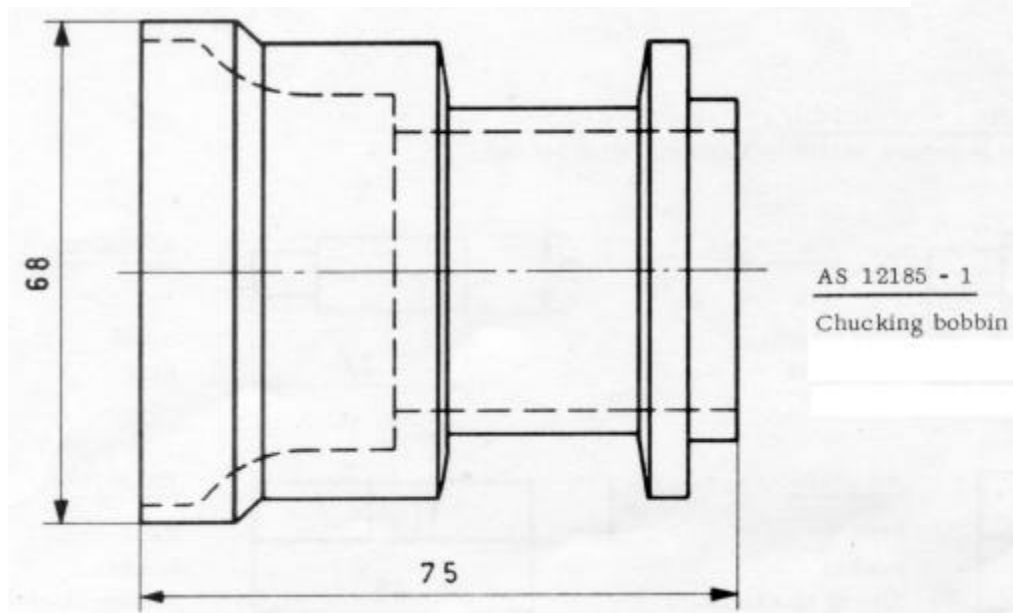
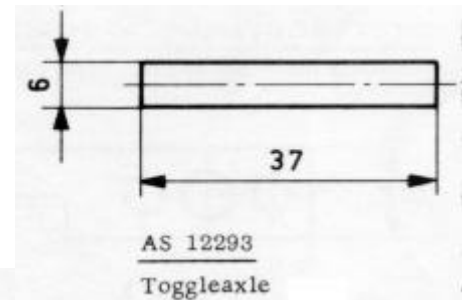
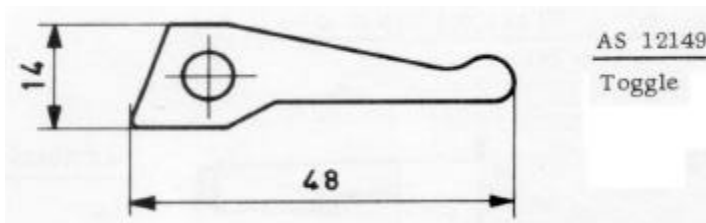


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Tornos AS 14 - Chucking



INA Cage Bearing - 778.304

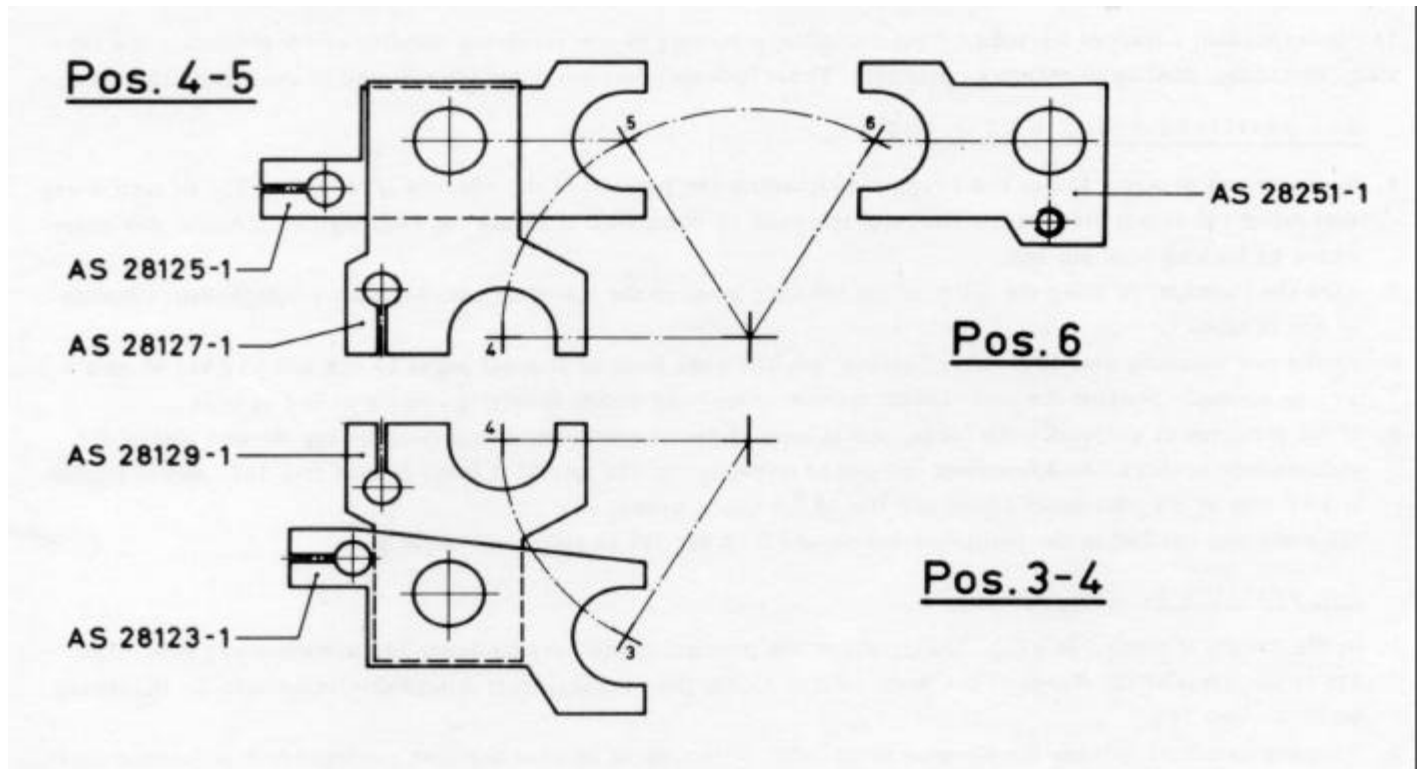




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Tornos AS 14 - Forks

Forks for revolving spindles

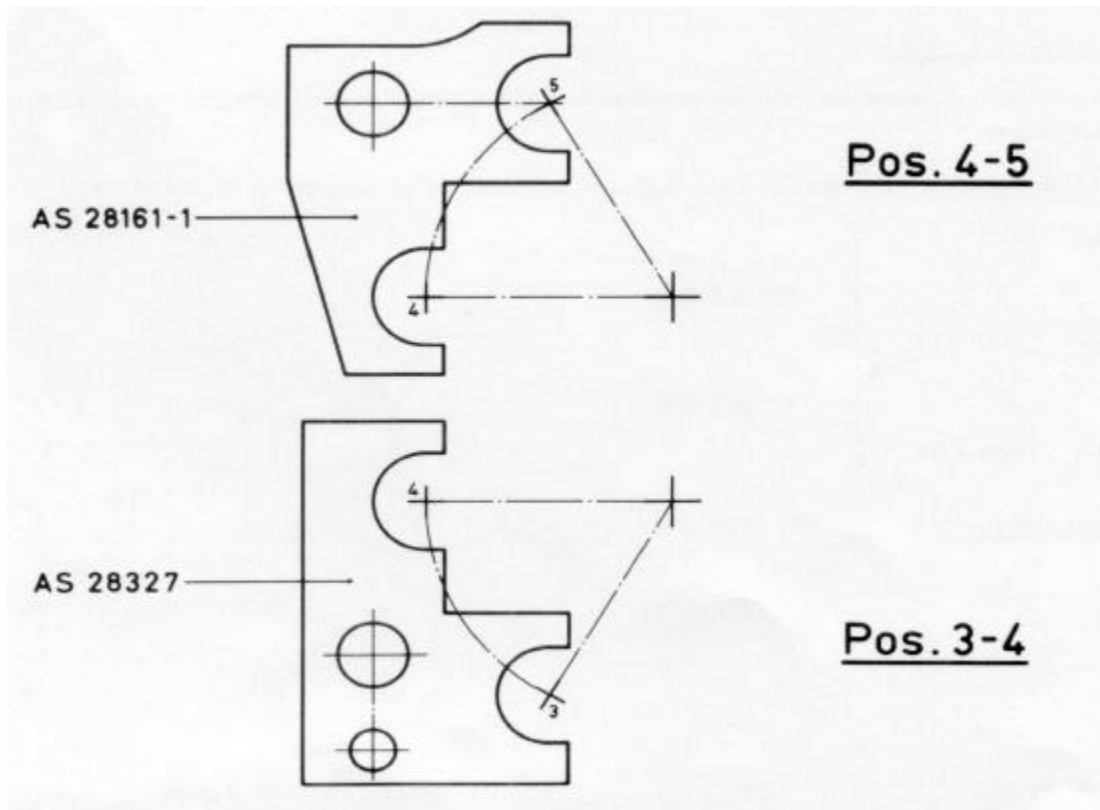




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Tornos AS 14 - Forks

Double forks for revolving spindle

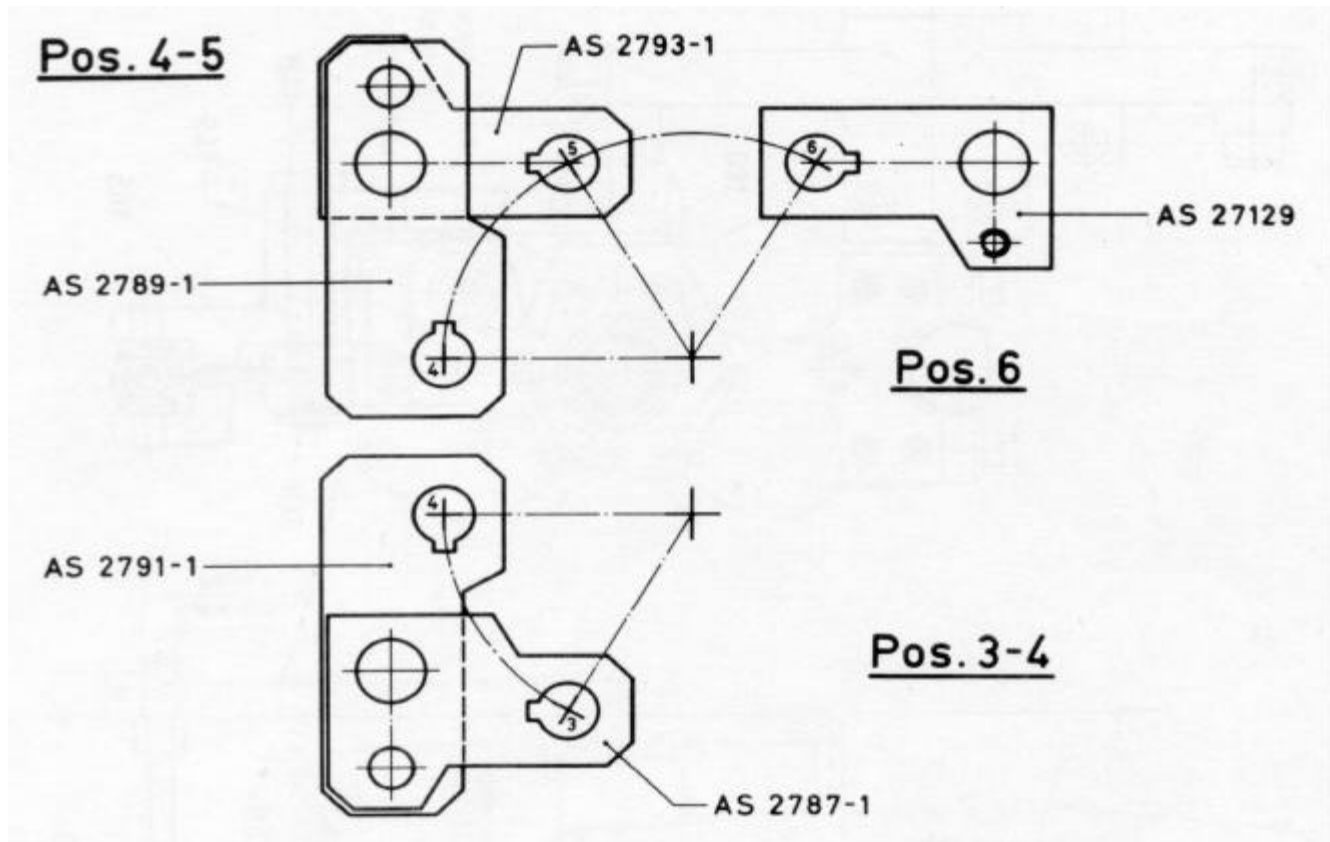




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Tornos AS 14 - Forks

Forks for stationary spindles

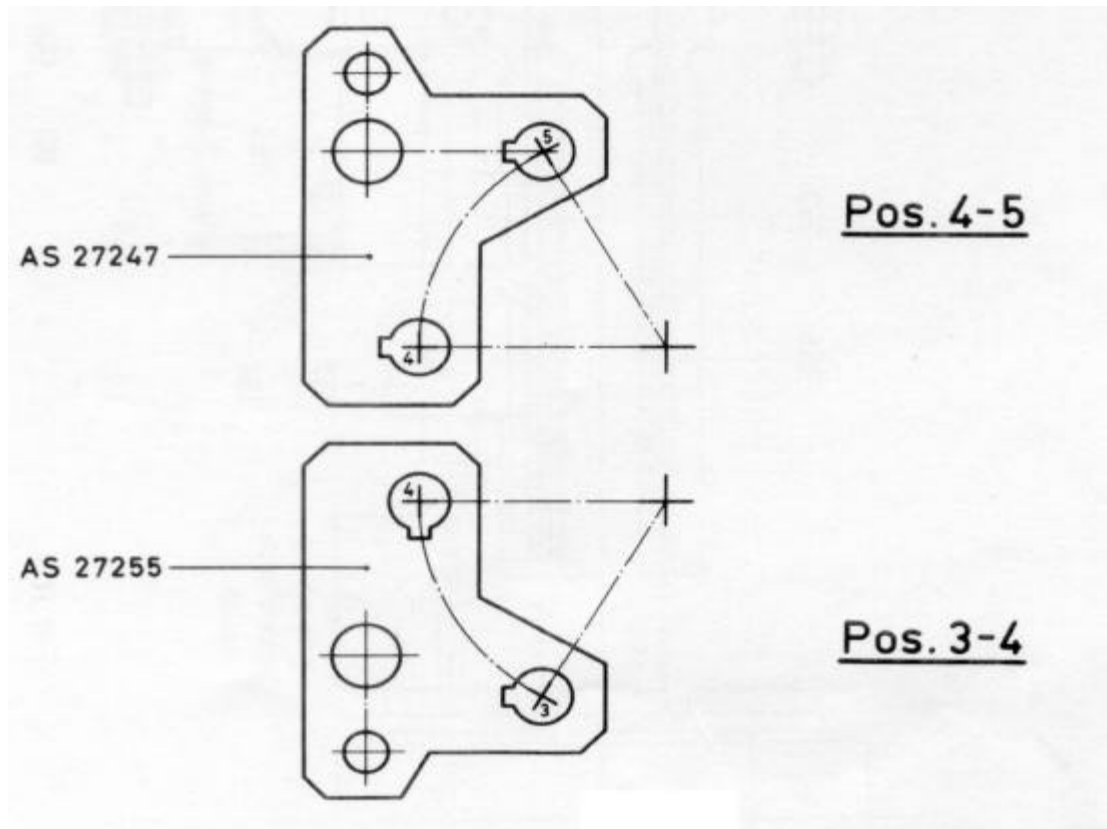




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Tornos AS 14 - Forks

Double forks for stationary spindles





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Tornos AS 14 - CAMS

Central slide cams

AS 1355-0	AS 1355-8	AS 1355-19
AS 1355-3	AS 1355-10	AS 1355-24
AS 1355-4.5	AS 1355-12	AS 1355-30
AS 1355-6	AS 1355-15	AS 1355-35

Cross slide cams

Normal cams

AS 14235-0	AS 14235-4
AS 14235-1	AS 14235-5
AS 14235-2	AS 14235-6
AS 14235-3	AS 14235-7.5

Part-off cams

AS 14235-1c	AS 14235-3c
AS 14235-1.5c	AS 14235-4c
AS 14235-2c	AS 14235-5c
AS 14235-2.5c	AS 14235-6c

Knurling cams

AS 14235-1.5M

Shaving cams

AS 14235-0.6R	AS 14235-3R
AS 14235-1R	AS 14235-6R
AS 14235-2R	AS 14235-12R

Independent feed cams

Standard
With pull out

Special cams made per request



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Tornos AS 14 - CAMS

Pick-off attachment cams

Standard cams (work with acceleration)

These cams can be used for a production of up to 30 parts per min.
Their working throw varies between 1 - 3mm on 50 degrees.

AS 24271-1

AS 24271-2

AS 24271-3

Maximum length of part = 40mm

For a working throw of more than 3mm, it is necessary to use special cams

Special cams (work without acceleration)

All these cams are individually studied. It is however possible, depending on the case, to obtain back drillings up to a depth of 20mm

For cam design, the following indications can be taken into consideration

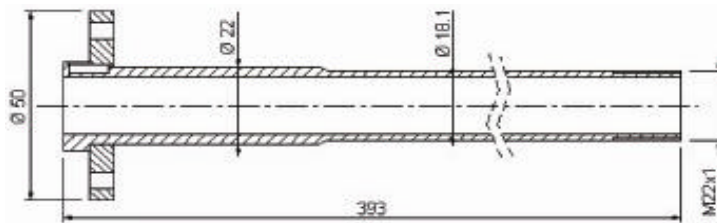
<u>Max production</u>	<u>Working degrees</u>	<u>Length part</u>
20 p/min	150°	40mm
30 p/min	150°	30mm
40 p/min	100°	20mm



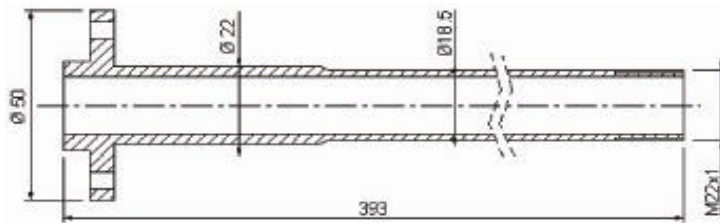
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Tornos AS 14 - Tubes

Collet tubes



AS 12/10-1
Collet tube



AS 12/10-2
Collet tube

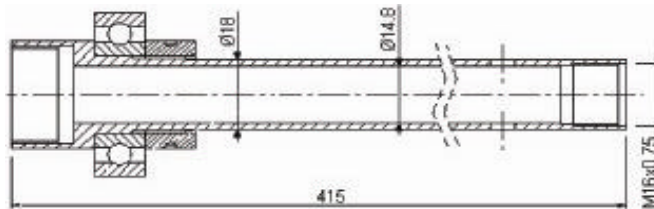
If you are looking for a specific tube that is not listed please contact us



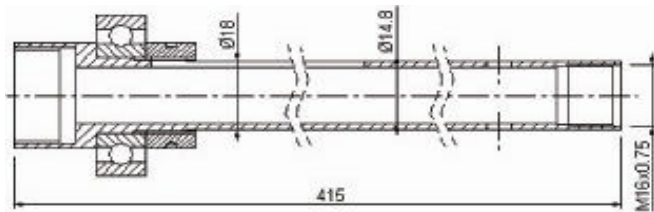
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Tornos AS 14 - Tubes

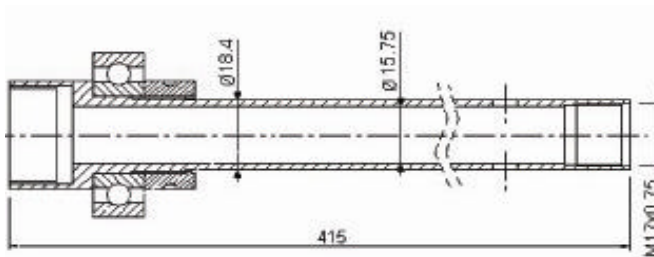
Feed tubes



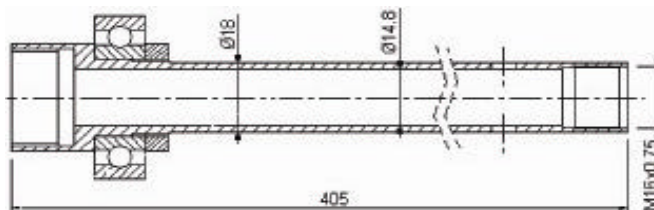
AS 12/10-3
Feed tube



AS 12/10-4
Orientable feed tube



AS 12/10-5
Feed tube



AS 12/10-6
Feed tube
For 85mm stroke

If you are looking for a specific tube that is not listed please contact us



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Tornos AS 14 - Gears

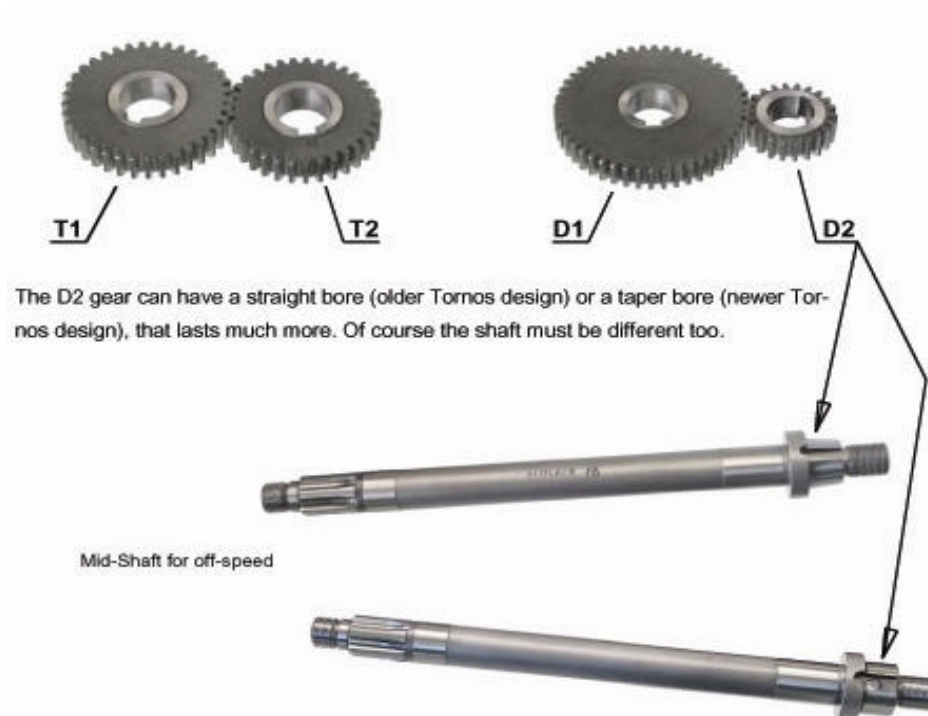
TORNOS MOUTIER SUISSE		Tableau des vitesses - Geschwindigkeits - Tabelle Speed - Chart																AS 14 Moteur Motor 1445 T/min U/min RPM			
 D2 D1 T2 T1	Accélération T/min Schnellgang U/min High Speed R.P.M.																	 P./min avec 180° accélération à T/min S./Min. mit 180° Schnellgang bei U/Min. P.P.M. with 180° High Speed by R.P.M.			
	Moteur Motor																				
Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread		Tours de broche par filet Spindelumdrehg. pro Gewinde Spindle Revs. per Thread			
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315		318		321		324		327		330		333		336							



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Tornos AS 14 - Gears

In speed					Off speed				
ratio	right		left		ratio	right		left	
	T1	T2	T1	T2		D1	D2	D1	D2
2	30	40	48	22	2	48	22	30	40
4	37	33	46	24	4	46	24	37	33
6	39	31	45	25					
9	40	30	44	26					

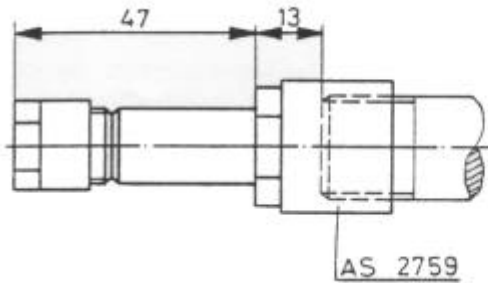


Threading off ration	gears			Threading ration	gears		
		Z	Ref. No.			Z	Ref. No.
2	D1	48	AS 26219	6	T1	39	AS 26325
	D2	22	AS 26221		T2	31	AS 26327
	D1	30	AS 26383		T1	45	AS 26413
	D2	40	AS 26381		T2	25	AS 26415
4	T1-D1	37	AS 26329	9	T1	40	AS 26215
	T2-D2	33	AS 26331		T2	30	AS 26217
	T1-D1	46	AS 26379		T1	44	AS 26333
	T2-D2	24	AS 26377		T2	26	AS 26335



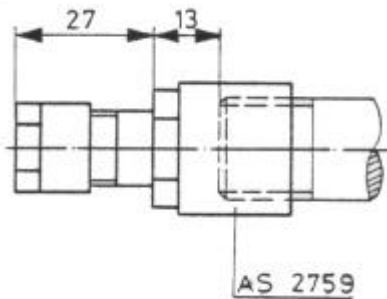
Rene Swiss Corporation

Tornos AS 14 - Spindle Extension



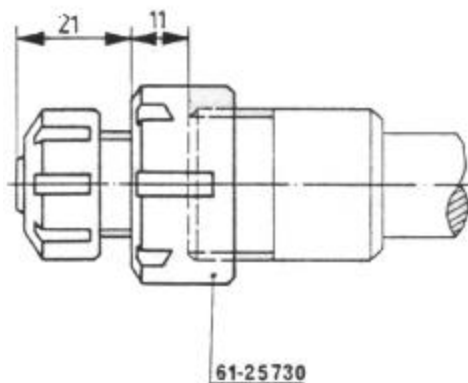
AS 31 / 4

E16 - F8 Extension



AS 31 / 26

E16 - F8 Extension



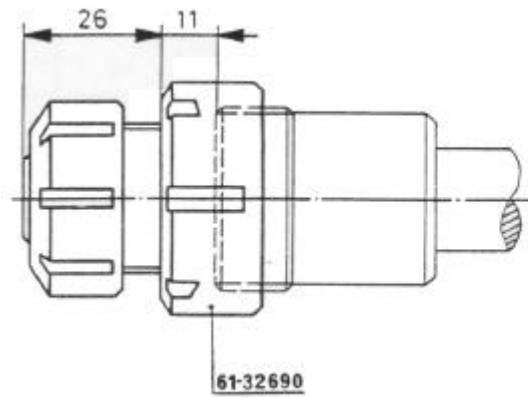
BS 31 / 1

E25 - E16 Reduction



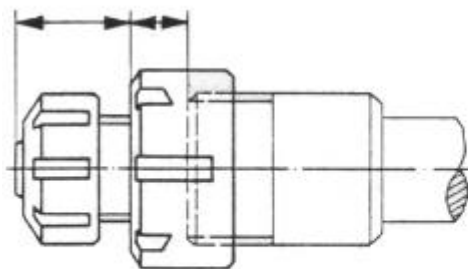
Rene Swiss Corporation

Tornos AS 14 - Spindle Extension



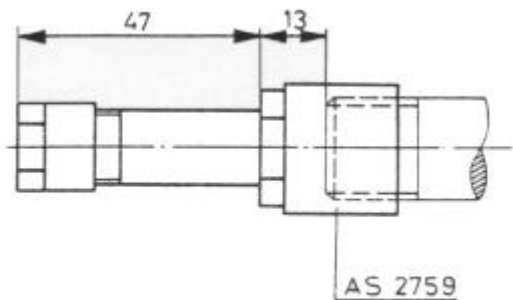
BS 31 / 2

E32 - E25 Reduction



BS 31 / 3

E25 - E20 Reduction

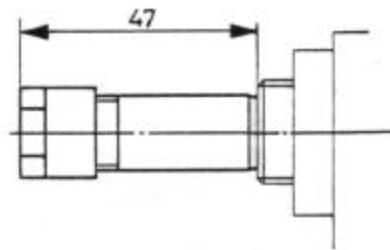


AS 31 / 5



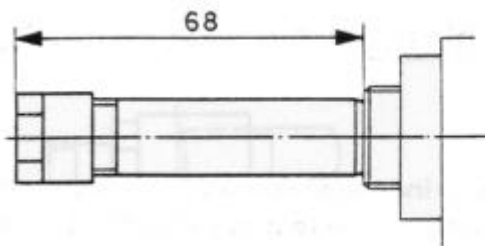
Rene Swiss Corporation

Tornos AS 14 - Spindle Extension



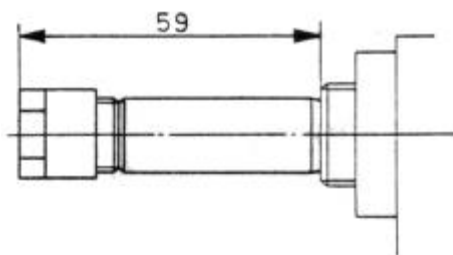
AS 31 / 1

W12 - F8 Extension



AS 31 / 2

W12 - F8 Extension



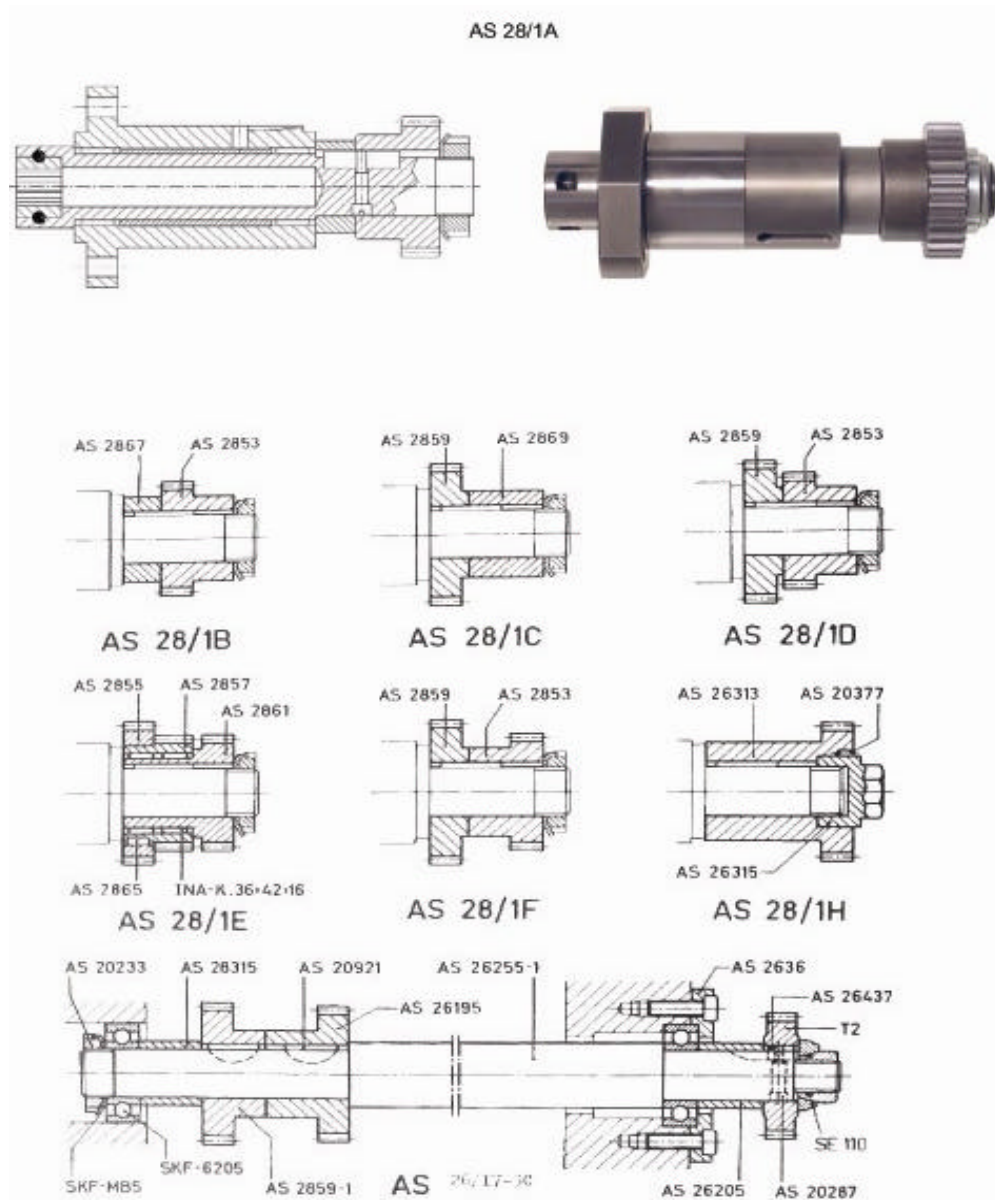
AS 31 / 3

W12 - F8 Floating extension



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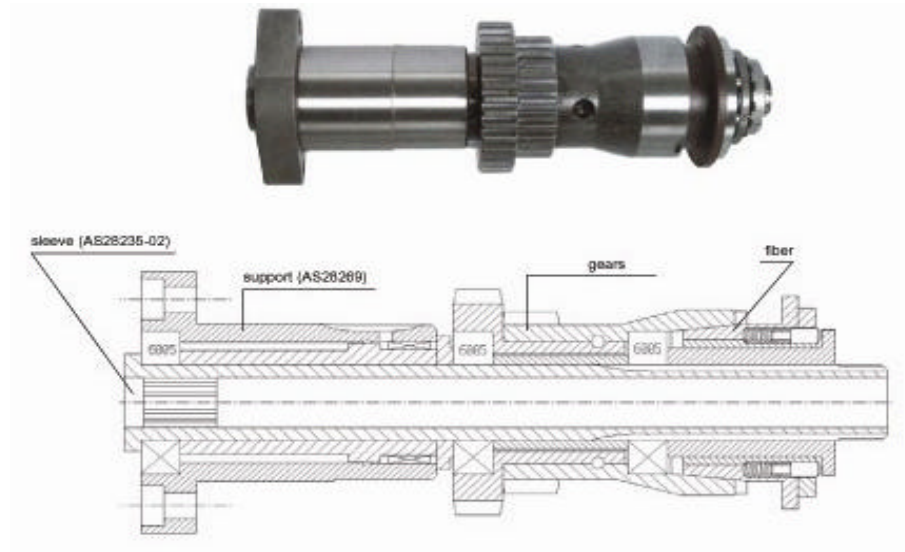
Tornos AS 14 - Equipment





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Tornos AS 14 - Equipment



AS 28/26

Driving quill with stopping device

This driving unit is designed to stop the rotation of the pick-up spindle just before the expulsion of the component, in order to avoid any damage to the same component. Otherwise it could hit a part of the machine at a very high speed. This is possible thanks to a mechanical fiber clutch that disconnects the driving and allows the brake to stop the spindle.



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Tornos AS 14 - Equipment



Independent non-rotating spindle

AS 27/8 For use with ESX/ERC 16 collet

AS 27/8 For use with ESX/ERC 25 collet Pos. 3-4-5-6

AS 27/8 For use with ESX/ERC 32 collet

AS 27/36 For use with ER 16 collet

Pos. 1-2

Independent rotating spindle

AS27/1 ESX16 pos.3-4-5-6



Fixed drill holder

AS 27/3 For use with W12 collet

AS 27/26 For use with ESX/ERC 16 collet

AS 27/3-1 For use with ESX/ERC 25 collet

Pos. 1-2-3-4-5-6



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Tornos AS 14 - Spare Part Break Down

Slides

Part Number	QTY	Description
AS 1311	3	Axle
AS 1365	5	Roller
AS 11201	1	Axle
AS 11315	1	Axle

Feed + Chucking

Part Number	QTY	Description
AS 11219-1	3	Axle
AS 11221-1	5	Roller
AS 11337-1	1	Axle
AS 11339-1	1	Axle
778.304	2	Needles cage INA K12 x 17 x 13

Indexing

Part Number	QTY	Description
AS 11363	1	Axle
AS 11365	1	Roller

Slides

Part Number	QTY	Description
AS 14171-2	6	Axle
AS 14211	2	Cap
AS 14213	2	Knee cap
AS 14217	4	Return plate
AS 14269	6	Roller
	2	Spring

Barrel

Part Number	QTY	Description
AS 12149	18	6 sets of Toggles
AS 12185-1	6	Chucking bobbin
AS 12293	18	Toggle axle
AS 12289	234	Needles
7007CVDUJ84	12	Front bearing
7206CG1DUJ84	12	Rear bearing



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Tornos AS 14 - Spare Part Break Down

Disengaging Device

Part Number	QTY	Description
AS 20851	1	Beak
AS 20859	1	Beak

Clutch

Part Number	QTY	Description
AS 20215	2	Sliding block
AS 20603-1	2	Axle
AS 20605	2	Axle
AS 201233	2	Sliding block
	6	Toggles for coupling

Clutch

Part Number	QTY	Description
AS 20603-2	2	Axle
AS 20605-1	2	Axle
AS 201163-1	2	Sliding block
AS 201233	2	Sliding block

Pick-off attachment AS 24/3

Part Number	QTY	Description
AS 1365	1	Roller
AS 2417	2	Toggle
AS 24177	2	Safety pin
AS 24207	1	Gripping bobbin
AS 24257	1	Roller
AS 24259	2	Toggle axle
AS 28299	1	Roller axle
	2	Bearings INA NK 8/12
	2	SNR Bearing 6004EEDBJ75

Independate feed AS 28/2 - 28/3 - 28/7

Part Number	QTY	Description
AS 1365	1	Roller
AS 2881	1	Roller axle
AS 28299	1	Roller axle

Stock stop AS 28/4

Part Number	QTY	Description
AS 1311	1	Roller axle
AS 1365	1	Roller

Quill with stopping device AS 28/13

Part Number	QTY	Description
AS 14269	1	Roller
AS 28245	1	Roller axle

Swing stop AS 29/2

Part Number	QTY	Description
AS 14171-2	1	Roller axle
AS 14269	2	Roller
AS 29173	1	Roller axle



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