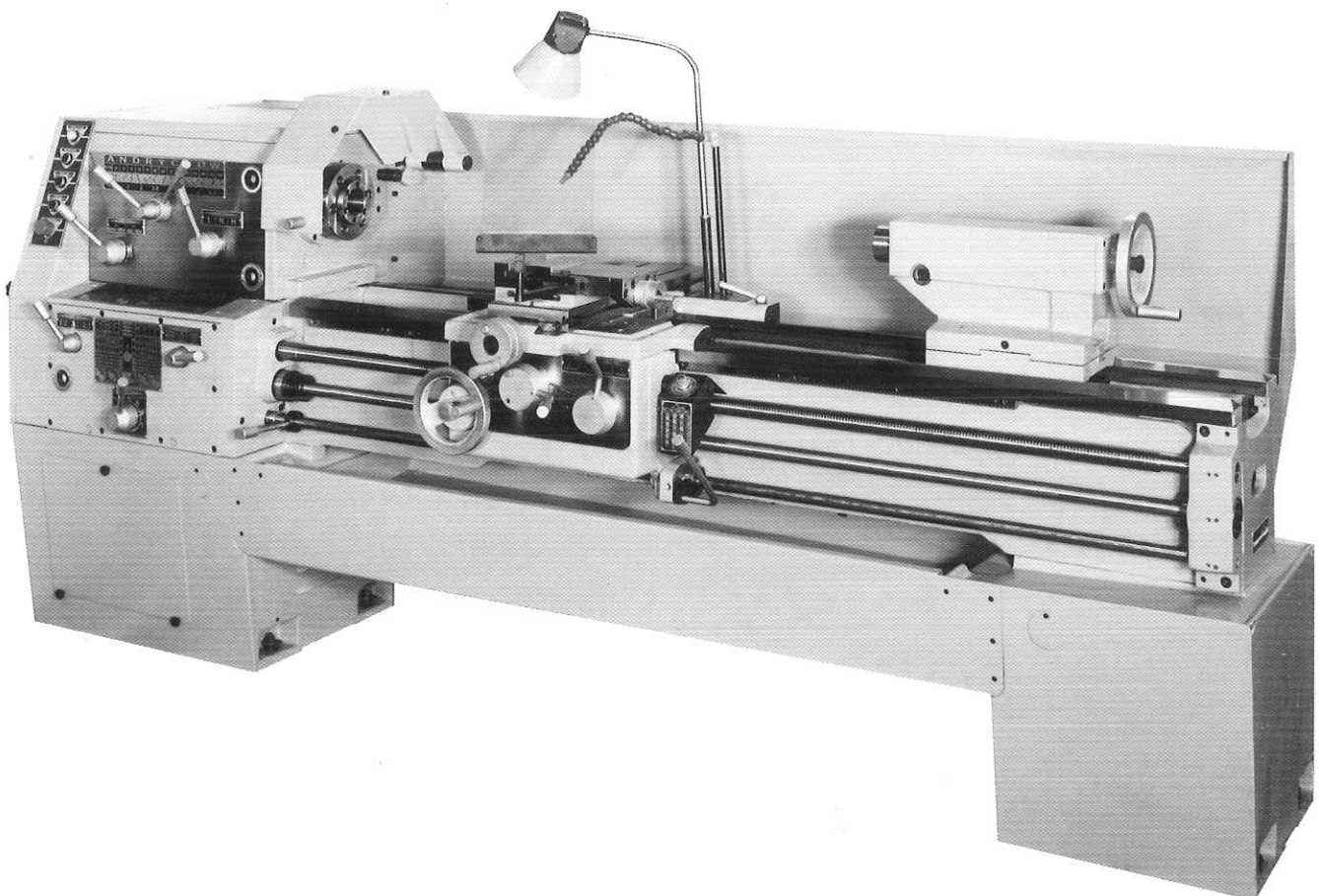


**TOOLMEX**

**ANDRYCHOW  
TUG-40  
17"/25" Geared  
Head Gap  
Bed Lathe**

- Fully clutched headstock.
- European precision and craftsmanship.
- Extra wide front V-way.
- Induction hardened and ground bedways.
- Extended cross slide with dual T-slots.
- Heavy duty construction tailstock quill 3" dia.
- Inch-metric threading w/o end gear change.
- Wider feed and thread ranges
- Removable gap permitting swing up to 25-3/4".
- 24-3/4" headstock bearing on bedways.
- Etched graphics for longer service life.



EUROPEAN BUILT - VERSATILITY - AFFORDABLE

**Sterling**  
MACHINERY EXCHANGE

[www.SterlingMachinery.com](http://www.SterlingMachinery.com)



17"/25" X 60" BC WITH FULL REAR SPLASHGUARD  
- STANDARD EQUIPMENT ON 40" AND 60" BC.

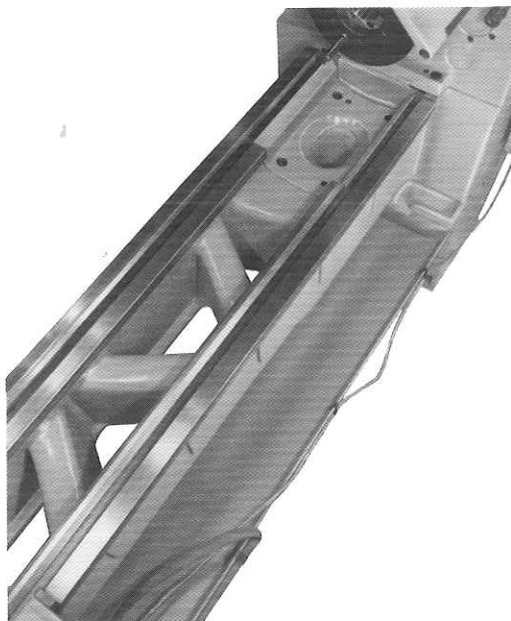
**TOOLMEX ANDRYCHOW**

The Andrychow TUG-40 lathe has been specifically designed for industrial applications as possible. The TUG can be found in maintenance shops because of its versatility and low investment cost. To date, Andrychow has built and sold over 40's. Combined with TUG-40 world renowned reputation by many to be the most profitable 17" geared head lathe.

**Bed**

**Extra Wide 25° Front V-Way**

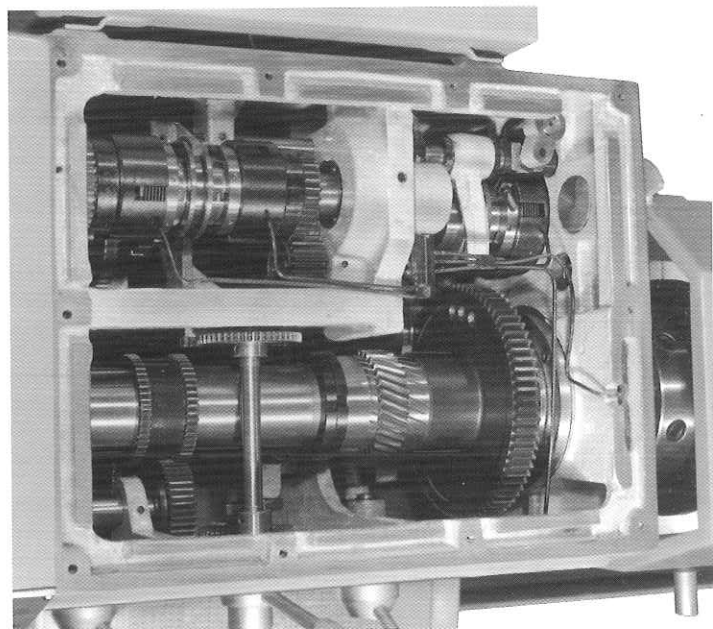
The bed is deep and extra-wide, well ribbed to prevent deflection under heavy cutting loads. Separate pairs of Induction Hardened and Ground V and flat guideways are provided for the carriage and tailstock. The removable gap provides 25-3/4" swing with 10-1/2" length from the face of the spindle to the end of the gap. The 7.5 H.P. main motor, with 5-belt sheave is housed in the left leg of the lathe with the coolant pump and reservoir in the right leg. Our unique design allows you to clean slideout chip pan from rear of machine or easy access to front by removing cover panel. Full rear splash guard on 40" and 60" bc with travel guard on 80" bc.



**Headstock**

**18-1600 RPM (Fully Clutched)**

The unit design of the massive headstock provides maximum power for roughing and smoothness for finishing. Hardened and ground alloy steel gears transmit required power from the 7.5 H.P. main drive. Fully clutched headstock allows super sensitive control of spindle, especially important during threading. Additionally, clutches extend motor life, act as a "shock absorber" and eliminate motor overheating due to constant start/stop of spindle (main motor runs continuously).



The spindle is made of alloy steel and is hardened and ground. The spindle is the quick change camlock D1-6" with a 2-1/16" bore, and supported in front by precision double roller bearings and two thrust bearings, and at the rear with ball bearings. Spindle can be easily shifted into neutral, free spindle positioning for fast, effortless indicating. Control panel is built into the headstock. Raised (etched) graphics allow operator to easily read speeds and feed charts even many years later.

**Tailstock**

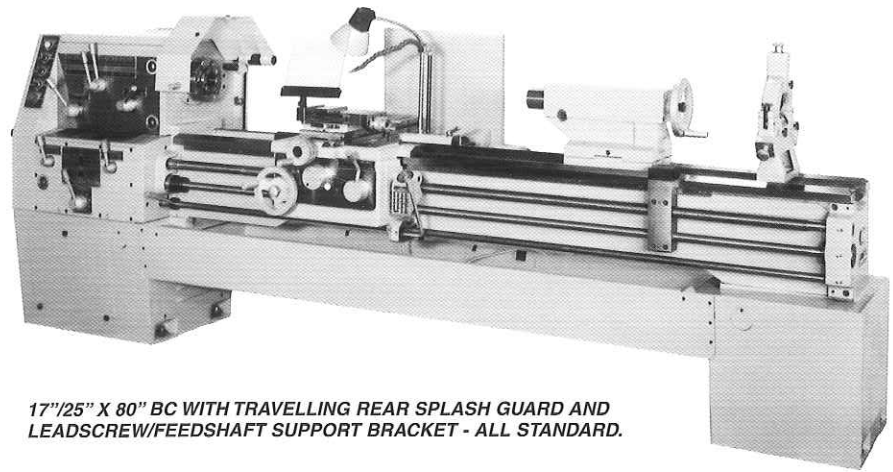
**Heavy Duty—3" Diameter Quill (Tanged)**

The tailstock is the setover type, provided with quick acting levers allowing locking of the quill and/or tailstock. Double clamping of body to bed with wrench for maximum rigidity. A standard 1/2" spindle hole with tang slot, allows the use of drills and reamers without slippage.

Wider selection of 14 spindle speeds, range: 18-1600 RPM, is quick and easy due to centrally located speed selection levers. Separate multiple-disc clutches—forward and reverse with another clutch-brake, provide fast starts and smooth stops. Costly—but necessary, our 1.4 speed multiplier ratio assures no open spindle speed gaps. Optional AC adjustable speed drive permits infinitely variable spindle speeds and even constant surface speed (also requires VSS drive).

# W TUG-40 LATHE

Designed to meet as wide a range of industrial production shops due to its big lathe features...and in small plants because of their low cost...delivered approximately 15,000 TUG/TUE units...for quality, our machine is considered the best around.



17 1/2" X 80" BC WITH TRAVELLING REAR SPLASH GUARD AND LEADSCREW/FEEDSHAFT SUPPORT BRACKET - ALL STANDARD.

## Carriage Simplified Operation

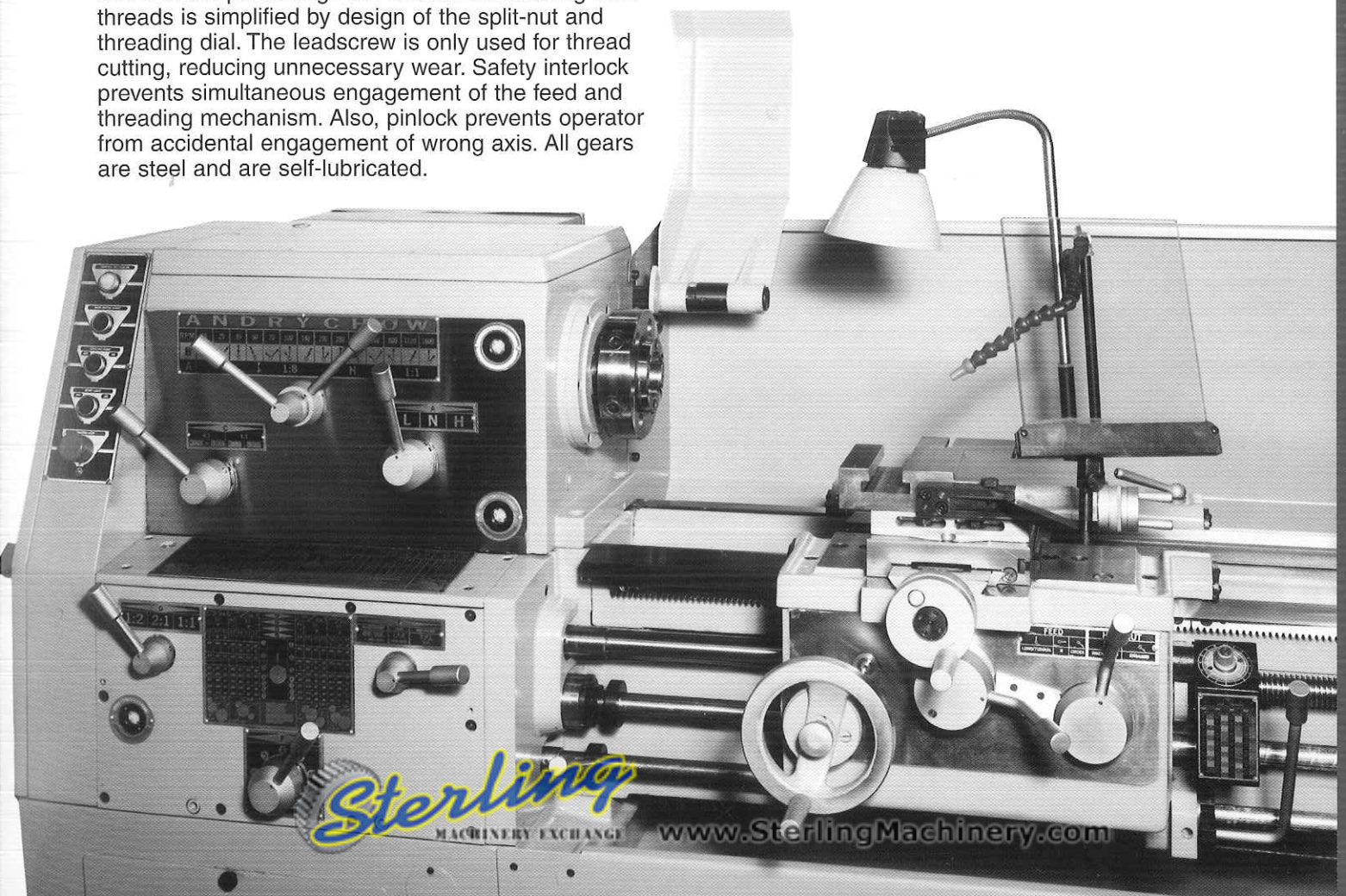
The carriage has been designed for increased stability. Almost 8" wide cross slide is equipped with dual T-slots (15" long) for fast-positive rear fixturing. Top slide and cross slide are provided with adjustable gibs, with their dials graduated in thousandths for accurate-easy sizing calculations. Longitudinal "free wheel" handwheel feature allows complete disengagement during thread or power feed minimizing errors or wear.

The apron is double-walled, with an oil reservoir and sight glass. Control lever for spindle Forward-Brake-Reverse is conveniently located on the right side—longitudinal manual wheel on the left side. Protection is provided by an overload clutch on the feed shaft and a shear pin through the leadscrew. Chasing inch threads is simplified by design of the split-nut and threading dial. The leadscrew is only used for thread cutting, reducing unnecessary wear. Safety interlock prevents simultaneous engagement of the feed and threading mechanism. Also, pinlock prevents operator from accidental engagement of wrong axis. All gears are steel and are self-lubricated.

## Feed Box

### End Gear Change Not Required

Our totally enclosed universal gearbox offers immediate selection of 42 feeds and a comprehensive range of Inch and Metric threads without changing quadrant gears. Easy to read graphics allow selecting over 150 kinds of threads on this machine, including Inch, Metric, Modular and Diametral pitch. All load carrying shafts run in anti-friction bearings. Conveniently located brake lever on right side of feedbox increases productivity.



**Sterling**  
MACHINERY EXCHANGE

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## EUROPEAN QUALITY BUILT FOR THE U.S.A.

- Lathes 14"-150" Swing
- Mills #2-#3
- HBM (CNC only)
- Grinders
- VBM
- Manual or CNC



**LARGE COMPUTERIZED PARTS CENTER,  
SCHAUMBURG, ILLINOIS.**

**STANDARD EQUIPMENT:** Complete 230 or 460V—3 phase—60 Hz electrics • 10" driving plate • Two dead centers MT 5 • Reduction sleeve 5/6 MT • T-slotted compound • Thread dial indicator— inch • Longitudinal feed stop dog • Cross feed stop dog • Pick-off gears • Complete coolant system • Work light • Service spanners and grease gun • Foundation bolts and leveling jacks • Operation manual with accuracy test certification • Detailed spare parts catalog • Full rear guarding on 40" and 60" bc.

**OPTIONAL EQUIPMENT:** Taper turning attachment [(graduated in degrees ( $\pm 10^\circ$ ) and inches (3-1/2" per foot)] • Four jaw independent chuck • 3 & 6 jaw self-centering scroll chucks • Follow rest (capacity 3/8"-5") • Steady rest (capacity 3/8"-5") plain or roller jaws • Live center (MT5) • T-slotted face plate 19-3/4" diameter • DRO • Collet Closures • AC Drive + CSS

## SPECIFICATIONS

### CAPACITY

Swing Over Bed .....	17-3/4"
Swing In Removable Gap (Length of Gap from Spindle Face) .....	25-3/4" (10-1/8")
Swing Over Carriage .....	10"
Distance between Centers .....	40", 60", or 80"
Bed Width (Depth, Min.) .....	13-7/16" (12-1/2")

### HEADSTOCK (fully clutched)

14 Spindle Speeds/Range (1.4 Constant Ratio) .....	18-1600 RPM
Main Drive Motor .....	7.5 H.P.
Spindle Bore .....	2-1/16"
Spindle Nose .....	Camlock D1-6"
Spindle Nose, Internal Taper .....	6 MT

### CARRIAGE

Length, Bearing on Ways .....	20-1/4"
Bridge, Width x Length .....	8-1/2" x 23"
Cross Slide Travel .....	10-1/2"
Top Slide Travel .....	5"

### FEED AND THREADS (W/O END GEAR CHANGES)

42 Longitudinal Feed Range .....	.0017 to .126 I.P.R.
42 Cross Feed Range .....	.0008 to .063 I.P.R.
34 Metric Threads/Range .....	.5 to 28mm
42 Inch Threads/Range .....	3/4 to 56 TPI
Leadscrew—Diameter & Pitch .....	1-7/16" x 4 TPI

### TAILSTOCK (W/TANG)

Quill Diameter .....	3"
Quill Travel .....	7"
Spindle, Morse Taper .....	5 MT
Set-Over for Taper Turning .....	$\pm 5/8$ "
Length, Bearing on Ways .....	12-1/2"

### MISCELLANEOUS

Approx. Weight (Net; 40" Center) .....	5,150 lbs.
(Each additional 20" add 350 lbs.)	
Floor Space (L x W x H) for 40" Center .....	104" x 41" x 49"
Electrics: UL Listed Main Disconnect, Contactors and Circuit Breakers .....	230 or 460V 3 Phase/60 Hz



■ West  
10702-4 Hathaway Dr.  
Santa Fe Springs, CA 90670  
1 (310) 946-9116

■ Central  
2015 S. Mitchell Blvd.  
Schaumburg, IL 60193  
1 (708) 307-3700

■ East  
1702 Taylors Lane  
Cinnaminson, NJ 08077  
1 (609) 786-1500

See your local distributor for more details...  
or check with the nearest Toolmex center.



[www.SterlingMachinery.com](http://www.SterlingMachinery.com)

All specifications in this brochure are subject to change without notice. Photos shown herein are a general representation of the various models and may include some optional equipment.

TUG40-5M-195  
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