



Turning Solutions For Components

with work holding examples

COMPONENT APPLICATION

Automobile



Component : Armature Assembly

ABOUT THE COMPONENT

Material - Sheet steel/Copper
Hardness



Ace Solution

MACHINE OFFERED

LT- 16 LM



MACHINE FEATURES

Spindle	A2-5
Spindlemotor	5.5 / 7.5 kW
Speed range	50-4000 rpm
Turret	BTP-80 / 85tn

CYCLE TIME

22 seconds

CRITICALITY ACHIEVED

Work Holding

Pull Back Collet



OPERATIONS

OD Turning

COMPONENT : SPINNING MILL
APPLICATION : SPINNING RING



ABOUT THE COMPONENT

Material - Bearing steel
Hardness



Ace Solution

MACHINE OFFERED LT- 16 LM



MACHINE FEATURES

Spindle	A2-5
Spindlemotor	5.5 / 7.5 kW
Speed range	50-4000 rpm
Turret	BTP-80 / 85tn

CYCLE TIME

28 seconds

CRITICALITY ACHIEVED

Work Holding

Pull Back Collet



OPERATIONS

OD turning, grooving, rough facing, rough turning, finish facing, finish turning. External grooving,

COMPONENT : PRESSURE PLATE
APPLICATION : AUTO MOBILE
CLUTCH



ABOUT THE COMPONENT

Material - Cast Iron
Hardness



Ace Solution

MACHINE OFFERED
LT- 20 Classic



MACHINE FEATURES

Spindle	A2-8
Spindlemotor	11/15kW
Speed range	50 – 3500 rpm
Turret	BTP-100 / 8 Stn

CYCLE TIME

2 Mins

CRITICALITY ACHIEVED

Work Holding

Pull Back Mandrel



OPERATIONS

COMPONENT : BRAKE DISC

APPLICATION : AUTO MOBILE
TWO WHEELER



ABOUT THE COMPONENT

Material - Steel
Hardness



Ace Solution

MACHINE OFFERED LT- 2 - XL



MACHINE FEATURES

Spindle	A2-6
Spindlemotor	7.5 / 11 kW
Speed range	50 – 2500 rpm
Turret	BTP80 / 8 Stn

CYCLE TIME

1 Min 15 Sec

Work Holding

Pull Back Mandrel



OPERATIONS

OD turning , Grooving and chamfering.

COMPONENT : Disc Front Brake

APPLICATION : DISC BRAKE



ABOUT THE COMPONENT

Material - FC- 17HD
Hardness



Ace Solution

MACHINE OFFERED VTL-30



MACHINE FEATURES

Spindle	A2-6
Spindlemotor	7.5 / 11 kW
Speed range	50 – 2500 rpm
Turret	BTP-80 / 8 Stn

CYCLE TIME

84 Sec

Work Holding

Pull Back Chuck



OPERATIONS

COMPONENT : MASTER CYLINDER

APPLICATION : AUTOMOBILE MASTER
BRAKE CLY ASSY



ABOUT THE COMPONENT

Material - ALUMINIUM
Hardness



Ace Solution

MACHINE OFFERED
LT-20Classic



MACHINE FEATURES

Spindle	A2-6
Spindlemotor	11 / 15 kW
Speed range	50 – 3000 rpm
Turret	BTP100 / 85tn

CYCLE TIME

Work Holding

Special Fixture with jaws



OPERATIONS

OD Turning

COMPONENT : BOTTOM CASE

APPLICATION : MOTOR BIKE
FRONT FORK



ABOUT THE COMPONENT

Material - Aluminium
Hardness



Ace Solution

MACHINE OFFERED
LT-20XL



MACHINE FEATURES

Spindle	A2-8
Spindlemotor	11 / 15 kW
Speed range	50 – 3000 rpm
Turret	BTP-80 / 85tn

CYCLE TIME

38 Sec

Work Holding

2 Jaw Special Chuck



OPERATIONS

OD Turning, facing, ID turning,
chamfering, ID grooving.

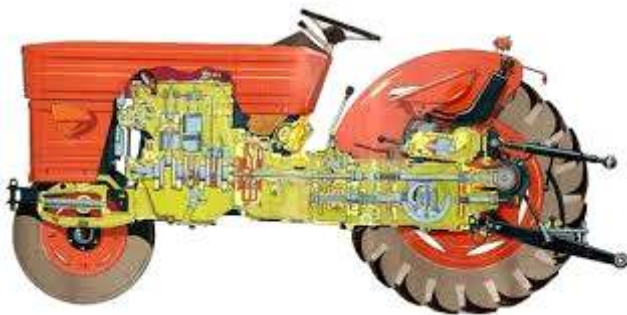
COMPONENT : CYLINDER HEAD

APPLICATION :



ABOUT THE COMPONENT

Material - Grey Iron
Hardness



Ace Solution

MACHINE OFFERED LT-20 Classic



MACHINE FEATURES

Spindle	A2-8
Spindlemotor	11 / 15 kW
Speed range	50 – 2500 rpm
Turret	BTP100 / 85tn

CYCLE TIME

4 Min 40 Sec

Work Holding

Special Jaws



OPERATIONS

COMPONENT : FEMALE V- BAND FLANGE

APPLICATION : PETROLEUM REFINERY



ABOUT THE COMPONENT

Material - Stainless Steel
Hardness



Ace Solution

MACHINE OFFERED
SIMPLE TURN 5075



MACHINE FEATURES

Spindle	A2-6
Spindle motor	
Speed range	50 – 2000 rpm
Turret	4 Station

CYCLE TIME

6 Min 24 Sec

Work Holding

Special Jaws



OPERATIONS

Rough face, OD profile, finish face,
rough and finish ID.

COMPONENT : HEAD

APPLICATION : HEAVY DUTY CYLINDER



ABOUT THE COMPONENT

Material -GGG40
Hardness



Ace Solution

MACHINE OFFERED LT-30



MACHINE FEATURES

Spindle	A2-8
Spindlemotor	18.5 / 22 kW
Speed range	50 – 3000 rpm
Turret	BTP125 / 8Stn

CYCLE TIME

6 Min 45Sec

Work Holding

Special Fixture with Jaws



OPERATIONS

Rough facing, OD Turning ,
rough and finish ID turning.

COMPONENT : COVER WATER PUMP

APPLICATION : WATER PUMP



ABOUT THE COMPONENT

Material - ALUMINIUM
Hardness



Ace Solution

MACHINE OFFERED SUPER JOBBER LM



MACHINE FEATURES

Spindle	A2-5
Spindle motor	5.5 / 7.5 kW
Speed range	50 – 3500 rpm
Turret	BTP80 / 85tn

CYCLE TIME
53 seconds

Work Holding

Face Clamping Fixture Finger Chuck



OPERATIONS

Rough Boring & Facing, finish Facing and
finish facing of Inner face, finish Boring.

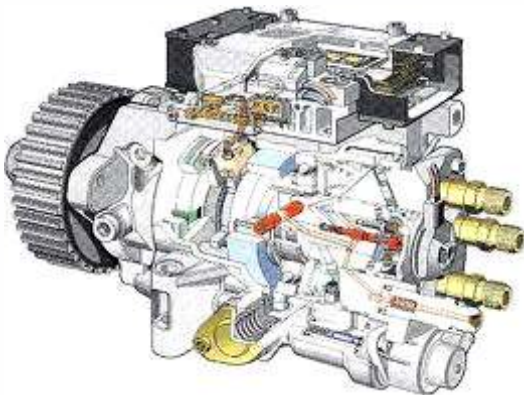
COMPONENT : GOVERNOR HOUSING

APPLICATION : DIESEL ENGINE



ABOUT THE COMPONENT

Material - ALUMINIUM
Hardness



Ace Solution

MACHINE OFFERED LT-2LM



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5/ 11kW
Speed range	50 – 3500 rpm
Turret	BTP80 / 8Stn

CYCLE TIME

44 seconds

CRITICALITY ACHIEVED

Bore dimension, face flatness and position

Work Holding

Face Clamping Fixture Finger Chuck



OPERATIONS

Facing and Boring

COMPONENT : HOUSING WATER UPUMP

APPLICATION : AUTOMOBILE WATER PUMP



ABOUT THE COMPONENT

Material - Grey cast Iron
Hardness



Ace Solution

MACHINE OFFERED SUPER JOBBER LM



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5 / 11 kW
Speed range	50 – 3500 rpm
Turret	BTP-80 / 85°

CYCLE TIME
66 seconds

Work Holding

Face Clamping Fixture Finger Chuck



OPERATIONS

ID profile turning, face and ID grooving.

COMPONENT : HOUSING REAR WHEEL DRIVE

APPLICATION : MOTOR BIKE



ABOUT THE COMPONENT

Material - Grey cast Iron
Hardness



Ace Solution

MACHINE OFFERED SUPER JOBBER LM



MACHINE FEATURES

Spindle	A2-5
Spindle motor	5.5 / 7.5 kW
Speed range	50 – 4000 rpm
Turret	BTP80 / 8Stn

CYCLE TIME

60 seconds

Work Holding

Face Clamping Fixture Finger Chuck



OPERATIONS

Rough Boring, facing, OD chamfer, grooving,
3finish ID grooving, boring, facing and back chamfer.

COMPONENT : CROSS

APPLICATION : AUTOMOBILE TRANSMISSION



ABOUT THE COMPONENT

Material - Grey cast Iron
Hardness



Ace Solution

MACHINE OFFERED LT - 20 CLASSIC



MACHINE FEATURES

Spindle	A2-5
Spindle motor	5.5 / 7.5 kW
Speed range	50 – 4000 rpm
Turret	BTP80 / 8Stn

CYCLE TIME 60 seconds

CRITICALITY ACHIEVED

Diameter, perpendicularity and coplanarity

Work Holding

Indexing Chuck Dia 225



OPERATIONS

Rough turns face, OD,
finish turns face and OD profile.

COMPONENT : TRIPOD

APPLICATION : AUTOMOBILE TRANSMISSION



ABOUT THE COMPONENT

Material - 16Mn Cr5
Hardness



Ace Solution

MACHINE OFFERED LT - 2 XL



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5 / 11 kW
Speed range	50 – 3500 rpm
Turret	BTP - 8 Stn

CYCLE TIME
35 seconds

CRITICALITY ACHIEVED

Diameter, perpendicularity and coplanarity

Work Holding

Indexing Chuck



OPERATIONS

OD profile turning.

COMPONENT : BEVEL GEAR

APPLICATION : REAR AXEL TRUCK
TRANSMISSION



ABOUT THE COMPONENT

Material - Hardened Steel
Hardness



Ace Solution

MACHINE OFFERED SUPER JOBBER LM



MACHINE FEATURES

Spindle	A2-6
Spindlemotor	7.5 / 11 kW
Speed range	50 – 3500 rpm
Turret	BTP-80 / 8Stn

CYCLE TIME
56 seconds

Work Holding

3 Jaw Universal Bevel Gear Chuck



OPERATIONS

Rough & Finish ID turning.

COMPONENT : CYLINDER LINER

APPLICATION : ENGINE CYLINDER LINER



ABOUT THE COMPONENT

Material - Alloy Cast Iron
Hardness



Ace Solution

MACHINE OFFERED
LT -20 XL



MACHINE FEATURES

Spindle	A2-8
Spindle motor	7.5/11 kW
Speed range	50 – 3000 rpm
Turret	BTP-100 / 12 Stn

CYCLE TIME
6Min 30 seconds

CRITICALITY ACHIEVED

Diameter size , Coaxiality
and cylindricity

Work Holding

Expanding Mandrel



OPERATIONS

Facing, OD turning, O - ring dia , under cut, top facing.

COMPONENT : TUBE

APPLICATION : CYLINDER FOR
EARTH MOVERS



ABOUT THE COMPONENT

Material - Alloy Cast Iron
Hardness



Ace Solution

MACHINE OFFERED LT -25



MACHINE FEATURES

Spindle	A2-8
Spindle motor	18.5 / 22 kW
Speed range	50 – 3000 rpm
Turret	BTP-125 / 12 Stn

CYCLE TIME
6Min 30 seconds

CRITICALITY ACHIEVED

Both side operation in single setting

Work Holding

Dead length Mandrel System



OPERATIONS

Facing, band turning, facing, grooving.

COMPONENT : PISTON

APPLICATION : TRUCK ENGINE



ABOUT THE COMPONENT

Material - Aluminium
Hardness



Ace Solution

MACHINE OFFERED LT -2 XL



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5 / 11 kW
Speed range	50 – 2500 rpm
Turret	BTP80 / 8Stn

CYCLE TIME

CRITICALITY ACHIEVED

Cavity Volume

Work Holding

Pin Type Fixture



OPERATIONS

Cavity Turning

COMPONENT : CASE DEFERENTIAL

APPLICATION : AUTOMOTIVE DEFERENTIAL



ABOUT THE COMPONENT

Material - Aluminium
Hardness



Ace Solution

MACHINE OFFERED LT -2 XL



MACHINE FEATURES

Spindle	A2- 6
Spindle motor	7.5/11 kW
Speed range	50 – 2500 rpm
Turret	BTP-80 / 85tn

CYCLE TIME

96 Seconds

CRITICALITY ACHIEVED

ID/OD Concentric within 10 microns.

Work Holding

Pin Arbour Chuck Dia 250



OPERATIONS

Facing, OD, ID, and Back Facing.

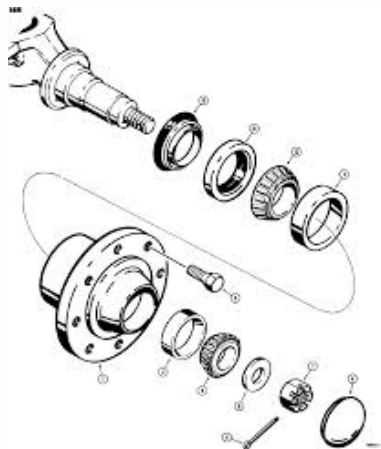
COMPONENT : HUB FRONT AXEL

APPLICATION : AUTOMOTIVE FRONT HUB



ABOUT THE COMPONENT

Material - Steel
Hardness



Ace Solution

MACHINE OFFERED LT -2 XL



MACHINE FEATURES

Spindle	A2-6
Spindlemotor	7.5/11 kW
Speed range	50 – 2500 rpm
Turret	BTP80 / 85tn

CYCLE TIME Seconds

Work Holding

Pin Arbour Chuck Dia 250

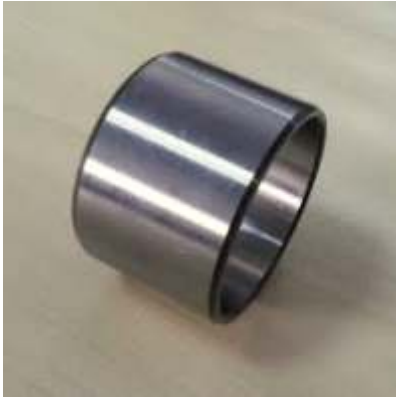


OPERATIONS

Facing rough & Finish, Centre Drill,
rough and finish flange facing, Chamfering, OD turning .

COMPONENT : OUTER RING

APPLICATION : BEARING



ABOUT THE COMPONENT

Material - SAE52100
Hardness



Ace Solution

MACHINE OFFERED CUB LM



MACHINE FEATURES

Spindle	A2-5
Spindle motor	3.7 / 5.5 kW
Speed range	50 – 4000 rpm
Turret	BTP63 / 8Stn

CYCLE TIME
24 Seconds

CRITICALITY ACHIEVED
Roundness 0.01mm

Work Holding

Pin Arbour Chuck



OPERATIONS

Turns face & chamfer and Rough &
Finish ID, chamfer..

COMPONENT : CAM SHAFT

APPLICATION : MOTOR BIKE



ABOUT THE COMPONENT

Material - Chill Casting
Hardness- 200 - 240HB



Ace Solution

MACHINE OFFERED LT 16 XL



MACHINE FEATURES

Spindle	A2-5
Spindle motor	5.5/7.5 kW
Speed range	50 – 4000 rpm
Turret	BTP-80 / 8Stn

CYCLE TIME
22 Seconds

Work Holding

Eccentric Compensating Chuck



OPERATIONS

Rough and Finish turns OD.

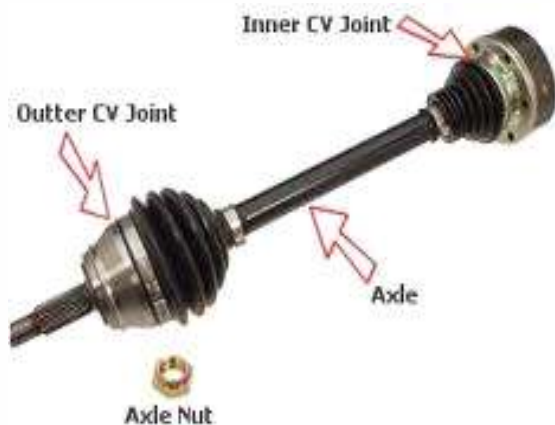
COMPONENT : OUTER RACE BELL

APPLICATION : CONSTANT VELOCITY JOINT



ABOUT THE COMPONENT

Material - S53C
Hardness- 85 - 105HRB



Ace Solution

MACHINE OFFERED
LT -2 XL



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5/11kW
Speed range	50 – 3500 rpm
Turret	BTP80 / 85tn

CYCLE TIME
75 Seconds

Work Holding

Compensating Universal Ball lock Chuck



OPERATIONS

OD Truning.

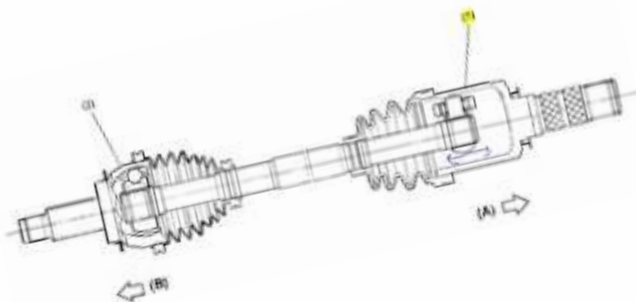
COMPONENT : TULIP

APPLICATION : AUTOMOBILE WHEEL DRIVE



ABOUT THE COMPONENT

Material - S53C
Hardness- 90- 110HRB



Ace Solution

MACHINE OFFERED LT -2 XL



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5/11kW
Speed range	50 – 3500 rpm
Turret	BTP80 / 85tn

CYCLE TIME
92 Seconds

Work Holding

Compensating Universal Ball lock Chuck



OPERATIONS

OD Truning.

COMPONENT : TRIPOD HOUSING

APPLICATION : AUTOMOBILE



ABOUT THE COMPONENT

Material
Hardness



Ace Solution

MACHINE OFFERED LT -2 LM 500



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5 / 11 kW
Speed range	50 – 3500 rpm
Turret	BTP80 / 8Stn

CYCLE TIME 139 Seconds

Work Holding

Compensating Universal Ball lock Chuck



OPERATIONS

Centering, OD profile turning and face grooving.

COMPONENT : DRIVEN PINON

APPLICATION : TRUCK TRANSMISSION



ABOUT THE COMPONENT

Material - Steel
Hardness



Ace Solution

MACHINE OFFERED LT -20 Classic



MACHINE FEATURES

Spindle	A2-6
Spindle motor	11 / 15 kW
Speed range	50 – 3000 rpm
Turret	BTP100 / 8 Stn

CYCLE TIME

3min 57Seconds

Work Holding

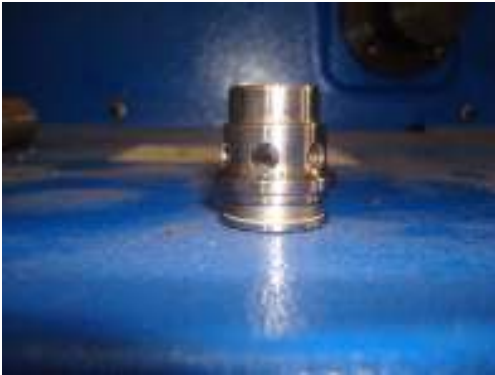
Compensating Universal Ball lock Chuck



OPERATIONS

COMPONENT : VALVE SEAT

APPLICATION : HYDRAULIC VALVE



ABOUT THE COMPONENT

Material - Bright Bar
Hardness



Ace Solution

MACHINE OFFERED SUPER JOBBER LM



MACHINE FEATURES

Spindle	A2-6
Spindle motor	9 / 11 kW
Speed range	50 – 4000 rpm
Turret	BSVN- 160/ 12Stn

CYCLE TIME

3min 21 Seconds

Work Holding

Dead Length Collet System



OPERATIONS

Roughing OD, BW drilling, rough ID, radial drilling of holes, finishing OD, Grooving, finishing ID, Parting.

COMPONENT : OUTER RING

APPLICATION : AUTO PART



ABOUT THE COMPONENT

Material - Seamless Steel Pipe
Hardness



Ace Solution

MACHINE OFFERED LT - 16LM



MACHINE FEATURES

Spindle	A2-5
Spindle motor	5.5/7.5 kW
Speed range	50 – 4000 rpm
Turret	BTP80 / 8 Stn

CYCLE TIME 16 Seconds

CRITICALITY ACHIEVED

Machining both sides in one setting

Work Holding

Dead Length mandrel with retractable stop



OPERATIONS

Facing and Chamfering

COMPONENT : SLEEVE SYNC 3

APPLICATION : AUTOMOBILE GEAR BOX



ABOUT THE COMPONENT

Material - SCR420H
Hardness 80 - 90 HRB



Ace Solution

MACHINE OFFERED SUPER JOBBER LM



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5/11 kW
Speed range	50 – 3500 rpm
Turret	BTP-80 / 8Stn

CYCLE TIME

11 Seconds

Work Holding

Diaphragm Chuck



OPERATIONS

ID Turning.

COMPONENT : INNER TUBE

APPLICATION : SHOCK ABSORBER



ABOUT THE COMPONENT

Material - SEA1541
Hardness



Ace Solution

MACHINE OFFERED LT-16XL



MACHINE FEATURES

Spindle	A2-5
Spindle motor	5.5 / 7.5 kW
Speed range	50 – 4000 rpm
Turret	BTP80 / 8 Stn

CYCLE TIME
32 Seconds

Work Holding

Double Angle Collect



OPERATIONS

COMPONENT : CYLINDER BLOCK

APPLICATION : 2 WHEELR ENGINE



ABOUT THE COMPONENT

Material - CAST IRON
Hardness - 93-104HRB



Ace Solution

MACHINE OFFERED LT-2XL



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5/11 kW
Speed range	50 – 3500 rpm
Turret	BTP80

CYCLE TIME 52 Seconds

CRITICALITY ACHIEVED

Face parallelity 0.02mm

Work Holding

Double Angle Mandrel

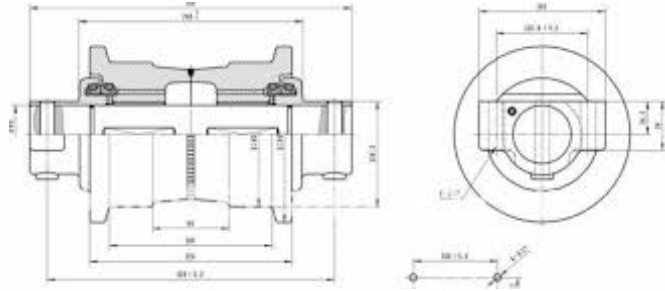


OPERATIONS

Both sides facing.

COMPONENT : ROLLER ASSEMBLY

APPLICATION : TRACKED VEHICLE



ABOUT THE COMPONENT

Material - Steel

Hardness



Ace Solution

MACHINE OFFERED LT-25



MACHINE FEATURES

Spindle	A2-8
Spindle motor	18.5 / 22 kW
Speed range	50 – 3000 rpm
Turret	BTP- 125

CYCLE TIME

4Min

Work Holding

Double Angle expanding Mandrel



OPERATIONS

Facing and Profile Boring.

COMPONENT : CRANK SHAFT

APPLICATION : Diesel Engine



ABOUT THE COMPONENT

Material - forged Steel
Hardness - 270BHN



Ace Solution

MACHINE OFFERED LT-2XL



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5 / 11 kW
Speed range	50 – 3500 rpm
Turret	BTP-80

CYCLE TIME

Work Holding

Eccentric Collet System



OPERATIONS

Pin turning

COMPONENT : CRANK SHAFT

APPLICATION : Diesel Engine



ABOUT THE COMPONENT

Material
Hardness



Ace Solution

MACHINE OFFERED LT-30



MACHINE FEATURES

Spindle	A2-8
Spindle motor	11
Speed range	50 – 3000 rpm
Turret	BTP125 / 85tn

CYCLE TIME

6 min 10 seconds

Work Holding

Eccentric Collet System



OPERATIONS

Pin turning

COMPONENT : CRANK SHAFT

APPLICATION : Air Compressor



ABOUT THE COMPONENT

Material : Forged Steel

Hardness : 270BHN



Ace Solution

MACHINE OFFERED

LT-2 XL 500



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5 / 11 kW
Speed range	50 – 3500 rpm
Turret	BTP80 / 85tn

CYCLE TIME

110 seconds

Work Holding

Eccentric Collet System



OPERATIONS

Pin turning

COMPONENT : Pressure Plate

APPLICATION : Air Compressor



ABOUT THE COMPONENT

Material : Cast Iron

Hardness :



Ace Solution

MACHINE OFFERED

LT-20 Classic



MACHINE FEATURES

Spindle	A2-8
Spindle motor	11 / 15 kW
Speed range	50 – 3500 rpm
Turret	BTP100 / 8Stn

CYCLE TIME

2 mins

Work Holding

Universal Ball Lock Chuck



OPERATIONS

Facing & ID Truning

COMPONENT : Cast Defferintial

APPLICATION : Automobile



ABOUT THE COMPONENT

Material : Cast Iron

Hardness :



Ace Solution

MACHINE OFFERED

LT-20 Classic



MACHINE FEATURES

Spindl e	A2-6
Spindle motor	11 / 15 kW
Speed range	50 – 3000 rpm
Turret	BTP100 / 8Stn

CYCLE TIME

1 min 45 Seconds

Work Holding

Universal Ball Lock Chuck



OPERATIONS

Facing, OD turning , boring, back boring, back facing.

COMPONENT : Front Axle
wheel Bearing Spindle
APPLICATION : Automobile



ABOUT THE COMPONENT

Material : Steel
Hardness :



Ace Solution

MACHINE OFFERED
LT-20 Classic



MACHINE FEATURES

Spindle	A2-6
Spindle motor	11 / 15 kW
Speed range	50 – 3000 rpm
Turret	BTP100 / 8Stn

CYCLE TIME

3 min 5 Seconds

Work Holding

Universal Ball Lock Chuck



OPERATIONS

Rough facing, U drill, ID chamfer, OD, ID, Facing,
angular facing, finish OD and threading.

COMPONENT : Stub Axle

APPLICATION : Automobile



ABOUT THE COMPONENT

Material : 40 cr4 m02 : SS 4027

Hardness :



Ace Solution

MACHINE OFFERED

LT-25



MACHINE FEATURES

Spindle	A2-8
Spindle motor	18.5 / 22 kW
Speed range	50 – 2000 rpm
Turret	BTP125 / 8Stn

CYCLE TIME

6 min 2 Seconds

Work Holding

Work Driver



OPERATIONS

OD , face , under cut, and chamfer.

COMPONENT : SHAFT

APPLICATION : Automobile



ABOUT THE COMPONENT

Material : Carbon Steel 40 C8



Ace Solution

MACHINE OFFERED LT-25



MACHINE FEATURES

Spindle	A2-6
Spindle motor	7.5 / 11 kW
Speed range	50 – 4000 rpm
Turret	BSVN160 / 12 Stn

CYCLE TIME
3 min 27 Seconds

CRITICALITY ACHIEVED
Turn mill application

Work Holding

Work Driver



OPERATIONS

Profile turning, threading , slot milling and drilling.