



 **ZMM**  
**BULGARIA**

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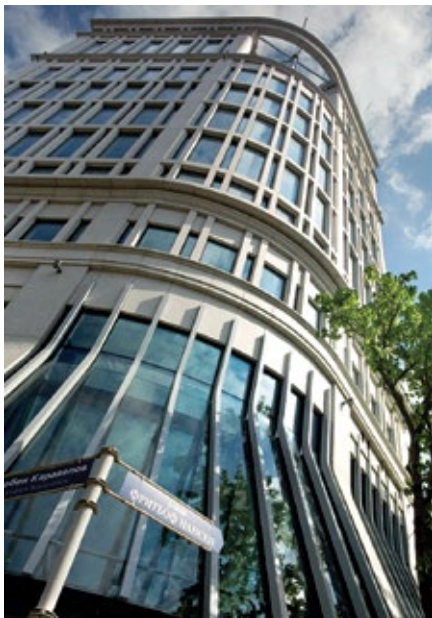




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**WE DO NOT JUST ASSEMBLE.  
WE MANUFACTURE.**





## ZMM BULGARIA HOLDING

ZMM Bulgaria Holding belongs to the family of **Industrial Holding Bulgaria**. One of the most significant industrial groups in the country, IHB operates mainly in the maritime transport business, ship building and repair, port operations, machine building.

For more information, please visit [www.bulgariaholding.com](http://www.bulgariaholding.com)

**ZMM Bulgaria Holding** is a privately owned company and a leading manufacturer of universal and CNC lathes. The Holding was established in 2001 and currently manages three production facilities, where it employs about 600 professionals.

- **ZMM Sliven:** manufacture of universal lathes, lathes with variable speed control, oil-country lathes, and CNC lathes.
- **IHB Metal Castings:** castings from gray cast iron according to EN 1561/2000; castings from nodular cast iron according EN 1563; patterns.
- **ZMM Nova Zagora:** design and manufacture of assemblies and parts for metal cutting and general machinery products.



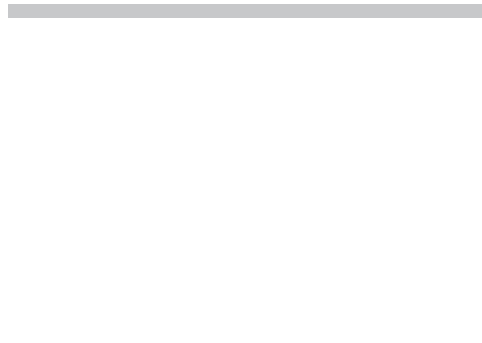
ZMM Sliven production plant



ZMM Nova Zagora production plant  
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IHB Metal Castings foundry  
tel.:+359 2 836 44 02  
[www.ihbmetalcastings.com](http://www.ihbmetalcastings.com)



## UNIVERSAL LATHES

Our universal lathes and lathes with infinitely variable spindle speed control have diverse features and accessories to meet the needs of clients in various industries and geographical locations. Standard on every machine are metric, inch, module and diametrical pitch threads. Distance between centers varies between 500mm and 10,000mm and center height between 165mm and 705mm. Our lathes are affordable, rugged, reliable and easy to operate. They are built to last and are known for consistent performance and durability even under the most demanding work conditions.

## OIL COUNTRY LATHES

Our oil country lathes are designed for turning pipes and pipe fittings for the oil and gas industry. These machines can be used for a variety of turning operations, including cutting metric, inch, module and pitch threads. A standard machine includes two four jaw independent chucks, a taper turning attachment, two stands - one with fixed steady and one with rolling quills. Our spindles are assembled with preloaded angular contact bearings from leading manufacturers like 'SKF' and 'FAG'. All major components are manufactured from stainless steel, which ensures reliable operation and accuracy.

## CNC LATHES AND CYCLIC CNC LATHES

Our CNC lathes are available with control systems and servo drives from Siemens, Heidenhain, Fanuc, and Fagor. CNC lathes have a maximum turning diameter over bed of 500, 890, 1090, and 1320mm. They are designed to perform a wide range of turning operations on medium, large and oversized parts in small and medium series production.

Cyclic CNC lathes, although at significantly lower prices than the CNC models, are equally functional and reliable. Longer life expectancy and ease of operation are among their major advantages.

ZMM Bulgaria is among the world's most experienced manufacturers of universal, oil country and CNC lathes and their modifications with infinitely variable spindle speed control. We are well acquainted with customers' needs and are able to render all necessary information, training and technical support at any time – directly or through our distributors. Our service engineers are available and ready to help you out. All you have to do is ask for our machine tool service representative.

All of our equipment comes fully assembled, clearly labeled and includes product manuals with detailed instructions. Our goal is to make installation as easy as possible so you can start producing. If you still have questions after receiving your machine, contact us. We are ready to help.

Fast access to spare parts can help you keep your machines running, control costs, extend the life of your equipment and maintain production levels.



# C10T.10/ C10T.12



For illustration purpose only



# OIL COUNTRY LATHES

STANDART MACHINE SPECIFICATIONS		Unit	C10T.10	C10T.12
CAPACITY	Height of centers	mm	400	
	Swing over bed	mm	800	
	Swing over cross slide	mm	560	
	Swing in gap	mm	990	
	Width of bed	mm	560	
	Distance between centers	mm	1500;2000;3000;4000;5000;6000	
SPINDLE	Spindle nose DIN 55027 SAS B5.9	No	A20 – A2.20	
	Spindle bore	mm	260	315
	Spindle taper	Metric	318	
HEAD STOCK	Number of spindle speeds		12	
	Spindle variable speed sub-ranges	rpm	8-400 (10-480)	
	Main motor power	kw	11 (15)	
FEEDS	Number of feeds		152	
	Longitudinal feed range	mm/rev	0,039 – 15	
	Cross feed range	mm/rev	0,02 – 7,5	
THREADS	Number of threads		76 of each kind	
	Metric thread range	mm	0,5 – 150	
	Inch thread range	Tpi	60 – 1/5	
	Module thread range	Module	0,125 – 37,5	
	DP thread range	DP	240 – 4/5	
CARRIAGE	Cross slide travel	mm	410	
	Top slide travel	mm	150	
TAIL STOCK	Quill diameter	mm	105	
	Quill taper	Morse	No.6	
	Quill travel	mm	225	
WEIGHT	For DBC 2000 mm	kg	6000	6100

# C10T.14



For illustration purpose only





# OIL COUNTRY LATHES

## STANDART MACHINE SPECIFICATIONS

		Unit	C10T.14
CAPACITY	Height of centers	mm	510
	Swing over bed	mm	1020
	Swing over cross slide	mm	780
	Swing in gap	mm	1210
	Width of bed	mm	560
	Distance between centers	mm	1500; 2000; 3000; 4000; 5000; 6000
SPINDLE	Spindle nose DIN 55027 SAS B5.9	No	A20 – A2.20
	Spindle bore	mm	358
	Spindle taper	Metric	360
HEAD STOCK	Number of spindle speeds		12
	Spindle variable speed sub-ranges	rpm	6,3 - 315
	Main motor power	kw	18,5
FEEDS	Number of feeds		152
	Longitudinal feed range	mm/rev	0,039 – 15
	Cross feed range	mm/rev	0,02 – 7,5
THREADS	Number of threads		76 of each kind
	Metric thread range	mm	0,5 – 150
	Inch thread range	Tpi	60 – 1/5
	Module thread range	Module	0,125 – 37,5
	DP thread range	DP	240 – 4/5
CARRIAGE	Cross slide travel	mm	510
	Top slide travel	mm	280
TAIL STOCK	Quill diameter	mm	105
	Quill taper	Morse	No.6
	Quill travel	mm	225
WEIGHT	For DBC 2000 mm	kg	7100

# ZMM SLIVEN



ZMM Sliven is specialized in the design and manufacture of universal metal cutting lathes, CNC lathes, equipment and spare parts. Over 95% of the output is exported to more than 80 countries across the globe. Each machine is manufactured as per the specific climate conditions of the region where it will be operated and in consideration of the particular needs of every individual client. Products of ZMM Sliven are recognized all over the world for their long working life and quality. For the time-being, the factory has manufactured a total of over 115,000 lathes.

ZMM Sliven has adopted a comprehensive quality management system and is ISO 9001 certified. All products of ZMM Sliven also bear the CE indication as proof of conformity with the norms and requirements of the European Community.



# ZMM NOVA ZAGORA

tel.:+359 457 630 56  
www.zmmnz.com

ZMM Nova Zagora supplies parts and units to over 30 metal- and woodworking machine manufacturers in Europe. ZMM Nova Zagora's products and services are organized in four groups:

- ROTATION PARTS: Axes and shafts - smooth and spline; Gear-wheels; Shaft-gear wheels; Chain gear-wheels, Tooth-belt pulleys, Piston rods;
- UNITS: Multi-disk clutches; Lathe gear and slide box ; Cylindrical and worm reduction gear;



- MACHINES: Chip conveyors; Machines built in automated wood processing complexes;
- HEAT TREATMENT: Soft annealing; Inter mediate annealing; Carburize; Nitro carburize; Core hardening; Surface hardening.

ZMM Nova Zagora is the county's leading manufacturer of chip conveyors for various CNC lathes and centers. They are designed as per customer's specifications using metal hinged bands with fluted working space to transport chips with various shapes.

As of 1998 ZMM Nova Zagora is duly certified and operates as per the ISO 9001 Quality Management System.

# IHB Metal Castings

tel.:+359 2 836 44 02  
www.ihbmetalcastings.com



IHB Metal Castings is a joint stock company with majority shareholder ZMM Bulgaria Holding. The foundry is specialized in the production of castings from modified gray cast iron - according to EN 1561 and nodular cast iron - according to EN 1563. Castings can be with medium and high degree of complexity in single and small series with single weights in the following ranges:

- Gray cast iron: from 80 to 8 000 kg per unit;
- Nodular cast iron: from 50 to 3 000 kg per unit;

The foundry is also capable of providing a wide range of wooden patterns and cores with accuracy from GTB17 to GTB18 according to DIN1685.

IHB Metal Castings supplies a large variety of castings including the full range of components for machine tools - bodies, bed slides, columns, tailstocks, boxes etc.



