84.58 - Lathes (including turning centres) for removing metal (+).

- Horizontal lathes :

8458.11 - - Numerically controlled

8458.19 - - Other

- Other lathes :

8458.91 - - Numerically controlled

8458.99 - - Other

The lathes (including turning centres) of this heading are machines used for surface-working metal by cutting away or otherwise removing metal.

These machines can be distinguished from tools (pneumatic, hydraulic or with motor) for working in the hand of **heading 84.67**, by the fact that they are usually designed to be mounted on the floor, or on a bench, or on a wall or on another machine, and are thus usually provided with a base plate, mounting frame, stand, etc.

The heading includes :

(1) **Lathes**, whether or not automatic, including slide lathes, vertical lathes, capstan or turret lathes, production (or copying) lathes. However, spinning lathes which function by deforming the metal are classified in **heading 84.63**.

(2) **Spindle or axle turning machines**, for turning simultaneously and symmetrically the two ends of the spindles or axles of large wheels, etc.

(3) **Turning centres**, for removing metal.

PARTS AND ACCESSORIES

Subject to the general provisions regarding the classification of parts (see the General Explanatory Note to Section XVI), parts and accessories (**other than** the tools of **Chapter 82**) of the lathes of this heading are classified in **heading 84.66**.

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The heading also **excludes** :

(a) Machine-tools for working any material by removal of material, by laser or other light or photon beam, ultrasonic, electro-discharge, electro-chemical, electron beam, ionic-beam or plasma arc processes; water-jet cutting machines (**heading 84.56**).

(b) Machining centres, unit construction machines (single station) and multi-station transfer machines, for working metal (**heading 84.57**).

(c) Cutting-off machines (**heading 84.61**).

(d) Tools for working in the hand, pneumatic, hydraulic or with self-contained electric or non-electric motor (**heading 84.67**).

(e) Machines and appliances for testing, of **heading 90.24**.

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Subheading Explanatory Note.

Subheadings 8458.11 and 8458.91

Numerically controlled machine-tools are, as a group, know by their abbreviations CNC (Computer Numerical Control) or NC (Numerical Control). The terms "Computer Numerical Control" and "Numerical Control" can be regarded as synonymous. To qualify as a numerically controlled machine-tool, the functions and movements of the machine-tool, tool or workpiece must be performed according to pre-programmed instructions. The programming is normally executed in an NC-specific language, for example, ISO-code. Programs and other data are stored in order to be accessible directly or subsequently. Numerically controlled machine-tools always integrate a control unit (separate "stand alone" unit or built in), incorporating an automatic data processing machine or a microprocessor, as well as servo systems, in order to achieve the desired motions of the machine-tool, tool or workpiece. CNC-machines, CNC-lathes and NC-milling machines are examples of numerically controlled machine-tools.

If the control unit is not presented with the machine-tool, the latter is nevertheless to be considered as a numerically controlled machine-tool **provided** it has the specific characteristics of this type of machine.