

# Standard machine specifications

## ■ Control axis specifications

Item	Specifications
Rapid feed rate	X·····10000mm/min Y·····10000mm/min Z·····12000mm/min B·····12000mm/min C·····75000° mm/min (208rpm)
Maximum turning feed rate	X·····6000mm/min Y·····6000mm/min Z·····6000mm/min B·····6000mm/min C·····24000° mm/min (67rpm)
Minimum input increment	X·····0.001mm/0.0001inch (Diameter value) Y·····0.001mm/0.0001inch (Diameter value) Z·····0.001mm/0.0001inch B·····0.001mm/0.0001inch C·····0.01°

## ■ Machining capacity

Item	Specifications	Remarks
Maximum turning diameter	φ 25mm	
Maximum headstock stroke	Rotary type GB	260mm
	Barstock gripping unit in use	250mm
Maximum drilling capacity	Stationary tool	φ 14mm/MT1
	X power-driven attachment	φ 8mm /ER16
	Y power-driven attachment	φ 8mm /ER16 φ 7mm /ER11
Maximum tapping capacity	Stationary tool	M12 × P1.75
	X power-driven attachment	M6 × P1.0
	Y power-driven attachment	M6 × P1.0
Maximum die cutting capacity	M10 × P1.5	
Maximum milling capacity	φ 10mm	
Maximum slotting capacity	2mm width×6mm depth	Cutter φ 50 × φ 12.7 × t

Note 1) The above machining capacities apply to S45C (AISI 1045, DIN C45) material.

The machining capacities may differ from the listed values depending on the machining conditions, such as the material to be machined or the tools being used.

Note 2) When drilling a hole larger than φ 10mm with an MT1 drill, a prepared hole may be required.

## ■ Headstock specifications

Item	Specifications	Remarks	
Headstock spindle speed (rpm)	350~7000rpm		
Speed control	Direct 4-digit S command		
Main spindle rotational control	AC spindle drive		
Main spindle minimum indexing angle	Type A	15°	Main spindle orientation
	Type B	0.01°	C-axis control
Main spindle motor	5.5KW (continuous)/7.5KW (30 minutes)	AC spindle motor	

## ■ Turret specifications

Item	Specifications	Remarks	
Turret	Twin turret•2 horizontal slides		
Number of tools	8-station turret × 2=16		
Tool selection	Random indexing shortest route		
Indexing & positioning	Cubic coupling		
Turret indexing device	Hydraulic rotary indexing motor		
Tool shank size	□ 16 × 68		
Tool holder and sleeve system	736 series•221 series• 251 series		
X power-driven attachment	Spindle speed (rpm)	300~4500rpm	Torque up version 220~3300rpm High-speed version 400~6000rpm
	Speed control	Direct 4-digit S command	
	Rotational control	Inverter control	
	Power-driven attachment motor	0.75kW	
	Power-driven attachment installation position	8 stations	Only for cross machining tools
Y power-driven attachment	Spindle speed (rpm)	300~4500rpm	Torque up version 220~3300rpm High-speed version 400~6000rpm
	Speed control	Direct 4-digit S command	
	Rotational control	Inverter control	
	Power-driven attachment	0.75kW	
	Power-driven attachment installation position	8 stations	

## ■ Expendable tools

Item	Specifications	Remarks
Main spindle collet chuck (standard/export)	Type KJR 25 (= MR-25)	Schaublin type F30 Art No.63
Guide bushing (standard/export)	Type KJR 25 (= MR-25)	Neukomm type B Art No.451.001

### ■ Coolant unit specifications

Item	Specifications	Remarks
Installation method	Installed separately outside machine	
Coolant tank capacity (liters)	180L	
Coolant motor (KW)	0.25kW	
Safety device	Coolant oil level detector	

### ■ Hydraulic unit specifications

Item	Specifications	Remarks
Installation method	Installed separately outside machine	
Hydraulic tank capacity (liters)	40L	
Normal pressure	35kg/cm <sup>2</sup>	The index motor is 50kg/cm <sup>2</sup> (full pressure 50kg/cm <sup>2</sup> and partial pressure 35kg/cm <sup>2</sup> )
Hydraulic pump motor	1.5kW	

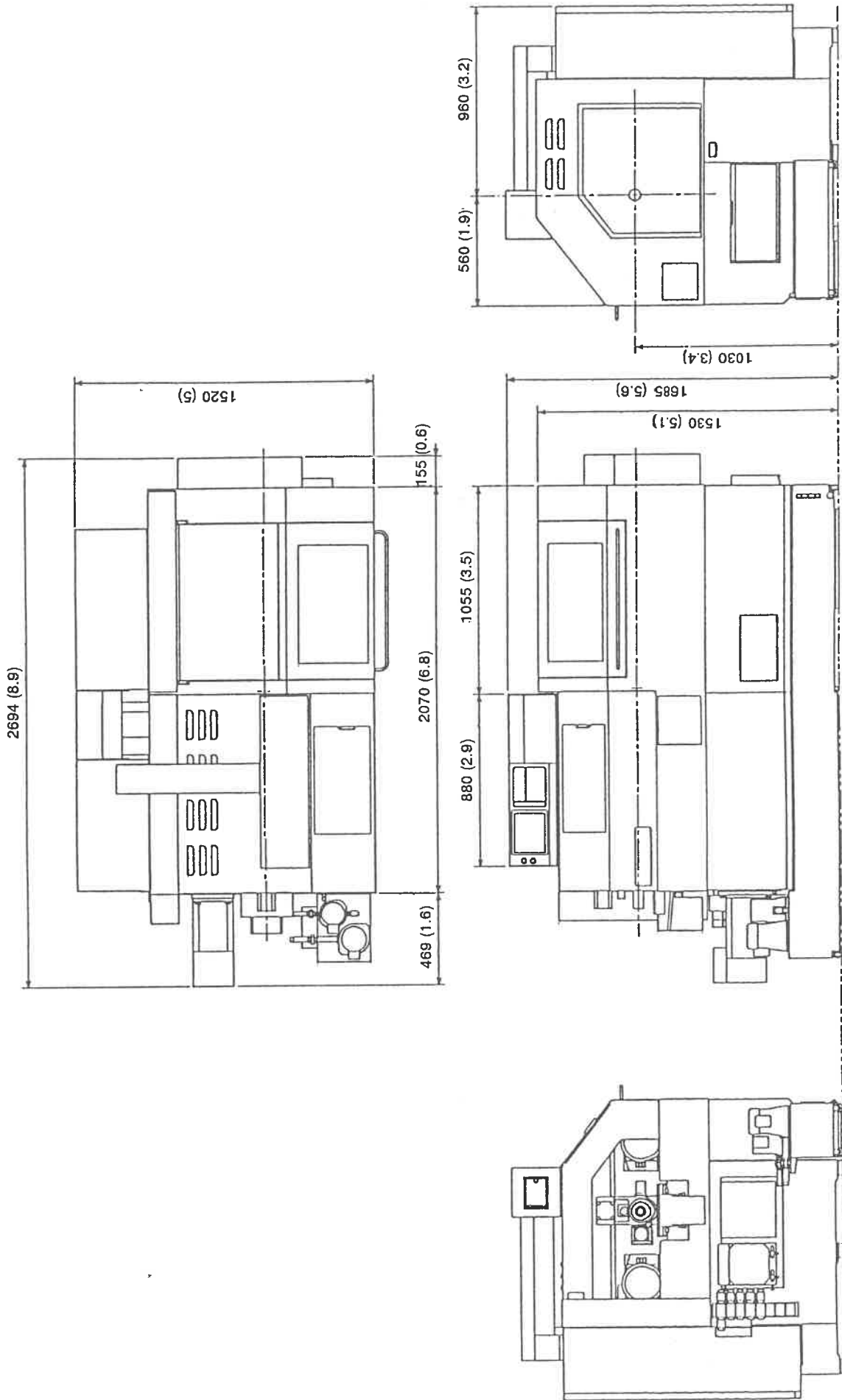
### ■ Machine configuration

Item	Specifications	Remarks	
Operation mode	Right-handed machine		
Machine configuration	Integrated mechanical•electrical structure		
Dimensions	Length × Width × Height	2070 × 1520 × 1685 (mm)	Except for leveling pads
	Center height	1000mm	Except for leveling pads
	Weight	Approximately 2,900kg	

### ■ Backworking attachment (Type B)

Item	Specifications	Remarks	
Pick-off capacity	Maximum chucking diameter	φ 25mm	
	Maximum pick-off workpiece length	155mm	For parts exceeding 155mm, use together with pipe ejection specification B (262•F)
	Maximum workpiece ejection length	62mm	Length from collet end surface
Machining capacity	Maximum drilling capacity	φ 10mm	
	Maximum tapping capacity (cutting)	M10 × P1.5	
Sub-spindle specifications	Spindle speed (rpm)	300-4500rpm	High-speed version 400-6000rpm
	Speed control	Direct 4-digit S command	
	Rotational control	Inverter control	
	Sub-spindle motor	2.2kw	
Collet chuck (standard/export)		Type KJR25 (=MR-25)	Schaublin type F30 Art. No. 63
3-spindle unit for backworking attachment	Number of tools	3 tools	
	Collet chuck	ER16	Max. φ 10mm
	Applicable drill sleeve	Part No. (736-21)	
	Applicable tap sleeve	Part No. (221-30)	

Diagram of external dimensions-1



Unit = mm (foot)