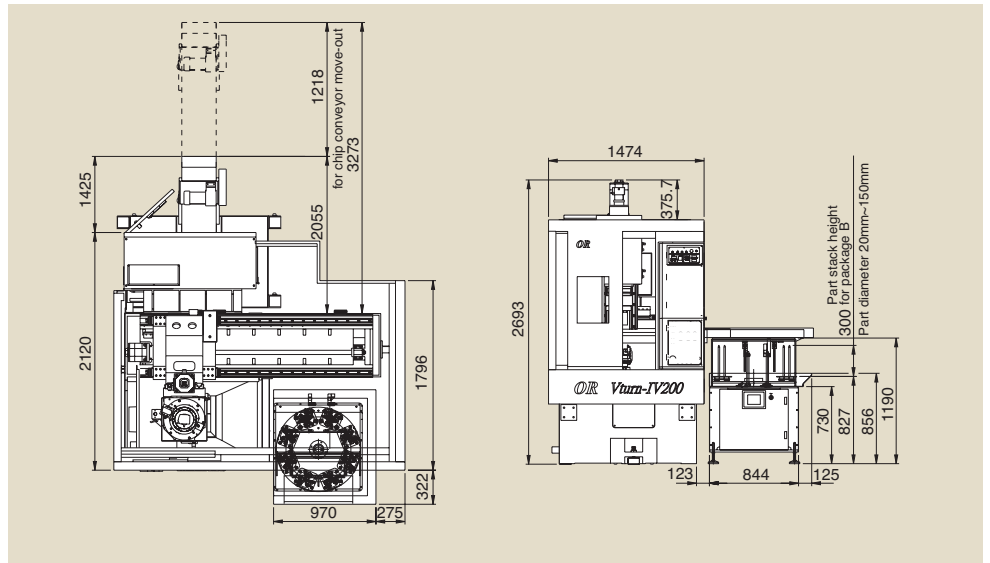


# MACHINE LAYOUT



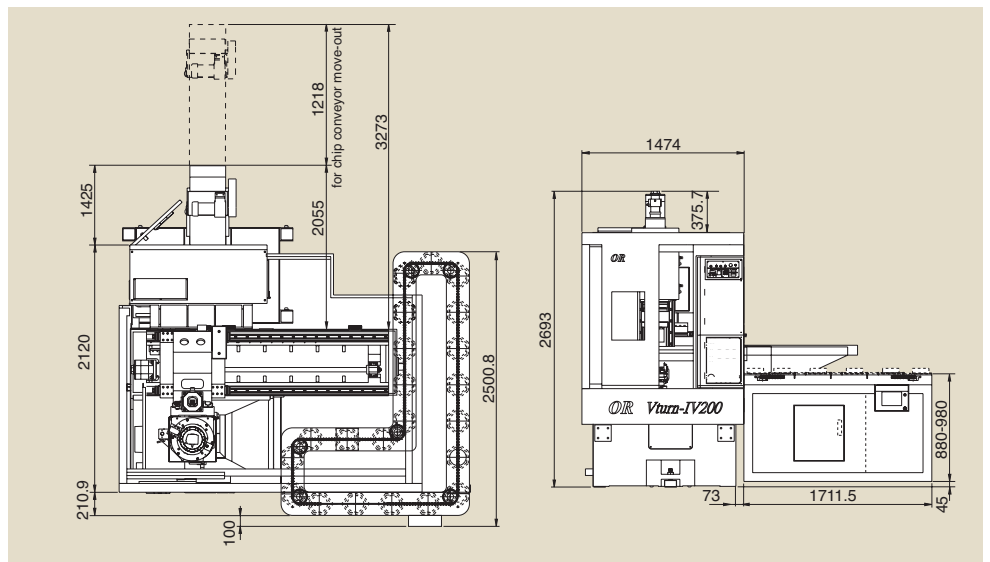
## Vturn-iV200/250 with work feeding package A or Package B :

No. of Pallets	8
Work diameter	ø150 mm
Work length	300 mm
Max. stack weight	50 kgs

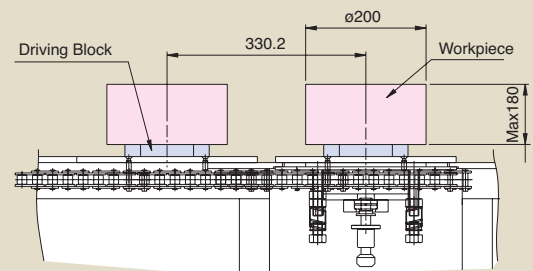
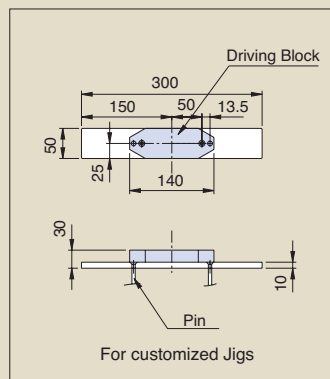


## Vturn-iV200/250 with work feeding package C

No. of Pallets	20
Work diameter	ø200 mm
Work length	180 mm
Max. weight	20 kgs



## Customized jig design



# CONTROLLER SPECIFICATION

Function		0i-T	21i-T
Control	Controlled axes	2 axes simultaneous control (one by manual)	
	Minimum output	X axis : 0.0005 mm, Z axis : 0.001 mm	
	Maximum input	0.001 mm	
	Fine acc/deceleration	Std.	
	HRV control	Std.	
Spindle	Spindle function	S4 digit	
	Constant surface speed	Direct designation of rpm with S code	
	Spindle override	50% ~ 120% (in 10% increment)	
	Override	0 ~ 150% (in 10% increment)	
Feed Tool	Manual pulse generator	0.001, 0.01, 0.1 mm/min	
	Manual continuous feed	0 ~ 1260 mm/min	
	Tool position offset	32 pairs	
	Tool nose radius compensation	G40 ~ G42	
	Tool geometry/wear offset	Std.	
	Tool function	T4 digit	
	Display of hardware & software configuration	Std.	
	Help function	Std.	
	Operator message history display	Std.	
Programming	Chamfering/corner R	Std.	
	Canned cycles	G90, G92, G94	
	Multiple repetitive cycle for turning	G70 ~ G76	
	Decimal point input	Std. as pocket calculator type	
	Background editing	Editing during automatic operation	
	Run hour display	Std.	
	Thread cutting	F code 0.0001 ~ 500,000 mm	
	Program code	Code 04 digits	
	M function	Code M2 digits	
	Inch / Metric conversion	G20, G21	
Tape	Tape memory and editing	640 m	1280 m
	Tape code	EIA RS-227 ISO 1154 (RJ-45)	
	Tape punching interface	RS232, 20 mA	
	Reader/punch interface	Automatic distinction of EIA / ISO code	
Miscellaneous	MDI/CRT	8.4" color	10.4" color
	Stored stroke limit	Std.	
	Dwell	Std.	
	Conversational programming	manual guide Oi	Manual guide i
	Automatic process specification	Std.	
	Direct input of drawing dimensions	Std.	

# MACHINE SPECIFICATION



Item/Model			Vturn-iV200	Vturn-iV250
Capacity	Swing over bed	mm	410	
	Max. turning dia.	mm	350	
	Std. turning dia.	mm	210	
	Max. turning length.	mm	380(O.D.), 160(I.D.)	
Travels	X axis stroke	mm	1320	
	Z axis stroke	mm	380	
Spindle	Max. spindle speed	mm	5000	4000
	Spindle nose	mm	A2-6	
	Spindle bore	mm	62	
	Inner bearing	mm	100	
	Chuck diameter	mm	210 (8")	254 (10")
Turret	No. of tools	no.	12	
	Tool shank size	mm	20	25
	Max. boring bar dia.	mm	32	40
	Tool exchange time	sec	0.2 (servo driven)	
Feedrate	Rapid feedrate	m/min	X/Z = 30/30	
	Cutting feedrate	mm/min	X/Z=0~1260	
Motor	Spindle motor	kW	7.5/11	11/15
	X/Z axis servo motor	kW	X:3.0, Z:4.0	
Controller	FANUC		0i-T	
Work feeder	Diameter x length	mm	ø150 x 300 (8 pallets)	
Machine	Power requirement	kVA	33	
	Machine dimension	mm	2850 x 3450	
	Machine height	mm	2650	
	Net weight	kg	7000	

## Standard accessories

- 3 sets of soft jaws
- Air blow system
- Chuck confirmation
- Tool holders
- 3 step warning light
- Chip conveyor with cart
- Leveling blocks
- Fanuc 0i-T control
- Work feeding package A
- Air conditioner for electrical cabinet

## Optional accessories

- Manual tool presetter
- Turn-over station
- Auto door
- VDI turret
- Higher power spindle 11/15 kW (for VT-iV200)
- Higher pressure coolant
- Coolant through spindle
- C-axis and VDI turret
- Fanuc 21i / 18i control
- Work feeding package B
- Work feeding package C
- Customized work feeding system
- Air seal detecting system (Part drawing is required for fitting)

