



Flat-Bed CNC Turning Center



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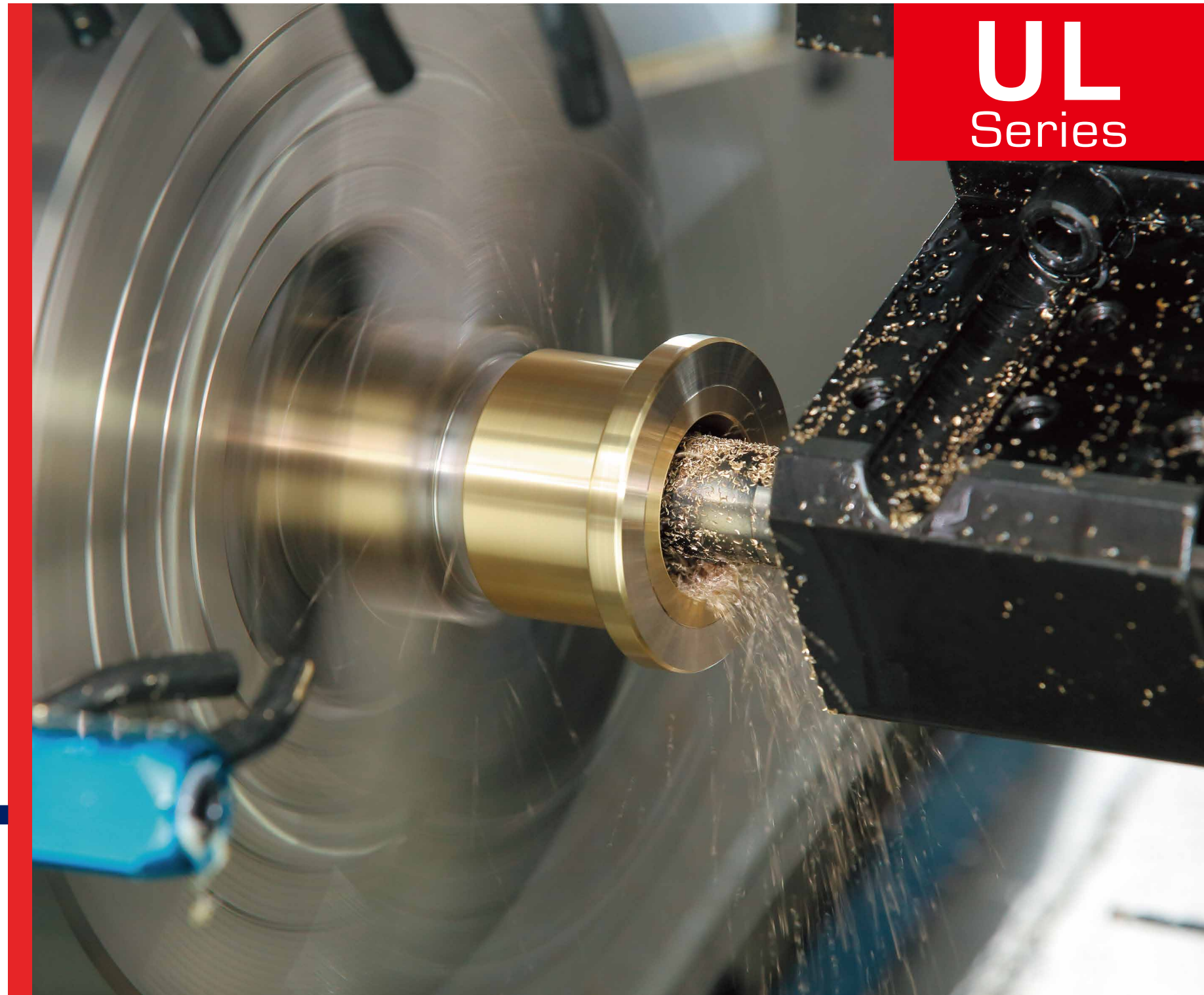
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UL
Series

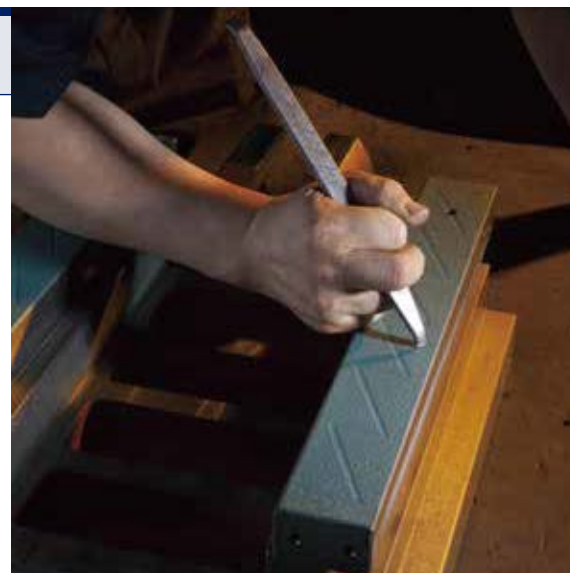


Optimized Mechanical Structure Design

Delicate Scraping Work

Gibs and sliding surfaces coated with Turcite-B are hand-scraped to create oil pockets and grooves for precise motion and durability of machine.

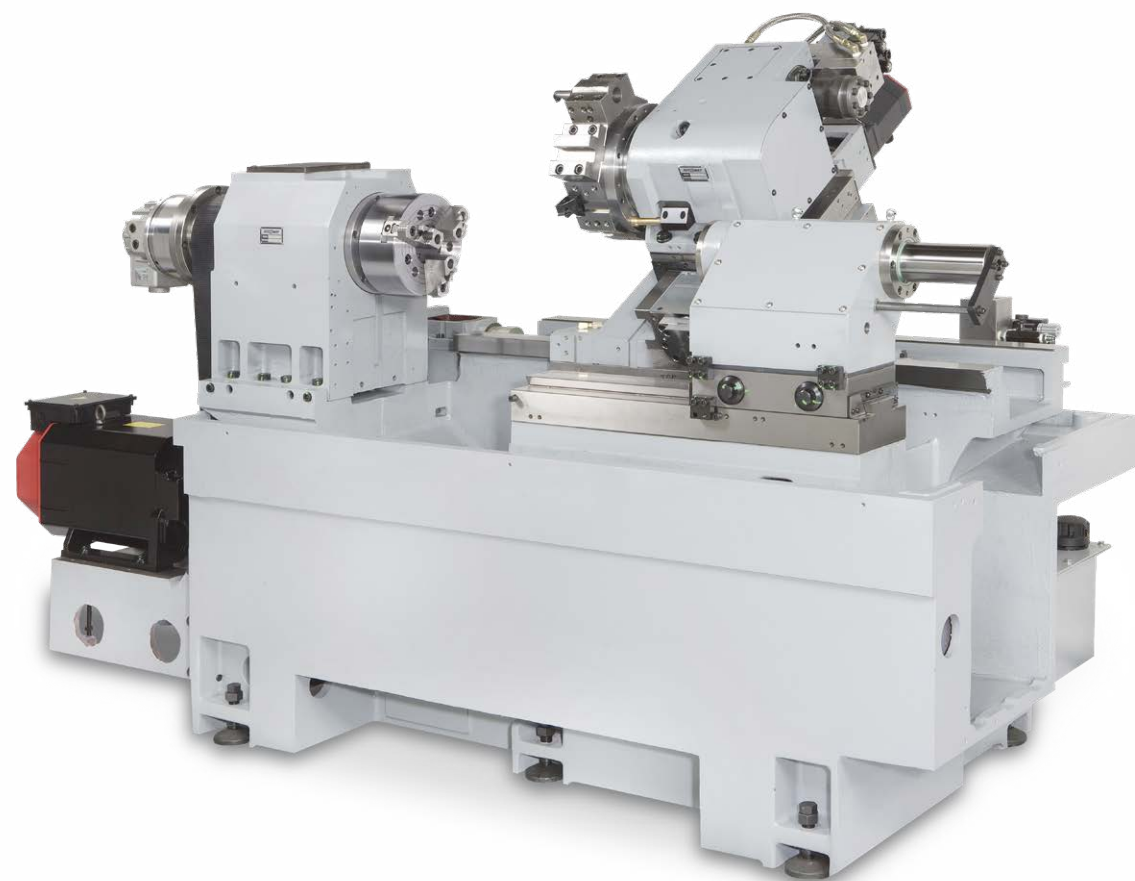
Skilled craftsmen perform continuous surface trimming to adjust flatness, squareness and straightness to satisfy accuracy requirements.



Rigid Casting Structure

One-piece flatbed base coupled with 30° slant saddle, made of high tensile strength MEEHANITE casting, heat treated and ground to reach hardness in HRC 53. All sliding surfaces are coated with Turcite B to maintain feeding and positioning accuracy plus long service life. Chip flushing function is excellent for this structure.

Large span of high-rigidity box way design, along with high damping coefficient, allows heavy or discontinuous cutting of carbon steel, stainless steel, and aluminum casting without inducing chatter.

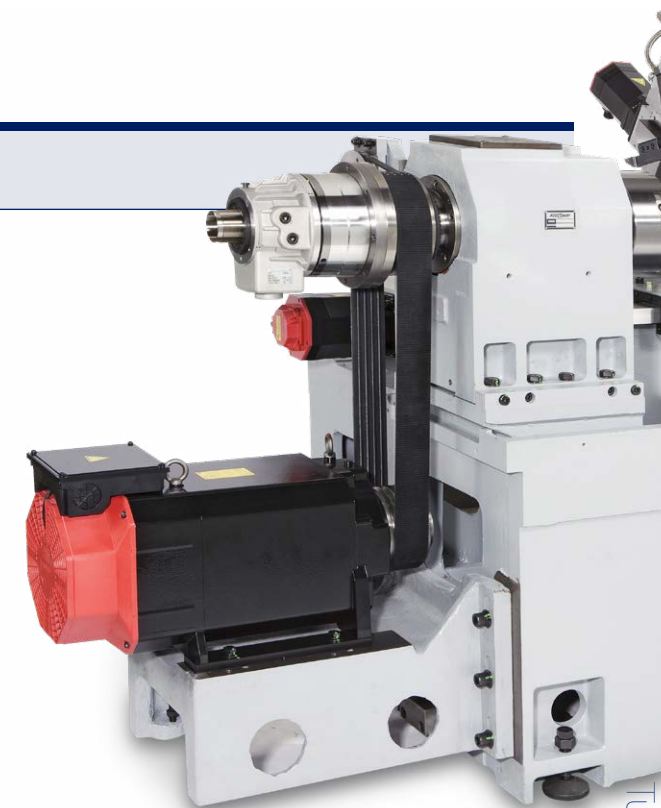
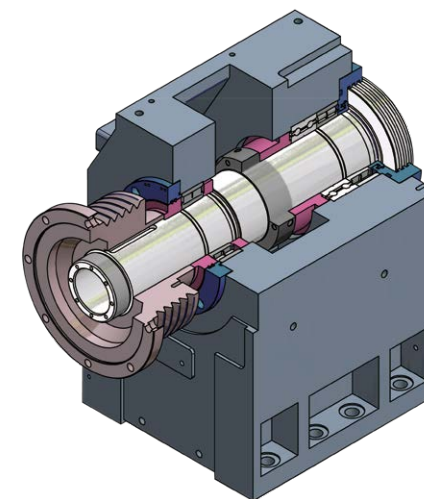


Powerful High-rigidity, Top-accuracy Spindle System

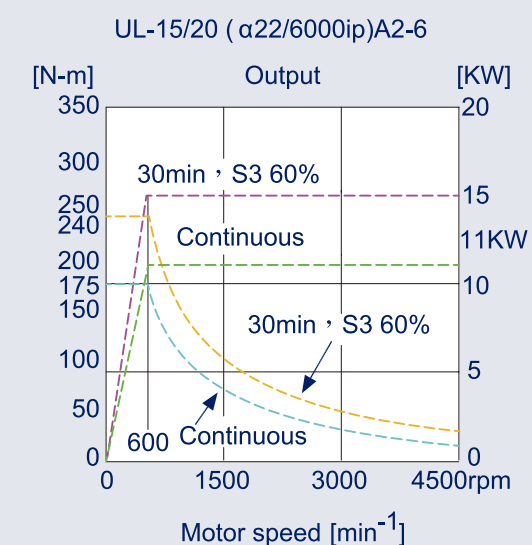
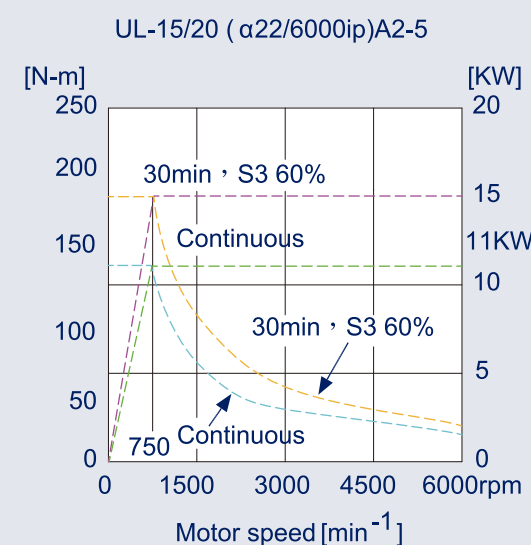
Spindle System

Symmetrical reinforced headstock structure design balances thermal displacement and reduces spindle errors. Annealed, and naturally seasoned to diminish residual stress for stable material quality and assure long-term machining accuracy.

High-performance, wide-range spindle motor powered by 20 hp offers full-scale power output at speed range of 750-6000 rpm. In addition, 240 N-m peak torque makes it become the most powerful and competitive lathe at this level.



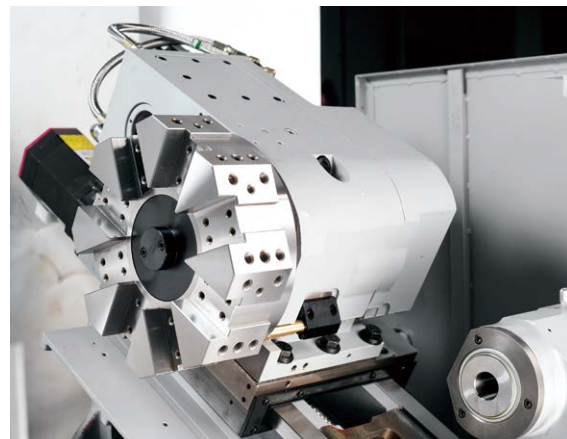
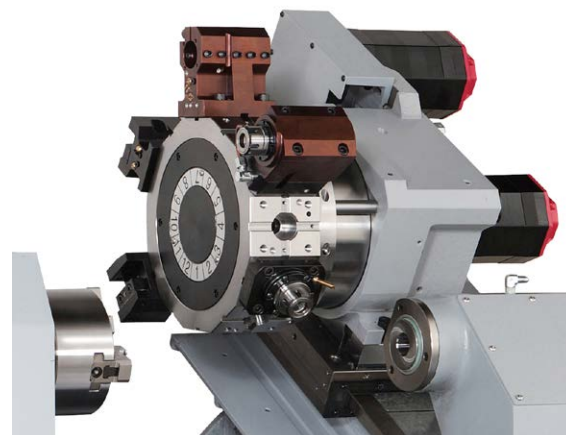
Spindle Motor Torque Chart



Precise Transmission & Position Control

High-accuracy Turret

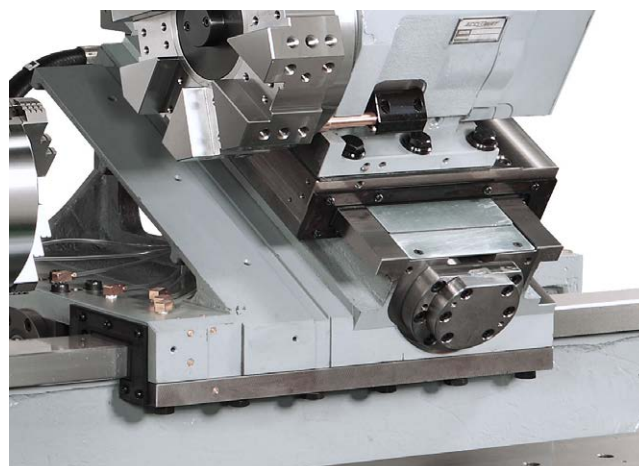
Large-size precision curve coupling combined with roller-cam mechanism and hydraulic actuator provide accurate positioning for indexing. Fast bi-directional index selects tools at 0.3 seconds for adjacent tool, and 1.5 seconds for opposite tool.



High Performance X/Z Axis Box Slideways

Pre-loaded double-nut ballscrews features high rigidity, and alleviate backlash significantly.

Square box slideways on X/Z axes have high stiffness, large contact areas and excellent damping effects. They are the best design to sustain heavy duty as well as segmented cuttings.



FANUC 0i-T controller

FANUC 0i-T controller with color LCD monitor, integrated with one-piece control panel, provides the most comfortable and convenient man-machine interface.



Optional Accessories

Automatic Door

Automatic door opens after the end of machining cycle. This function saves time and increases more efficiency.



Tool Setter

To eliminate downtime for tool inspection and compensation, tool setter measures and offsets tool wear to maintain 5 μ m repeatability accuracy.



Parts Catcher

Upon completion of turning cycle, receives workpiece automatically, then conveys it to collection box, and saves more time if fitted with bar-feeder and parts conveyor.

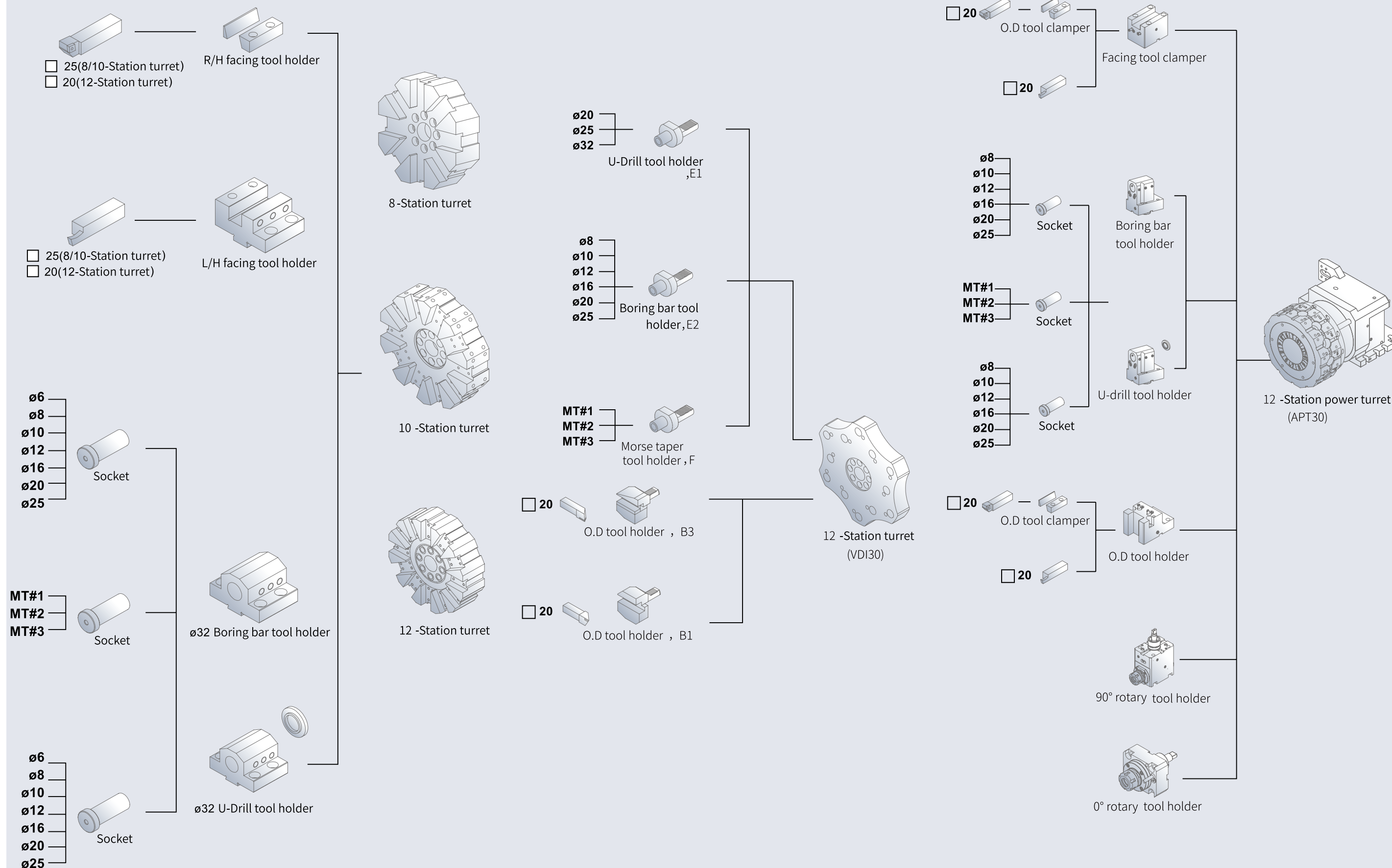


Auto loading and unloading mechanism

Applicable for single machine or multi-machines operation with completed process cycle. Saving operation time will be satisfied requirements with automation and cost reduction.

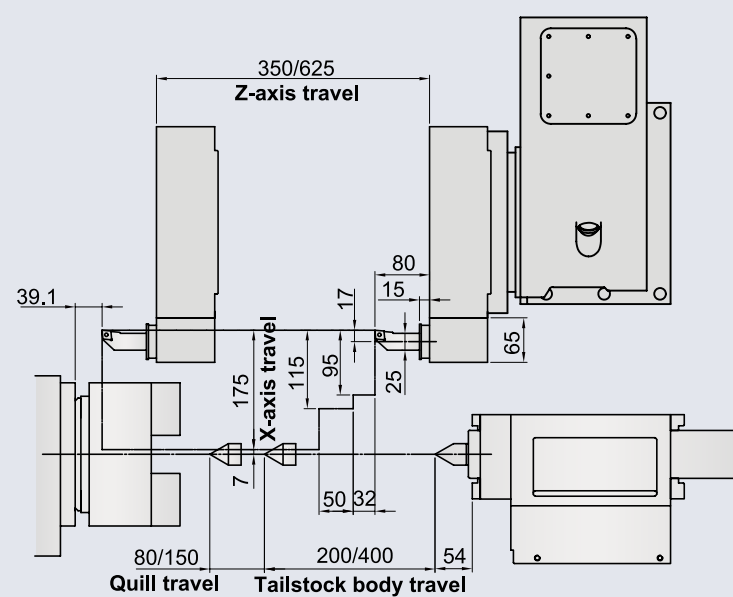
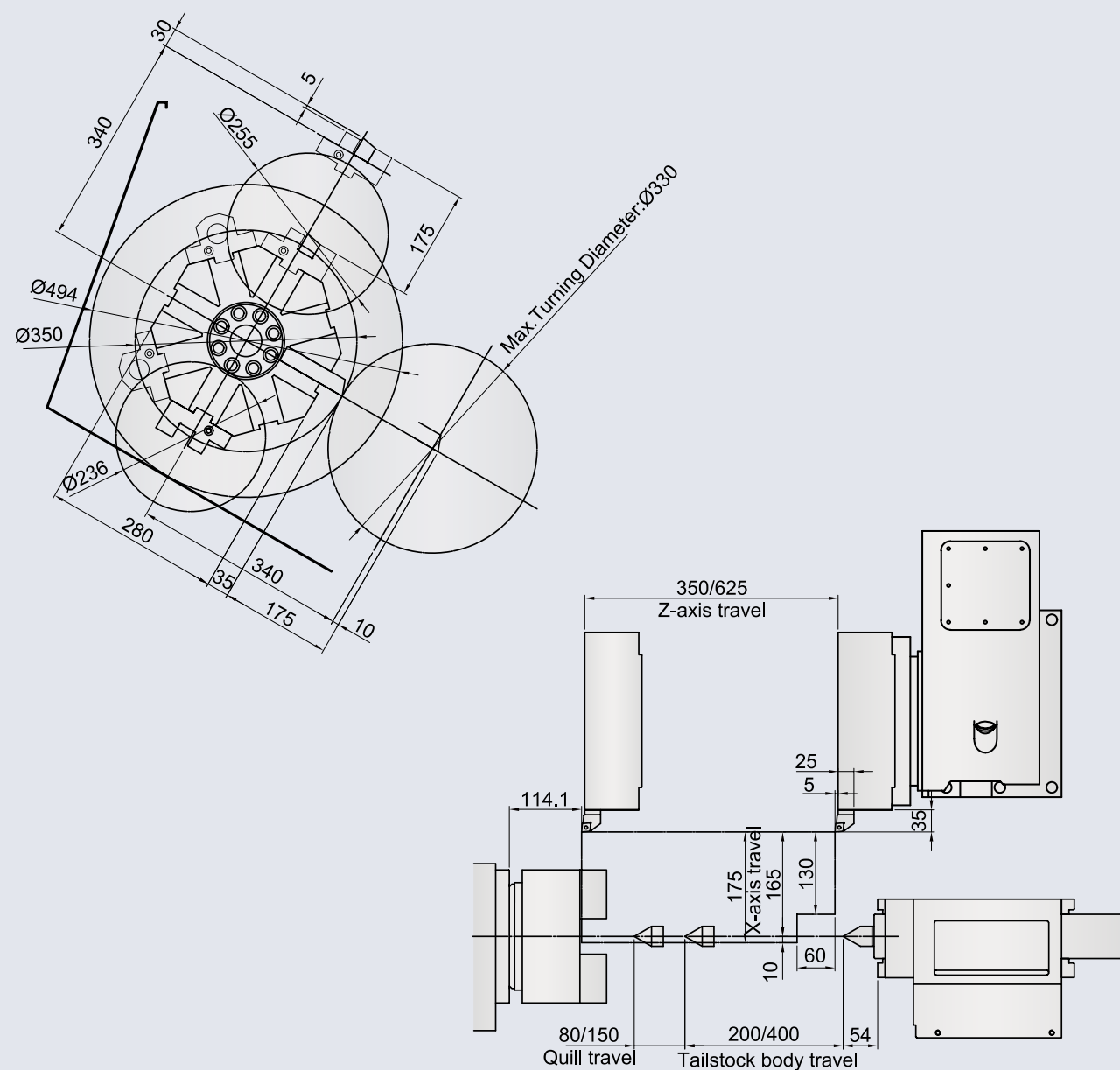


Tooling Diagram



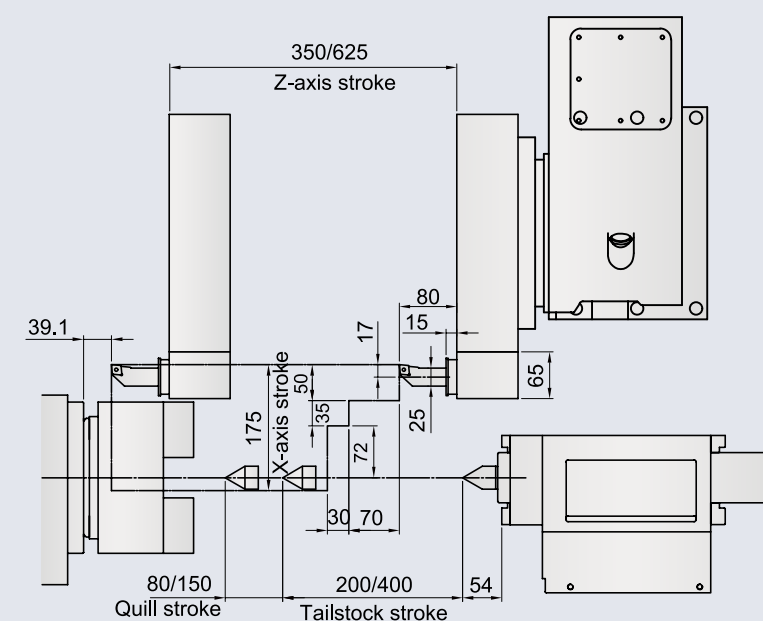
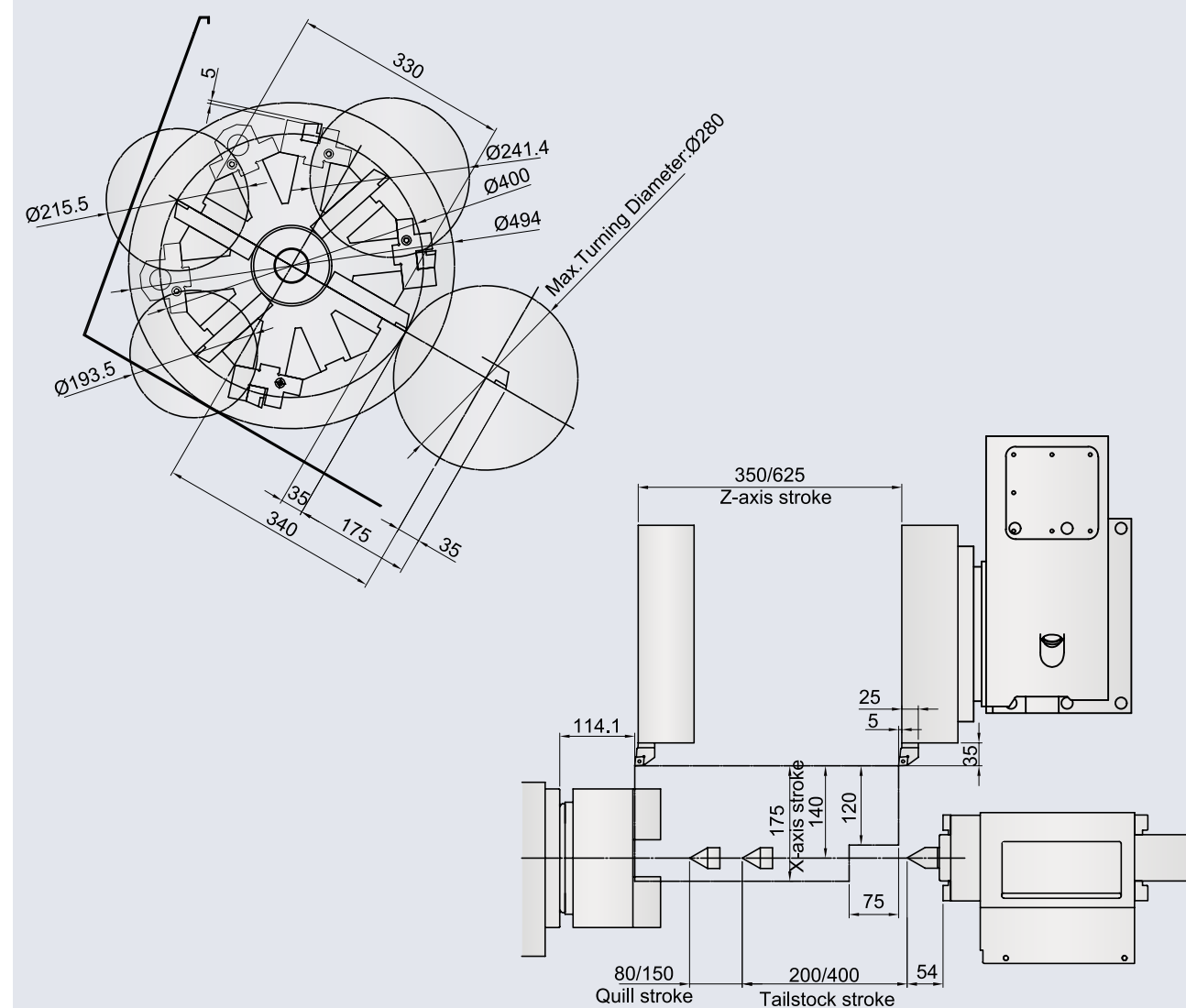
Working Range Diagram

8-station turret



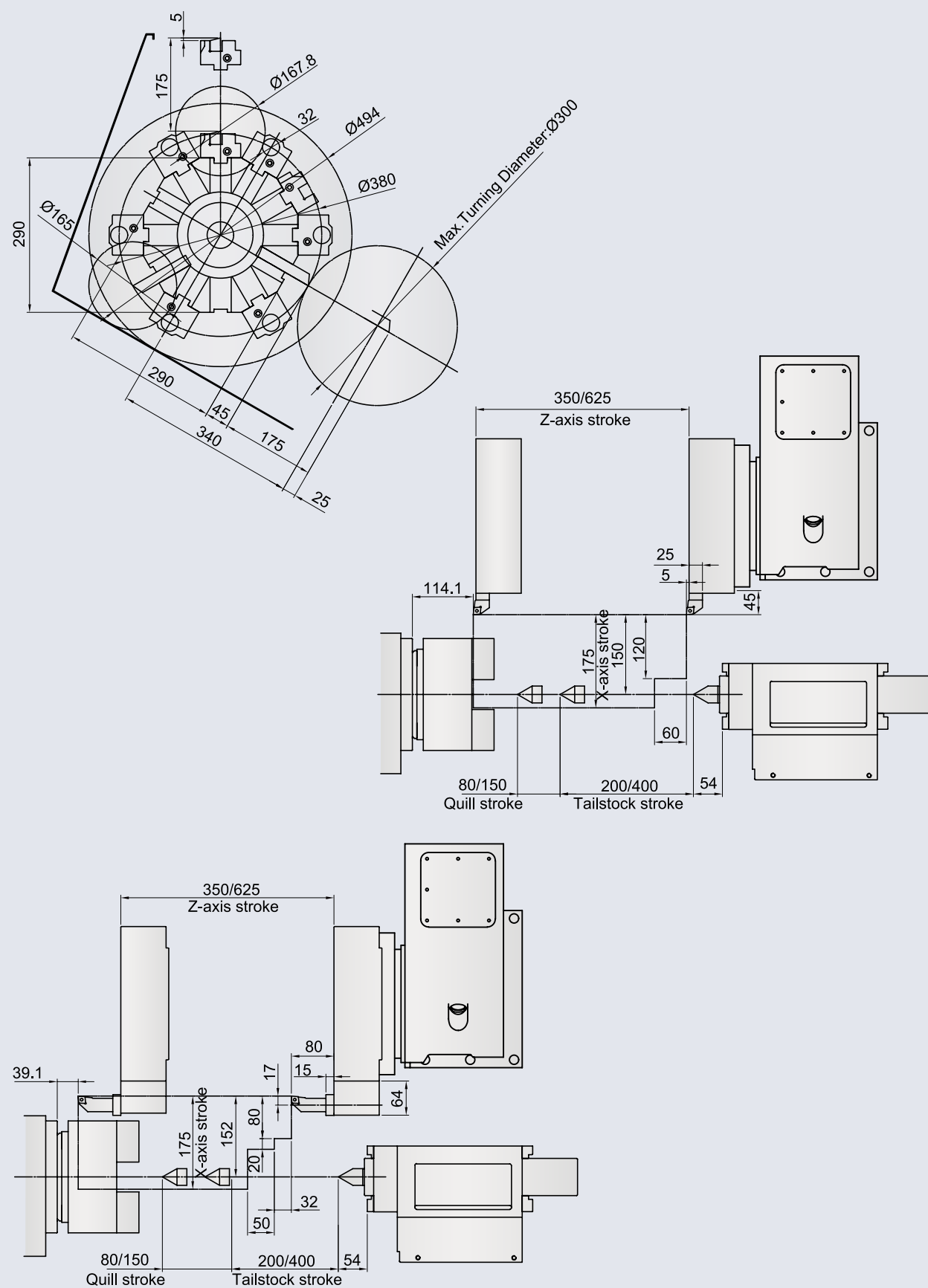
Working Range Diagram

10-station turret



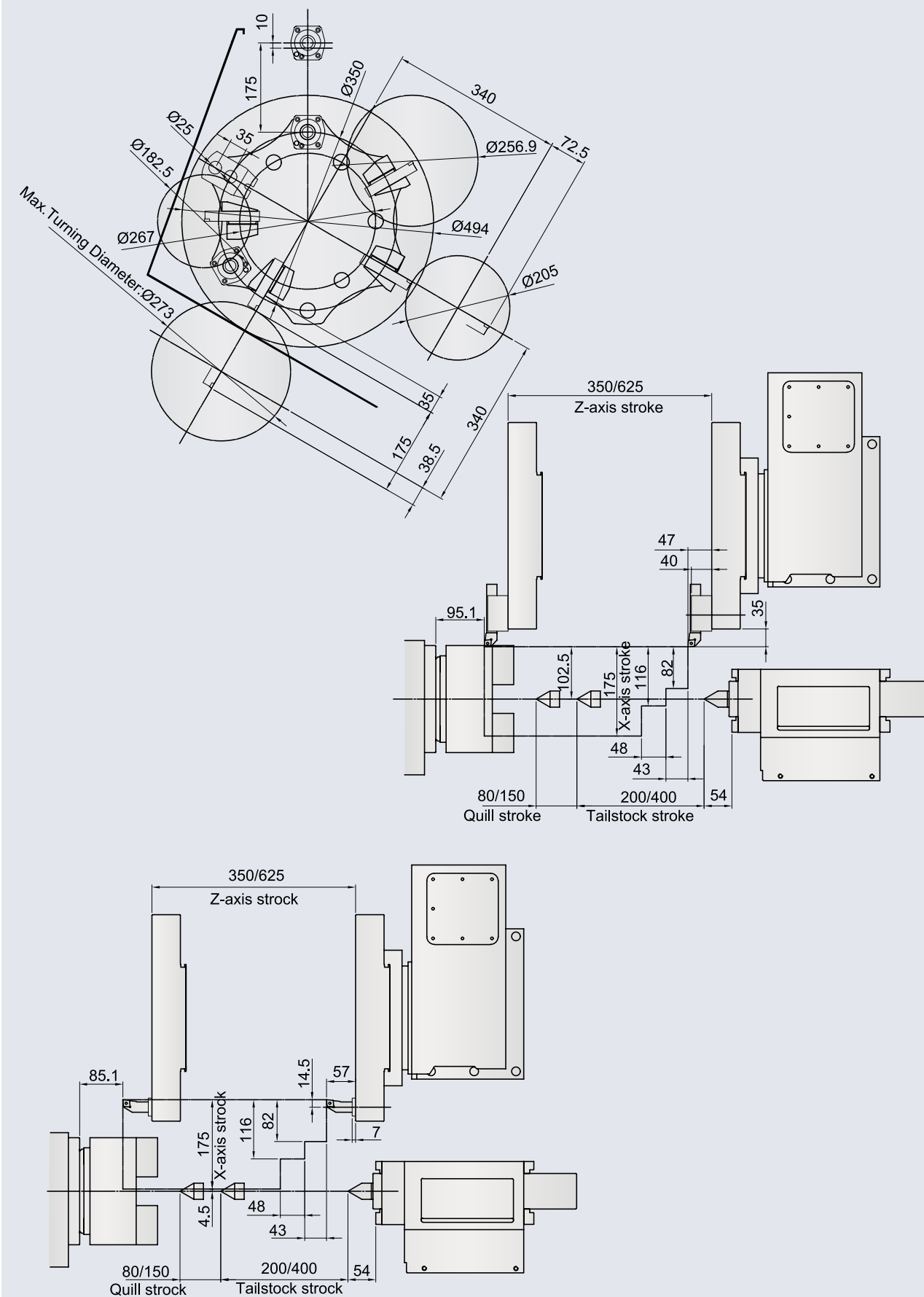
Working Range Diagram

12-station turret



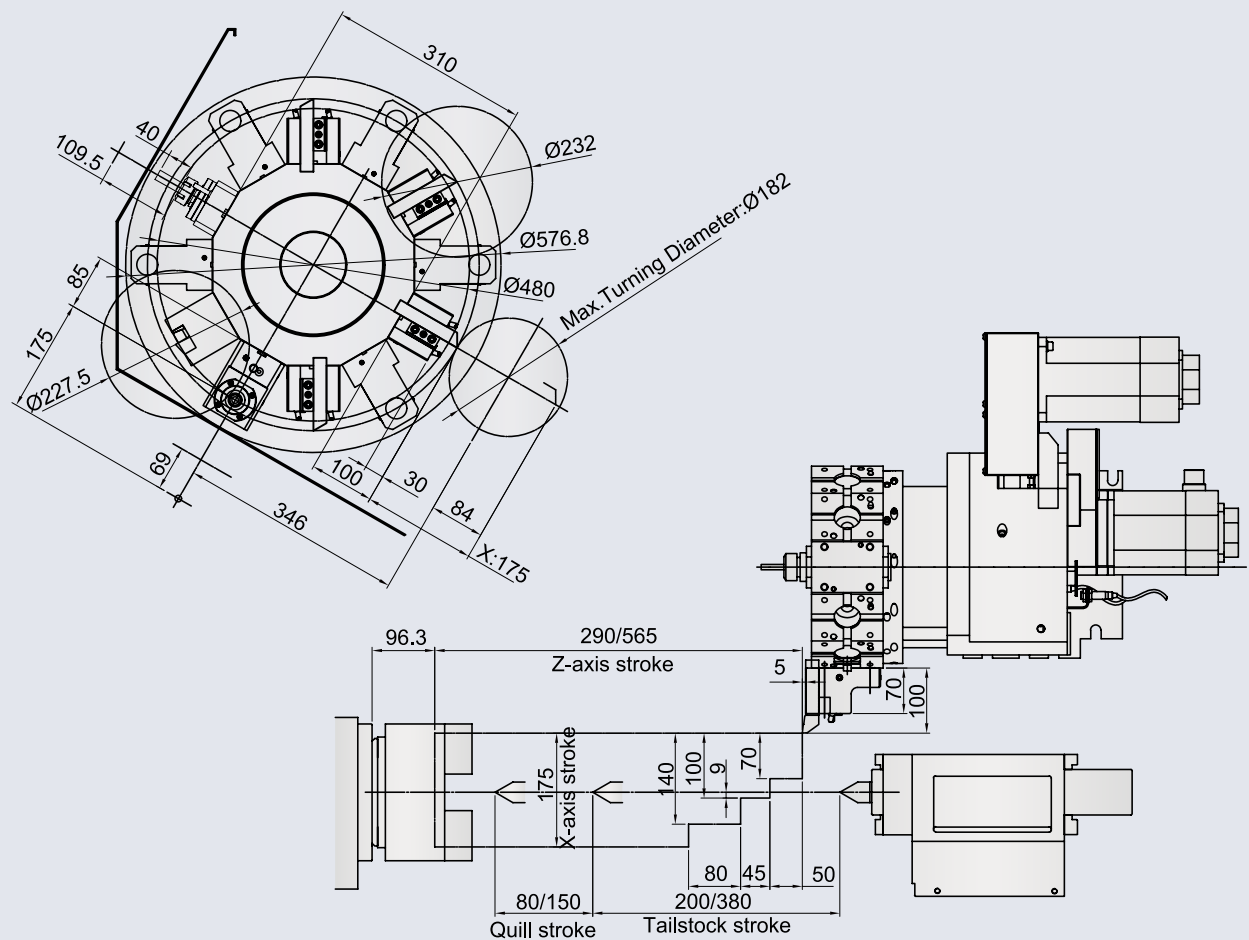
Working Range Diagram

12-station VDI 30 turret

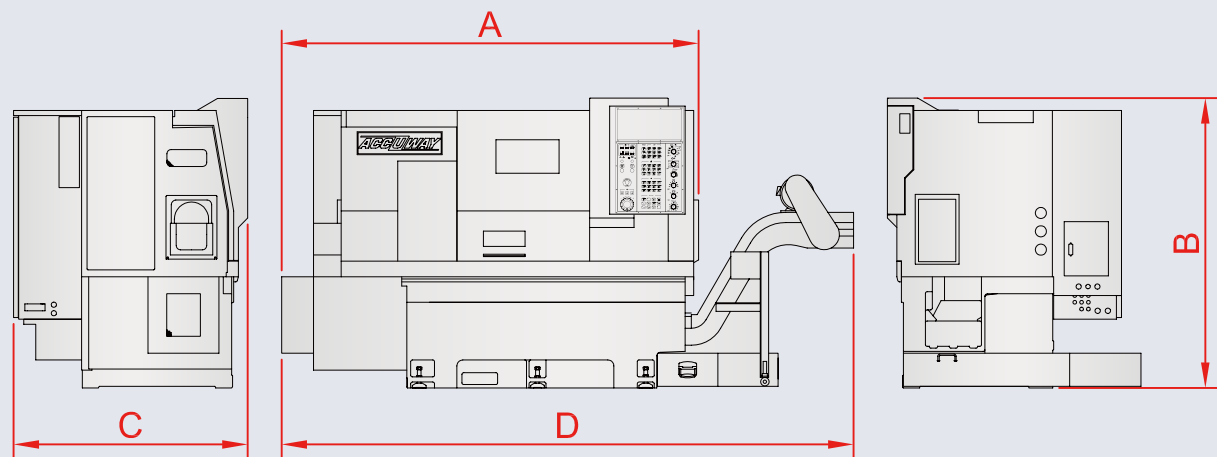


Working Range Diagram

12-station APT 30 power turret



Machine Dimensions



Model	A	B	C	D
UL-15	2250	1700	1500	3100
UL-15M	2350	1750	1500	3100
UL-20	2450	1700	1500	3400
UL-20M	2600	1750	1500	3400

Specifications

ITEM/MODEL		UL-15	UL-15M	UL-20	UL-20M
Controller		FANUC 0i-T			
CAPACITY					
Swing over bed	mm	455			
Swing over saddle	mm	260			
Max. turning diameter	mm	280	180	280	180
Max. turning length	mm	300	210	600	500
Guide way type		Box Way			
SPINDLE					
Spindle nose taper	ASA	A2-6 (A2-5)			
Chuck diameter	inch	8 (6)			
Bar capacity	mm	52/65 (44)			
Spindle speed	rpm	4500/4000 (6000)			
Spindle motor power (Cont. / 30min)	kW	11/15			
TRAVELS					
X-axis travel	mm	175			
Z-axis travel	mm	350		625	
Y-axis travel	mm	-			
FEED RATES					
X-axis Rapid Traverse Rate	m/min	20			
Z-axis Rapid Traverse Rate	m/min	20			
Y-axis Rapid Traverse Rate	m/min	-			
TURRET					
Tooling system		BOT	-	BOT	-
Turret driven type		Hydraulic/Servo	Servo mechanical	Hydraulic/Servo	Servo mechanical
Number of tools	station	10/12 (8)	12	10/12 (8)	12
Square tool shank size	mm	25/20 (25)	20	25/20 (25)	20
Round tool shank size	mm	32			
Max. Rotary Tool Speed	rpm	-	6000	-	6000
Rotary Tool power	kW	-	4.5	-	4.5
TAILSTOCK					
Tailstock body travel	mm	200		400	
Quill travel	mm	80		150	
Quill diameter	mm	70			
Quill taper	MT#	4			
DIMENSION					
Machine dimension L x W x H	m	2.2 x 1.5 x 1.7	2.4 x 1.5 x 1.75	2.5 x 1.5 x 1.7	2.7 x 1.5 x 1.75
Net weight	kg	2850	3000	3350	3500

■ Specifications are subject to change without prior notice.