

OKK

VM5Ⅲ Based Compact Blade Machining Center



5-axis Controlled Vertical Machining Center

VM-X5/250B

- VM5Ⅲ base box-way construction X, Y & Z axis delivers rigidity and excellent vibration dampening.
- B axis Spindle head is driven by a roller gear producing zero backlash, agile response and tight accuracy.
- A axis direct drive rotary table also outputs zero backlash, agile response and tight accuracy. Optional dual drive synchronized rotaries eliminates work piece twisting.
- Ideal for machining of medium to small Turbine Blades. Finishing complicated undercut root work pieces in one holding is accomplished with the high swivel B axis.



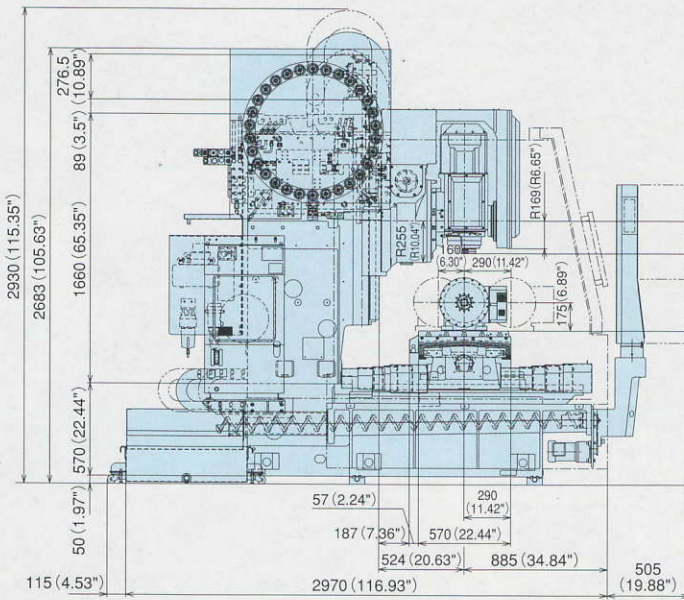
Main Specification (The specification here is for a prototype)

Item	Unit	Specification
Travel on X-axis(Table right/left)	mm	620 (24.41")
Travel on Y-axis(Saddle forth/back)	mm	320 (12.60") +130/set up stroke (5.12")
Travel on Z-axis(Spindle head up/down)	mm	510 (20.08")
Travel on A-axis(Table turning)	deg	360
Travel on B-axis(Spindle head swivelling)	deg	+90~ -90
Distance from table top surface to spindle nose	mm	220 (8.66") ~730 (28.74")
Distance from column front to spindle center	mm	524 (20.63")
Spindle speed	min ⁻¹	100~12,000
Number of spindle change step		Stepless
Spindle nose		DIN69893 HSK-A63
Spindle bearing bore diameter	mm	φ70 (dia.2.76")
Rapid traverse rate	m/min	X/Y:30 (1181ipm) Z:20 (787ipm)
	min ⁻¹	A:100 B:30
Cutting feed rate	mm/min	X/Y/Z:1~20,000 (0.04~787ipm) ※1
	min ⁻¹	A:100 B:15

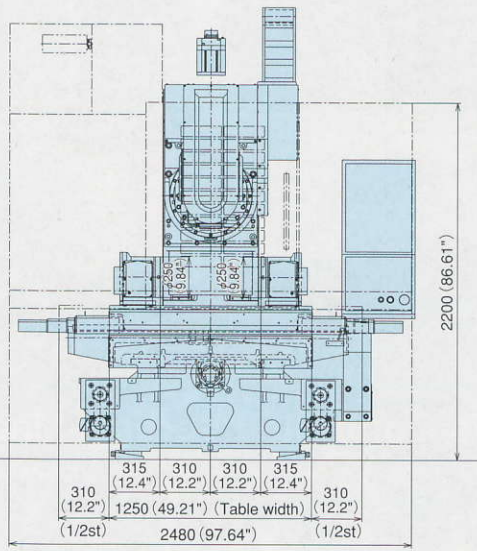
Item	Unit	Specification
Tool shank		DIN69893 HSK-A63
Number of stored tools	tools	30
Maximum tool diameter (with adjacent tools)	mm	φ80 (dia.3.15")
Maximum tool diameter (without adjacent tools)	mm	φ110 (dia.4.33")
Maximum tool length (from the gauge line)	mm	280 (11.02")
Maximum tool weight (Moment)	kg(N·m)	10 (9.8N·m) / 22lbs (7ft·lbs)
Tool selection method		Address fixing method
Spindle motor	kW	7.5 (10HP) / 5.5 (7HP)
Power supply	KVA	38
Controller type		Neomatic 750VW
Machine height from the floor surface	mm	2,930 (115.35")
Floor space required for operation (width×depth)	mm	2,480 (97.64")×2,970 (116.93")
Floor space with maintenance area (width×depth)	mm	2,980 (117.32")×4,002 (157.56")
Machine weight	kg	7,500 (16534lbs)

※1 for HQ and HyperHQ control

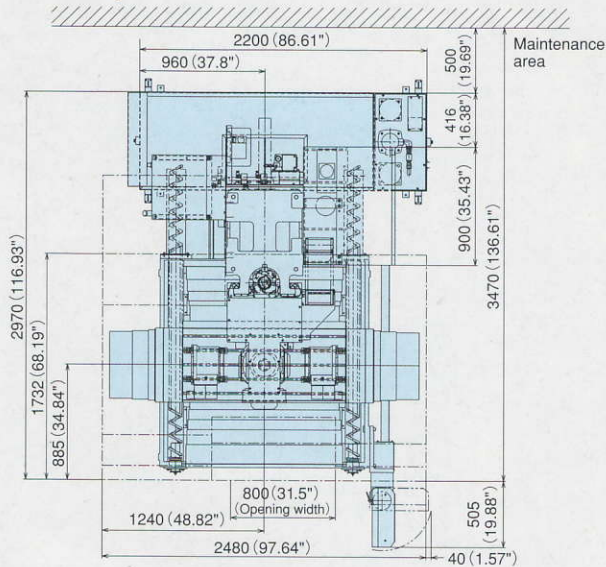
Front view



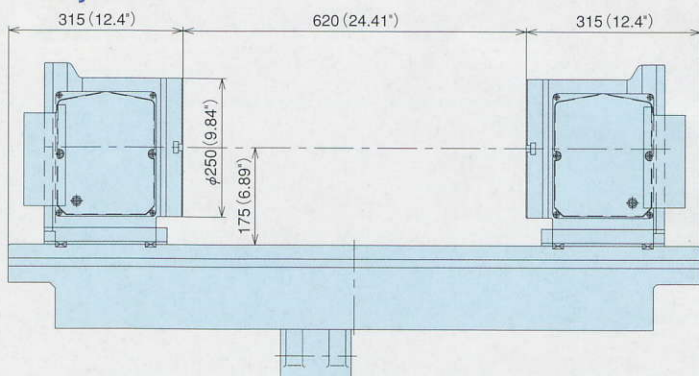
Side view



Floor space



Rotary table



When two Rotary tables are used

- Maximum workpiece length : 600 [mm] (23.62")
- Maximum workpiece diameter : φ250 [mm] (dia. 9.84")
- Maximum workpiece weight : 200 [kg] (441lbs)

(Workpiece both end must be fixed with Rotary table)
(*for a Rotary table 100 [kg] (221lbs))



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