

VC-608/610/711

Vertical Machining Center for High Speed Contouring



Tongtai Tongtai Machine & Tool Co., Ltd.

Headquarters

No.3, Luke 3rd Rd., Luzhu Dist., Kaohsiung City 82151, Taiwan
 TEL : 886-7-9761588 FAX : 886-7-9761589
 www.tongtai.com.tw

Taoyuan Branch	TEL : 886-3-4551399	FAX : 886-3-4559730
Taichung Branch	TEL : 886-4-23589600	FAX : 886-4-23589993
Japan Branch	TEL : 81-4-71438355	FAX : 81-4-71438360
Europe Branch	TEL : 31-161-454639	FAX : 31-161-454768
Romania Branch	TEL : 40-264-415273	FAX : 40-264-403983
Malaysia Branch	TEL : 603-78597113	FAX : 603-78597115
Vietnam Branch	TEL : 84-4-62766090	
Thailand Branch	TEL : 66-2-7443440	FAX : 66-2-3986518
Indonesia Office	TEL : 62-21-45850875	FAX : 62-21-45850876

China Operation Center

Shuzhou Tong-yu Machine & Tool Co., Ltd.

No.555 Huahong Rd., Economic Development Zone of Wujiang,
 Suzhou City, Jiangsu Province, China
 TEL : 86-512-63430168
 FAX : 86-512-63431622
 E-mail : sales@tong-yu.com.cn

Wuhan Branch	TEL : 86-27-59409109	FAX : 86-27-59409110
Chongqing Branch	TEL : 86-23-67865925	FAX : 86-23-67867717
Guandong Branch	TEL : 86-755-27222119	FAX : 86-755-27222115
Tianjin Branch	TEL : 86-22-24417640	FAX : 86-22-24416738
Shanghai Office	TEL : 86-21-24208138	FAX : 86-21-34073262
Shenyang Office	TEL : 86-24-24142968	FAX : 86-24-24115782

Affiliates

Honor Seiki Co., Ltd.	Asia Pacific Elite Corp.	Quick-Tech Machinery Co., Ltd	PCI-SCEMM - rue Copernic	ANGER Machining GmbH
TEL : 886-7-9759888	TEL : 886-4-23589313	TEL : 886-6-3841155	TEL : 33-4-77426161	TEL : 43-7229-71041-0
FAX : 886-7-9759999	FAX : 886-4-2358913	FAX : 886-6-3841177	FAX : 33-4-77426023	FAX : 43-7229-71041-199
www.honorseiki.com.tw	www.apecnc.com	www.quicktech.com.tw	www.pci.fr	www.anger-machining.com



VC-608/610/711



High rigidity structure

- Wide span column with the best force flow route ensures the machine rigidity.
- Through finite element analysis (FEA), the static, modal and optimization analyses of structure were processed for ensuring high dynamic rigidity and stability.

Various spindles are available

- For ensuring the motor's performance, direct-drive spindle with 12,000 rpm is equipped as standard (15,000 rpm is optional).

Tongtai self-made built-in spindle (optional)

- Maximum spindle speed 20,000rpm, which allows the machine to expand the range of machining applications.
- Oil-air lubricated bearings and the floating sleeve on rear-end bearing are able to reduce thermal generation and avoid thermal expansion that affects machining accuracy and bearing life.

Main Specifications

Spindle	12,000 rpm Direct-drive spindle (standard) 15,000 rpm Direct-drive spindle (optional) 20,000 rpm Built-in spindle (optional) Rapid traverse 24 m/min
Three axes	X/Y/Z axis stroke VC-608 850/610/530 mm VC-610 1,050/610/530 mm VC-711 1,100/710/710 mm <input type="checkbox"/> 45 mm high rigidity roller guideways X/Y axis Ø40 mm Z axis Ø45 mm (VC-608/610) / Ø50 mm (VC-711) High precision ballscrews with the pitch 10 mm on Z axis
ATC	Tool capacity 24 pc (optional : 30 pc)



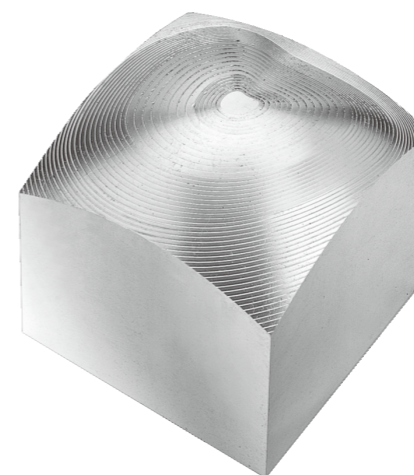
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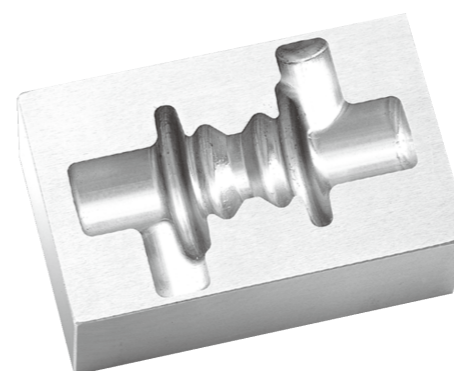
High accuracy



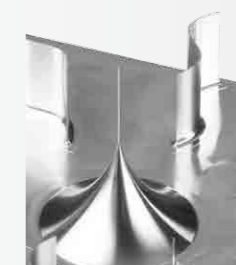
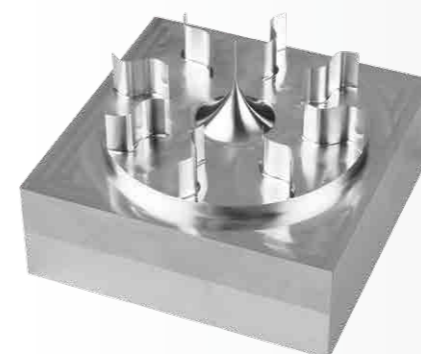
Machining examples



Car lamp mold	
Materials	NAK80 (HRC 40°)
Size	120×120×80 mm
Tools	R 0.2 mm
Spindle speed	20,000 rpm
Cutting feedrate	1,000 mm/min
Machining time	9.8 hr



Crankshaft mold	
Materials	SKD11 (HRC 60°)
Size	80×50×30 mm
Tools	R1.5 mm
Spindle speed	13,000 rpm
Cutting feedrate	2,200 mm/min
Machining time	70 min



Thin wall machining	
Materials	A6061
Size	100×100×70 mm
Tools	R1.0 mm
Spindle speed	10,000 rpm
Cutting feedrate	1,000 mm/min

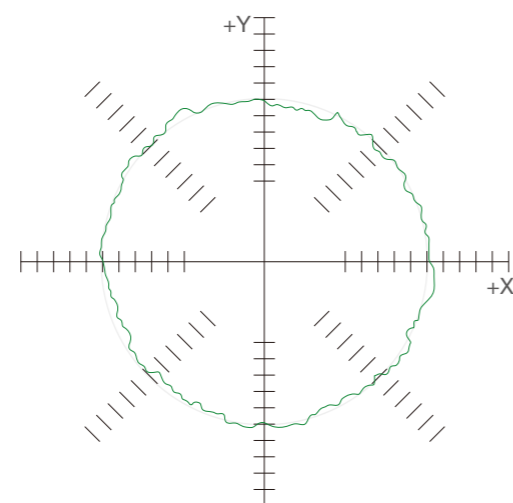
Three axes accuracy

Test standard : VDI3441

	Positioning accuracy	Repeatability accuracy
X axis	4.59	3.79
Y axis	3.42	2.64
Z axis	4.78	3.76

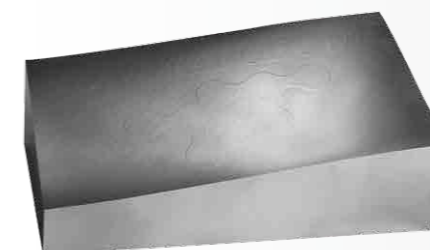
Unit : μm

X-Y Ball-bar test

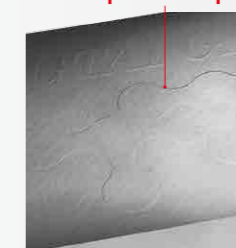


F : 1,000 mm/min
R : 150 mm
Circularity : 3.2 μm

Scale: 2 $\mu\text{m}/\text{div.}$



Depth : 2 μm



Micromachining	
Materials	A6061
Size	150×80×70
Tools	R1.0 mm
Spindle speed	14,000 rpm
Cutting feedrate	1,000 mm/min

Basic structure

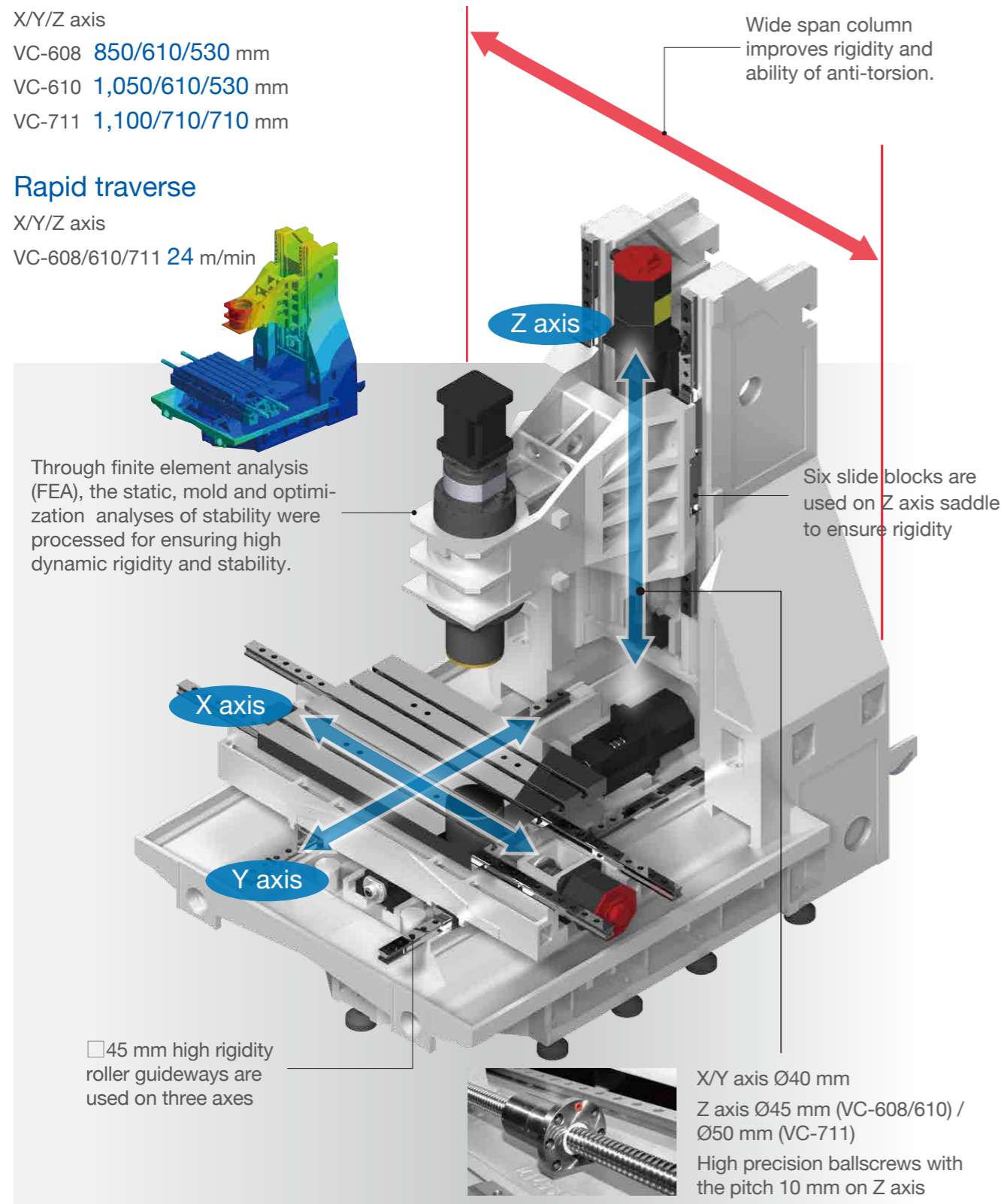
High rigidity structure

Stroke

X/Y/Z axis
 VC-608 850/610/530 mm
 VC-610 1,050/610/530 mm
 VC-711 1,100/710/710 mm

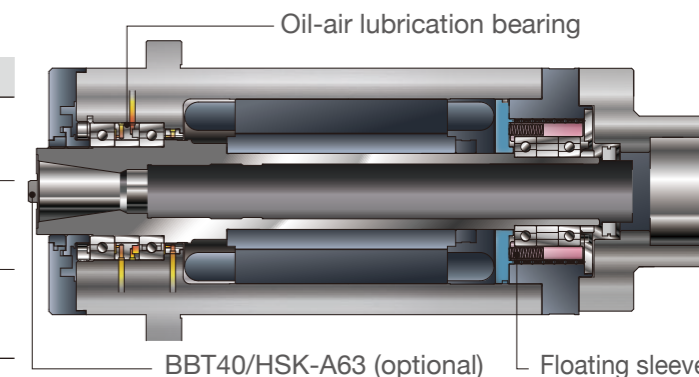
Rapid traverse

X/Y/Z axis
 VC-608/610/711 24 m/min



Spindle

Specification	Max. speed	Horsepower	Torque
12,000rpm direct-drive spindle (standard)	12,000 rpm	11/7.5 kW	70/48 Nm
15,000rpm direct-drive spindle (optional)	15,000 rpm	15/11/7.5 kW	95/70/48 Nm
Built-in spindle (optional)	20,000 rpm	40/30 kW	38/29 Nm



- The spindle of VC series is equipped with oil-air lubricated bearings and oil-cooling cartridge, it constrains the thermal generation and reduces the thermal expansion in the spindle.
- Floating sleeve on rear-end bearing is used in 20,000 rpm built-in spindle, that is avoids the preload variation of bearing induced by thermal expansion that affects bearing life.
- BBT dual-contact tool holder is equipped to enhance the stability and machining quality.

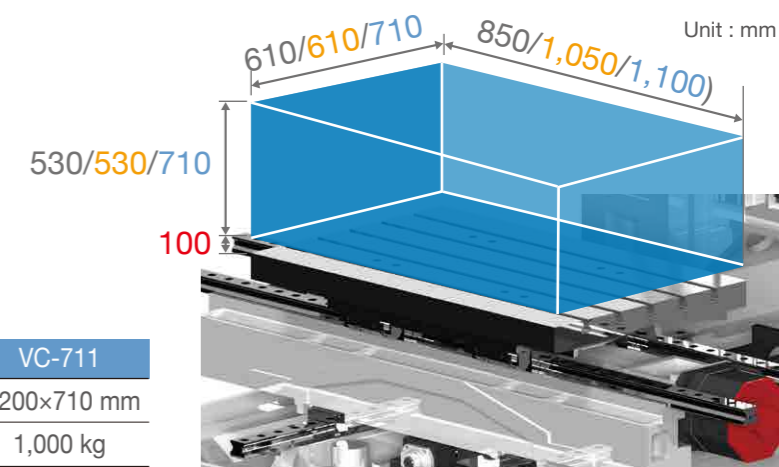
ATC

The cam-type tool changer has higher accuracy and lower noise. In addition, the stable tool clamping can ensure spindle accuracy and expand bearing life.

Tool capacity **24** tools
30 tools (optional)



Working area

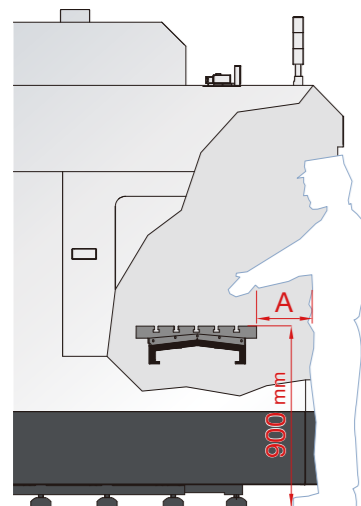


Specifications	VC-608	VC-610	VC-711
Table size	950×600 mm	1,100×650 mm	1,200×710 mm
Max. load	500 kg		1,000 kg

Operation

Accessibility

Suitable table height and reasonable distance between table and operator provide an excellent machining experience during operation.



Distance A	
VC-608	245 mm
VC-610	270 mm
VC-711	300 mm

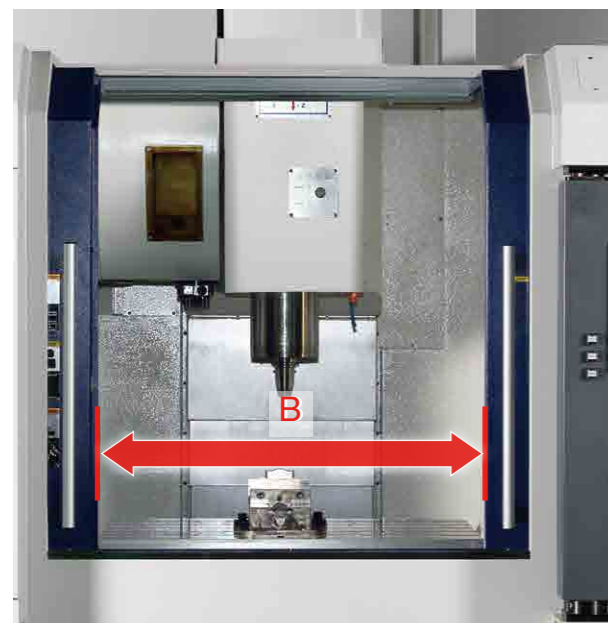
Swivel-type operation panel

The operation panel is able to swivel from 0 to 90 degrees, which improves visibility during operation.



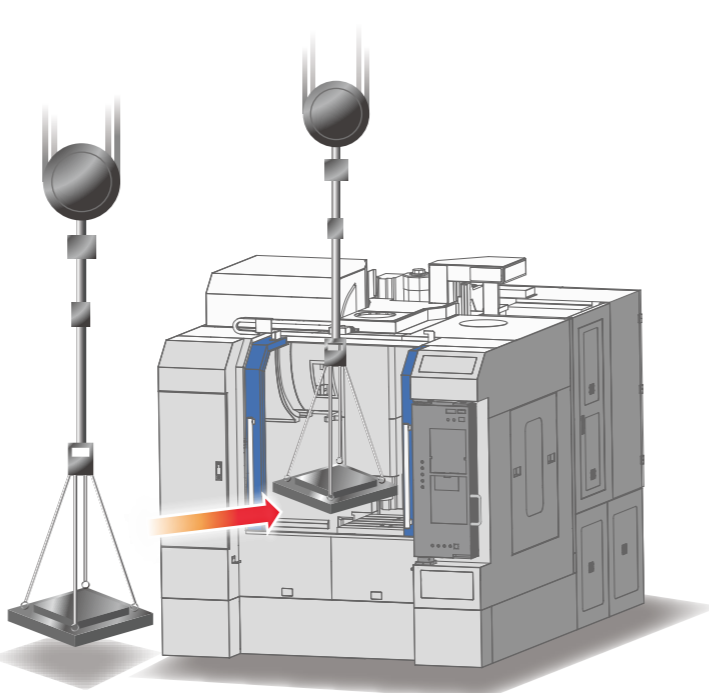
Door opening width

The wide door opening makes machine operation and loading/unloading more convenient.



Distance B	
VC-608	950 mm
VC-610	1,100 mm
VC-711	1,200 mm

Spacious working zone facilitates operation of overhead travelling crane.



High resolution control

Equipped with Mitsubishi M720-VS series controller, which supports high speed and high accuracy control, combined with high rigidity and high stability machine structure, MDV-608/611 shows outstanding performance in high speed contouring.

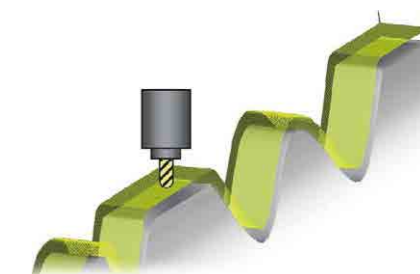
- Supports high-class, high speed, and high accuracy control
- Super Smooth Surface controlling function



High-speed & High accuracy control mode I/II

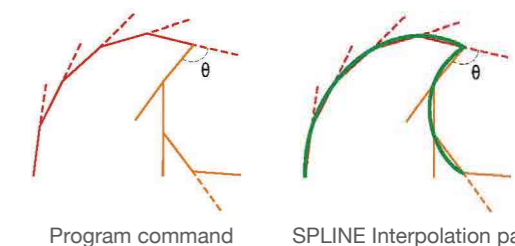
Utilizing our block look ahead from the commanded paths, unnecessary deceleration is reduced even when fine steps exist; thereby, realizing smooth surfaces. Machining time can be shorter than conventional system.

High speed & high accuracy control model I : G05.1Q1
High speed & high accuracy control model II : G05P10000



SPLINE Interpolation

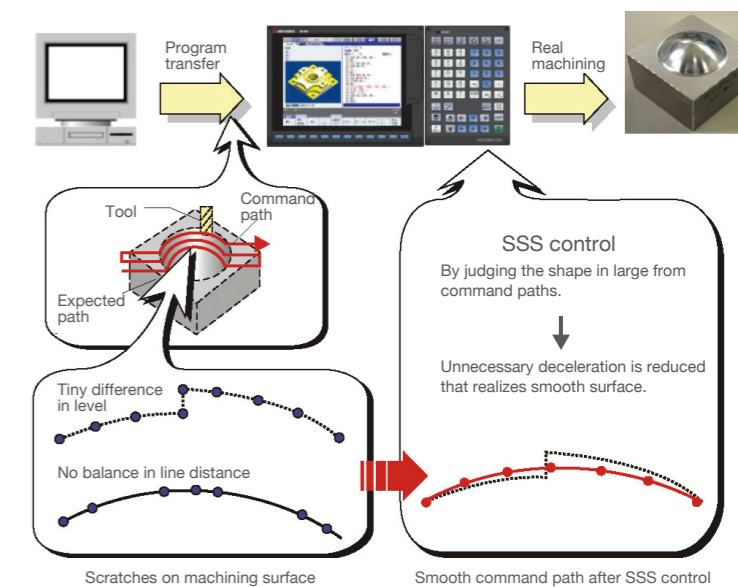
This function can be commanded in high speed and high accuracy mode II to automatically generate a spline curve that passes through a sequence of points commanded by the fine segment machining program, and interpolates the path along this curve. This allows highly accuracy machining at a high speed.



SSS Control

SSS control (Super Smooth Surface) ensures high machining stability and quality with virtual no effects resulting from cutting shape or speed; that is suitable for high precision mold machining.

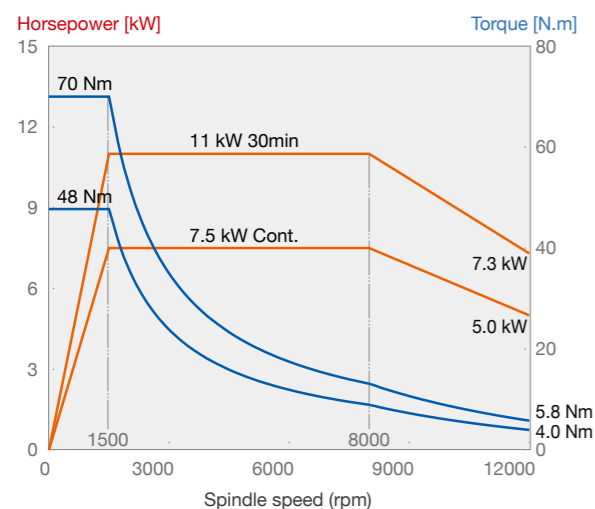
Optimum speed control is always performed even with the program with error, resulting smooth surface in short time.



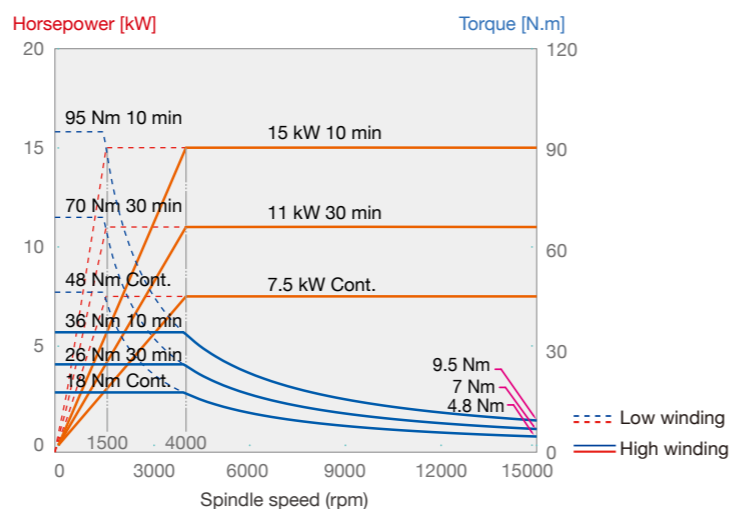
Spindle output and torque chart · Machine dimensions

Specification · Standard/Optional accessories

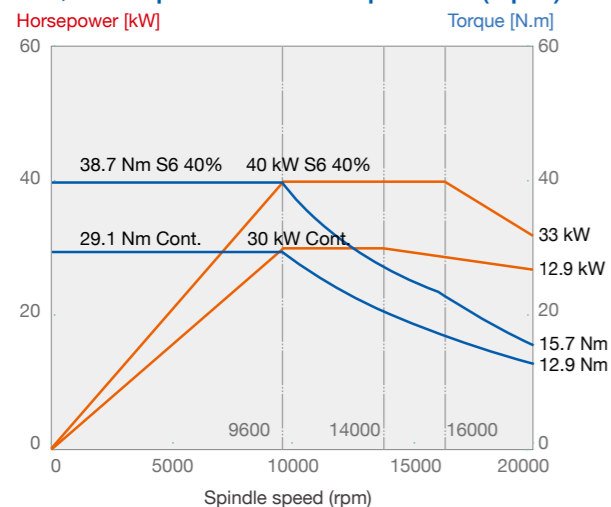
12,000 rpm Direct-drive spindle (std.)



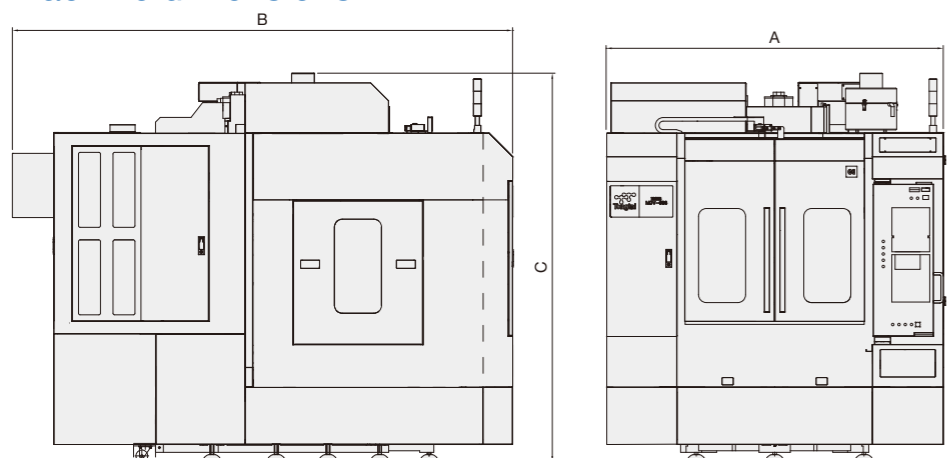
15,000 rpm Direct-drive spindle (opt.)



20,000 rpm Built-in spindle (opt.)



Machine dimensions



	A	B	C
VC-608	2,150	3,190	2,478
VC-610	2,800	3,190	2,478
VC-711	2,800	3,400	2,730

Unit : mm

Specification

Item	Specification	Unit	VC-608	VC-610	VC-711
Table	Table size (L×W)	mm	950×600	1,100×650	1,200×710
	Max.loading capacity	kg		500	
	Table height from floor	mm		900	
	T-slot (size×No.)	mm		18×5	
Spindle	Spindle taper		7/24 Taper No.40		
	Spindle speed	rpm	direct-drive spindle12,000 (opt. direct-drive spindle15,000 · Built-in spindle 20,000)		
Stroke	X/Y/Z axis stroke	mm	850/610/530	1,050/610/530	1,100/710/710
	Spindle nose to table	mm	100~630	100~630	100~810
Feed	X/Y/Z axis rapid traverse	m/min	24/24/24		
	Cutting feedrate	mm/min	1~10,000		
ATC	Tool shank		BBT-40 (opt. HSK-A63)		
	Tool capacity	pc	24 (opt. 30)		
	Max. tool diameter	mm	Ø95		
	Max. tool diameter (w/o adjacent tool)	mm	Ø180		
	Max. tool length	mm	300		
	Max. tool weight	kg	7		
Motor	Spindle motor	kW	7.5/11(opt. 15/11/7.5, 40/30)		
	X/Y/Z servo motor	kW	2/2/3		
	Coolant motor	kW	0.55		
	Controller		Mitsubishi M720-VS (opt. Fanuc 31i)		
Machine size	Width×Depth×Height	mm	2,150×3,190×2,478	2,800×3,190×2,478	2,800×3,400×2,730
	Weight	kg	7,000	8,000	9,000

*specifications may be changed without prior notice

Standard/Optional accessories

		Standard	Optional
Tool shank	BBT-40	●	
	HSK-A63		○
Coolant through spindle pump	20 bar		○
	35 bar		○
	70 bar		○
Cooling system	Spindle cooling system	●	
	Hydraulic temperature control system		○
	Coolant temperature control system		○
	Air conditioner for electrical cabinet		○
Chip conveyor	Two chip augers	●	
	Scraper type conveyor		○
	Magnetic scraper type conveyor		○
	Hinge type conveyor		○
	Bed flushing pump.		○
Lubrication system	General lubricant system	●	
	LHL integrated lubrication system		○
Positioning accuracy control	Three axes linear scale 5µm resolution		○
	Three axes linear scale 3µm resolution		○
	Three axes magnetic scale with 5µm resolution		○
Tool measuring system	Tongtai made touch type broken tool detector		○
	Marposs Mida Laser 75P Tool breakage detector		○
4 th axis rotary table			○
Automatic door			○
Others	Renishaw OMP60/RMP60		○
	Machining air blow		○
	Minimum quantity lubrication (MQL)		○
	Air gun		○
	Coolant gun		○
	Oil skimmer		○
	Oil mist collector		○
	Mitsubishi M720-VS	●	
	Mitsubishi M730-VW		○
	FANUC Oi-MD		○
	FANUC 31i-MB		○
SIEMENS 828D		○	