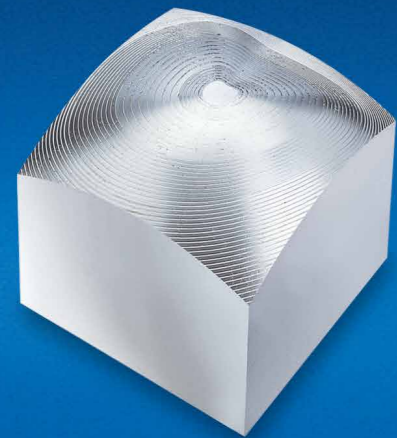


Examples of Machining

**Lamp mold**

Tool : 0.1R ball nose end mill
Speed : 20000 rpm
Feedrate : 1000 mm/min
Machining time : 9.8 hr
Material : NAK80、HRC 40°
Workpiece size : 120×120×80 mm

**Cellphone mold**

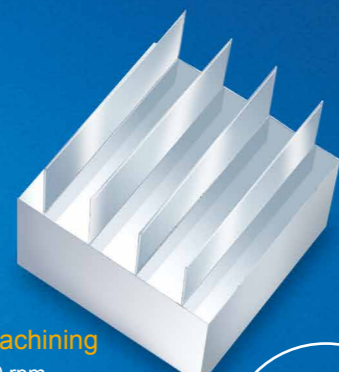
Tool : 0.3R ball nose end mill
Speed : 18000 rpm
Feedrate : 1200mm/min
Machining Time : 5.4hr
Material : NAK80、HRC 40°
Workpiece size : 80×180×50 mm

**Fan mold**

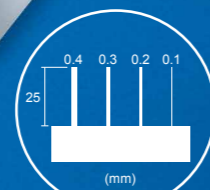
Machining time : 5.75 hr
Material : NAK80、HRC 40°

**Forging mold**

Machining time : 4.8 hr
Material : SKD61、HRC 52°
Workpiece size : 100×100×35 mm

**Thin wall machining**

Speed : 20000 rpm
Feedrate : 8000mm/min
Material : AL 7075
The wall : 0.4/0.3/0.2/0.1 mm

**Crankshaft mold**

Tool : Ø3 ball nose end mill
Speed : 13000 rpm
Feedrate : 2200 mm/min

Finishing time : 1.2 hr
Material : SKD11、HRC 60°
Workpiece size : 80×50×30 mm

**Connecting rod**

Material : NAK80(HRC40)
Workpiece size : 300×180×40 mm
Machining time : 4.5 hr

MDV-812 Standard Specifications

Item	Specification	Unit	MDV-812
Table	Working area (LxW)	mm	1,320×800
	Max. load capacity	kg	2,000
	Table height from floor	mm	850
	T-Slots (size x No.)	mm	18×7
Spindle	Spindle nose		7/24 Taper No. 40
	Spindle speed	rpm	Direct drive type 12,000 (Opt. 15,000)(Opt. Built-in type 20,000)
	Spindle bearing diameter	mm	Ø75
Stroke	X/Y/Z axis stroke	mm	1,200/800/500
	Spindle nose to table	mm	150-650
Feed	X/Y/Z rapid traverse	m/min	30/30/30
	Cutting feedrate	mm/min	1-10,000
ATC	Tool shank		BBT-40 (Opt. HSK-63A)
	Tool capacity	pc	16 (Opt. 40)
	Max. tool diameter	mm	16 Tools : Ø125 / 40 Tools : Ø70
	Max. tool length	mm	300
	Max. tool weight	kg	8
Motor	Spindle motor (50% ED)	kw	11/7.5 (Opt. 15/11/7.5,40/30)
	X/Y/Z servo motor	kw	7.0/7.0/7.0
	Coolant motor	kw	0.37×2
Machine	L×W×H	mm	4,390×3,350×3,370
	Weight	kg	13,000

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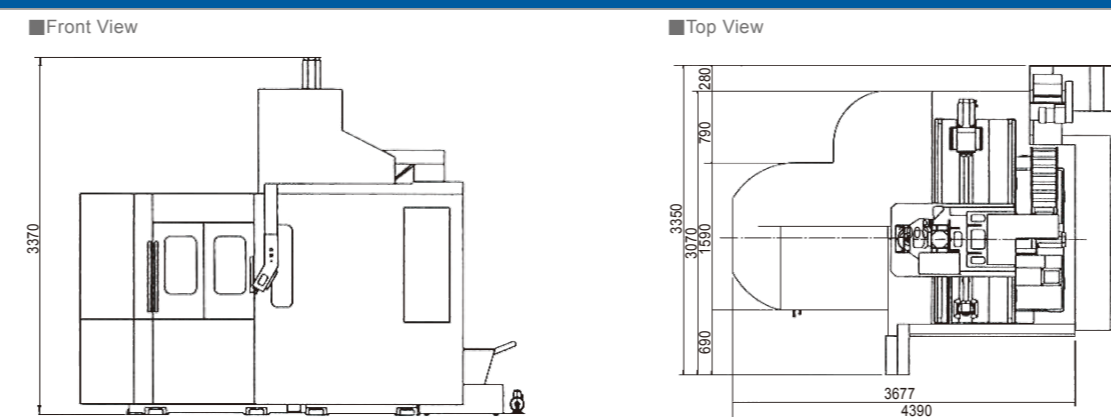
Standard accessories

- Spindle speed 12000 rpm
- Spindle nose BT-40
- Air blow unit
- Rigid tapping
- Halogen
- Coolant unit
- Automatic lubrication equipment
- Door interlock unit
- Spindle cooler unit
- Spindle load meter
- Workpiece counter
- Fanuc Oi-M

Optional accessories

- Spindle speed 20000 rpm
- Spindle nose HSK-A63
- Transformer / stabilizer
- Auto door
- Fully enclosed splash guard
- Linear scale
- Coolant through spindle
- Tool length automatic measuring unit
- Tool life management
- Tool breakage detector
- Function modular package A
- Function modular package B
- Oil skimmer / oil & mist collector
- Chip conveyor / chips tank
- 4th axis function
- A/C for electrical cabinet
- M code
- Auto power off
- Sub operation box

Machine Dimensions



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, 886-7-9761590
Website : www.tongtai.com.tw

Taoyuan Office TEL : 886-3-4551399 FAX : 886-3-4559730
Taichung Office TEL : 886-4-23589600 FAX : 886-4-23589993
Japan Branch TEL : 81-4-71438355 FAX : 81-4-71438360
Europe Branch TEL : 31-161454639 FAX : 31-161454768
Tongtai East Europe SRL TEL : 40-0264415273 FAX : 40-0264402983
Malaysia Branch TEL : 603-78597113 FAX : 603-78597115
Vietnam Office TEL : 84-4-62766090
Thailand Office 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 Road, Economic Development Zone,
Songling Town, Wujiang 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
Guangdong Branch TEL : 86-769-61158108 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

2016.10.31 Design by Tongtai Machine & Tool Co., Ltd.



ISO 9001 ISO 14001 CE
A Worldwide Tradition of Quality Products and Customer Service

MOLD & Die Milling Series MDV-812

High ■Quality ■Precision ■Efficiency ■Economy



Tongtai Machine & Tool Co., Ltd.

MDV-812 Vertical Column Type Machining Center

- Reduce machining processes and delivery time.
- Give perfect surface accuracy finishing and save the time for further polishing.
- Capable to machine material with hardness above HRC 40°. The time of EDM could reduce by means of small diameter ball nose endmill to clean up corner.
- Excellent in machining aerospace industrial alloy, light and thin wall work pieces.

- X/Y/Z stroke=1200/800/500 mm
- X/Y/Z rapid traverse=30m/30m/30 m/min
- Max. load capacity=2000 kg
- Machine size (W×L×H)=3350×4390×3370 mm
- Machine weight=13000 kg

- High rigidity and double wall machine structure design ensures accuracy and stability during high speed machining.
- High grade cast steel machine bed with annealing for stress relieving before any machining process. This approves the long-term accuracy and stability.



- Linear guide ways are high preloaded, high rigidity designed and using roller type bearing



- ATC 16 Tools/40 Tools (Opt.)
- BT-40/HSK-63A (Opt.)



- Rigid type coupling Ensure μm fine feeding and no backlash accuracy.



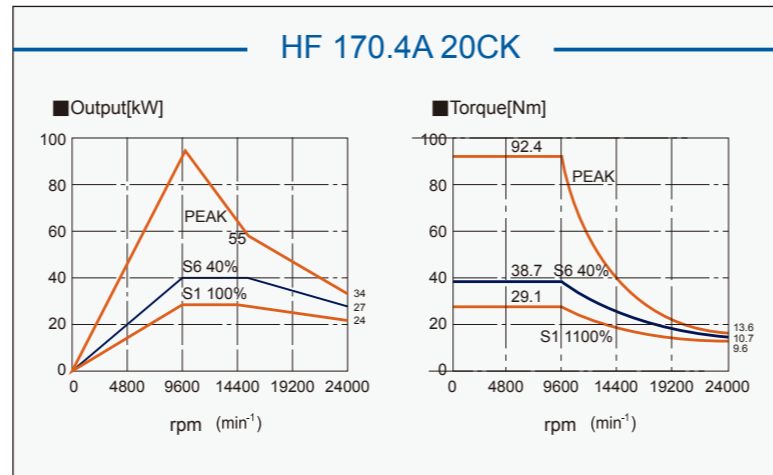
- Ball screw Use preloaded mechanism to reduce effect upon thermal expansion during machining.



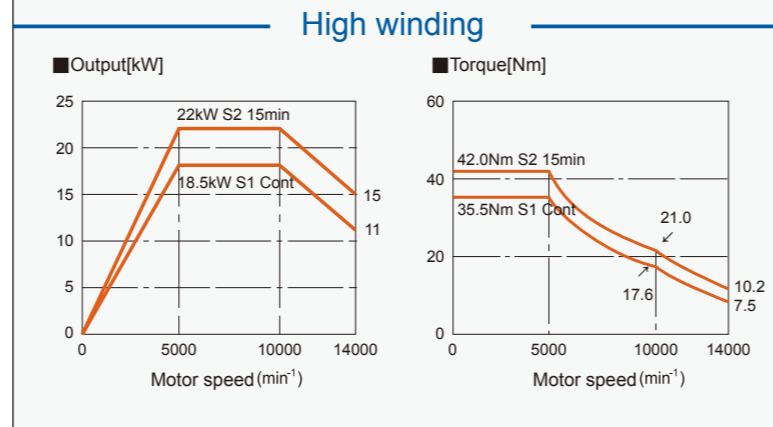
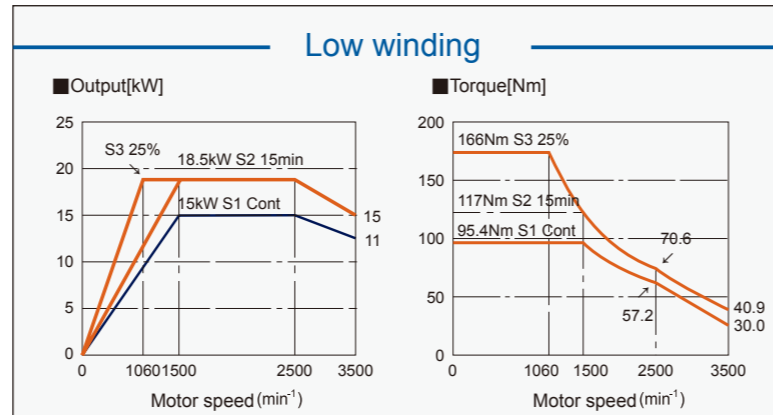
- Dual screw type chip conveyor design provides excellent chip disposal.



Spindle output and torque chart



FANUC α B112L-18.5(BT-40 12000 rpm)



Controller FANUC Oi-M (Standard) / SIEMENS 840D (Optional)



- High precision of B function (Opt.)
- Data. Server with ATA flash card.
- DNC operation through PCMCIA port.
- Servo HRV3 control
- AI Nano HPCC.
- Look-ahead blocks 600.

Electrical cabinet



Air conditioner for internal temperature control (Optional)

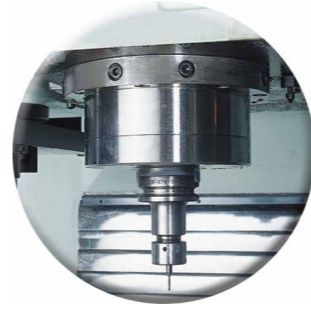
Spindle



Powerful spindle 12000 rpm

- 18.5/22kW
- 7/24 Taper No.40
- High grade grease lubrication

Reinforced pull stud mechanism : Lengthen the accuracy and lifetime of spindle bearings.



High Speed 20000 rpm (Opt.)

- 30/45 kW
- BBT-40/HSK-63A
- Oil mist lubrication.

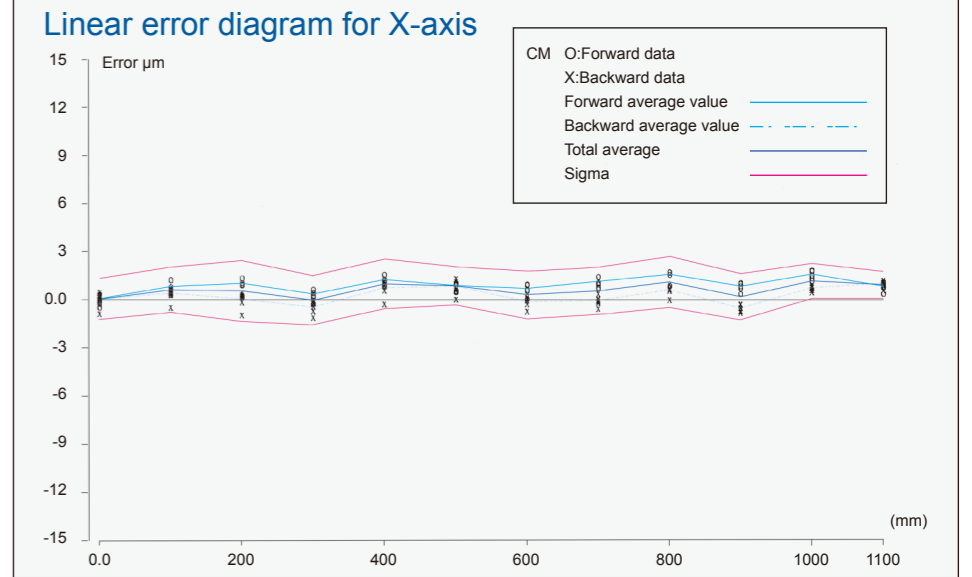


Spindle cooling system

Performance and accuracy test



	Positioning accuracy	Repeatability
VDI3441 (Germany)	0.01 mm Fully Stroke	± 0.003 mm



Numerical analysis
 P : P Infinite : 4.222 μm
 Accuracy F : 3.600 μm
 Accuracy R : 4.039 μm
 Ps : P diffuse : 2.823 μm
 Ps : Average : 2.110 μm
 Pa : P DEV : 1.225 μm
 Rs+U : Repeatability : 3.776 μm
 Original accuracy : 2.946 μm
 Original accuracy : 2.306 μm
 Original accuracy : 2.411 μm
 Original repeatability : 2.301 μm
 Original repeatability : 1.086 μm
 Original repeatability : 1.389 μm
 U : Mean Rv E : .6311 μm

Machine Name : Vertical machining center
 File date and time : 2001/08/13 09:20:09 AM
 Plant : TONGTAI
 Machine Type : MDV-812

Environment data

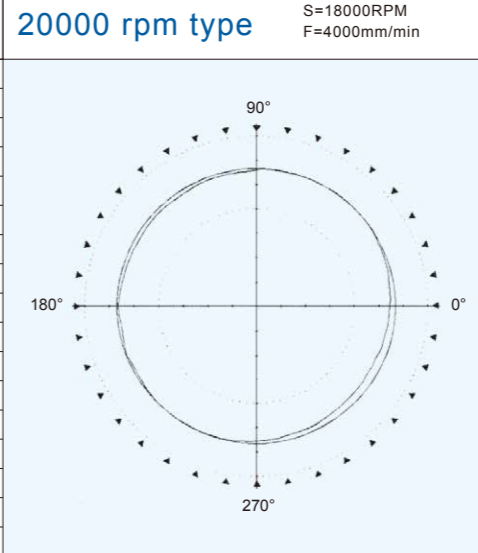
	Min.	Max.	Average
Temp	29.05	29.26	29.16
Pressure	756.76	756.83	756.79
Air humidity	75.0	75.0	75.0
MT1 temp.	30.82	30.88	30.85
MT2 temp.			
MT3 temp.			

Expansion coefficient : 11.7 $\text{rpm}/^\circ\text{C}$

THP TR265 Version 3.29

LS ROUNDNESS RESULTS

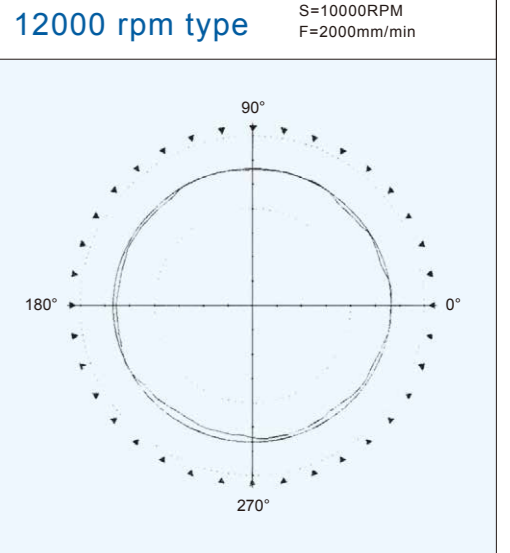
Feature name	11174
Feature no.	02
R	53.873 mm
O	5.60 μm
E	0.98 μm
\angle	140.6 deg
\wedge	6.16 μm
Scale	2.00 μm
Z height	112.9 μm
Datum	SPINDLE
Filter type	2CR
Filter	1-500 μm
Profile	100.0%
Meas. Mode	External
Meas. Date	19-04-2000
Meas. Time	08:52:59



THP TR265 Version 3.29

MC ROUNDNESS RESULTS

Feature name	10658
Feature no.	05
R	105.67 mm
O	4.50 μm
E	1.17 μm
\angle	218.6 deg
\wedge	4.23 μm
Scale	10.00 μm
Z height	40.9 μm
Datum	SPINDLE
Filter type	2CR
Profile	100.0%
Meas. Mode	External

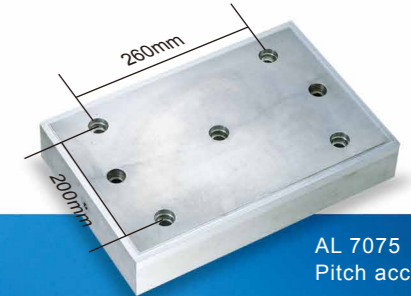


End milling circular differential accuracy



AL 7075

The position accuracy for boring and hole differential



AL 7075 Pitch accuracy 0.0075 μm