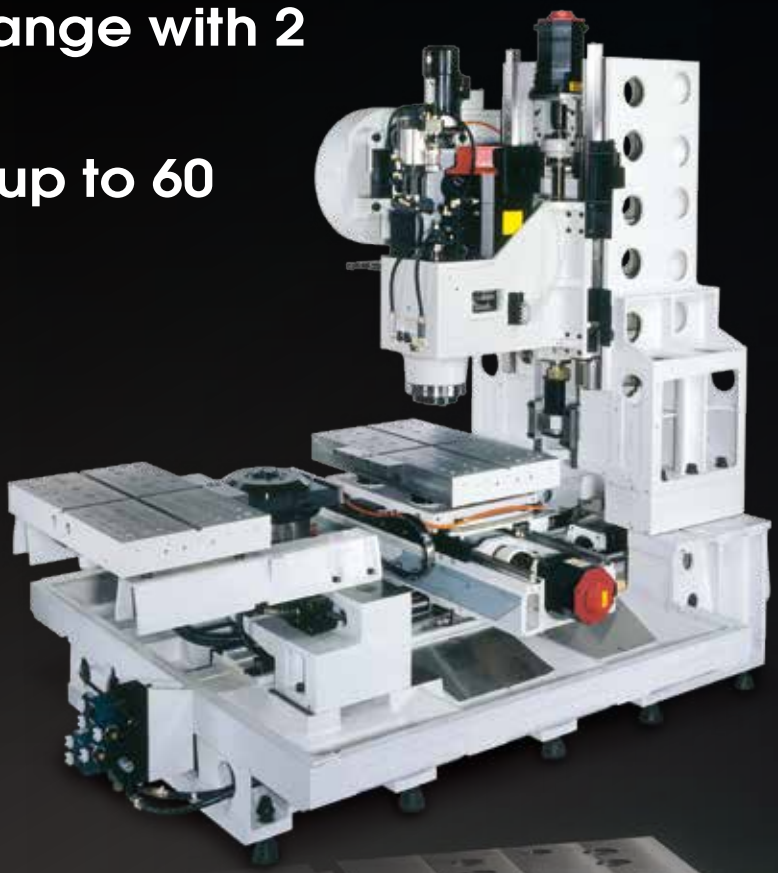
QUASER

we cut faster

MV154APC SERIES

High speed VMC
One piece base and rigid frame.
Automatic pallet change with 2 pallets as standard.
Large tool capacity up to 60 (opt.)



HIGH PRODUCTIVITY M / C

Rapid : 60 m/min

Axes acc / dec : 7 / 7 / 6 m/s^2

Chip to chip : 4 sec

Spindle 0~15,000 min^{-1} : 2.9 sec

Magazine rotation #1~#31 : 9.8 sec

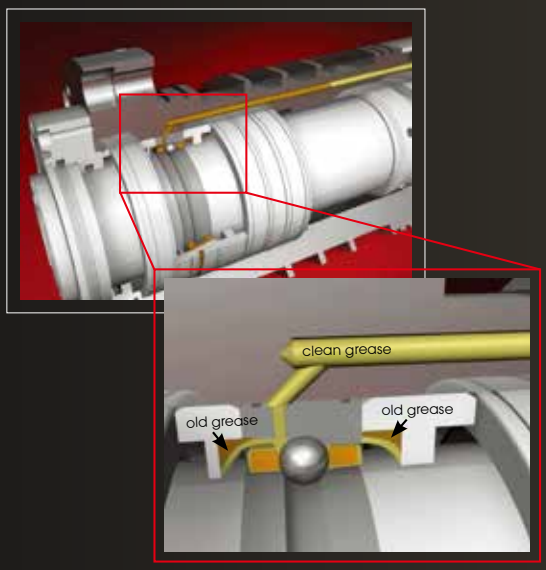
FANUC = F

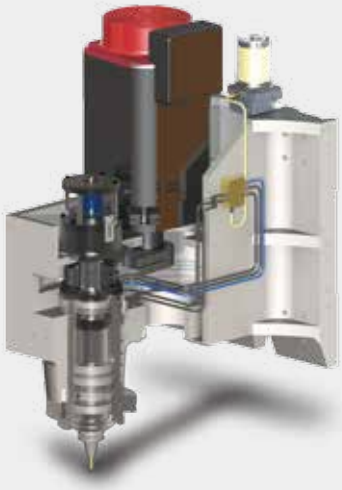
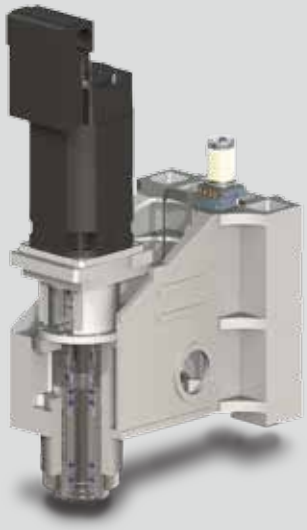
		MV154APC/E		MV154APC/P				MV154APC/HS	
Spindle code		9B	12B	9B	12B	15C	20C	15C	20C
Motor power X / Y / Z (kW)	F	3 / 3 / 4		3 / 4 / 4				4 / 7 / 7	

(Covers & Middle wall removed for explanation)
MODEL MV154APC / HS

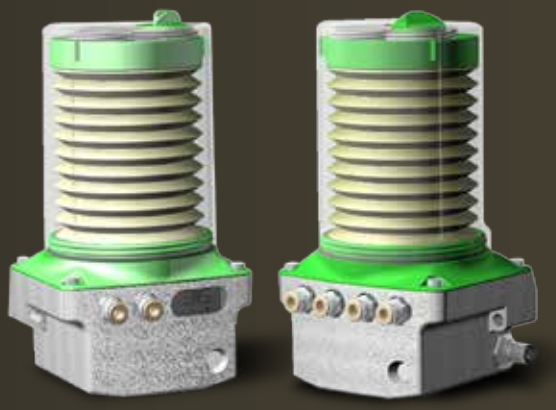
Grease replenishing system

- Use car industry re-greasing principle to supply "clean grease" at 60~100 hr interval by 25~50 mm^3 / shoot.



Transmission	Lubrication
Belt driving 	Re-grease system
Coupling 	Re-grease system

- The grease volume in 1st installation can support 30,000 hr or 3 years.



- Standard on all models

Spindle code	Speed range	Model
		ISO40
GB-4.1R	9,000 / 12,000 min^{-1}	MV154APC/E MV154APC/P
GC-4.0R GC-4.1R (2017-Q3)	15,000 min^{-1}	MV154APC/P MV154APC/HS
MC-4.1R (Future versions)	15,000 min^{-1}	
MC-4.0R (Future versions)	20,000 min^{-1}	

48 ATC (std.)

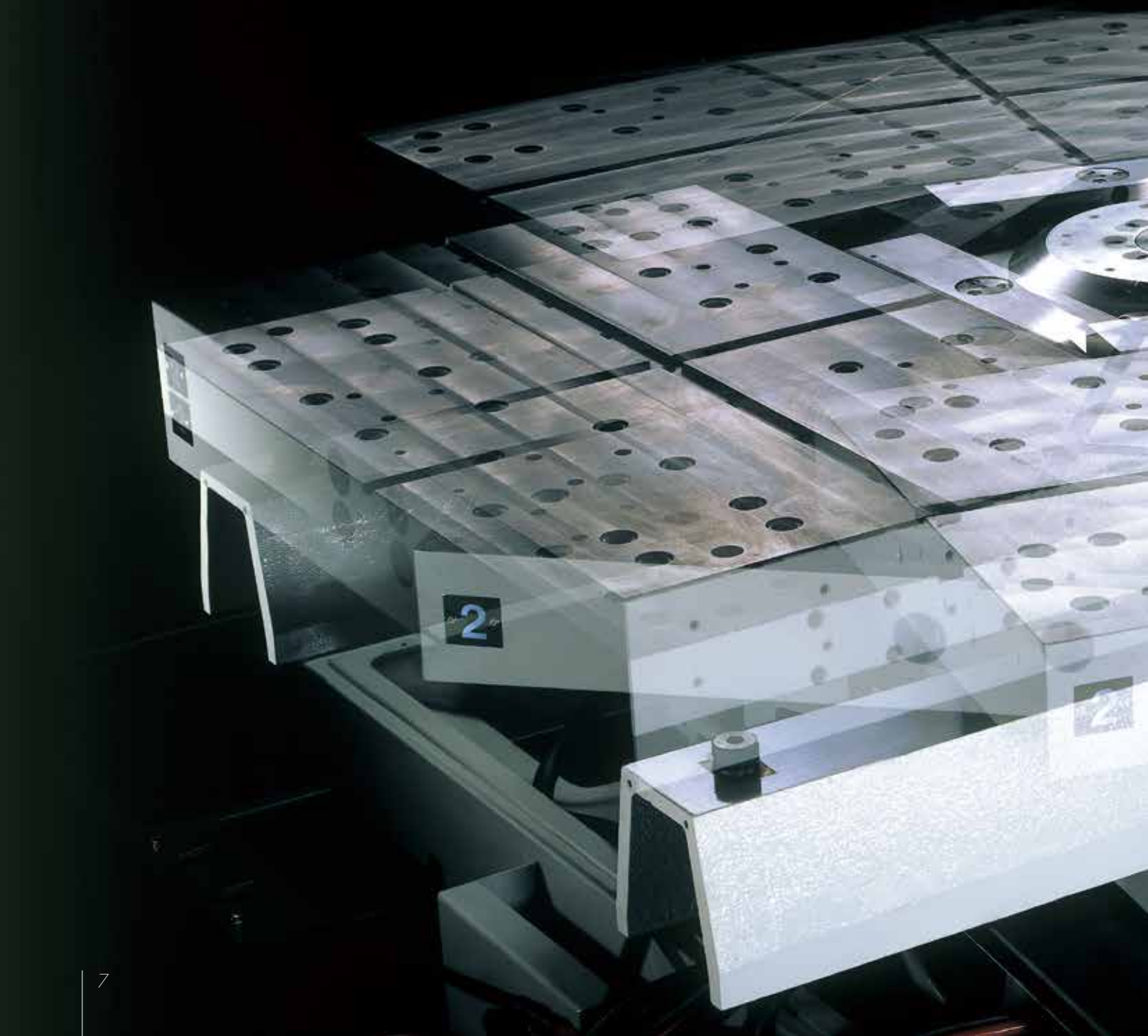
Tool to tool :
2.6 seconds (/HS)
Chip to chip :
4 seconds (/HS)

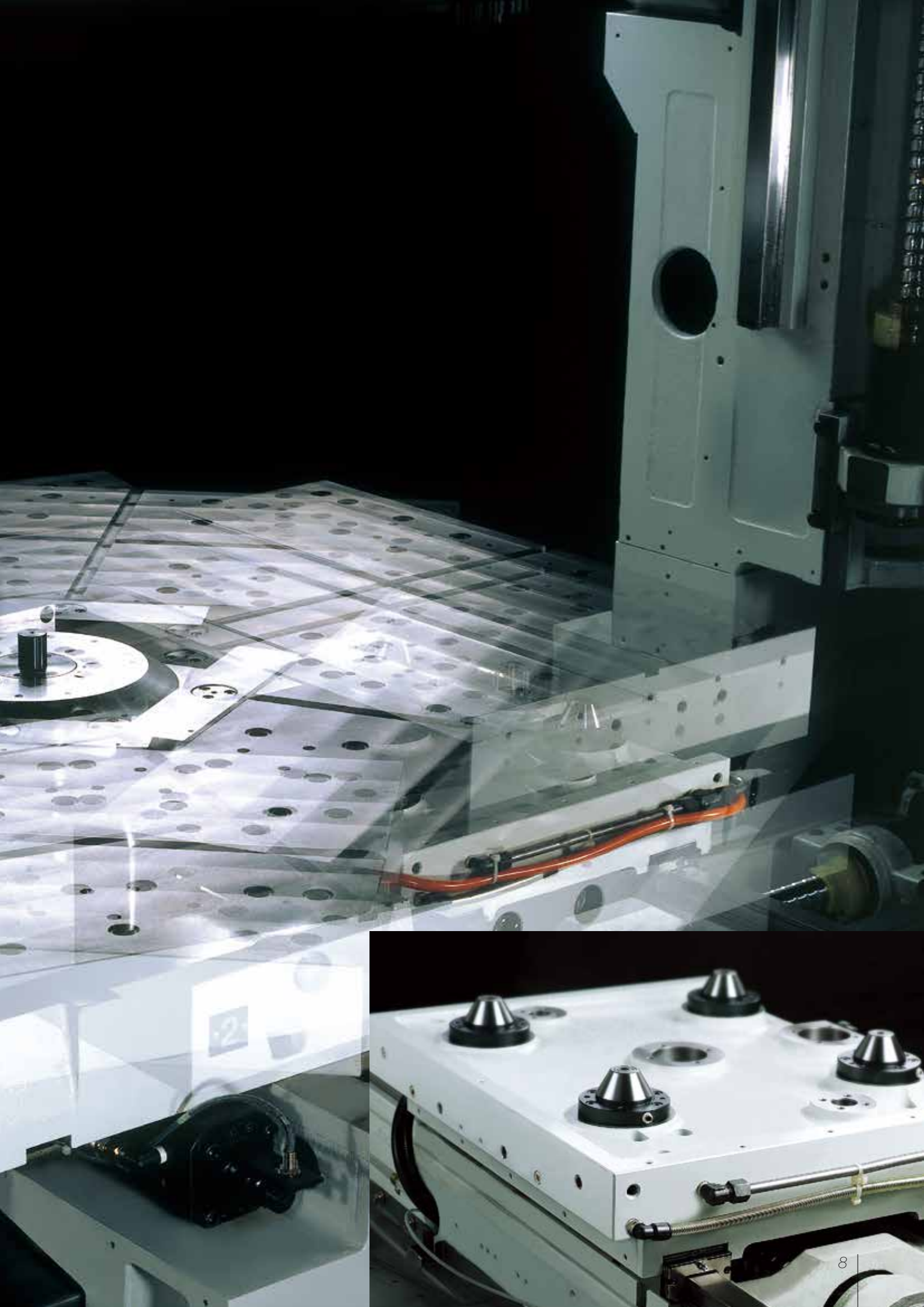
60 ATC (opt.)

45,000 N hydraulic clamping force through four taper cones which use the same mechanism from our long proven horizontal center.

Special cares against swarfs have been built-in include:

- Air blasting at cones connection
- Air pressure monitor against swarf envision

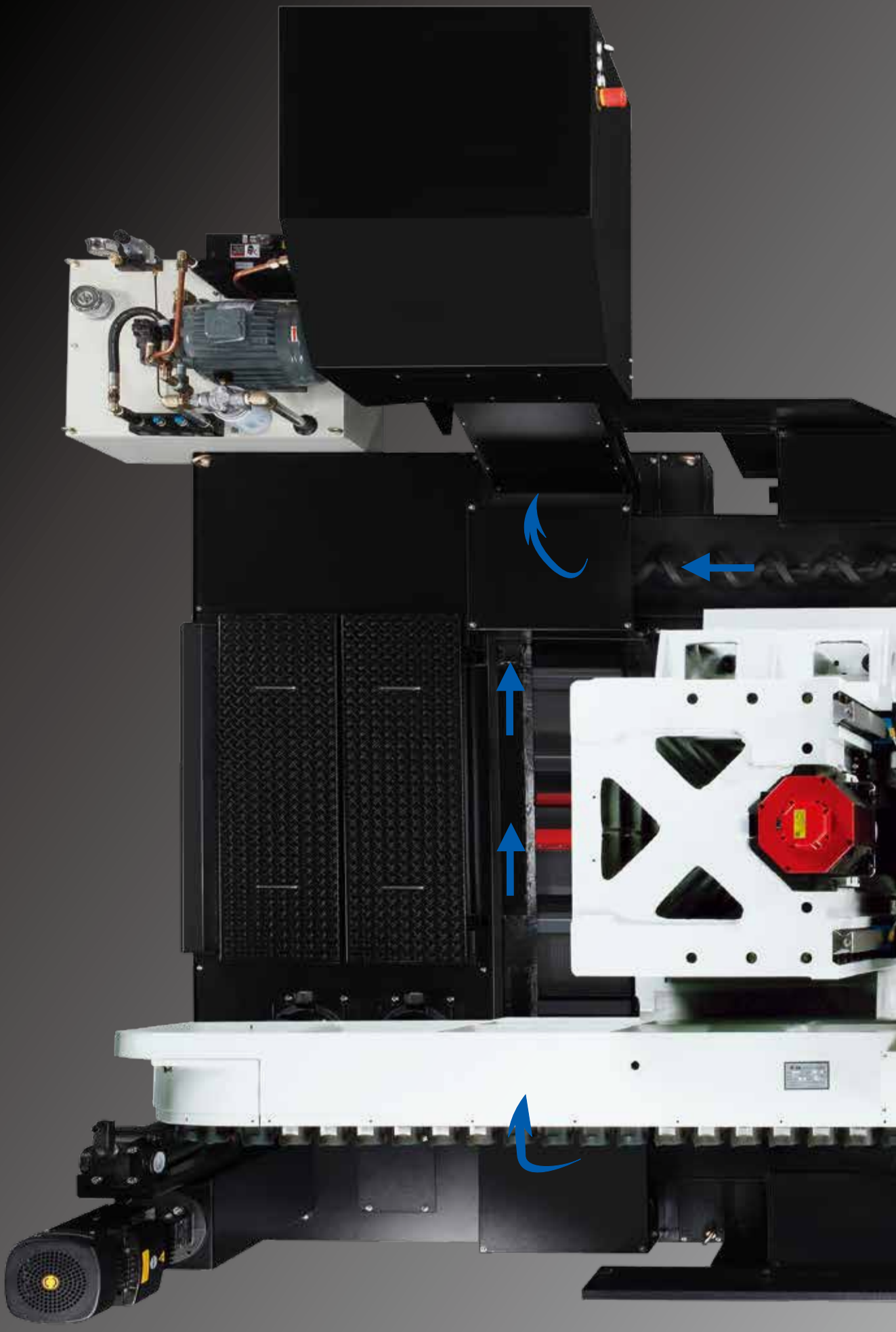




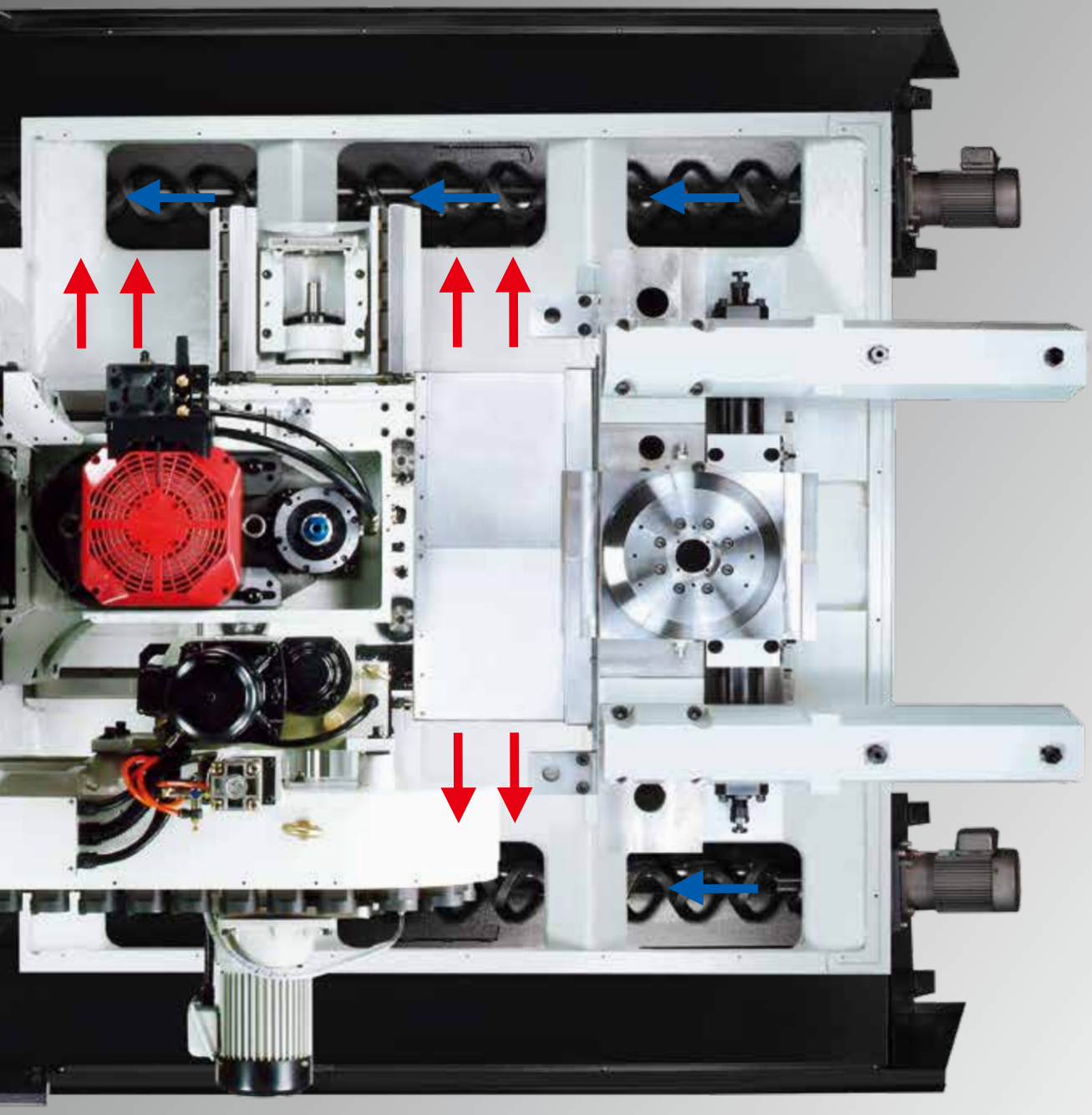

QUASER
we cut faster
MV154
APC/HS

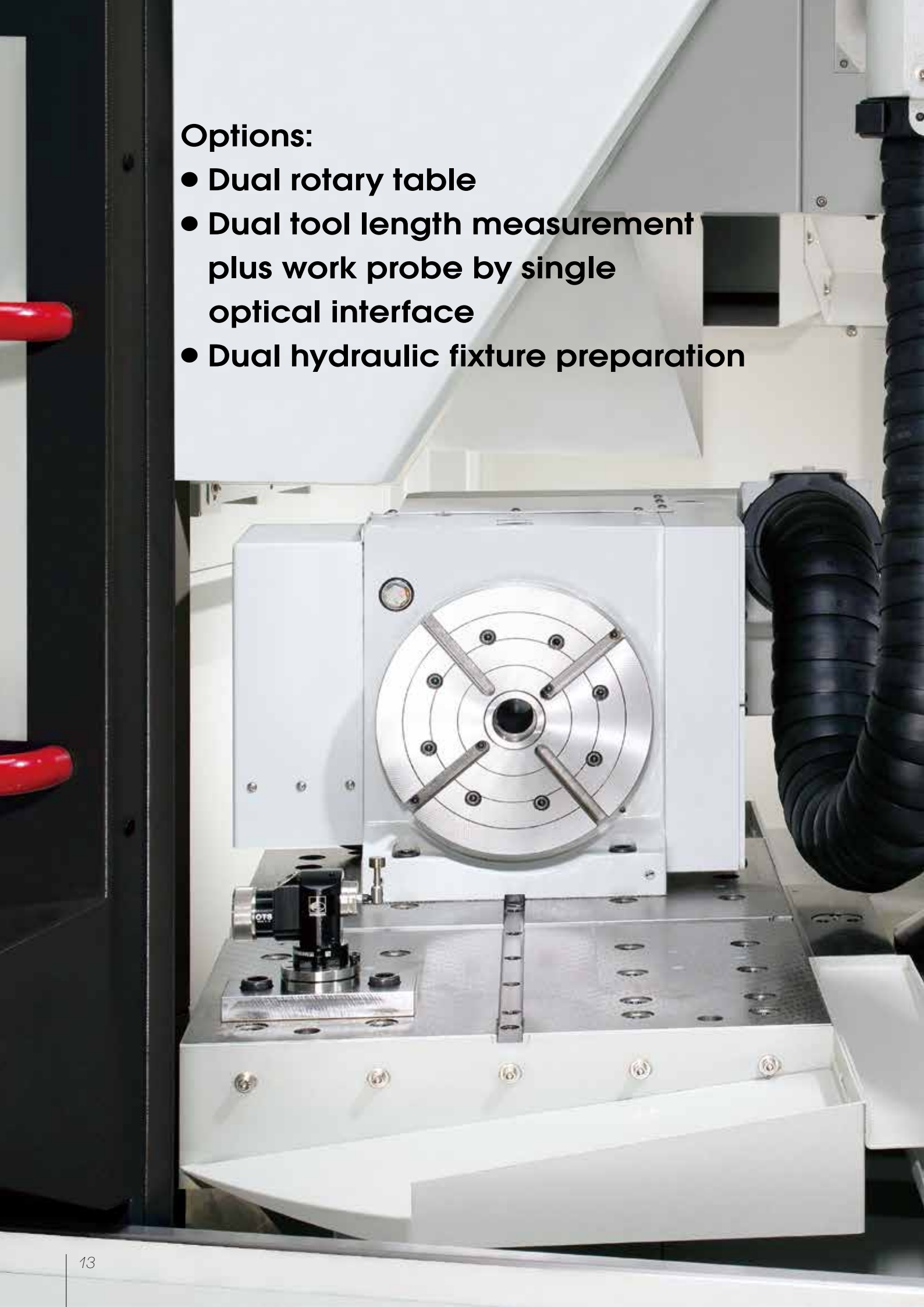
Large side operation door offers easy workpiece & tool checking;
The 920 mm width loading / unloading doors with top free design for heavy work piece.

Note: Machine might be different form the photo if there is any update.



Dual auger + main conveyor at the back for large volume swarf management.





Options:

- Dual rotary table
- Dual tool length measurement plus work probe by single optical interface
- Dual hydraulic fixture preparation

Technical data

Technical data		MV154APC/E		MV154APC/P				MV154APC/HS	
		Economic		Performance				Super high speed	
Spindle code		9B	12B	9B	12B	15C	20C	15C	20C
Work range									
Table size (mm)		800 x 500							
Travel	X (mm)	700							
	Y (mm)	500							
	Z (mm)	560							
Spindle nose to table surface (mm)		150 ~ 710							
Max. work piece size X / Y / Z (mm)		800 x 500 x 370							
Table load capacity (kg)		250							
Feed force	X (N)	6,283		4,712				6,912	
	Y (N)	6,283		8,639				9,425	
	Z (N)	11,519		11,519				9,425	
Rapid movement X / Y / Z (m/min)		32		40 / 40 / 32				60	
Acceleration X / Y / Z (m/s^2)		5 / 5 / 5		6 / 6 / 5				7 / 7 / 6	
Dia. & pitch of the ball screw		Ø45 / P=12 / 12 / 12		Ø45 / P=16 / 16 / 12				Ø45 / P=20 / 20 / 20	
Accuracy Positioning / Repeatability									
ISO 230-2		0.008 / 0.004							
JIS 6338 (300 mm)		± 0.003 / ± 0.002							
VDI 3441		0.008 / 0.004							
Main spindle									
Spindle taper		BBT40							
Max. spindle speed		9,000	12,000	9,000	12,000	15,000	20,000	15,000	20,000
Spindle base speed		1,125	1,500	1,125	1,500	1,400	1,500	1,400	1,500
Spindle output power kW (S3-25%)		18.5		25		26	15(2)	26	15(2)
Spindle output torque Nm (S3-25%)		157	118	212	159	177	96(2)	177	96(2)
Spindle transmission		Belt				Coupling		Coupling	
Spindle diameter (mm)		Ø70				Ø70 / Ø80	Ø70	Ø70 / Ø80	Ø70
Tool changer									
Tool selection		Random							
Magazine positions		48 (std.) / 60 (opt.)							
Max. tool diameter (mm)		76.2							
w/o adjacent tool (mm)		125							
Max. tool length (mm)		280							
Max. tool weight (kg)		7							
CTC time – ISO 10791-9 (sec.)*		5		4.3				4	
Pallet changer									
Number of pallet		2							
APC method		Swing type							
APC cycle time (sec)*		12							

Note: * At 60 Hz ** The GC-4.0R expect upgrade as GC-4.1R from Q3.2017 shipment. *** Future versions

(1) Standard for EU area. (2) S3-60%

- Machine specification might be different from the catalog if there is any specification update.

Main spindle

Belt spindle –9,000 / 12,000 min^{-1}
Coupling spindle –15,000 / 20,000 min^{-1}

Control

(F) : QUASER mill i (For E type)
FANUC 31iB (For P / HS type)

Technical data	MV154APC/E Economic		MV154APC/P Performance				MV154APC/HS Super high speed	
Spindle code	9B	12B	9B	12B	15C	20C	15C	20C
Coolant system								
Coolant tank capacity (Liter)	433							
Pump capacity*								
- Nozzle coolant	75 L / min., 3 bar							
- Through spindle coolant	25 L / min., 20 bar							
- Wash down	75 L / min., 3 bar							
Machine size								
Height (mm)	3,080				3,150			
Floor space W x D (mm)	3,400 x 4,340							
Weight (kg)	9,500							
Connections								
Main power	220V / 60 Hz, 400 V / 50 Hz							
Power consumption (KVA)	25		30		36	31	37	36

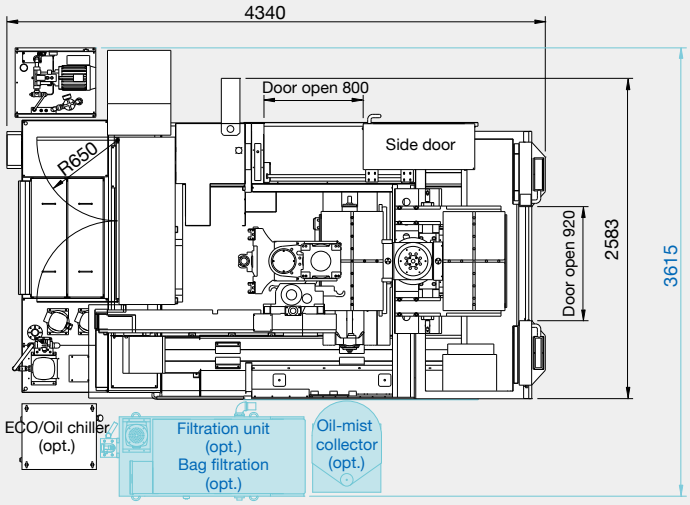
● = Standard ○ = Option × = N / A

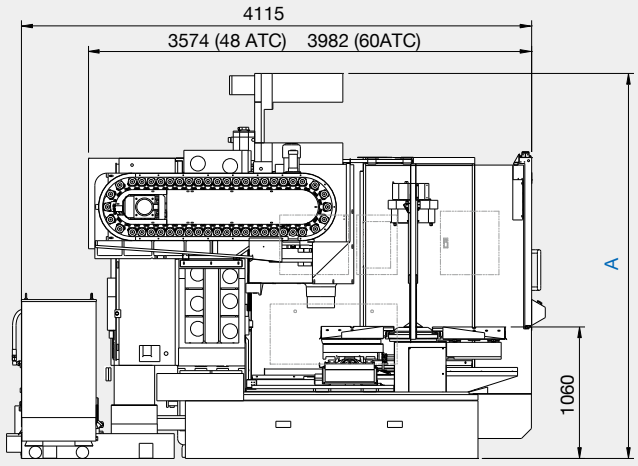
Standard / Option accessories	MV154APC/E Economic		MV154APC/P Performance				MV154APC/HS Super high speed	
Spindle code	9B	12B	9B	12B	15C	20C	15C	20C
QUASER mill i	●	●	×	×	×	×	×	×
FANUC 31iB	×	×	●	●	●	●	●	●
AICC II (Look-ahead 200 blocks)	○	○	●	●	●	●	●	●
FANUC - data server	○	○	○	○	○	○	○	○
FANUC - high speed processing (Look ahead 600 blocks)	×	×	○	○	○	○	○	○
9,000 min^{-1} Belt spindle (GB-4.1R)	●	×	●	×	×	×	×	×
12,000 min^{-1} Belt spindle (GB-4.1R)	×	●	×	●	×	×	×	×
15,000 min^{-1} Coupling spindle (GC-4.0R** / MC-4.1R***)	×	×	×	×	● / ○	×	● / ○	×
20,000 min^{-1} Coupling spindle (MC-4.0R***)	×	×	×	×	×	●	×	●
Pull stud for BT tooling	●	●	●	●	●	●	●	●
Balance tooling for spindle warm up	●	●	●	●	●	●	●	●
BBT spindle attachment (simultaneous contact)	●	●	●	●	●	●	●	●
48 position tool magazine	●	●	●	●	●	●	●	●
60 position tool magazine	○	○	○	○	○	○	○	○
Linear encoder	○	○	○	○	○	○	●	●
Remote manual pulse generator	●	●	●	●	●	●	●	●
Dual tool measurement	○	○	○	○	○	○	○	○
Work probe	○	○	○	○	○	○	○	○
Hydraulic fixture preparation	○	○	○	○	○	○	○	○
Ø255 rotary table, 1 unit (factory mount only)	○	○	○	○	○	○	○	○
Ø255 rotary table, 2 units (factory mount only)	○	○	○	○	○	○	○	○
Coolant system	●	●	●	●	●	●	●	●
Chip conveyor	●	●	●	●	●	●	●	●
Cutter air blast	●	●	●	●	●	●	●	●
Oil-mist collector	○	○	○	○	○	○	○	○
Bag filtration	○	○	○	○	○	○	○	○
Filtration unit	○	○	○	○	○	○	○	○
Documentation & hand tools shelf	●	●	●	●	●	●	●	●
Foundation bolts & blocks	●	●	●	●	●	●	●	●
Tools with tool box	●	●	●	●	●	●	●	●
Work light	●	●	●	●	●	●	●	●
Machine status light	●	●	●	●	●	●	●	●
CE & EMC (1) / GB	○	○	○	○	○	○	○	○

MV154APC

Installation dimension

	Spindle code	A
MV154APC/E	9B/12B	3,080
MV154APC/P		
MV154APC/HS	15C/20C	3,150





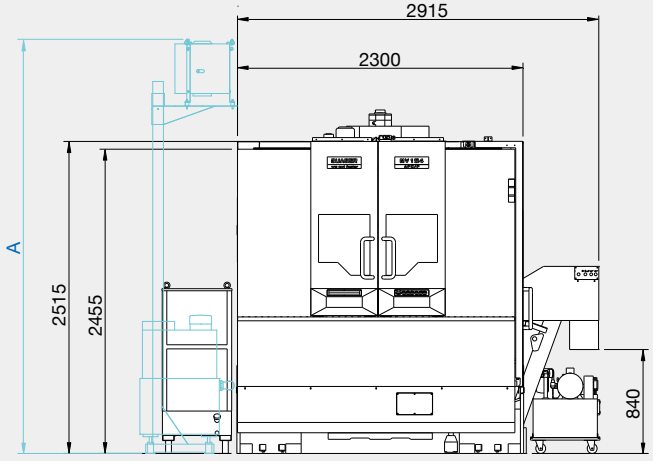
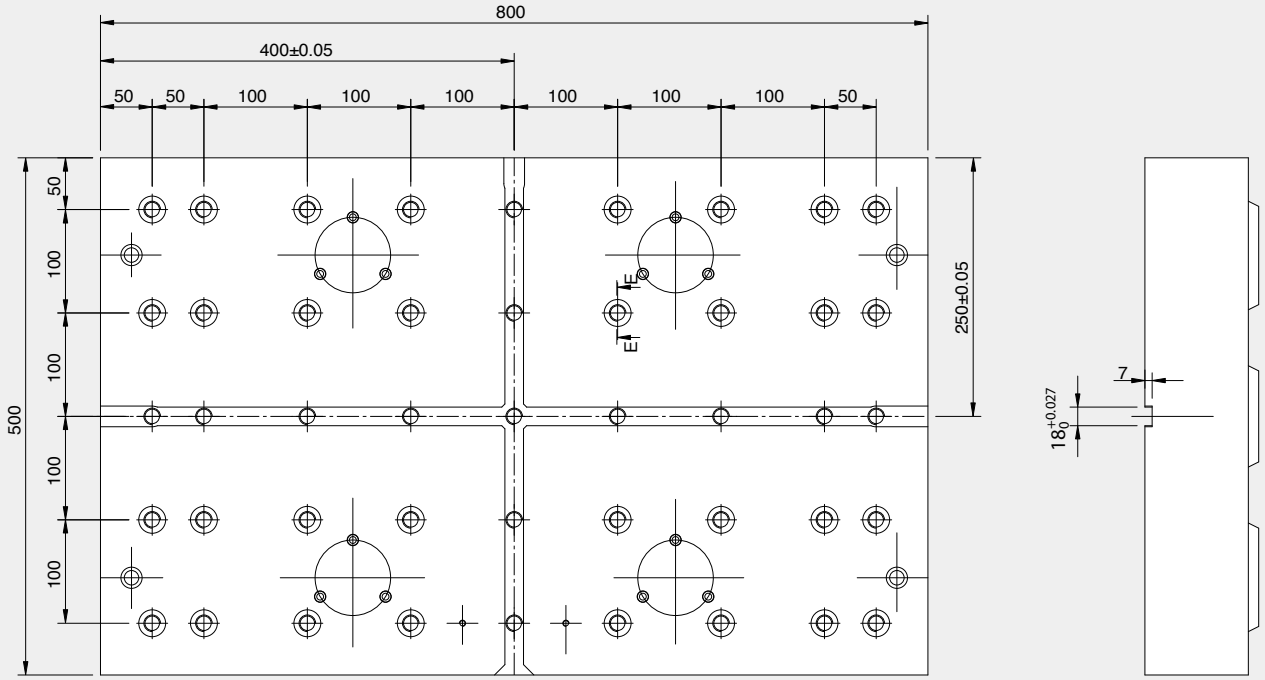
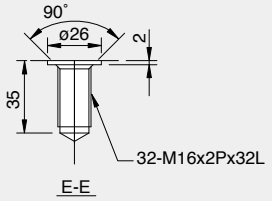


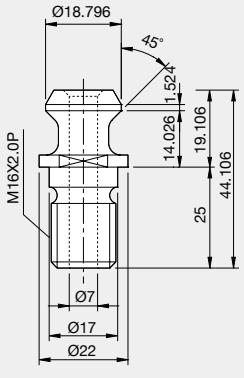
Table dimension



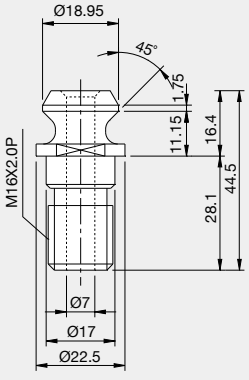


Pull stud and applicable tools

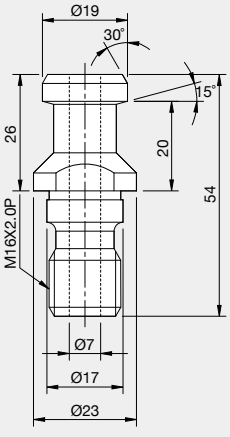
BT 40 (QUASER SUPPLY)

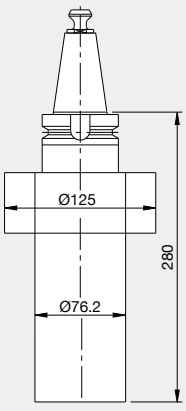


ISO (7388-B)



DIN (69872-A)





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MV154APC-E-29/07/2016