

Automated Turning



Magazine Barfeed Unit, Completely Integrated with the Tornado CNC Turning Center, Operated and Controlled Directly from the FANUC 21i/18i TB Control System...

- No mechanical stops to set
- Automatic measurement of each bar loaded
- Automatic calculation of pieces to be machined from each bar
- Text pages on screen for production schedule facility
- Work scheduling to produce a variety of components automatically

The Innovative 'Lights-Out' Package Integrates the TORNADO Turning Center and the MBF1000 Barfeed System to offer 24 Hour Unmanned Operation...

- Cost efficient and unmatched productivity
- Colchester/Harrison MBF1000 barfeed automation software
- Part probing plus probing routines
- Chip and parts management system
- Production scheduling
- Tool management system
 - Tool setting probe
 - Sister tool replacement routines
- In process gauging

Specification	T2	T4/T6M/MS	T8/M/MS/T10/M
Bar Capacity			
Round inch	.23"-1.65"(6-42mm)	.23"-2.12"(6-54mm)	.23"-2.59"(6-66mm)
Hexagonal A/F Max	1.41"(36mm)	1.77"(45mm)	2.20"(56mm)
Square A/F Max	1.14"(29mm)	1.41"(36mm)	1.77"(45mm)
Maximum length of bar stock		39.37"(1000mm) (T2/T4)	43.3"(1100mm) (T6/T8/T10)
Material rack capacity		1"(25mm) - 20 pieces	1.5"(45mm) - 12 pieces 2.5"(65mm) - 7 pieces
3 Push Rod diameters		.23"(6mm), .39"(10mm), .71"(18mm)	
Master liner		For supporting bar stock in headstock spindle	
Feed/load			
Bar feed to spindle liner		Full positioning by integral servo drive	
Bar load to guide vee		Electrically driven multi-vee pick and place from adjustable table	
Bar stock preparation		Chamfer not required - de-burr only	
Bar guide within spindle		.0197"(.05mm) -.0394"(1mm) clear support bushings or liners	
Vee guide adjustment		Manual unclamp/clamp lever with handwheel height adjustment	
Total working travel		46.69"(118mm)	
Bar pusher rapid traverse rate		Same as lathe	
Programming		Programming pages on G.E.Fanuc 21i/18i TB for operation and unmanned running including height adjustment	
Overall dimensions		66.9"(170mm) L x 40.2"(102mm) W x 46.1"(117mm) H	