



CAMPRO CPV-1200B

HIGH PERFORMANCE VERTICAL MACHINING CENTER

MACHINE FEATURES

- Constructed with high quality meehanite cast iron and heat treated to relieve stress thereby assuring maximum rigidity and accuracy.
- Box ways on all 3 axes greatly upgrades stability and dampening capability.
- Automatic lubrication unit with intelligent pressure failure detection function provides reliable supply for saving cost and for environmental protection.
- Oil-coolant separation design which meets the environment protection requirements allows centralized collection for all way oil.

STANDARD FEATURES:

- * Fanuc Oi-MF Control (Package 1)
- * AI APC Contour Control
- * 12,000 RPM Spindle (Belt Drive)
- * Powerful 25 hp high torque spindle motor
- * High Column (20.9" + 9.8")
- * Cartridge Spindle Design
- * CAT40 Big Plus Spindle
- * 1000 PSI Coolant Through Spindle Prep
- * Spindle Air Blow
- * Rigid tapping

STANDARD FEATURES (CONT'D):

- * Custom Macro B (User Definable)
- * Twin Arm 24 Tool ATC
- * Portable Manual pulse generator
- * Massive One-piece Meehanite cast iron bed
- * Chip Auger
- * 4th Axis Prep (no amplifier)
- * Low friction Turcite mating way surfaces
- * Double Anchored, Pre-tensioned Ballscrews
- * Fast 787 IPM Rapid Traverse rate
- * Full enclosure splash guard
- * Flood coolant with large coolant tank
- * Work light
- * Operator call lamp (red, yellow, green)
- * Spindle load meter
- * Assembly and operation tools
- * Auto Power Off
- * Heat exchanger for Electrical Cabinet
- * Instruction manual, parts list, and electrical diagram
- * Fanuc operator and maintenance manuals
- * WARRANTY-MACHINE: One-Year
- * WARRANTY-CONTROL: Two-Year Parts and Labor

SPECIFICATIONS

CAPACITY:

X axis travel	47.2"
Y axis travel	29.6"
Z axis travel	25.5"
Table loading area	51.1" x 27.5"
Allowable table load	3,306 pounds

SPINDLE:

Spindle nose to table top	5.1" – 30.7"
Column to spindle center	30.7"
Spindle taper	CAT 40 Big Plus
Spindle speed	12,000 RPM
A.C. spindle motor	25 HP
Spindle torque	132 ft-lbs.
Spindle Driving Method	Belt Drive

AUTOMATIC TOOL CHANGER:

ATC Type	Twin Arm Type
Number of Tools	24
Tool Shank	CAT 40
Max. Tool Dia.	3.1"
Max tool Diameter (No Adjacent Tool)	5.9"
Max. Tool Length	9.8"
Max. Tool Weight	15.4 lbs.
Tool Selection	Random Bi-Directional

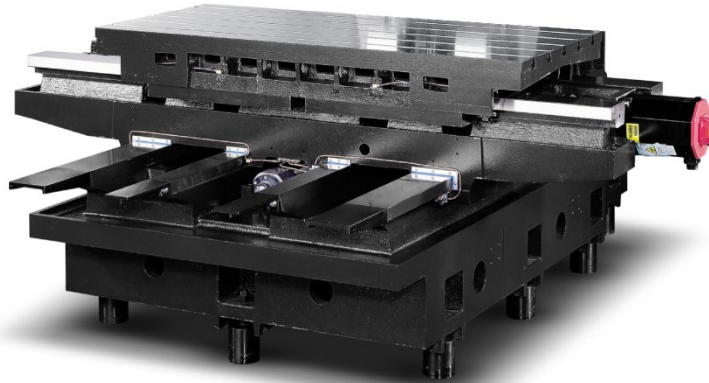
SPECIFICATIONS (CONT'D.):

MOTION:

X and Y axis rapid traverse rate	590 IPM
Z axis rapid traverse rate	590 IPM
Cutting feed rate	393 IPM
Slide Type	Box Ways
Least command increment	.001mm,
Positioning accuracy	+/- .00020" (full stroke)
Repeatability	+/- .00008"

GENERAL:

Floor Space Required (W x D X H)	131" x 106" X 113"
Machine Weight	23,150 lbs.
Standard Power Source Requirement - Fanuc	205-235 Volts / 3 Phase/60HZ
Power Capacity	53 Amps Minimum
Air Source Requirement	85 – 115 PSI



CONSTRUCTION:

Balanced 12,000 RPM Spindle with 6000 BTU spindle oil cooler for High Speed Machining.

Hardened and Ground C3 Double Nut Ballscrews (Ø40 mm) are pre-tensioned to minimize backlash, provide high precision movement, and reduce heat deformation on all axes.

All solid ways are coated with high grade Turcite-B. Hardened and ground slideways give an extra 40% wear resistance.

4 Solid Box Ways are on a one-piece base instead of two supporting ways connected to the main base, which provides more rigidity under heavy machining.

Main frame is made of Meehanite casting for superior rigidity

CONSTRUCTION (CONT'D)

BED, COLUMN, AND SADDLE:

The bed is a rigid one-piece casting with heavy ribbing to prevent deformation during heavy cutting. Fine grain Meehanite cast iron is used for its excellent dampening characteristics. Extra wide boxways provide excellent support for the saddle, regardless of the load distribution on the table. The table is fully supported by the saddle in all positions. There is no table overhang. The rigid box type column casting is heavily ribbed to prevent twisting or distortion.

SPINDLE, HEADSTOCK, AND COLUMN

The high speed, 12,000 RPM, 40 taper spindle is a true cartridge type unit supported by precision class bearings that are permanently grease lubricated. The spindle is driven by a high torque 20 HP (30 min.) A.C. motor delivering an impressive 132 ft/lbs. Power is transferred through a heavy-duty cogged drive belt eliminating slippage, promoting thermal stability, and minimizing vibration. An encoder is attached to the spindle to allow rigid tapping.

GUIDEWAYS

Wide Box ways are used for unsurpassed long-term rigidity and accuracy. Each guideway is induction hardened and precision ground. Turcite is bonded to the mating way surfaces and then hand scraped to ensure perfect fit and tolerances. The Turcite resin with forced way lubrication provides a low friction surface and virtually eliminates guideway wear. All guideways are fully protected from chips and damage.

OIL JACKET SPINDLE CHILLER (STANDARD)

Machine accuracy is maintained by using a refrigeration system that circulates cooled oil around the spindle reducing the thermal effects of any heat generated.

AUTOMATIC TOOL CHANGER

The high quality 24-position tool changer uses a fast random bi-directional twin arm with 2.5 second tool-to-tool change time, and 6 seconds chip to chip.

BALL SCREWS AND AXIS DRIVES

Each axis is driven by a high precision double-nut ballscrew. The ballscrews are centered between the guideways. The ballscrews are supported on both ends by angular contact thrust bearings. This double anchored pretension design provides outstanding positioning repeatability with virtually no thermal growth. All axes have large diameter 40 mm ball screws that are connected directly to oversize AC servo drive motors without gears or belts, to eliminate backlash. Each axis has a flexible coupling to protect the ball screw in the event of a sudden impact. These couplings can be quickly reset.

PORTABLE MANUAL PULSE GENERATOR

The hand held "Manual Pulse Generator" lets each axis move in increments of 0.0001", 0.0010" or 0.0100" making fixture or part alignment quick and easy. The 10-foot cord gives full access to the machine.

PROGRAM AND DATA PROTECTION KEY SWITCH

The keyed switch enables the protection mode for both the program and offset data. Removing the key limits access to only authorized personnel. In the unprotected position the key can not be removed and all data is available for edit.

290 PSI (20 BAR) THROUGH-SPINDLE-COOLANT SYSTEM (Option)

A dedicated 290-PSI positive displacement pump delivers the coolant directly to the tool tip. The immediate benefit is more aggressive feeds and speeds can be maintained throughout the cutting process. There is also no need to stop and adjust coolant nozzles increasing the in-cut time and operator safety. Protecting the spindle and the vital rotary union from contamination is a canister filter with a replaceable 10-micron element.

CONSTRUCTION (CONT'D.)

1,000 PSI THROUGH-SPINDLE-COOLANT (OPTION)

Severe applications, holes with high length to diameter ratios or tough materials require high-pressure coolant to evacuate chips and keep the cutting edge cool. The increased coolant and chip flow improves finishes and tool life, while allowing more aggressive feeds and speeds.

FULLY ENCLOSED GUARDING

The fully enclosed guarding, including cut-out for filter mist, is made of heavy gauge sheet metal to contain both chips, coolant and coolant mist. The large dual sliding doors open to provide unrestricted overhead access for ease of lifting heavy fixtures or work pieces.

CHIP DISPOSAL AND COOLANT SYSTEM

High volume coolant system washes chips down into the front of sheet metal enclosure for chip auger evacuation and provides flood coolant through adjustable head mounted nozzles along with four flushing nozzles mounted directly to spindle nose.

Control Specifications - Fanuc OiM-F Control

8.4" color LCD screen

Color graphics

Simultaneous Controlled Axis

Least input Increment on X, Y, and Z is .001 mm

Least command increment on X, Y, and Z is .001mm

Inch/Metric Conversion (G20/G21)

Interlock on All Axes

Machine Lock on All Axes

Emergency Stop

Stored Stroke Check 1, 2, 3,

Mirror Image

Backlash Compensation

Unexpected disturbance torque detection

Stored pitch compensation

Automatic Operation (Memory)

MDI Operation

Search Function (Sequence, Program)

Program restart

Dry Run

Single Block

Buffer Register

Manual Handle Interrupt

Manual Jog Feed (Rapid, Jog, Handle)

Manual Handle Feed Rate (x1, x10, x100)

Feed Command (F Code Feedrate Direct Command)

Feedrate Override 0-200% (10% Unit)

Jog feed 0-5,000 mm/min (197 ipm)

Rapid traverse override (F0, F25%, F50%, F100%)

Override Cancel

Rapid Traverse Bell-Shaped Acceleration/Deceleration

Block Skip

Exact Stop Mode / Exact Stop (G61/G09)

Dwell (G04)

Helical Interpolation

Threading/Synchronous Feed

Manual Reference Point Return

1st Reference Point Return G28

Control Specifications - Fanuc OiM-F Control (CONT'D.)

Reference Point Return Check G27
2nd Reference Point Return G30
3rd and 4th Reference Point Return
Program stop, optional stop, end of pgm M00, M01, M02, M30
Tape Code EIA RS-244/ISO 840 (Automatic Recognition)
Optional Block Skip (9 ea)
Maximum Programmable Dimensions +/- 9999.9999" (+/- 8 digits)
Program Number O4 Digit
Absolute and Incremental Command G90/G91
Decimal Point Input
Plane Selection G17. G18. G19
Work Coordinate System Setting (G52 – G59)
Work Coordinate Preset
Additional Work Coordinate System 48 pairs
Manual Absolute "On" fixed
Programmable Data Input G10
Sub Program Call 4 Levels of Nesting Custom Macro #100 to #199
Addition to Custom Macro Common Variables #500 to #999
Circular Interpolation by radius R
Canned Cycle (G73, G74, G76, G80 ~ G89)
Optional Chamfering / Corner R
Skip Function (G31)
Automatic Coordinate System Setting
Coordinate System Rotation
Programmable Mirror Image
Single direction positioning (G60)
External Data Input (Tool Offset, message, machine zero point shift)
Cylindrical interpolation
A1 Advance Preview Control (G5.1)
Polar Coordinate Command
Miscellaneous Function (M3 digits)
Miscellaneous Function Lock
Spindle Speed Command (S5 Digits, binary output)
Spindle Speed Override (50% ~ 120%) 10% Unit
Rigid Tapping
Cutter Compensation C (G40-G42)
Tool Length Measurement
Tool Length Compensation (G43, G44, G49)
Tool Offset Amount (+/- 6 Digits)
Tool Offset Pairs (400 Pairs)
Tool Life Management
Reader/Puncher Interface RS232C
Memory Card input/output
Embedded Ethernet (100 Mbps)
Part Program Storage Length: 320M
Registered Programs 400 ea
Memory Lock
Back Ground Editing
Extended Part Program Editing (Copy, Move, Change of NC Program)
Self Diagnosis Function
History Display of Alarm and Operator Message

Control Specifications - Fanuc OiM-F Control (CONT'D.)

Help Function

Run Hour / Parts Count Display

Actual Cutting Feedrate Display

Spindle / Servo Setting Screen

Multi-language display (Selection of 5 Optional Language)

Erase CRT Screen Display (Screen Saver)

Bi-Direction Pitch Error Compensation

Tool Management Function

Protection of Data at 8-Levels

Tool Monitoring Function (HWTM – Built-on Fanuc Type)

Fanuc Manual Guide i conversational programming

Alpha i AC digital servo system with 1,000,000 pulse encoders

Full MDI keyboard

PCMCIA data card slot on left side of LCD for program input / output – up to 2GB storage

Advanced Preview Control (Look ahead of multi-blocks – 20 blocks look ahead)

Automatic Acceleration / deceleration with Bell Shaped rapid acc / dec

3 axes simultaneous control std. (4 axis opt.)

Scaling

Custom Macro B

High speed skip signal