

TORNADO

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

Specification	T2	T4/T6M/MS	T8/M/MS/T10/M
Bar Capacity			
Round inch	.23"-1.65" (6-42mm)	.23"-2.04" (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		

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 life monitoring
- Tool wear/breakage detection
- Sister tool replacement routines
- In process gauging