

ACRA®

SUPER MAX-P SERIES

VERTICAL MACHINING CENTER



- ASMC-510P / 610P
- ASMC-850P / 1000P



THE LEADER IN QUALITY AND RELIABILITY
~SINCE 1973~



EMC / CE / ISO9002 CERTIFIED

SUPER MAX-P SERIES VERTICAL MACHING CENTER



- ❶ Floating cushion retractor design can lower the impact on spindle bearings during tool change.

It also helps to maintain the spindle's accuracy and extends the life of spindle.



HIGH RIGIDITY, HIGH ACCURACY CONSTRUCTION

- ❷ High rigidity, high accuracy construction parts are extreme heavy ribbed meehanite cast iron.

The axes slide-ways are SQUARE-shaped for improving heavy cutting stability and consistent accuracy. 40mm diameter ultra precision ballscrews directly coupled to the feed motors. P5 class bearing an oversized mount blocks capture all both ends.



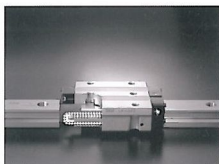
RELIABLE AUTOMATIC TOOL CHANGING UNIT

- ❸ The carousel type ATC unit utilizes the pneumatic tool un-clamp system and unique compact mechanism. This provides the exceptional smoothness and reliable tool change operation.

The 16 Tools for ASMC-510P/610P and tools for ASMC-850P/1000P magazine can locate the next tool in random shortest way with one single command. An optional 16 Tools for ASMC-510P/610P and 20/24 Tools for ASMC-850P/1000P arm type ATC unit is available.

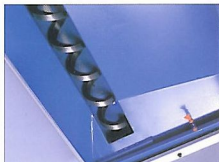


- ❹ OPT. ARM Type ATC

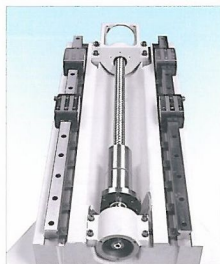


- ❺ Linear roller guides for 3 axes increase loading capacity rigidity and vibration absorption. The design can also maintain accuracy and stability in operation.

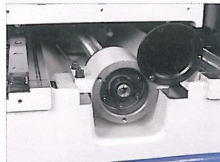
Size: X-16x30c2r108012p
Y-16x30c2r84012p
Z-16x35c2r2012p



- ❻ Built-in chip auger for quick chip removal. Material: forged iron dia. x pitch x rate in 90mm x 80-11 x r55-60"

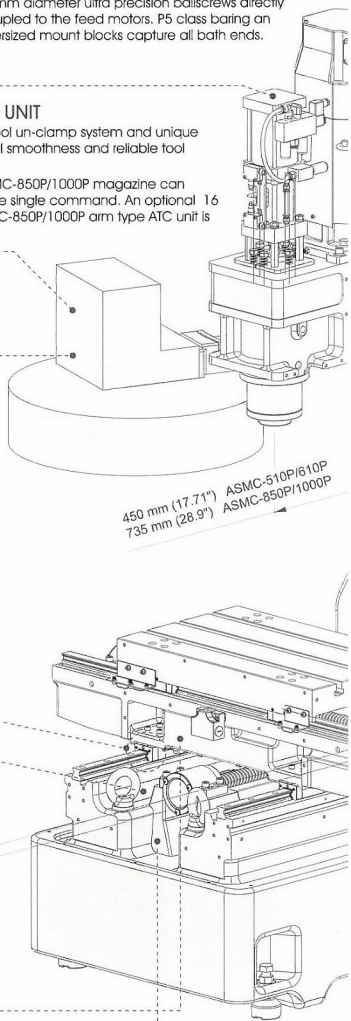


- ❷ All ballscrews for 3 axes are C3 grade and are hardened and ground for best feeding accuracy.



- ❸ Pre-extended ball screw ensures straightness and lengthen the life of ball screw.

28 mm (1-1/16") ASMC-510P/610P
34.2 mm (1-1/32") ASMC-850P/1000P



FULL ENCLOSED SLIDING SPLASH GUARDS

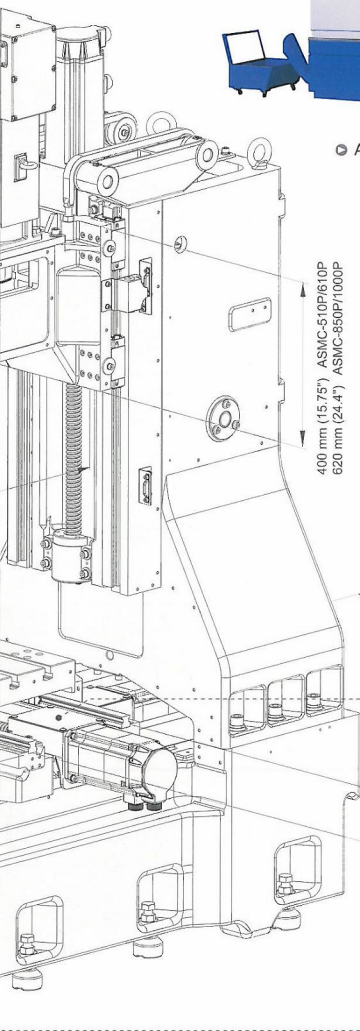
- Chip auger is standard for all ACRA machines. Their wide-view and super transparent acrylic-plastic windows offer safety and free from splashing of contamination while operating the machine.



ASMC-510P / ASMC-610P

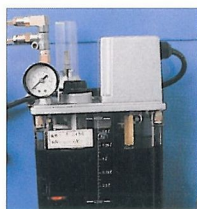


ASMC-850P / ASMC-1000P



RELIABLE MACHINE OPERATOR INTERFACE

- The control panel rotates, also meets the safety requirement. The automatic diagnosis function displays the malfunction on screen for quick trouble shooting. The touch switch, diagram and text on screen make the operation easy. The portable MPG is ideal for easy work-piece set-up.

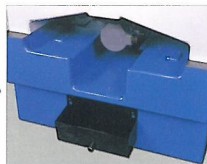


AUTOMATIC LUBRICATION SYSTEM

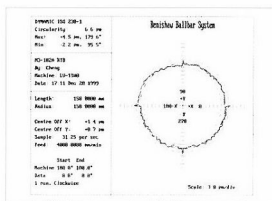
- All 3 axes slide-ways and ballscrews are lubricated by automatic lubrication system, which prevent the head distortion during a long time, high speed machining process.



- High precision couplings are used to ensure working accuracy in the transmission between ballscrew and servo motors.



- Tramp oil recovery.



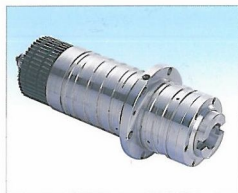
- The Reineshaw ball bar instrument calibrates the circularity and the geometrical accuracy to ensure the precise three dimensional motions.

STANDARD ACCESSORIES

- Full Enclosed Splash Guard
- X.Y.Z Axes Guide-Way Cover
- Spindle Air Blow
- Coolant System
- Rigid Tapping
- Automatic Lubrication System
- Auto Zero-Point Ret Protect
- Floating Cushion Retractor
- Work Lamp
- Alarm Lamp
- EC Cabinet Heat Exchanger
- Lube / Coolant System
- M-Code M81 And M84
- Memory Size-Mitsubishi-600M, Fanuc-200M
- Portable M.P.G
- Chip Auger
- Auto Power Off -M30
- Tools and Toolbox
- Leveling Bolts and Pad
- Operating Manual and Maintenance Manual.
- Standard Controller-Mitsubishi M70

OPTIONAL ACCESSORIES

- Arm-Type ATC
- CNC Rotary Table - 4th Axis
- CNC Tilting Rotary Table
- Spindle Oil Cooler
- Touch Probe & Digitizing Software
- Coolant Through Spindle Device
- Automatic Tool Length Measurement
- 10000 or 12000 RPM Spindle & Oil Cooler
- Coolant Through Toolholder Device
- Chain Hinge Type CE Conveyor
- Air Conditioner For Electric Cabinet
- Linear Scale Feedback
- Oil Skimmer
- Machine Vices
- Package Toolings
- Mitsubishi M70 Controller
- Fanuc Oi-MC / 18i-MB
- Anilam 6000i
- Siemen 802D / 810D / 840D
- Selca S4045 / S4045PD Controller
- Heidenhain iTNC-530 Controller
- Fagor 8055MC Controller
- Transformer
- Sub Tables
- CE Mark



• BT#40 SPINDLE



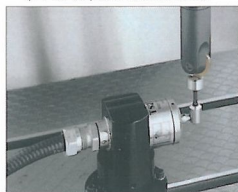
• SPINDLE OIL COOLER



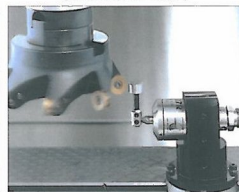
• 100mm / 125 mm / 250 mm
(4" / 5" / 10") CNC ROTARY TABLE



• WORKPIECE PROBE
(RENISHAW MP-10/12)



• AUTOMATIC TOOL LENGTH & RADIUS MEASUREMENT (RENISHAW TS-27R)



WIDER SELECTION CONTROLLERS



SIEMENS

802D / 810D / 840D



HEIDENHAIN

iTNC - 530



SELCA

S4045 / S4045PD



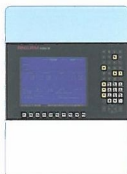
FANUC

Oi - MC / 18i - MB



MITSUBISHI

M70



ANILAM

6000i

SPECIFICATION

MODEL		ASMC-510P	ASMC-610P	ASMC-850P	ASMC-1000P
Table	Table overall size	650 x 400 mm (25.6" x 15.75")	750 x 400 mm (29.5" x 15.75")	950 x 630 mm (37.4" x 24.8")	1100 x 630 mm (43.3" x 24.8")
	T slots	No.3 x 18 mm x 110 mm (No.3 x 0.7" x 4.3")		No.5 x 18 mm x 130 mm (No.5 x 0.7" x 5.1")	
	Max. loading	300 kgs (660 Lbs)		600 kgs (1323 Lbs)	
Travels	X-axis	510 mm (20")	610 mm (24")	850 mm (33.5")	1050 mm (41.3")
	Y-axis	410 mm (16")		560 mm (22.0")	630 mm (24.8")
	Z-axis	460 mm (18")		560 mm (22.0")	610 mm (24.0")
Distance	Spindle to column way	450 mm (17.7")		630 mm (24.8")	700 mm (27.6")
	Spindle to table surface	90-550 mm (3.5" - 21.05")		120-680 mm (4.7" - 26.8")	120-730 mm (4.7" - 28.7")
Spindle	Taper	BT#40 or CAT#40			
	Speed	50 ~ 8000 rpm			
	Motor-Continuous	3.75 KW (5 HP)	5.5 KW (7.5 HP)	7.5 KW (10 HP)	11.2 KW (15 HP)
Axis motor: X / Y / Z		1 KW		2 KW	
Rapid feed rate X/Y/Z	Standard	24 / 24 / 20 M/min (944 / 944 / 787 IPM)			
	Optional	32 / 32 / 28 M/min (1260 / 1260 / 1100 RPM)		36 / 36 / 30 M/min (1416 / 1416 / 1180 RPM)	
	Minumum setting	0.001 mm (0.00004")			
Automatic Tool Changer	Type of ATC	Carousel or Optional-Arm Type		Carousel or Optional-Swing Arm Type	
	No. of ATC	16 (Std.) / 20 (Opt.)	16 Swing Arm (Opt.)	20	
	Max. tool Length	250 mm (10")		300 mm (11.8")	
	Max. tool weight	7 kgs (15.4 Lbs)			
	Tool to tool	7 SEC			
	Chip to Chip	11 SEC			
Ball screws on 3 axis	Diameter x pitch	36 mm x 10 pitch or 36 mm x 12 pitch		40 mm x 12 pitch	
	Precision grade	DOUBLE NUT		C3-0.008 / 300 mm	
Coolant & Lubrication	Coolant motor power	0.8 KW (1.05 HP)			
	Coolant tank volume	150 L (39.6 Gal)		200 L (53 Gal)	
	Coolant motor capacity	20 L/min (5.3 Gal/min)			
	Lubrication motor power	0.3 KW			
	Lubrication motor volume	2L (0.5 Gal)			
Accuracy	Positioning	±0.005 / 300 mm (±0.0002" / 12")			
	Repeatability	±0.003 mm (±0.00018")			
	Roundness	±0.001/300 mm (±0.0004" / 12")			
Machine Net Weight		3300 kgs (7273 Lbs)	3400 kgs (8636 Lbs)	5600 kgs (12346 Lbs)	
Power required		17 KVA		22 KVA	
Pneumatic required		6 kgf/cm ² (86 PSI)			
Floor space		2050 x 2600 x 2160 mm (80.7" x 102.4" x 85")		2240 x 2650 mm (88.2" x 104.3")	

* We reserve the right to modify and improve above specification without notice.



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