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AMS[®]
In Pursuit of Excellence

SPECIAL

Vertical Machining Centers



FIER V
LEADER 400 XL
DM 800

Ace Micromatic
Group Company

Special Vertical Machining Center

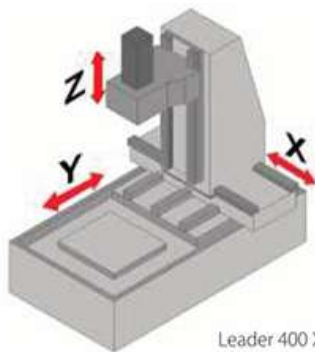


Fier V

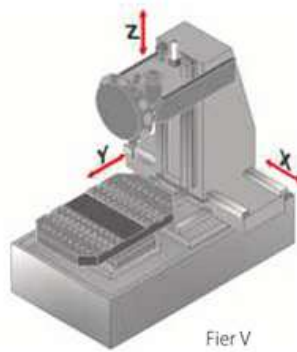
Special machining centers includes column moving vertical machining center Leader 400 XL & Fier V, High precision machining center DM 800. Leader 400 XL & Fier V can be offered with Rotary type pallet changer or a fixed table suiting the application.

The DM 800 is discerned by a completely new design, the box in box design supports the spindle headstock. The concept of allowing the table to move only along y axes lets a variety of components to be loaded on to the table, especially the large sized heavier ones to be machined on it comfortably. The structural configuration of the machine makes it suitable for a die - mold or aerospace applications. High precision spindles, high spindle speeds and feed rates ensures that the demand for superior performance is met.

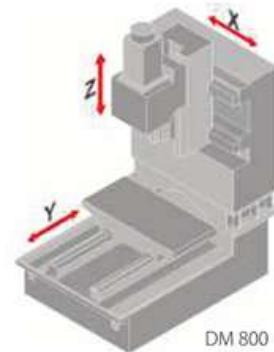
Ease of Operation



Leader 400 XL



Fier V



DM 800

Automatic tool changer



Front mounted ATC



Side mounted ATC

12 tool front mounted ATC is standard for Fier V, 30 tool side mounted ATC is standard for Leader 400 XL, 20 tool side mounted ATC is standard for DM 800

Chip Conveyor



Removing chips is very important in terms of productivity & environmental protection. AMS provides various chip handling systems for better work environment. Coil conveyor & screw conveyor also offered for cast iron and steel applications.

	Al Chips	Cast Iron Chips	Steel (Short Chips)
Scraper	✓	✓	
Slat cum scraper	✓	✓	✓
Magnetic		✓	✓

CNC Control System Options



Fanuc 0iMATE MD/ 0iMD

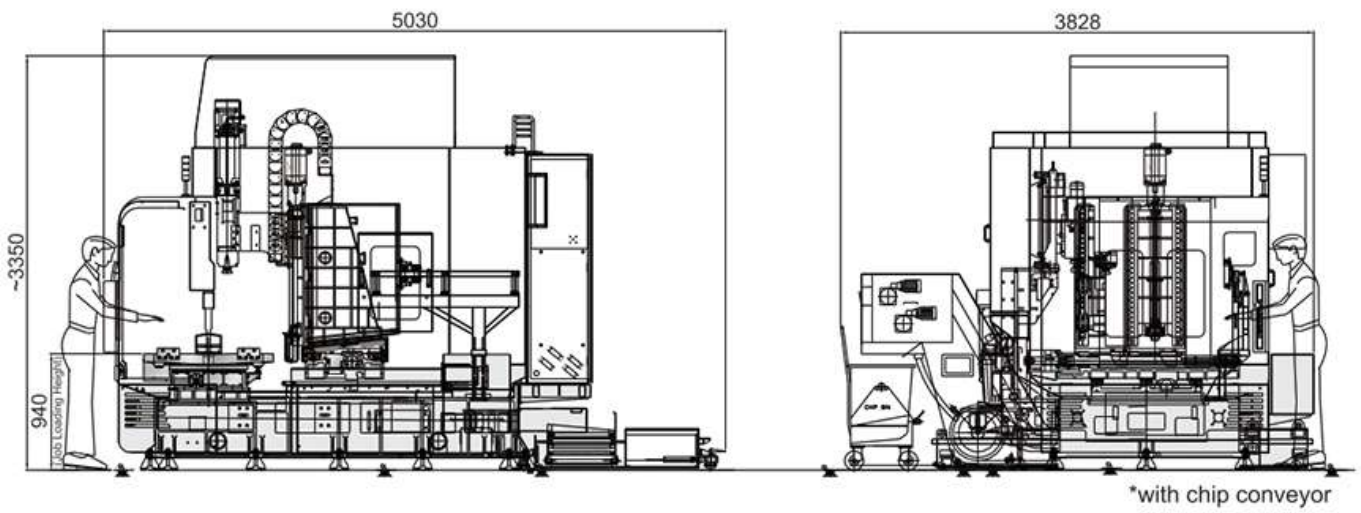


Siemens 828D / 840D

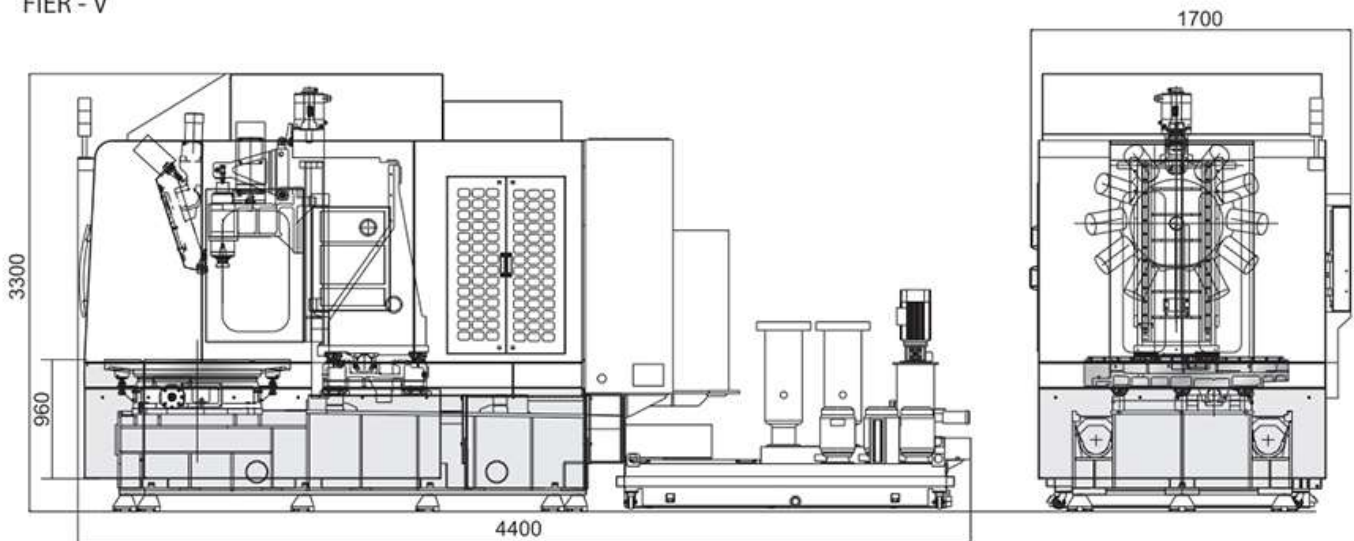
Fanuc 0iMate MD is standard for Fier V, Fanuc 0iMD is standard feature for Leader 400 XL & DM 800. Siemens 828D / 840D can be offered as an optional for DM 800

Machine Layout

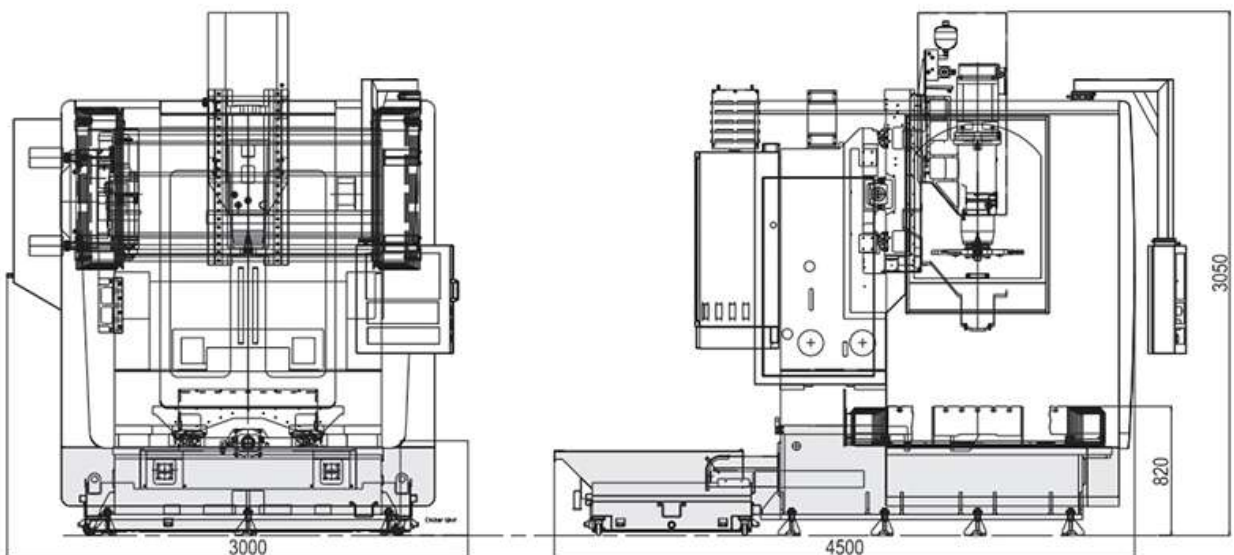
Leader 400 XL



FIER - V



DM 800



Specifications

		Leader 400 XL	FIER-V	DM-800
CAPACITY				
Longitudinal travel (X - Axis)	mm	600	500	1000
Headstock travel (Y - Axis)	mm	450	450	800
Cross travel (Z - Axis)	mm	500	350	500
Spindle face to table top	mm	250 - 750	180-530	160 - 650
Distance from floor to table top	mm	860	900	820
TABLE				
Table	mm x mm	750 x 400 (2)	760 x 375 (2)	1000 x 700
T - slot (No.x size x pitch)		M16 TAP@100 PITCH	M16 TAP@100 PITCH	6 x 18 x 100
Max. load on Table	kgf	300	300	1500
SPINDLE & AXES				
Spindle taper		7 / 24 No.40	7 / 24 No.40	7 / 24 No.40
Spindle speed - Std. / Opt	rpm	8000 / 10000	8000	8000 / 10000
Spindle power	kW	11 / 7.5	7.5/5.5	15/11
Spindle power - Opt	kW	15/11		
Rapid traverse - X / Y / Z	m / min	50/50/40	40/40/32	20/20/16
Feed rate	mm / min	1 - 10000	1 - 10000	1 - 10000
Guideways	Type	LM	LM	LM
ACCURACY - As per ISO 230-2				
Positioning accuracy		0.010	0.010	0.010
Repeatability		± 0.003	± 0.003	± 0.003
ACCURACY - As per VDI / DGQ 3441				
Positioning accuracy		0.015	0.015	0.015
Repeatability		± 0.005	± 0.005	± 0.005
AUTOMATIC TOOL CHANGER				
Tool change system		Twin Arm	Disc Armless	Twin Arm
Tool storage capacity - Std.	Nos.	30	12	20 / 30
Max. tool dia with adjacent pockets full	mm	75	125	80
Max. tool dia with adjacent pockets empty	mm	125		125
Max. tool length	mm	250	250	250
Max. tool weight	kgf	8	6	8
Chip to chip time **	sec.	5	3.2	6.5
Tool shank type		BT - 40	BT - 40	BT - 40
CNC System Std-FANUC		0iMD	0i MateMD	0iMD
Opt.- Siemens				828D / 840D
INSTALLATION DATA				
Floor space	mm x mm	2600 x 4400	1700 x 4400	3000 x 4500
Machine height	mm	3300	2700	3050
Basic machine weight	kgf	7000	4500	9500
Power supply (Basic Machine)	kVA	40	16	40

** Valid for Standard specifications *All specifications are subject to change without prior notice

Standard features

- Rigid tapping
- Tool shank: BT-40
- Spindle power:
Fier V – 7.5 / 5.5 kW
Leader 400 – 11 / 7.5 kW
DM 800 – 15 / 11 kW
- Spindle speed of 8000 rpm
- Three tier indication lamp
- Full guarding
- Coolant tank & Chip tray
- Flood coolant & coolant gun
- Manual pulse generator (Handheld)
- Laser calibration & ball bar test
- Panel cooler for electrical cabinet

Optional features

- Through spindle coolant system
- Higher spindle power & speed
- Spindle chiller unit
- Chip conveyor
- Coil conveyor
- TPM Friendly machine
- Tooling up solutions & Automation

AMS[®] ACE MANUFACTURING SYSTEMS LTD.

In Pursuit of Excellence

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