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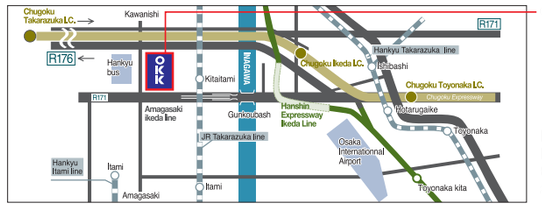
Access map



OKK Inagawa factory
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From Kansai International Airport : Please take a airport bus bound for Osaka (Itami) International Airport and take a taxi to OKK.


Technical Center


M-Plant


W-Plant

Technical center is for test cutting, demonstration and training.
M-plant is for machining and final assembly of machining center.
W-plant is for final assembly of large sized machining centers.
All are located at Inagawa, Itami city, Hyogo, Japan

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OKK A DIVERSIFIED MANUFACTURER OF MACHINE TOOLS
Specializes In:
Machining centers
Graphite cutting machining centers
Grinding centers
CNC Milling machines
Conventional milling machines
Total die and mold making systems
Flexible manufacturing cells and systems

Other Products Include:
Water Maters

NOTE :
OKK reserves the right to change the information contained in this brochure wihtout notice.
OKK is not responsible to make changes to previously sold machines or accessories.
The machines in the photographs of this brochure may include optional accessories.

The export of this product is subject to an authorization from the government of the exporting country.
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OKK
100 Years of Reliability & Precision
OKK CORPORATION

High-speed, High-accuracy
Hyper Machining Center

VP SERIES

VP 400
VP 500
VP 600

Higher Speed and Higher Precision!
Hyper MCs Debut to Respond to Users' Advanced Needs.

OKK's new series of hyper machining centers "VP Series" are the most efficient ever in the manufacturing fields of dies, jigs and tools that demand higher speed and precision along with the mass processing field that requires maximum productivity.

High-speed, High-accuracy
Hyper Machining Center

VP Series

High Response

VP500, 2APC Specification
(Direct-turn APC)

※Signal lamp (Option)

VP400, Standard Specification

VP600, Standard Specification

● Main features

Five models to choose from

Five models consisting of two standard models, and three 2APC models are available to meet specific needs of users.

High performance for improved productivity

The VP Series offers the spindle rotating speed of 12000 rpm, rapid traverse speed of 48 m/min (1890 ipm) for X and Y axes and 36 m/min (1418 ipm) for Z axis, and tool change time (tool-to-tool) of 1.2 seconds.

New structure and new technologies for enhanced machining accuracy. Equipped with linear roller guides. Improved fine-motion feed control and circular cutting accuracy. Minimal thermal displacement.

New and advanced European design

European-standard style for superb operability and workability.

● The machines in the photographs of this brochure may include optional accessories.

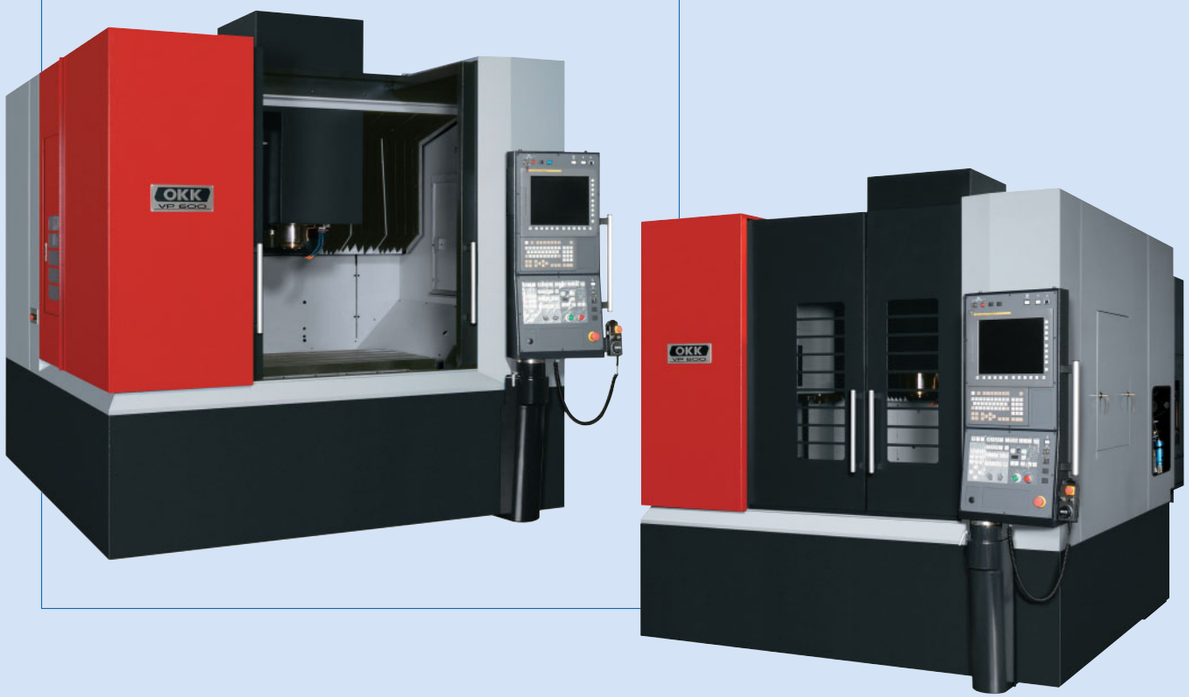
High-speed, High-accuracy Hyper Machining Center

VP 400
VP 600

● Standard Specification

Cutting rigidity is improved and minute feed characteristic is assured by adoption of massive main body structure, highly rigid linear roller guide and double anchoring method.

VP 600



Drastically reduced workpiece machining time

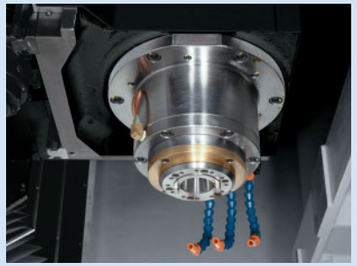
Rapid traverse rate	48 m/min(1890 ipm)(X and Y) 36 m/min (1418 ipm)(Z)
Maximum feed acceleration	0.7 G
Spindle startup time	1.5 s (0 →12000 rpm) ※
Tool changing time	1.2 s (Tool-to-Tool) 3.8 s (Cut-to-Cut)

※With spindle motor 22/18.5kW (30/25HP) , option

Standard provision of 12000rpm spindle

Cutting performance is largely improved by the use of the motorized spindle (MS) which integrates a motor covering a wide and high output range. Acceleration time of the spindle can be as short as only 1.5 seconds (※) from the non-operating state to the speed of 12000rpm. High-speed spindle of 20000rpm or 37/18.5kW (50/25HP) high-power spindle can also be adopted optionally.

※With spindle motor 37/18.5kW (50/25HP), option

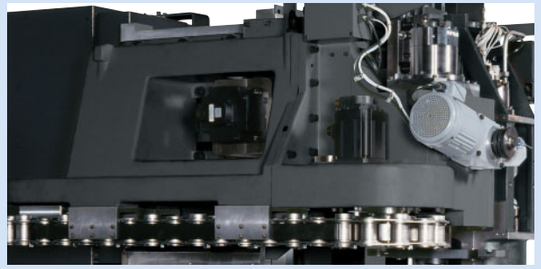


OKK's original tool changer ensures stable and high-speed operation

Tool changer adopts an OKK's original mechanism to completely synchronize between the ATC unit and the spindle and assures the stable operation and the tool changing time of 1.2 seconds (tool-to-tool) / 3.8 seconds (cut-to-cut).

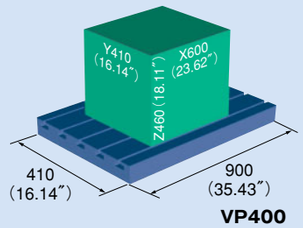
Extensive tool storage capacity

In addition to the standard provision of 20-tool magazine, optionally available are 30-tool magazine and separate type magazines for 40-tool, 60-tool, 80-tool and 120-tool storage.

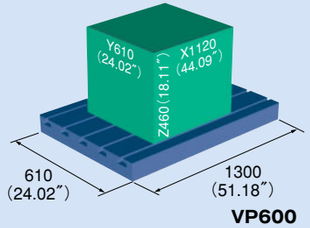


Wide machining area for versatile workpieces

VP400 table



VP400



VP600

● The machines in the photographs of this brochure may include optional accessories.

Machining with High Accuracy

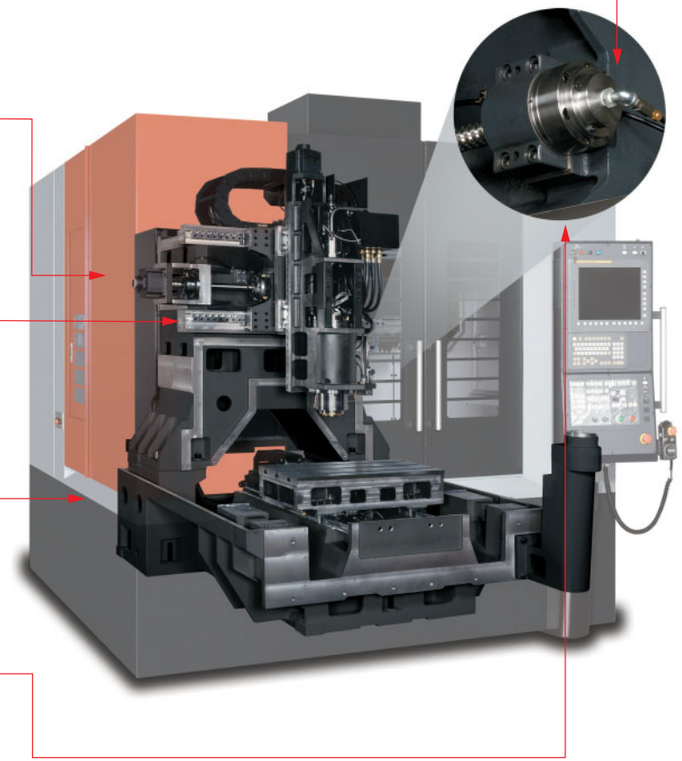
Core cooling system in the ball screw and its supports minimizes thermal displacement caused by the high-speed axis movement.

Double-anchoring method used for the ball screw support and improvement rigidity of the feed-system servo minimizes lost motion. (Chart 1)

Optimum arrangement of the spindle head and the saddle ensures improved thermal stability in the Y-axis direction and improved motion rigidity. (Fig. 1)

Use of the highly-rigid linear roller guides with minimum friction coefficient has improved the fine-motion feed control and the circular cutting accuracy. (Chart 2 + Fig. 3)

Use of the Soft Scale for compensating thermal displacement of the spindle and the HQ (High & Quick Response) control assures high and stable machining accuracy. (Fig. 2)



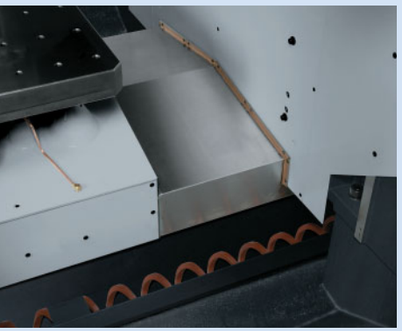
Structure with High Rigidity

Machine main body with thick-walled box-shaped structure and further improved thermal stability of the casting as a part of a thorough thermal displacement countermeasures.

Using the double-anchoring method for the ball screw support, improves the feeding rigidity four times as high as the conventional machines.

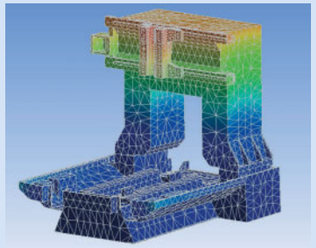
Measures for Ecology

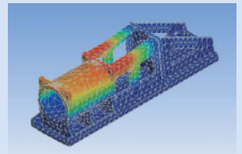
Grease lubrication is used for the spindle bearing and the ball screw feed guide sections.

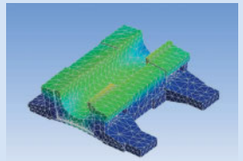


To prevent the main body structure from being exposed to coolant directly, the coolant shelter is provided as standard equipment, and all possible measures are taken against thermal displacement.

Rigidity Analysis by Finite Element Method (FEM) (Fig.1)



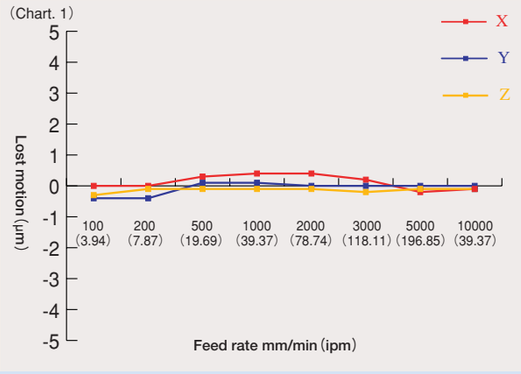




High-accuracy motion characteristic proved by the data

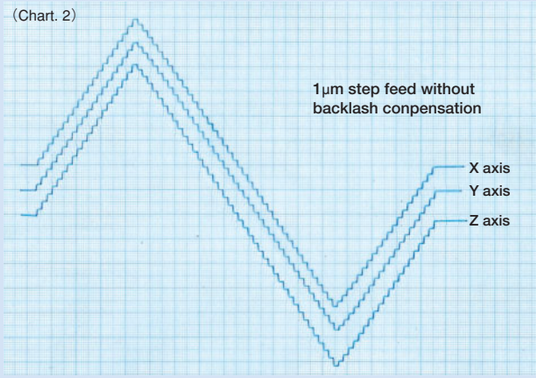
Lost Motion Measurement Data
(Actual Measurement Value)

(Chart. 1)



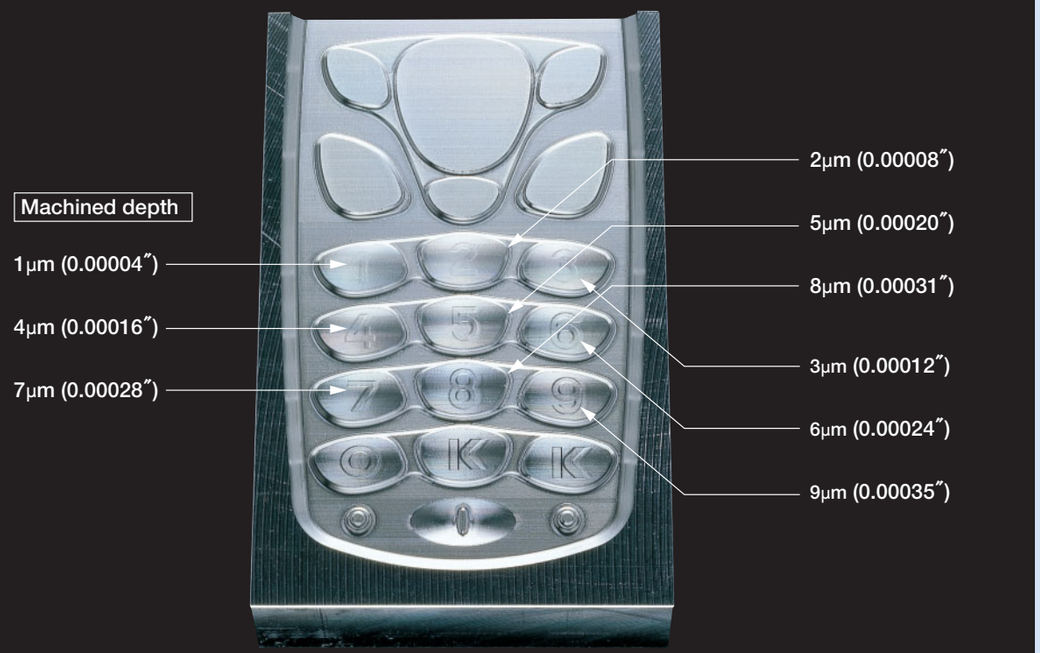
Minute Feed Measurement Data
(Actual Measurement Value)

(Chart. 2)



The data obtained under the OKK's internal testing conditions are shown here.
The data obtained may vary with status of the machine.

(Fig. 2)



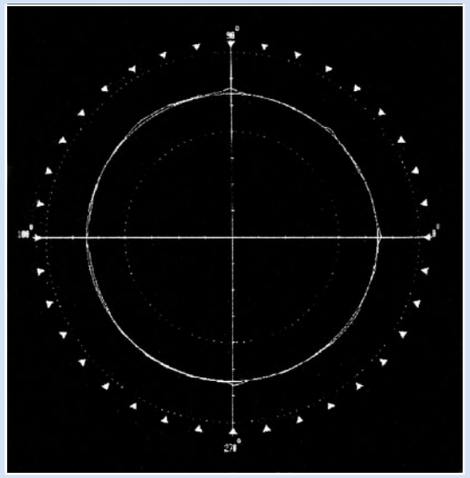
Cellular phone
(Machining of slightly different depth)

Model: VP400
Machined time: 3 hours
Workpiece size: 80 x 50 x 15 mm (3.15″×1.97″×0.59″)
Spindle speed: 12000 rpm
Feed rate: 600 to 4000 mm/min (23.62 to 157.48 ipm)
Workpiece material: NAK80 (HRC40)
Type of tool used: R2 to R0.5 ball end mill

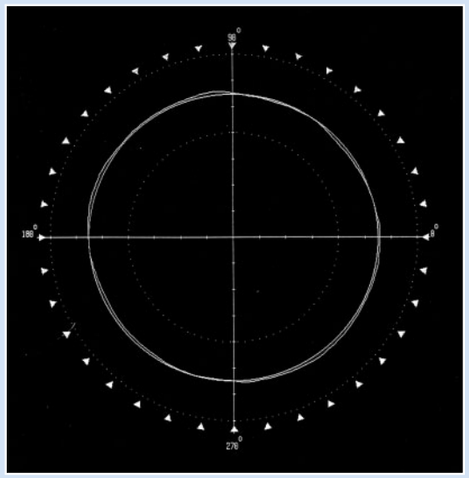
Listed data may not be attainable due to cutting conditions and other circumstances.

		Tolerance	Actual value
Straightness per full stroke : μm (inch)	X-Y	VP400:5 (0.0002″) VP600:5 (0.0002″)	VP400:X2 (0.00008″) Y1 (0.00004″) VP600:X4 (0.00016″) Y2 (0.00008″)
	Y-Z	5 (0.0002″)	2 (0.00008″)
	Z-X	5 (0.0002″)	2 (0.00008″)
Perpendicularity : μm (inch)	X-Y	5μm/300mm (0.0002″/11.81″)	2 (0.00008″)
	Y-Z (full stroke)	8 (0.00031″)	4 (0.00016″)
	Z-X (full stroke)	8 (0.00031″)	2 (0.00008″)
Positioning accuracy per full stroke : μm (inch)	X	±2.0 (±0.00008″)	±0.5 (±0.000020″)
	Y	±2.0 (±0.00008″)	±0.6 (±0.000024″)
	Z	±2.0 (±0.00008″)	±0.7 (±0.000028″)
Positioning repeatability per full stroke : μm (inch)	X	±1.0 (±0.00004″)	±0.4 (±0.000016″)
	Y	±1.0 (±0.00004″)	±0.3 (±0.000012″)
	Z	±1.0 (±0.00004″)	±0.2 (±0.000008″)
Spindle runout on table surface (for 300mm (11.81″) distance)	X-axis direction	8 (0.00031″)	3 (0.00012″)
	Y-axis direction	8 (0.00031″)	1 (0.00004″)
Spindle runout : μm (inch)(with a test bar mounted)	At base	3 (0.00012″)	1 (0.00004″)
	At 300 mm (11.81″)	12 (0.00047″)	8 (0.00031″)
Circularity : μm (inch) ϕ250mm, F500 (9.84″, 19.69 ipm)	CW	5 (0.00020″)	2.4 (0.000094″)
	CCW	5 (0.00020″)	2.6 (0.000102″)
Spindle vibration value : μm (inch)	X Y direction		3 (p-p)

Circular Cutting Accuracy (Fig. 3)



F500:2.4μm (19.69 ipm:0.000094″)



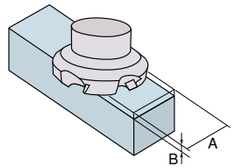
F5000:2.6μm (196.85 ipm : 0.000102″)

NOTES
※The values indicated above are of the standard specification machine having no linear scale.
※The sample data above was obtained in the short-time processing. The results may vary in the continuous processing.
※The sample data above was obtained under the OKK's internal cutting test conditions. The results may vary with the tools and fixtures used for processing.

Sample Cutting Data (VP600) (Workpiece material:S43C)

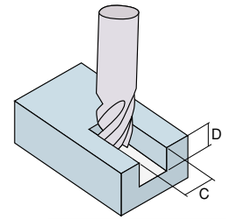
Values are for reference only.

Face milling
ϕ100×5t (Standard spec.)
ϕ80×4t (High power spec.)



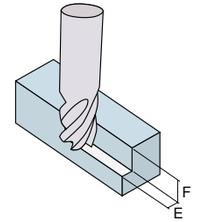
	Standard specification	High-power specification
Spindle speed	1000 rpm	1200 rpm
Cutting speed	314 m/min (8425 ipm)	300 m/min (1181 ipm)
Cutting width (A)	80 mm (3.15″)	60 mm (2.36″)
Cutting depth (B)	3 mm (0.12″)	4 mm (0.16″)
Feed rate	700 mm/min (27.56 ipm)	1450 mm/min (57.09 ipm)
Feed per tooth	0.14 mm/tooth (0.0055″/tooth)	0.3 mm/tooth (0.012″/tooth)
Cutting amount	168 cm³/min (10.1cu-inch/min)	348 cm³/min (20.9 cu-inch/min)
Spindle motor load	109 %	70 %

Grooving
ϕ32×2t



	Standard specification	High-power specification
Spindle speed	1400 rpm	1400 rpm
Cutting speed	141 m/min (5551 ipm)	141m/min (5551 ipm)
Cutting width (C)	32 mm (1.26″)	32 mm (1.26″)
Cutting depth (D)	5 mm (0.2″)	5 mm (0.2″)
Feed rate	1000 mm/min (39.37 ipm)	1200 mm/min (47.24 ipm)
Feed per tooth	0.357 mm/tooth (0.014″/tooth)	0.4 mm/tooth (0.016″/tooth)
Cutting amount	160 cm³/min (9.6cu-inch/min)	192 cm³/min (11.5cu-inch/min)
Spindle motor load	103 %	65 %

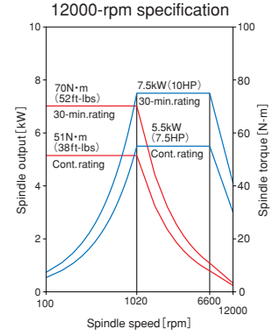
Side cutting
ϕ16×4t



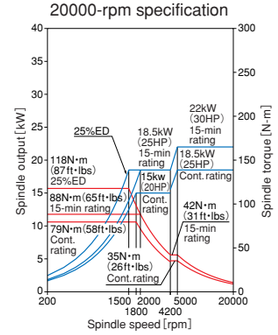
	Standard specification	High-power specification
Spindle speed	4000 rpm	6000rpm
Cutting speed	200 m/min (7874 ipm)	300 m/min (11811 ipm)
Cutting width (E)	1.5 mm (0.059″)	2 mm (0.08″)
Cutting depth (F)	30 mm (1.18″)	24 mm (0.94″)
Feed rate	2800 mm/min (110.24 ipm)	6000 mm/min (236.22 ipm)
Feed per tooth	0.175 mm/tooth (0.007″/tooth)	0.25 mm/tooth (0.01″/tooth)
Cutting amount	126 cm³/min (7.6cu-inch/min)	288 cm³/min (17.3cu-inch/min)
Spindle motor load	64 %	57 %

■MITSUBISHI

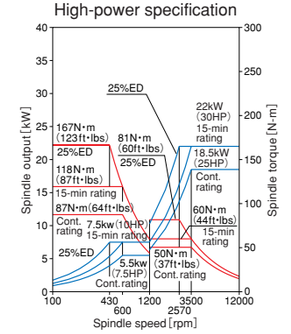
12000-rpm specification



20000-rpm specification

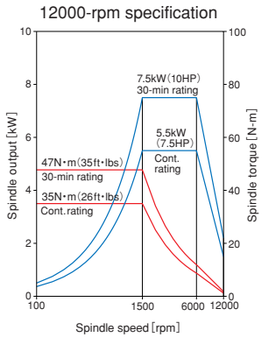


High-power specification

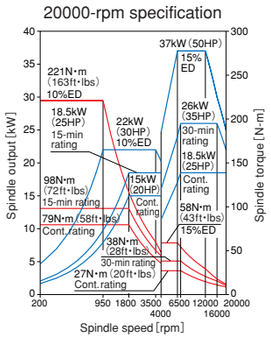


■FANUC

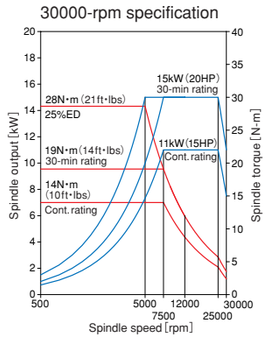
12000-rpm specification



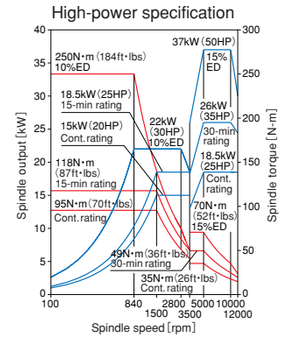
20000-rpm specification



30000-rpm specification



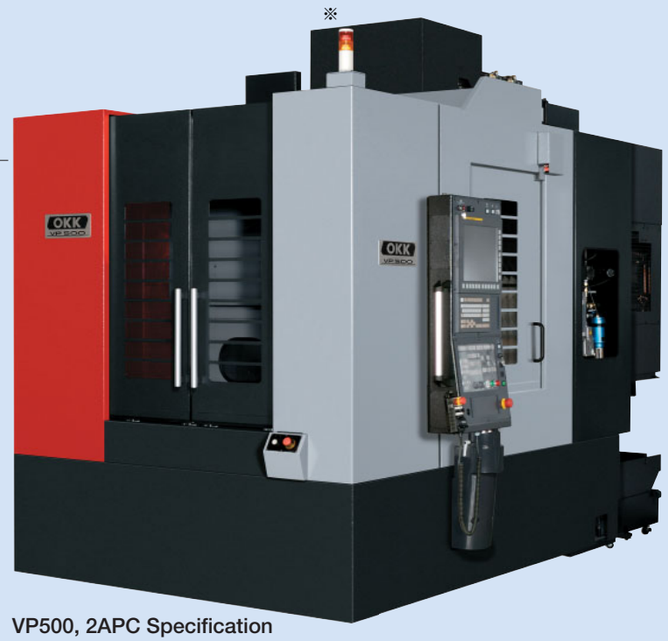
High-power specification



●For VP400 and VP600, the 12000-rpm specification is standard specification.
For VP500-2APC, the high-power specification is standard specification.

VP 400
VP 500
VP 600

● 2APC Specification



※

VP500, 2APC Specification

Realizes the pallet change in the shortest time in its class and the largely reduced non-cutting time

Pallet size

■VP400:500×400mm (19.69″×15.75″)
■VP500:600×500mm (23.62″×19.69″)
■VP600:800×500mm (31.50″×19.69″)

※

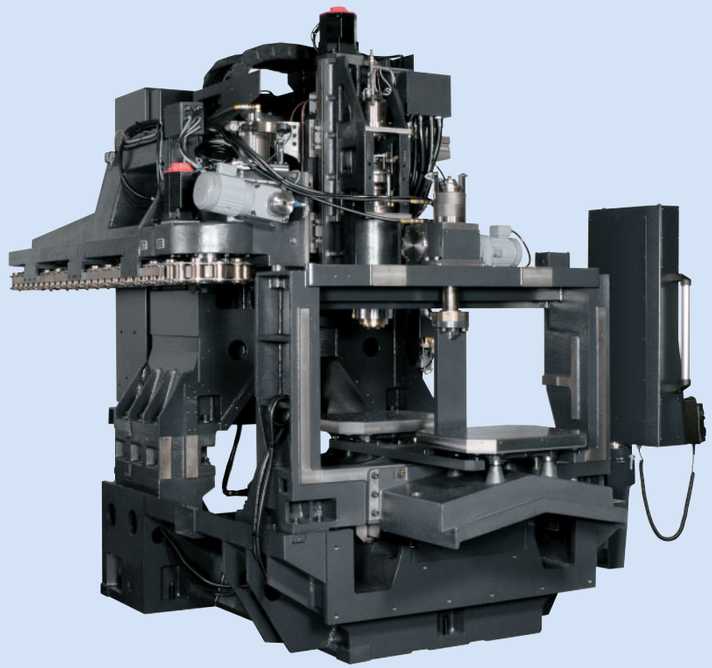
VP400, 2APC Specification

※Signal lamp (Option)

● Automatic Pallet Changer

OKK's original cam-driving type pallet changer realizes the pallet exchange in the shortest time in the class i.e. 5.0 seconds on VP400, 7.0 seconds on VP500, and 8.0 seconds on VP600.

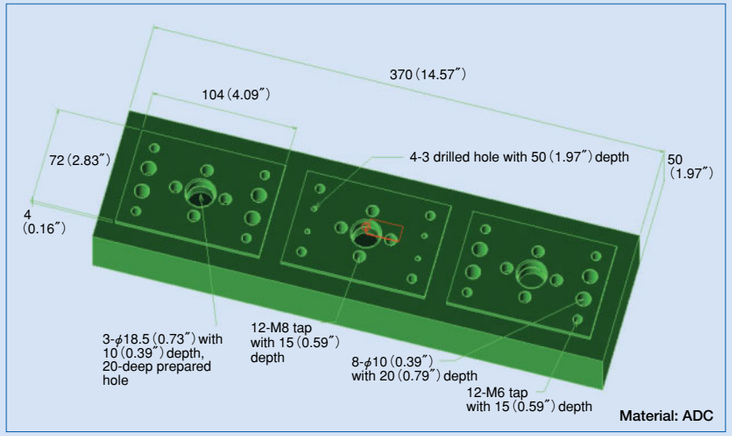
※



Sample Cutting Data

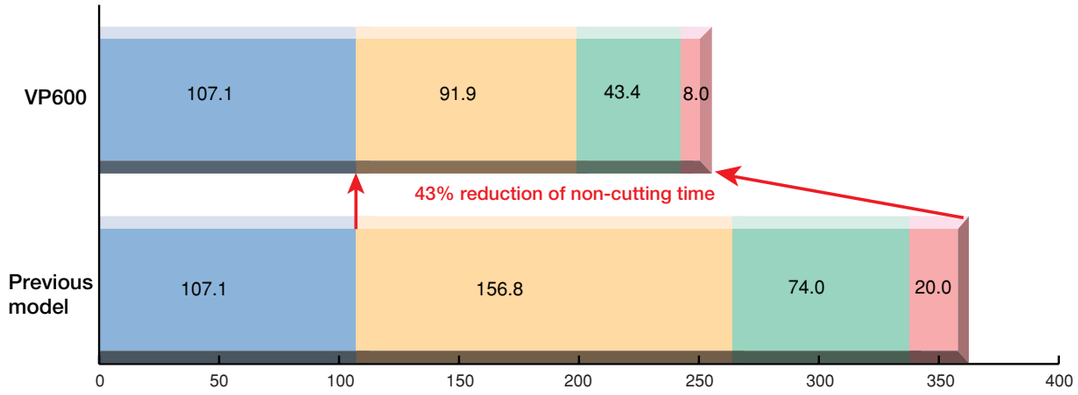
43% reduction of non-cutting time
(Comparison with our previous model)

- Acceleration 0.6G (X)
- Rapid traverse rate 48 m/min (1890 ipm)
- ATC time 1.2 s (Tool-to-Tool)
- APC time 8 s (VP600)



Unit: sec

	Actual cutting time	Positioning	ATC	APC	Total	Difference in time
VP600	107.1	91.9	43.4	8.0	250.4	
Previous model	107.1	156.8	74.0	20.0	357.9	107.5



Number of tools used : 10
Comparison is made under the same feed rate.

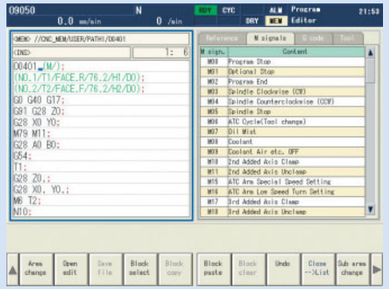
●The machines in the photographs of this brochure may include optional accessories.

OKK's Dedicated Control Functions

Programming Support Function

Program Editor

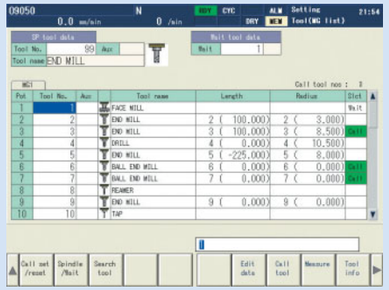
It enables editing of the programs in the NC memory, data server (or hard disc) and memory card. It also enables managing the programs i.e. copying, deleting, changing the program name, etc.



Setup Support Function

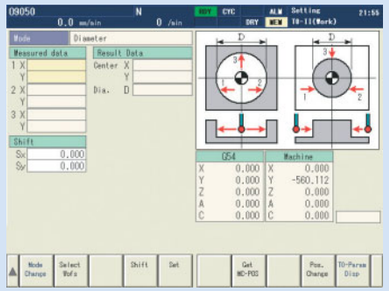
Tool Support

You can manage each tool's various information such as the tool name, schematic and offset number comprehensively through a single screen. It contains the functions that are convenient for the setup operation. For example the tool measurement is also available by just switching the menu.



T0 Softwaer (Option)

This screen enables the simple manual measurement using the touch sensor (option: T1-A or T1-B).
You can move the sensor to the desired measuring point by handle mode then the machine starts the automatic measurement after the sensor contacts the workpiece. You can set the results of the measurement as the data for the desired workpiece coordinate system and tool offset number through the single key operation.



High-efficiency Control Technologies

Hyper HQ Control (Option)

High-speed processing is enabled by improved capability of processing fine line segment toolpaths.

〈N730 capability of processing fine line segments〉

Type	Fine line segment data processing speed (m/min)	Instruction method
Without Hyper HQ control	16.8 (0.66 ipm)	
Hyper HQ control mode Ⅰ	16.8 (0.66 ipm)	ON : G5P1 OFF : G5P0
Hyper HQ control mode Ⅱ	135 (5.31 ipm)	ON : G5P2 OFF : G5P0

〈F31i capability of processing fine line segments〉

Type	Fine line segment data processing speed (m/min)	Instruction method
Without Hyper HQ control	15.0 (0.59 ipm)	
Hyper HQ control A mode	30.0 (1.18 ipm)	ON : G5.1Q1 OFF : G5.1Q0
Hyper HQ control B mode	150 (5.91 ipm)	ON : G5.1Q1 OFF : G5.1Q0

The above values show (theoretical) maximum speeds for processing 1-mm-segment blocks construction a straight line. Actual processing speeds depend on the machine and NC data.

HQ Tuner (Option)

The HQ tuner provides the programmer a 10-step adjustment of parameters for hyper HQ control in accordance with processing conditions.
It adjusts the hyper HQ control in accordance with the current process.
For example, during roughing routines the programmer can place a higher priority on speed and in finishing routines a higher priority on dimensional accuracy at corners and circular arcs.

Network Function

Data Server (Option for F31i/F32i)

Large machining programs can be transferred to the data server through the network connected to the host computer at high speed.
The transferred machining programs are executed as the main program or the sub program called up with the M198.

Hard Disc Operation (N730 Standard Function)

Large machining programs can be transferred to the hard disc installed in the machine through the network connected to the host computer at high speed.
The transferred machining programs are executed as the main program or the sub program.

Main Specifications

Item		VP400	VP500-2APC	VP600
Travel on X axis (Saddle:right/left)		600mm (23.62″)	600mm (23.62″)	1120mm (44.09″)
Travel on Y axis (Table:back/forth)		410mm (16.14″)	510mm (20.08″)	610mm (24.02″)
Travel on Z axis (Spindle head:up/down)		460mm (18.11″)	460mm (18.11″)	460mm (18.11″)
Distance from table top surface to spindle nose		150~610mm (5.91″~24.02″)	150~610mm (5.91″~24.02″)	150~610mm (5.91″~24.02″)
Distance from column front to spindle center		620mm (24.41″)	620mm (24.41″)	740mm (29.13″)
Table work surface area (X-axis direction × Y-axisdirection)		900×410mm (35.43″×16.14″)	(Pallet) 600×500 (23.62″×19.69″)	1300×610mm (51.18″×24.02″)
Max. workpiece weight loadable on table		500kg (1100 lbs)	(Pallet) 400kg (880 lbs)	1200kg (2640 lbs)
Table work surface configuration (Number and nominal dimension of T slots and spacing)		Three 18-mm (0.71″) T slots with 125-mm (4.92″) pitch	(Pallet) 45pcs×M12 screw hole (nominal size)	Five 22-mm (0.87″) T slots with 125-mm (4.92″) pitch
Height from floor level to table work surface		800mm (31.5″)	1000mm (39.37″)	850mm (33.46″)
Spindle speed		100~12000rpm	100~12000rpm	100~12000rpm
Number of spindle speed shift steps		Stepless	Electrical 2 speeds	Stepless
Spindle nose (nominal number)		7/24 taper No. 40	7/24 taper No. 40	7/24 taper No. 40
Spindle bearing bore diameter		φ65mm (2.56″)	φ65mm (2.56″)	φ65mm (2.56″)
Rapid traverse rate		48 m/min (X and Y axes), 36 m/min (Z axis)	48 m/min (X and Y axes), 36 m/min (Z axis)	48 m/min (1890ipm), 36 m/min (1417ipm)
Cutting feed rate		1(0.04)~36000mm/min (1417ipm)※1	1(0.04)~36000mm/min (1417ipm)※1	1(0.04)~36000mm/min (1417ipm)※1
ATC (Automatic Tool Changer)				
Type of tool shank (Nominal number)		JIS B 6339 BT40	JIS B 6339 BT40	JIS B 6339 BT40
Type of pull stud (Nominal number)		MAS 403 P40T-1	MAS 403 P40T-1	MAS 403 P40T-1
Tool storage capacity		20 tools	20 tools	20 tools
Maximum tool diameter		φ110 (4.33″)	φ110 (4.33″)	φ110 (4.33″)
Maximum tool length (from the gauge line)		300mm (11.81″)	300mm (11.81″)	300mm (11.81″)
Maximum tool weight		7kg (15.4 lbs)	7kg (15.4 lbs)	7kg (15.4 lbs)
Tool selection method		Memory random method	Memory random method	Memory random method
Tool changing time (tool-to-tool)		1.2 s	1.2 s	1.2 s
Tool changing time (cut-to-cut)		3.8 s	3.8 s	3.8 s
Motor				
Spindle motor (30-min rating/ continuous rating)	MITSUBISHI	7.5/5.5kW (10/7.5HP)	22/18.5kW (30/25HP)※2	7.5/5.5kW (10/7.5HP)
	FANUC	7.5/5.5kW (10/7.5HP)	26/18.5kW (35/25HP)	7.5/5.5kW (10/7.5HP)
Feed motors	MITSUBISHI	X/Y:2.0/Z:3.5kW (2.7/4.7HP)	X/Y:2.0/Z:3.5kW (2.7/4.7HP)	X/Y:2.0/Z:3.5kW (2.7/4.7HP)
	FANUC	X/Y/Z : 4.5 kW (6.0HP)	X/Y/Z : 4.5 kW (6.0HP)	X/Y/Z : 4.5 kW (6.0HP)
Coolant pump motor		0.4kW (0.54HP)	0.4kW (0.54HP)	0.4kW (0.54HP)
Motor for spindle head oil cooler pump		0.4kW (0.54HP)	0.4kW (0.54HP)	0.4kW (0.54HP)
Motor for magazine	MITSUBISHI	1.5kW (2.0HP)	1.5kW (2.0HP)	1.5kW (2.0HP)
	FANUC	1.4kW (1.9HP)	1.4kW (1.9HP)	1.4kW (1.9HP)
Required power supply				
Power supply		MITSUBISHI 31 kVA FANUC 23 kVA	MITSUBISHI 52 kVA FANUC 42 kVA	MITSUBISHI 31 kVA FANUC 23 kVA
Supply voltage		AC200V ±10% AC220V ±10%※3	AC200V ±10% AC220V ±10%※3	AC200V ±10% AC220V ±10%※3
Supply frequency		50/60±1 60±1	50/60±1 60±1	50/60±1 60±1
Compressed air supply pressure		0.4~0.6MPa(57.1~85.7psi)	0.4~0.6MPa(57.1~85.7psi)	0.4~0.6MPa(57.1~85.7psi)
Air supply flow rate (atmospheric pressure)		160L/min(ANR)42.3GDM	400L/min(ANR)(105.7GDM)	160 L/min (ANR)
Spindle cooling oil tank capacity		50 L (13.2gal)	50 L (13.2gal)	50 L (13.2gal)
Coolant tank capacity		280 L (74gal)	280 L (74gal)	280 L (74gal)
Machine height (from floor level)		2746mm (108.11″)	2946mm (115.98″)	2796mm (110.08″)
Floor space required for operation (left-to-right × depth)		2016×2690mm (79.37″×105.91″)	2016×3315mm (79.37″×130.51″)	2516×3100mm (99.05″×122.05″)
Required floor space incl. maintenance area (left-to-right × depth)		3000×3300mm (118.11″×129.92″)	3000×3800mm (118.11″×129.92″)	3500×3700mm (137.80″×145.67″)
Machine weight		8000kg (17600 lbs)	10000kg (22000 lbs)	10500kg (23100 lbs)
Controller	MITSUBISHI	N730	N720 (N730)	N730
	FANUC	F31i	F32i (F31i)	F31i
Environmental temperature		5~40℃	5~40℃	5~40℃

※1:Under the HQ or Hyper HQ control.
※2:High-power specification (15-min rating/continuous rating)
※3:When the supply voltage is 220VAC, 60Hz only is applicable for the supply frequency.

Standard Accessories

Item	Q'ty
Lighting unit	1 set
Coolant unit (Separate type coolant tank)	1 set
Splash guard (Overall machine cover)	1 set
X/Y axes slideway protection cover	1 set
Spindle head cooling oil temperature controller	1 set
Automatic grease supply unit	1 set
Automatic power off (at M02/M30)	1 set
Leveling block	1 set
Parts for machine transportation	1 set
Electrical spare parts (fuses)	1 set
Instruction manual	1 copy
Electrical instruction manual (operating manual,maintenance instruction manual, parts list, and hardware diagrams)	1 copy
ATC shutter (Only for VP500-2APC)	1 set
Air/oil pressure suply unit for fixtures (Only for VP500-2APC)	1 set

Special Accessories (Option)

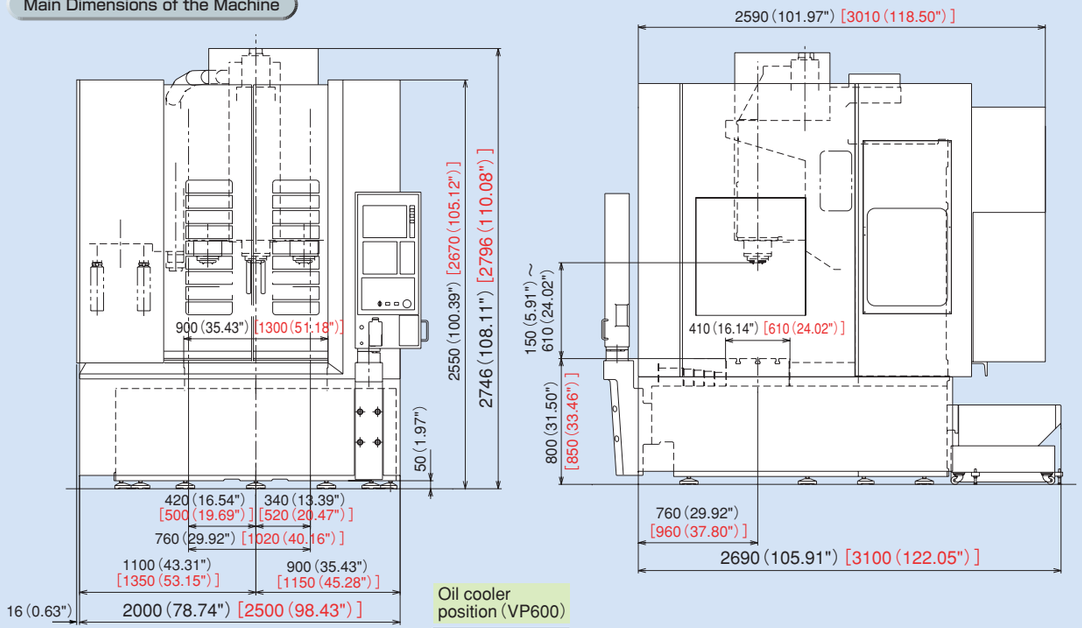
Item	Contents
High-speed spindle	20000rpm 22/18.5kW (30/25HP) 30000rpm 15/11kW (20/15HP) HSK-E40
Compatibility with two-face locking tool	
Increased spindle driving motor power (VP400/VP600)	22/18.5kW (30/25HP) (15-min rating/ continuous rating)
Tool storage capacity	30, 40, 60, 80, 120 tools [※4]
Pallet changer	Direct-turn type
Coil-type chip conveyor built in the bed	2 conveyors
Lift-up type chip conveyor	Scraper type/ Scraper type with floor magnet/ Drum type for aluminum chips
Application of oil hole holder	Nikken / BIG / Others [※5]
Application othrough-spindle	2 MPa / 7 MPa (280/1000 psi)
Cartridge for Automatic lubricating unit	
Workpiece flushing gun	
Oil mist, air blower	
Air blower	
Signal lamp	2-lamp type / 3-lamp type
Automatic splash guard operation	
NC rotary table	Rotary table type [※5]
Coolant cooler	
Mist collector	
Touch sensor system T0 (Manual)	Workpiece measurement, Tool length/diameter measurement
Touch sensor system T1 (Automatic)	Workpiece measurement, Tool length/diameter measurement Tool break detection
Tool breakage detection with limit switches	
Linear scale	0.1μm (0.000004″) absolute positiondetection for X, Y and Z axes

[※4]:When the tool storage capacity is 40 or more, maximum diameter of the tools is restricted to 82mm and the address fixed method is used for selection of tools.
[※5]:Inform us of the desired manufacturer1 and model.

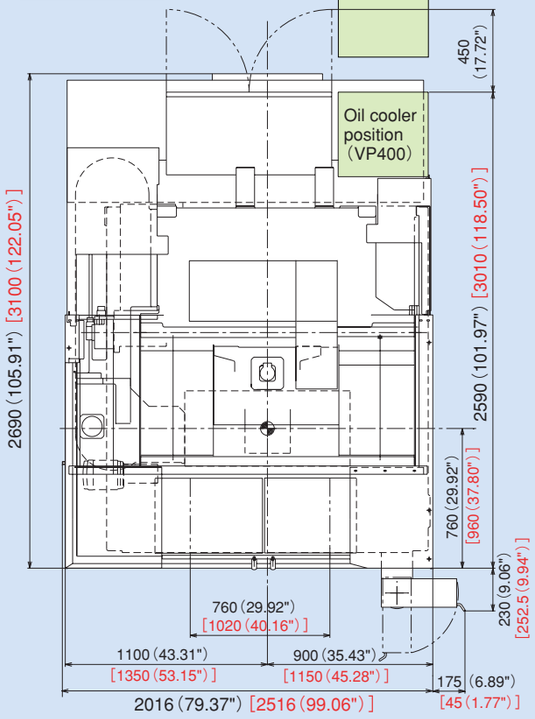
Standard Specification (VP400/600)

[ ]: VP600 dimensions

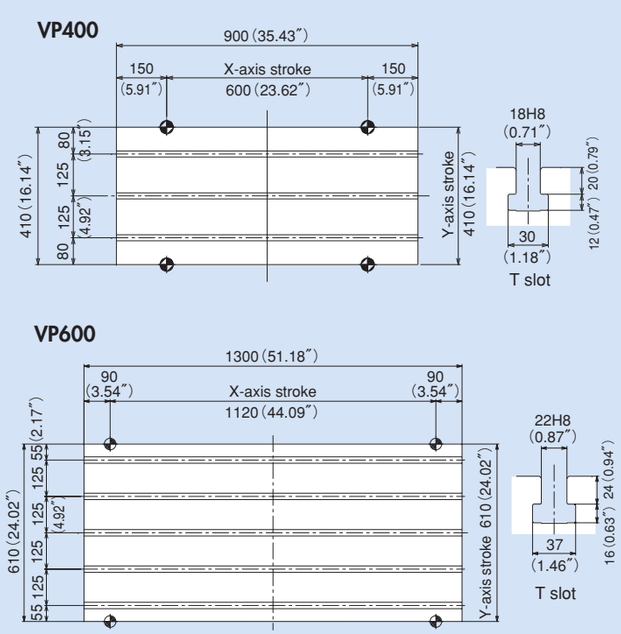
Main Dimensions of the Machine



Floor Space

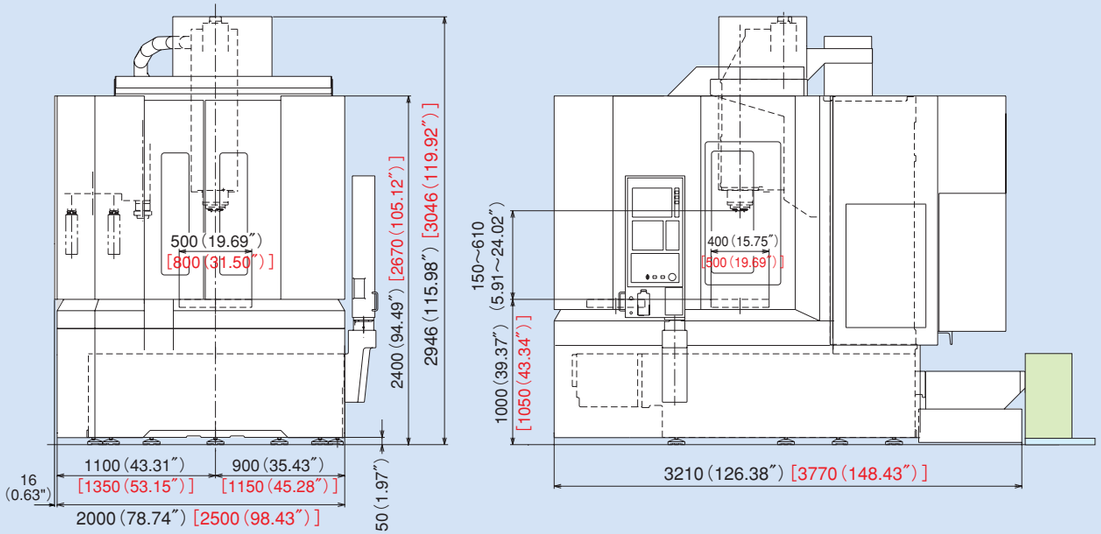


Table

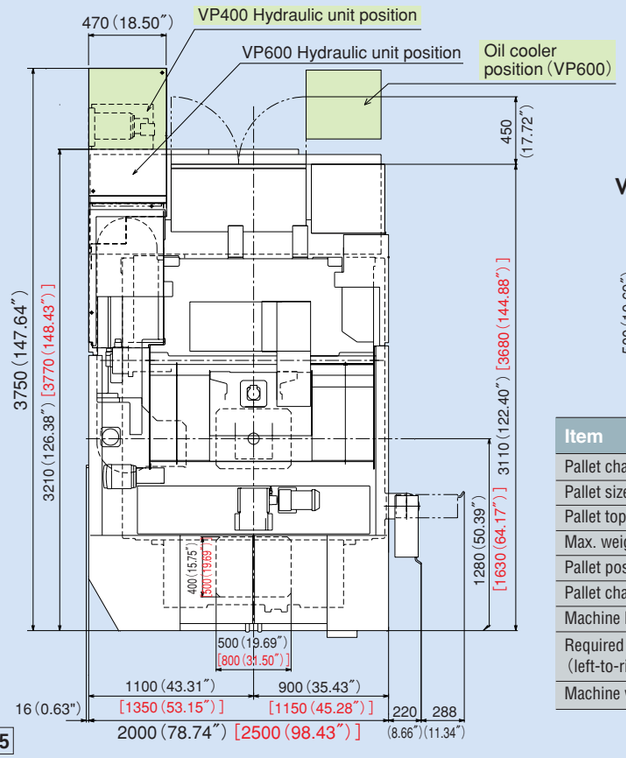


●APC Specification (VP400/600)

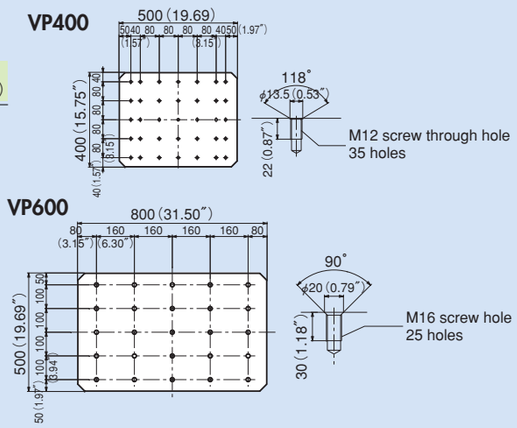
[ ] : VP600 dimensions



Floor Space



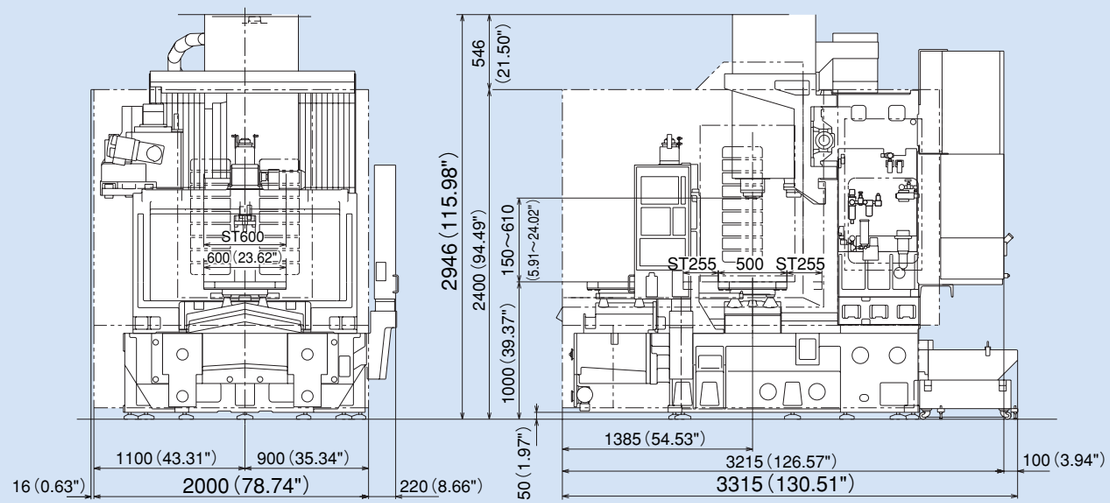
Pallet



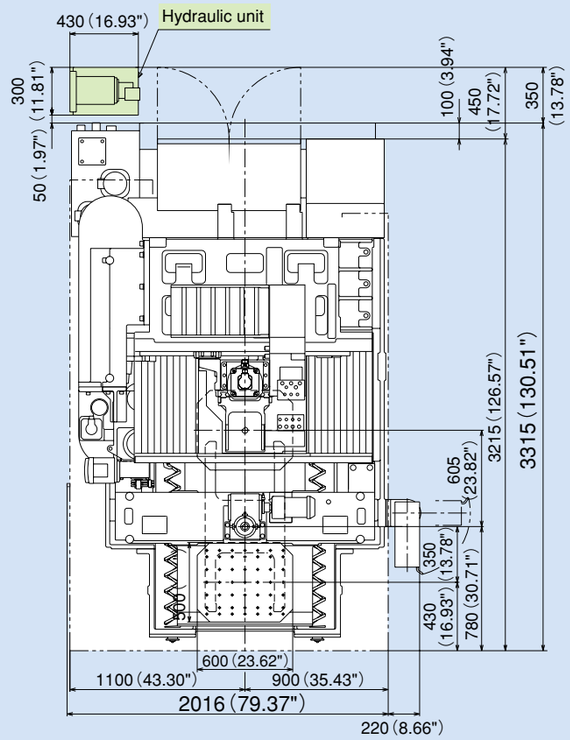
Item	VP400	VP600
Pallet changing method	Direct-turn method	
Pallet size	500mm×400mm (19.69″×15.75″)	800mm×500mm (31.50″×19.69″)
Pallet top surface machining	M12 taps	M16 taps
Max. weight loadable on pallet	300 kg (660 lbs)	500 kg (1100 lbs)
Pallet positioning method	4 taper cones	
Pallet changing time	5.0 s	8.0 s
Machine height	2946mm (115.98″)	3046mm (119.92″)
Required floor space (left-to-right × depth)	2016mm×3210mm (79.37″×126.38″)	2516mm×3770mm (99.05″×148.42″)
Machine weight	9500kg (20900 lbs)	12500kg (27500 lbs)

●APC Specification (VP500-2APC)

Main Dimensions of the Machine

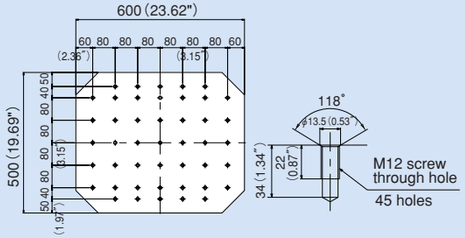


Floor Space



Pallet

VP500-2APC



Item	VP500-2APC
Pallet changing method	Direct-turn method
Pallet size	600mm×500mm (23.62″×19.69″)
Pallet top surface machining	M12 taps
Max. weight loadable on pallet	400 kg (880 lbs)
Pallet positioning method	4 taper cones
Pallet changing time	7.0 s
Machine height	2946mm (115.98″)
Required floor space (left-to-right × depth)	2016mm×3315mm (79.37″×130.51″)
Machine weight	10000kg (22000 lbs)

CONTROLLER

N730 VP400, VP600　N720(N730) VP500-2APC (Windows XP-installed Open CNC)

Standard Specification

No.of controlled axes: 3 axes(X, Y, Z)
No.of simultaneously controlled axes: 3 axes
Least input increment: 0.001mm/0.0001"
Minimum control unit: 1nm
Max. programmable dimension:
±99999.999mm / ±9999.9999inch
Absolute/incremental programming: G90/G91
Decimal point input I/II
Inch/Metric conversion: G20/G21
NC tape: EIA/ISO data input format
Program format: Meldas standard format
(M2 format: Instruction needed)
Positioning: G00
Linear interpolation: G01
Circular interpolation: G02/G03(CW/CCW)
(Radius designation on arc)
Cutting feed rate: F5.3 digits, direct command
One-digit F code feed
Dwell: G04
Manual handle feed: Manual pulse generator
1 set(0.001/0.01/0.1mm)
Rapid traverse override: 0/1/25/50/100%
Cutting feed rate override: 0 to 200%(every 10%)
Feed rate override cancel: M49/M48
Rigid tapping: G84, G74
Part program storage capacity: 160m(60KB)
No. of registered programs: 200
Part program editing
Background editing
Buffer modification
10.4-inch color touch panel LCD / QWERTY key MDI
Integrating time display
Clock function
User definable key
MDI(Manual Data Input)operation
Menu list
Parameter / Operation / Alarm guidance
Ethernet interface
IC card interface / USB Memory interface
IC card driving
Hard disc driving
S function: 4/5-digit direct command
Spindle speed override: 50 to 150%(every 5%)
T function: 4-digit direct command
ATC tool registration
M function: 3-digit programming
Multiple M-codes in 1 block: 3 codes(Max. 20 sets)
Tool length offset G43, G44
Tool offset: G45 to G48
Cutter compensation: G38 to G42
Tool offset sets: 200 sets
Tool offset memory II:
tool geometry and wear offset
Manual reference position return
Automatic reference position return: G28/G29
2nd to 4th reference position return: G30 P2 to P4
Reference position return check: G27
Automatic coordinate system setting
Coordinate system setting: G92
Selection of machine coordinate system setting : G53
Selection of workpiece coordinate
system setting: G54 to G59
Local coordinate system setting: G52
Program stop: M00
Optional stop: M01
Optional block skip: /
Dry run
Machine lock
Z-axis feed cancel
Miscellaneous function lock
Program number search
Program restart function
Cycle start
Auto restart
Single block
Feed hold
Manual absolute on/off parameter
Machining time computation
Interruption of automatic operation
Manual numerical command
Sub program control
Canned cycle: G73, G74, G76, G80 to G89
Linear angle designation
Circular cutting
Mirror image function: Parameter
Mirror image function: G code
Variable command: 200 sets
Automatic corner override
Exact stop check/mode
Programmable data input: G10/G11
3D solid program check
Graphic display check
Backlash compensation
Memory pitch error compensation
Manual tool length measurement
Emergency stop
Data protection key
NC alarm display
Machine alarm message
Stored stroke limit I/II
Load monitor
Self-diagnostics
Absolute position detection

Optional Specification

15-inch color touch panel LCD /
QWERTY ey MDI
Additional one axis control:
name of axis(A, B, C, U, V, W)
Additional two axes control:
name of axes(A, B, C, U, V, W) NOTE
Simultaneously controlled axes:
4 axes(N730) /5 axes(N750)
Tape format: M2/M0 format
Unidirectional positioning: G60 ***PK***
Helical interpolation ***PK***
Cylindrical interpolation
Hypothetical axis interpolation
Spiral interpolation
●NURBS interpolation
Handle feed 3 axes(Remote control
pulse handle not available)
Part program storage capacity:
320m〔125KB〕(200 in total)
Part program storage capacity:
600m〔250KB〕(400 in total) ***PK***(N720)
●Part program storage capacity:
1280m〔500KB〕(1000 in total) ***PK***(N730)
●Part program storage capacity:
2560m〔1MB〕(1000 in total)
●Part program storage capacity:
5120m〔2MB〕(1000 in total)
Spindle contour control
Computer link B: RS232C-1CH
3-dimensional cutter compensation
Tool offset sets: 400 sets
●Tool offset sets: 999 sets
Addition of workpiece coordinate system(48 sets):
G54 P1 to P48 ***PK***
●Addition of workpiece coordinate system(96 sets):
G54 P1 to P96
Optional block skip: Total 9
●Tool retract and return
Sequence number comparison and stop
Corner chamfering/corner R : Insert in straight
line-straight line, straight line-circle ***PK***
User macro and user macro interruption ***PK***
Variable memory expansion: 300 sets(total)
Variable memory expansion: 600 sets(total) ***PK***
Pattern rotation
Programmable coordinate system rotation:
G68, G69/G68.1, G69.1 ***PK***
Parameter coordinate system rotation ***PK***
Special canned cycles: G34 to G36, G37.1/G34 to G37
Scaling: G50, G51
Chopping function
Playback
Skip function: G31 ***PK***
Automatic tool length measurement: G37/G37.1
Tool life management II with 200 sets spare tools ***PK***
Additional tool life management sets: 400 in total
Additional tool life management sets: 600 in total
Additional tool life management sets: 800 in total
Additional tool life management sets: 1000 in total
External search(Standard for the machine with APC)

Original OKK Software

Machining support integrated software
(incl.help guidance, etc.) ····· STD
Tool support function ····· STD
Program Editor ····· STD
EasyPRO ····· STD
Work Manager ····· OP
HQ control ····· STD
Hyper HQ control mode I ····· OP
Hyper HQ control mode II ····· OP
NC option package(including PK) ····· OP
Win GMC7 ····· OP
Cycle Mate ····· OP
Soft scale II m ····· STD
Touch sensor T0 software ····· OP
Tool failure detection system(Soft CCM) ····· OP
Adaptive control unit(Soft AC) ····· OP
Automatic restart at tool damage ····· OP

● : N730 specification
Note : N750(Windows XP-installed Open CNC)

F31i-B VP400, VP600　F32i-B(F31i-B) VP500-2APC (Windows CE-installed Open CNC)

Standard Specification

No.of controlled axes: 3 axes(X, Y, Z)
No.of simultaneously controlled axes: 3 axes
Least input increment: 0.001mm/0.0001 inch
Max. programmable dimension:
±999999.999mm/±39370.0787 inch
Absolute/Incremental programming: G90/G91
Decimal point/Pocket calculator type decimal point
input
Inch/Metric conversion: G20/G21
NC tape: ISO/EIA data input format
Program format: FANUC standard format
Nano interpolation(Internal)
Positioning: G00
Linear interpolation: G01
Circular interpolation:
G02/G03(CW/CCW) (Radius designation on arc)
Cutting feed rate: 6.3-digit F-code, direct command
Dwell: G04
Manual handle feed: Manual pulse generator 1 set
(0.001/0.01/0.1 mm)
Rapid traverse override: 0/1/10/25/50/100%
Cutting feed rate override: 0 to 200%(every 10%)
Feed rate override cancel: M49/M48
Rigid tapping: G84, G74(Mode designation: M29)
Part program storage capacity: 160m[64KB]
No. of registered programs: 120
Part program editing
Background editing
10.4 inch color LCD QWERTY key MDI
Clock function
MDI(manual data input)operation
Memory card interface / USB interface
S function: 5-digit direct command
Spindle speed override: 50 to 150%(every 5%)
T function: 4-digit direct command
ATC tool registration
M function: 3-digit programming
Multiple M-codes in 1 block: 3 codes(Max. 20 sets)
Tool length offset: G43, G44/G49
Cutter diameter/angle compensation: G41, G42/G40
Tool offset sets: 99 sets
Tool offset memory C
Manual reference position return
Automatic reference position return: G28/G29
2nd reference position return: G30
Reference position return check: G27
Automatic coordinate system setting
Coordinate system setting: G92
Selection of machine coordinate system setting: G53
Selection of workpiece coordinate system setting:
G54 to G59
Local coordinate system setting: G52
Program stop: M00
Optional stop: M01
Optional block skip: /
Dry run
Machine lock
Z-axis feed cancel
Miscellaneous function lock
Graphic display
Program number search
Sequence number search
Program restart function
Cycle start
Auto restart
Single block
Feed hold
Manual absolute on/off Parameter
Sub program control
Canned cycle: G73, G74, G76, G80 to G89
Mirror image function parameter
Automatic corner override
Exact stop check/mode
Programmable data input: G10
Backlash compensation Parameter for
each rapid traverse and cutting feed
Smooth backlash
●Memory pitch error compensation
(interpolation type)
●Memory pitch error compensation
Skip function
Tool length measurement
Emergency stop
Data protection key
NC alarm display/alarm history display
Machine alarm message
Stored stroke limit 1
Load monitor
Self-diagnostics
Absolute position detection
Manual guide i(basic)

Optional Specification

15-inch color LCD/QWERTY key MDI
Additional one axis control:
name of axis (A, B, C, U, V, W)
Additional two axes control:
name of axes(A, B, C, U, V, W) NOTE
Simultaneously controlled axes:
4 axes, 5axes(F31i-B5) NOTE
Minimum setting unit IS-C:
0.0001mm/0.00001inch
●FS15 tape format
●FS10/F11 tape format
Unidirectional positioning: G60
Helical interpolation ***PK***
Cylindrical interpolation
●Hypothetical axis interpolation
●Conical/spiral interpolation
●Smooth interpolation
(Hyper HQ control B mode is required)
●NURBS interpolation
(Hyper HQ control B mode is required)
●Involute interpolation
F1-digit feed
Handle feed 3 axes(Remote control
pulse handle not available)
●Part program storage capacity:
320m〔128KB〕(250 in total)
●Part program storage capacity:
640m〔256KB〕(500 in total)
Part program storage capacity:
1280m〔512KB〕(1000 in total) ***PK***
●Part program storage capacity: 2560m〔1MB〕(1000 in total)
●Part program storage capacity: 5120m〔2MB〕(1000 in total)
●Part program storage capacity: 5120m〔2MB〕(400 in total)
●Part program storage capacity: 10240m〔4MB〕(1000 in total)
●Part program storage capacity: 20480m〔8MB〕(1000 in total)
RS232C interface: RS232C-1CH
Data server: ATA card(1GB) ***PK2***
●Data server: ATA card(4GB)
Spindle contour control
Tool offset
●3-dimensional cutter compensation
●Tool offset sets: 200 sets ***PK***
●Tool offset sets: 400 sets
●Tool offset sets: 499 sets
●Tool offset sets: 999 sets
Addition of workpiece coordinate system(48 sets):
G54.1 P1 to P48 ***PK***
Addition of workpiece coordinate system(300 sets):
G54.1 P1 to P300
●Machining time stamp function
Optional block skip: 9 in total
●Tool retract and return
Sequence number comparison and stop
Manual handle interruption
Programmable mirror image ***PK***
Optional chamfering/corner R
Custom macro ***PK***
Interruption type custom macro
Addition of custom macro common variables: 600
●Figure copy
Programmable coordinate system rotation: G68, G69
Scaling: G50, G51
Chopping function
●Playback
Automatic tool length measurement: G37/G37.1
●Tool life management: 256 pairs ***PK***
●Tool life management: 128 pairs
●Addition of pairs for tool life management: 1024 in total
High-speed skip
Run hour and parts count display ***PK***
Manual guidei(milling cycle)

Original OKK Software

Machining support integrated software
(incl.help guidance, etc.) ····· STD
Tool support function ····· STD
Program Editor ····· STD
EasyPRO ····· STD
Work Manager ····· OP
HQ control ····· STD
Hyper HQ control A mode ····· OP
●Hyper HQ control B mode ····· OP ***PK2***
●Hyper HQ value kit(including PK2) ····· OP
●NC option package(including PK) ····· OP
Special canned cycle(including circular cutting) ····· OP
Cycle Mate F ····· OP
Soft scale II m ····· STD
Touch sensor T0 software ····· OP
Tool failure detection system(Soft CCM) ····· OP
Adaptive control unit(Soft AC) ····· OP
Automatic restart at tool damage ····· OP

● : F31i specification ● : F32i specification
NOTE : F31i-B5(WindowsCE-installed Open CNC)
is needed.