

## STANDARD EQUIPMENT

- Spindle drum locking by a triad of rims with spur gearing
- SIMODRIVE SIEMENS variable speed motors
- PLC – SIEMENS SIMATIC programmable logic controller; S 7.300 model
- 6 cross slides and 6 frontal slides
- 4 compound slides in the 1<sup>st</sup>, 2<sup>nd</sup>, 4<sup>th</sup> and 5<sup>th</sup> stations
- Standard bar stock guide
- Feeding, clamping and bar stop in the 6<sup>th</sup> station
- 4 safety clutches preventing from the slides overloading
- Independent drive of the central block

## MACHINE VERSIONS

- MORI-SAY 620AC
- MORI-SAY 620SAC – machines with stop of spindles

## OPTIONAL EQUIPMENT

- Feeding, clamping and bar stop in the 3<sup>rd</sup> station
- Device for the general stop of spindles – 620SAC version
- Hydraulic oriented stop of spindles – 620SAC version
- NC oriented stop of spindles – 620SAC version
- Pick-up spindle with hydraulically controlled collet clamping
- Brake of the pick-up spindle
- Pick-up tool slide with a mechanical drive
- Tool holders
- Tapping and thread chasing attachments
- Thread rolling with two roller dies
- Attachment for outer polygon machining and thread milling
- Attachment for internal polygon machining
- Cams for frontal, cross and compound slides
- Necking-down attachment
- High-speed drilling attachment
- Rotary reaming attachment
- NC compound slides for the 4<sup>th</sup> and 5<sup>th</sup> stations
- Preparation for the automatic bar magazine
- Preparation for the oil mist exhaustion
- Selection of the equipment for swarfs carrying out and coolant in an independent sedimentation tank
- High-pressure coolant and tool wash-out
- Setting-up for a part machining and the machine acceptance in the TAJMAC-ZPS plant

	620AC	620SAC
<b>Number of spindles</b>		6
Inner dia of clamping tube	∅ mm	28
<b>Bar stock dimension</b>		
Round cross section	∅ mm	20
Hexagonal cross section	mm	17
Square cross section	mm	14
Pitch diameter of spindles	mm	180
Max. length of bar feeding	mm	100
<b>Frontal slides – number</b>	6	6
Range of working strokes I, II, IV. and V.	mm	68
Range of working strokes III, and VI. stations	mm	90
<b>Cross slides – number</b>	6	6
Adjustability	mm	13
Range of working strokes	mm	0 – 36
<b>Compound slides – number</b>	4	4
Range of working strokes I, II.	mm	0 – 51
Range of working strokes IV., V.	mm	0 – 55
<b>Working cycle</b>		
Working time	sec.	0.8 – 90
Idle time	sec.	0.5 – 0.8
Speed range of spindles	l/min	500 – 6 500
General stopping of spindles	no	yes
<b>Motors</b>		
Main motor	kW	9
Feed motor (for working times)	kW	7.5
Machine operational input	KW/kVA	19/21
<b>Machine dimensions</b>		
Machine total length		
– with bar stock guide	mm	6 098
– without bar stock guide	mm	3 000
Width	mm	1 230
Height	mm	2 197
Machine weight including standard equipment	kg	5 000

Description, illustrations and numerical data may not always correspond with the machine latest version.

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- High accuracy at mass and series production
- High rigidity at machining
- SIMATIC S 7 programmable logic controller
- Controlled feed and spindle motors
- High thermal and dynamic stability
- Range of diameters from 3 mm to 20 mm
- Machine version with oriented stopping of spindles
- Minimum values of working and idle times

# SIX-SPINDLE AUTOMATIC LATHE

# MORI-SAY 620AC

Traditional cam automatic lathe of the high accuracy, rigidity and quickness. It is intended for the mass and series production of precise components from the bar stock.

## CONSTRUCTION

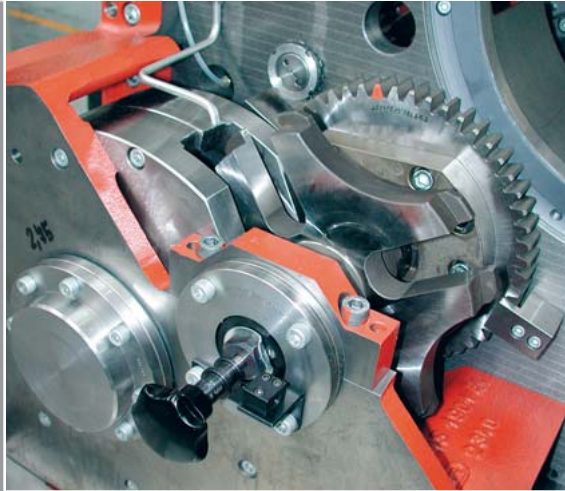
- Conception characteristics is the high accuracy and rigidity at machining
- 6 spindles
- 6 independent frontal slides
- 6 cross slides
- 4 compound slides in the 1<sup>st</sup>, 2<sup>nd</sup>, 4<sup>th</sup> and 5<sup>th</sup> stations
- Variable speed motors for machine speeds and feeds
- Hardened slide-ways of all slides
- Arrestment of the spindle drum by a triad of rims with spur gearing
- Display for programming and diagnostics of machine functions
- Absolute angular sensing device with programmable outputs
- Bar stock guide
- Work space lighting by fluorescent lamps
- Automatic two-circuit central lubrication
- Efficient device for swarf removal
- Quick-change disk cams for movements of frontal, cross and compound slides
- 4 safety clutches preventing from the slides overloading



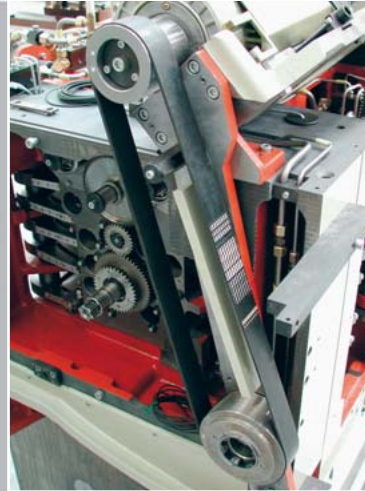
■ Machine heart – spindle drum and central block of frontal slides



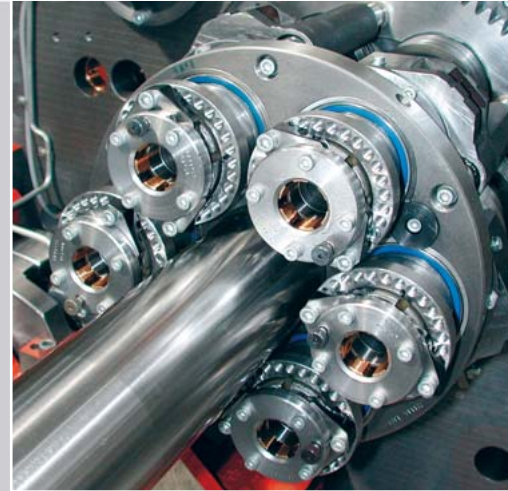
■ Quick-change operational cam



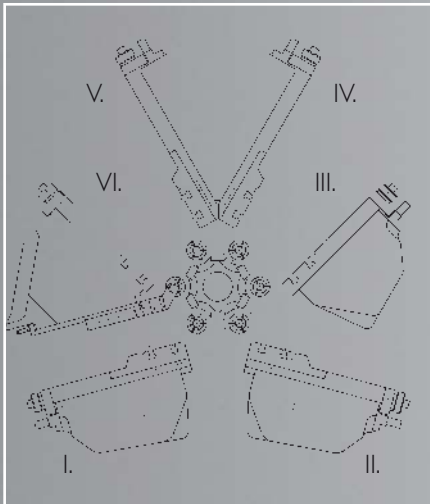
- Geneva mechanism of spindle drum indexing. By the cam alterable length of arm ensures the high dynamics of indexing.



- Tipping drive of working spindles enables an easy access to the interchangeable gear wheels of attachments and to the rocker arms of longitudinal and compound slides



- Back side of spindle drum with work spindles



- Arrangement of 6 independent cross slides



## ADVANTAGES

- Each frontal, cross and compound slide is controlled by an independent disk cam providing the possibility of the stroke adjustment on the rocker arm of the corresponding drive
- Precise arrestment of the spindle drum is ensured by a triad of rims with spur gearing
- Mechanical control of the spindle drum arrestment
- Possibility of the use of different types of automatic loaders and automatic magazines
- Other mains voltage than  $3 \times 400 \text{ V}/50 \text{ Hz}$
- Possibility of the bar feeding and clamping in the 3<sup>rd</sup> station
- Mounting of the bar stop in the 3<sup>rd</sup> station
- Mounting of the oriented stop of spindles
- Machine paint according to the customer's demand
- Machine setting-up for a particular component of the customer
- Various types of swarf conveyors
- Possibility of the connection to an individual exhausting device or central exhausting system
- Cams for cross and frontal slides are interchangeable