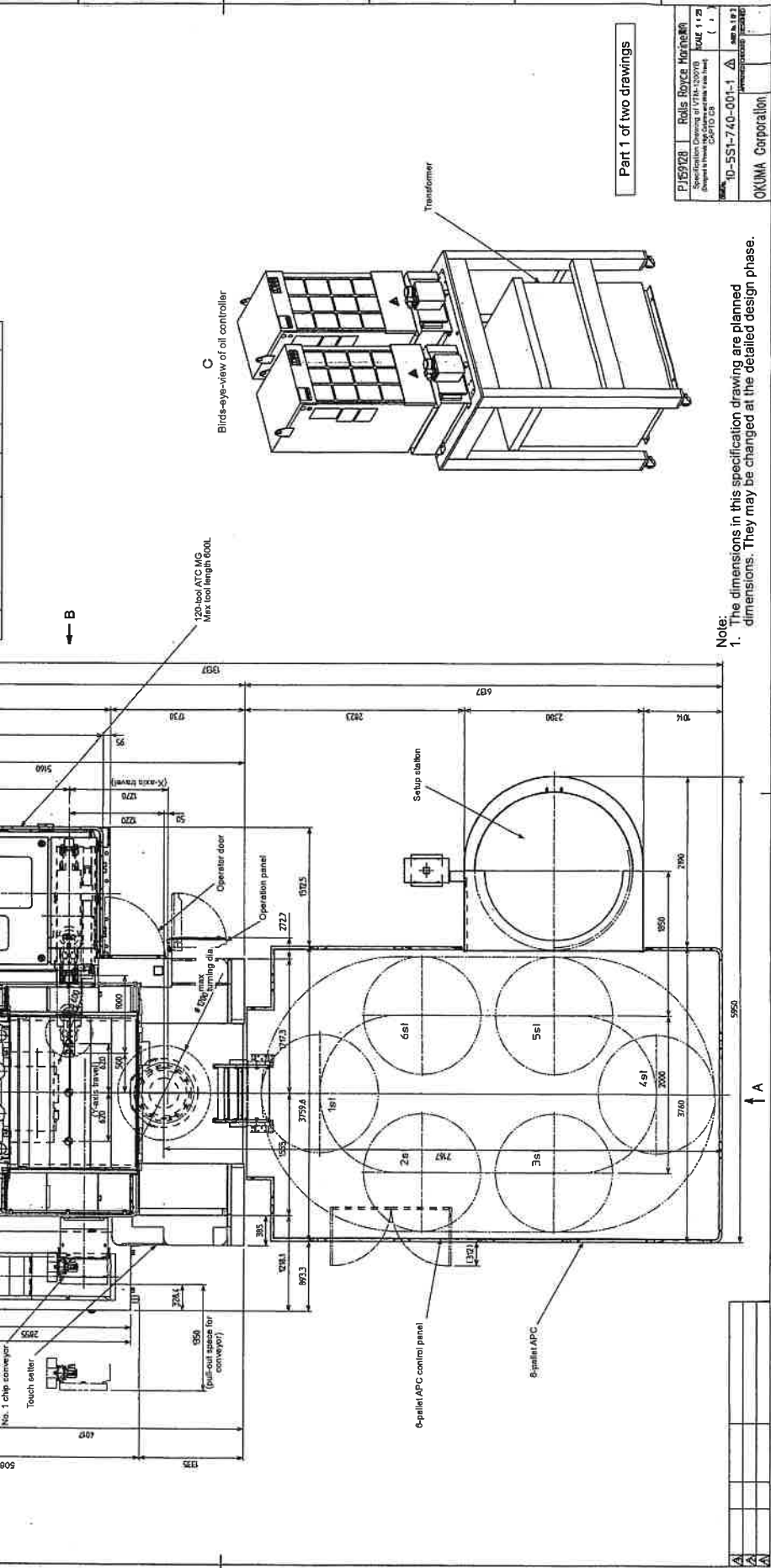


Category	Item	Specification	Unit	Item	Specification
Capacity	Max swing	±1,500	mm	Tool shank	CAPT-CH
	Max turning diameter	±1,200	mm	Max tool weight	30
	Max turning length	1,000	mm	Max tool length	600 (w/o gauge line)
	Spindle nose	±300 (at nose) (JIS B6109-2)	mm	Max tool diameter	450 (w/o adjacent tool) 4170 (w/ adjacent tool)
Main spindle	Spindle nose	5 to 500	mm	Tool magazine capacity	120
	Spindle bore diameter	4160	mm	Main spindle drive	30222 (30 mm/min)
	Diameter	3,000	mm	Milling tool drive	37780/22
	Max work weight	41,290	kg	X-axis drive	3 (3 min/20 min/cent)
	Max chuck size	1,270	mm	Z-axis drive	4.6
	Travel	32,000	mm/min	Y-axis drive	4.6
	Rapid traverse	1,240 (-620 to +620)	mm/min	Hydraulic pump	3.7
	Travel	32,000	mm/min	Lubricating oil pump	0.17
	Rapid traverse	1,500	mm/min	Coolant pump	3.04 (through M-spindle) 1.24 (through M-spindle) 0.254 (filter supplied) periphery x1, chip flushing x2)
	Control angle	300	deg		
Turntable	Rapid traverse	25	mm/min		
	Rotating angle (N/C)	0.01	deg		
	Rotating angle (Control)	0.2	deg		
	Type	H			
	No. of tools	One tool common to L-tool and M-tool			
	Tool shank diameter	Ø26, Ø32	mm		
	Boring bar shank diameter	Ø40, Ø50	mm		
	Rotary tool spindle speed	40 to 5,000 (CP: 10,000)	mm		
	Rotary tool spindle torque	3 min/20 min/cent	N.m		
	Rotary tool spindle torque	3 min/20 min/cent	N.m		

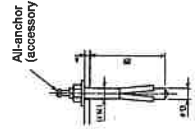


Part 1 of two drawings

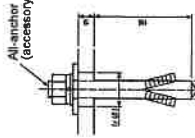
P16928	Rolls Royce Marine
Specification Drawing of VTR-100010	Year 11.2
Approved by: [Signature]	Checked by: [Signature]
Rev. ID-551-740-001-1	Rev. 1.0
OKUMA Corporation	



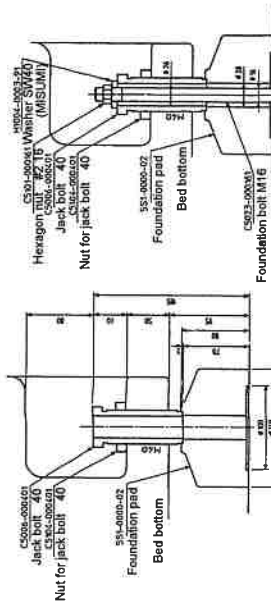
All-anchor (accessory included in APC)



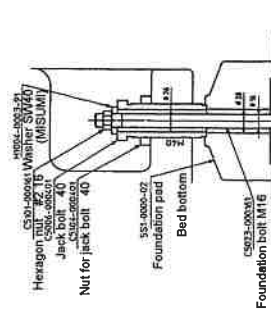
(Detailed view of attachment section, E-E (1/2), four places are marked with  $\triangleright$ )



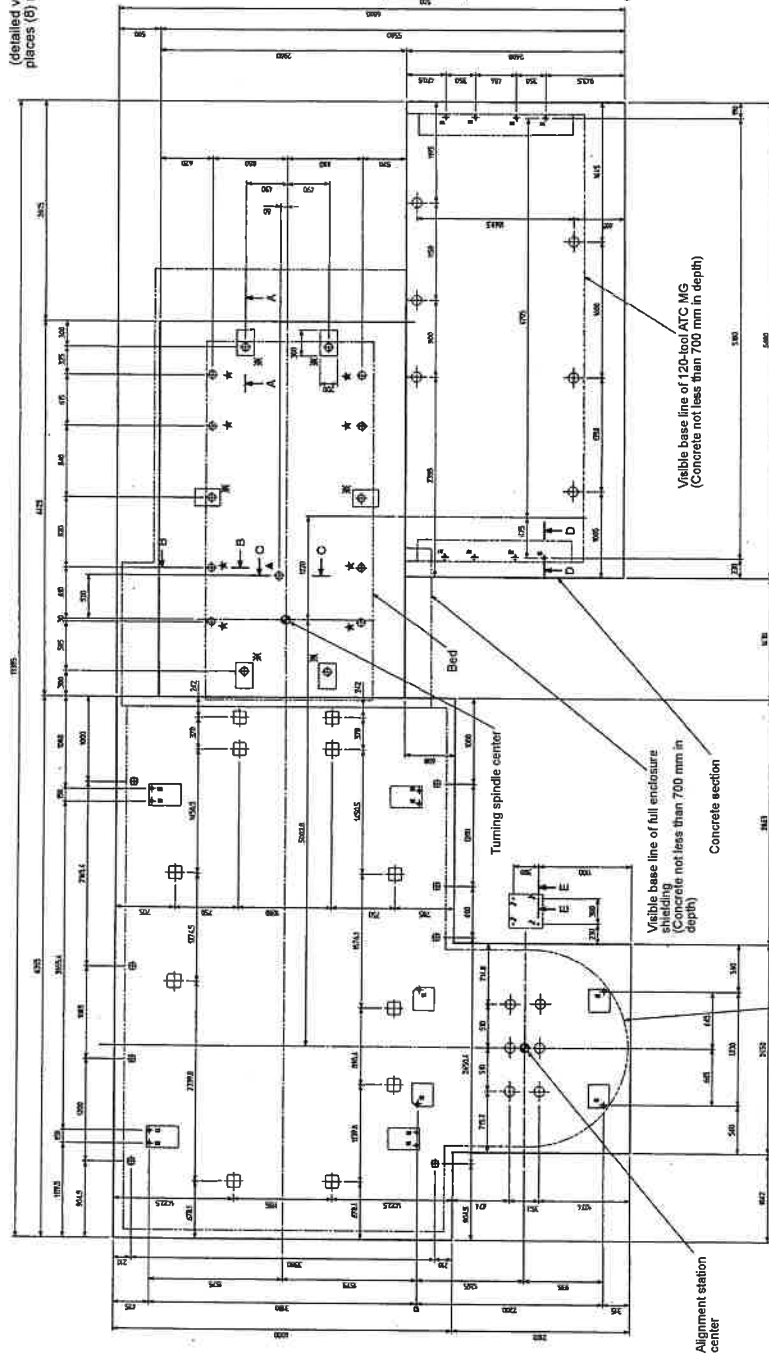
(Detailed view of attachment section, D-D (1/2), places are marked with #.)



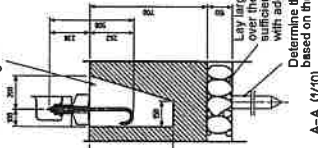
(Detailed view of mounting section, places (B) marked with a black star)



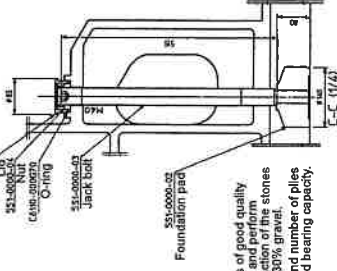
(Detailed view of mounting section, places (A) marked with a black star)



Pour and harden mortar with the foundation bolts lifted up with the machine together.



(cross section of foundation, places (A) marked with an asterisk)



(Detailed view of mounting section, place (1) marked with a black triangle)

Visible base line of APC (Concrete not less than 700 mm in depth)

Visible base line of full enclosure (Concrete not less than 700 mm in depth)

Visible base line of 120-bed ATC/MG (Concrete not less than 700 mm in depth)

Machine Weight and Estimated Value of Surface Pressure	Column specification	
	Standard column	High column
Force generated by overall machine weight	319 kN	319 kN
Force generated by concrete foundation weight	219 kN	219 kN
Average surface pressure on concrete foundation bottom	0.039 MPa	0.040 MPa
Soil bearing capacity	0.058 MPa	0.061 MPa

Unit: mm

The machine weight includes the weight of standard accessories such as shuck, toolholder, and chip conveyor.

- Notes 1. This drawing represents the almost standard specifications. Adjust the concrete thickness according to the ground condition of a machine mounting place.  
 2. The locations of the magazine and APC (OP) other than this machine should be made flush with the top surface of the machine foundation because the height must be adjusted with these units and the (1). The bolts and their nuts are not standard accessories.  
 (2) Avoid installation of the machine in a place where it may be subject to sever changes in temperature, direct sunlight, dirt, shock, or the like.  
 (3) Provide vibration proofing construction if vibration-generating equipment is installed around the machine.  
 (4) For the concrete foundation, the concrete foundation should be within 10 mm.  
 (5) Refer to the Installation Drawing at the see in the manual.  
 (6) For the foundation blocks of the magazine and APC, refer to the separate specification drawing.

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