

Methods

Methods MV 800H & MV 1000H Performance Machining Centers



Designed for productivity and efficiency

Methods Brand 3-Axis Vertical Machining Centers are made to Methods' design and engineering standards by Litz Hitech Corp., a reputable, well-established, quality machine tool builder and are fully backed by Methods industry-leading technical service and parts support. Methods Machining Centers are affordable, mid-range, best-in-class products providing durability, accuracy and long term reliability.

Key Design Features

Machine structure features

19 precision hand
scraped joints

Powerful 30hp direct drive
hollow shaft spindle motor
w/1000 psi CTS prep

24/30 Tool ATC with Fast 1.5
sec. Tool-to-Tool time

Spindle / head
cooling system

Spindle air
dryer system

Fixed pre-tensioned,
double-nut 1.57" (40 mm)
ball-screws in X/Y/Z Axes

Auto oil lubrication
system for all axes

Chiller cooled spindle
motor plate minimizes
heat migration

Thermal compensation utilizes
(3) thermo-couples for actual
temperature feedback

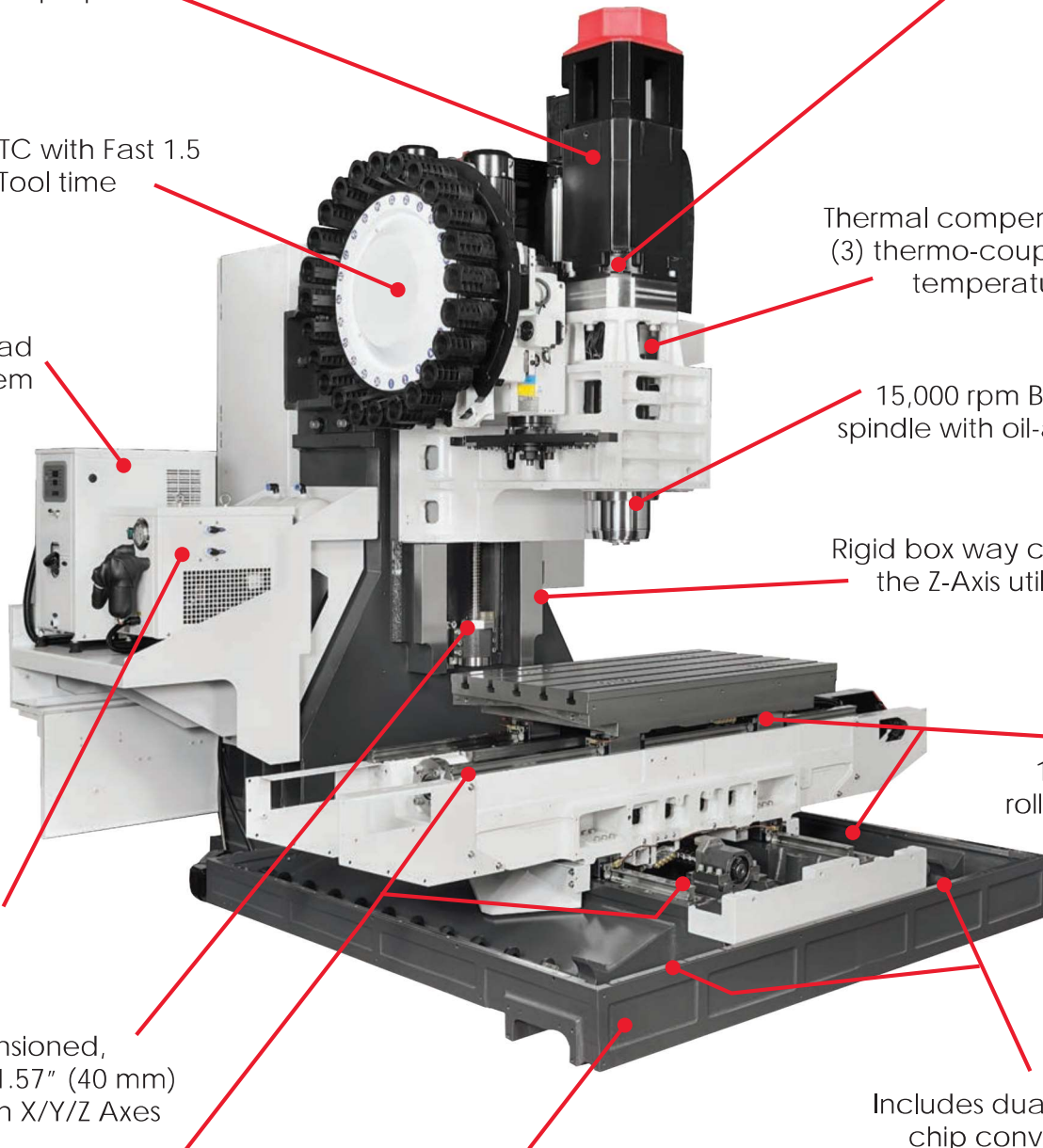
15,000 rpm Big Plus/CAT40
spindle with oil-air lubrication

Rigid box way construction in
the Z-Axis utilizing Turcite B

Robust
1.378 (35 mm)
roller guideways

Includes dual chip screws,
chip conveyor, coolant
wash down, and coolant
flush gun

Machine design qualified
using FEA (Finite Element
Analysis) techniques to
provide superior machining
performance. All castings
are MEEHANITE certified

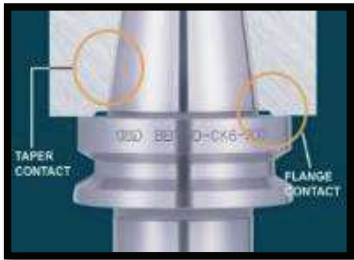




FANUC 0iMF with 10.4" LCD Screen is the Industry Benchmark for Quality and Reliability. We are not FANUC compatible, we are FANUC. Functions include Manual Guide i, AICC II, 2.0 ms Block Processing Time (BPT) and 200 Block Look Ahead, Ethernet 100 mbps, USB, PCMCIA, RS232C. This package is well suited for industries such as medical, aerospace, automotive and job shops. The Pendant mounted control can be rotated up to 77 degrees for ease of use. The remote MPG hand-wheel allows for easy workpiece set-up.

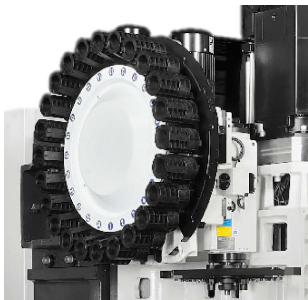


15,000 rpm Big Plus/CAT40 Taper Spindle with oil-air lubrication and spindle chiller provides power, speed, stiffness, required for the most adverse machining applications while providing long spindle life, thermal stability and overall machining accuracy.

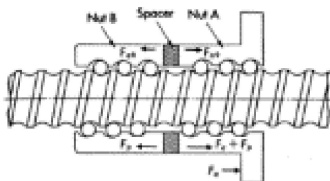


Powerful Direct Drive 30 hp, Hollow Shaft Spindle Motor allows machining of tough-to-machine materials with fine surface finishes and the ability to add Coolant Through Spindle (CTS) easily. A standard spindle chiller and cooled spindle motor plate minimizes heat migration from the spindle motor to the headframe for added thermal stability.

BIG PLUS Dual Contact Spindle provides a stiffer interface between both the spindle surface and tool holder flange surface, & spindle taper and tool holder taper. This design provides higher rigidity, stiffness, longer tool life, and improved accuracy when performing high-speed and difficult to machine applications when compared to traditional 40 Taper Tooling. Tool retention force is a Superior 2,205 lbf (1000 kgf).



CAM Type Automatic Tool Changer provides fast, reliable 1.5 sec. Tool-to-Tool Time and includes both Heavy Tool & Big Tool Functions. This designed incorporates an inverter type cam-box-motor for easy ATC recovery in the event of a mishap. ATC capacity is 24 tools on the MV 800H & 30 tools on the MV 1000H.



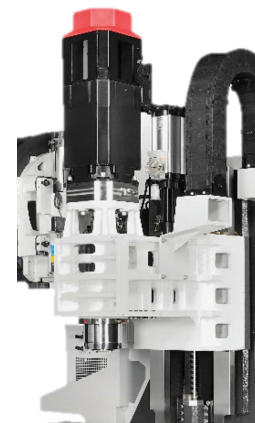
Fixed, Pre-Tensioned 1.57" (40 mm) Double-Nut Ball-Screws are featured in the X, Y & Z Axes. This design minimizes thermal growth, enhances rigidity, stability, and precision of the machine. The X & Y-Axis feature an impressive 2,362 ipm (60 m/min) rapid rate reducing non-cutting time.

Features & Benefits

Robust 1.378" (35 mm) LR Type Roller Guideways in the X & Y-Axis utilize cylindrical rollers with greater contact area and vibration-damping characteristics that provide improved rigidity, cutting performance, surface finish and longer overall service life when compared to LM Ball Type Guideways.



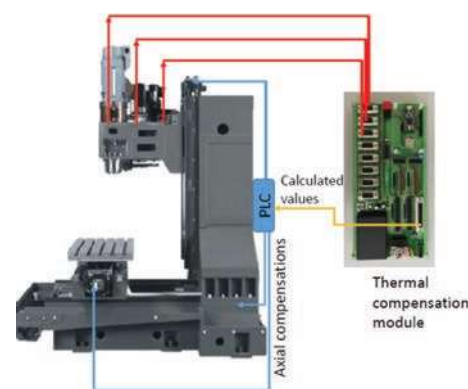
Rigid Box Way Construction in the Z-Axis Utilizing Turcite B. Turcite B was specifically developed for the Machine Tool Industry providing superior rigidity, low friction coefficient, reduced vibration, and superior damping characteristics without stick-slip. This design ensures both cutting performance and machining accuracy. In addition Turcite B also has a very high wear resistance extending the life of the product. Distance between box ways is 14.6" (370 mm). All castings are MEEHANITE certificated.



Machine Structure Features 19 Precision Hand Scraped Joints for increased structural rigidity, maximum stiffness, and optimum cutting performance. Proper hand scraping techniques improve the overall machine geometry, and minimizes the amount of electronic compensation required on the machine. For example, ball-screw bearing housings can be aligned to closer tolerances, improving all axes laser interferometry results and minimizing required electronic compensation. Proper scraping improves all axes straightness, squareness and tram, also limiting the effects of roll, pitch and yaw.



Thermal compensation utilizes (3) Thermo-Couples for actual temperature feedback. This feedback then allows the proprietary software to accurately compensate for thermal growth, greatly minimizing the impact of overall thermal movement. Thermal compensation combined with spindle chiller, chilled motor plate, oil-air lubrication, and fixed, pre-tensioned double-nut ball-screws proved a thermally stable machine.



Efficient Chip and Coolant Management featuring Spindle Coolant Ring (4-ports on the spindle face) Spindle Flushing (3-adjustable ports right side of spindle) Spindle Air Blast (2-lock lines right side of spindle) Coolant Wash Down System (base chip wash-down), Coolant Wash-down Gun, Dual Chip Screws, and Hinge Type Chip Conveyor 41.34" (1050 mm drop height), provides efficient chip and coolant evacuation and management.



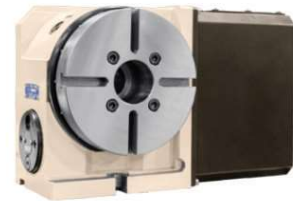
Standard Features

- FANUC 0i-MF Control, 10.4" LCD, MGI, AICC II, 2.0ms BPT, 200 block look ahead Ethernet 100 mbps, USB, PCMCIA, RS232C
- 15,000 rpm, Oil-Air Lubricated Spindle
- Big Plus/CAT40 Taper
- aT15 Direct Drive, 30 hp (15 min), Hollow Shaft Spindle Motor
- Spindle Chiller, Motor Plate Cooling, Spindle Air Dryer, and Thermal Compensation
- 24/30 Tool (800/1000) Dual Swing Arm ATC w/ 1.5 second Tool-to-Tool time
- 1280 meters of memory (512 K), Custom macro B, 400 tool offsets, Helical Interpolation, Rigid tapping, Auto power off
- Remote manual pulse generator (MPG) hand-wheel
- Extra set of 8 M-functions (4 on 4 off)
- Chain/Hinge Type Chip Conveyor 41.3 (1050 mm) Drop-off Ht. Speed 55 ipm (1400 mm/min)
- Dual chip augers
- Prepped for 1000 psi (70 bar) coolant through spindle (does not include pump)
- Pre-wired for 4th Axis (does not include drives, or motors)
- Fixed pre-tensioned 1.57" (40 mm) double-nut ball-screws in the X/Y/Z-Axes
- Z-Axis Box Way with Turcite B
- LR Type 1.378" (35 mm) Roller Guideways in the X/Y-Axes
- X/Y/Z Rapid Travel at 2362/2362/1181 in/min (60/60/30 m/min)
- Automatic oil lubrication system with gravity waste-oil recovery tank
- Fully enclosed splash guard
- Dust-proof electrical cabinet with Heat Exchanger
- Coolant System includes Spindle coolant nozzles (3), Spindle coolant ring nozzles (4), Spindle air blast nozzles (2), Coolant chip flush wash down, and Coolant flush gun
- Bright interior work lights
- 3-color signal light
- Air gun
- Tool kit
- Methods Safety Spec (CE Mark Modified)
- Machine Operating Manual & Control Manual (CD)
- 2-Year Machine and Control Warranty



Options

- Heidenhain Linear Scales in X/Y/Z Axes*
- Tool and Part Probe Measurement
- High Pressure Coolant Through Spindle (up to 1000 psi)
- MIDACO Pallet Changers
- 4th Axis Rotary Tables
- CT to BT Arm
- Oil/Coolant Separator
- Filter Mist Collector
- Electrical Cabinet Air Conditioner*
- Transformer



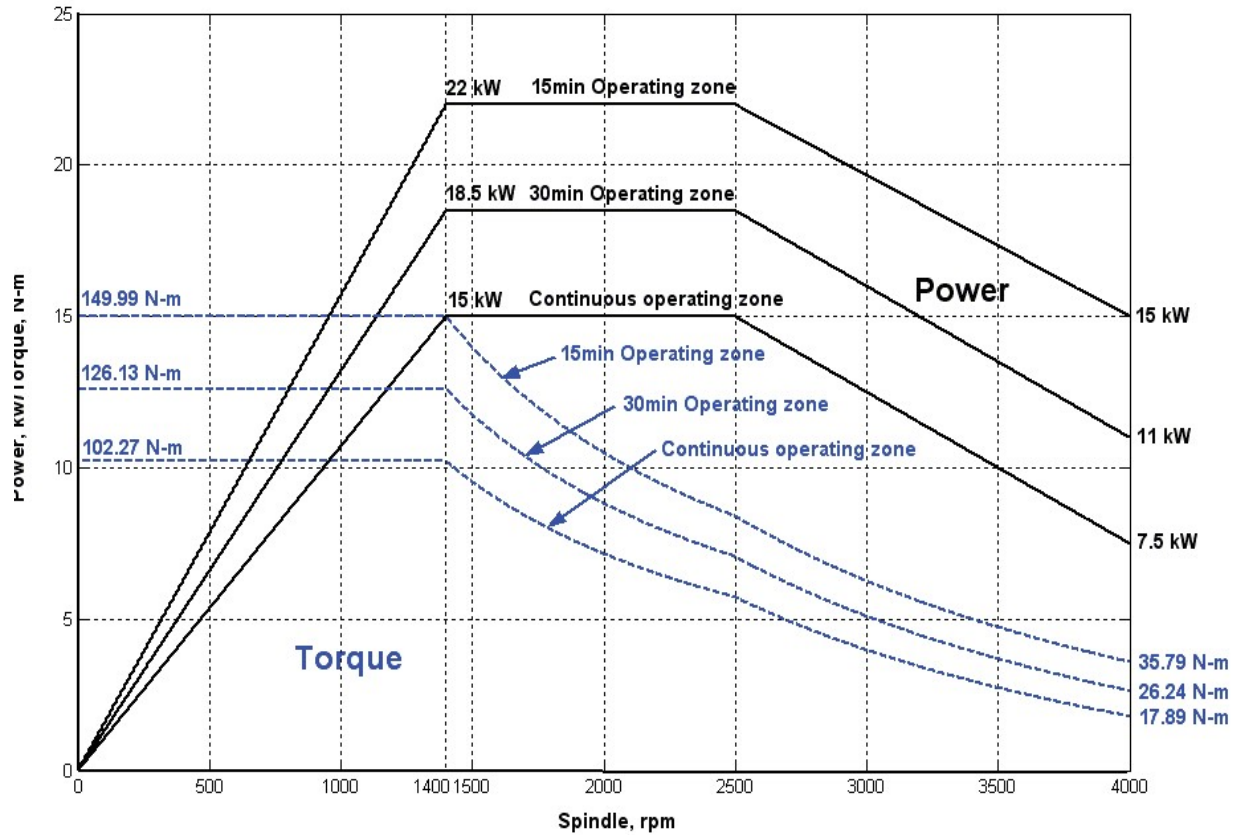
Specifications

FEATURES	UNIT	MV 800H	MV 1000H
X/Y-Axis Roller Guideways			
X/Y-Axis Travel	in (mm)	X - 31.50 (800) Y - 20.47 (520)	X - 39.40 (1000) Y - 20.47 (520)
X/Y-Axis Rapid Traverse	in/min (m/min)	2,362 (60)	
X/Y-Axis Max Cutting Speed	in/min (m/min)	1,181 (30)	
X/Y-Axis LR Type Roller Guideways	in (mm)	1.387 (35)	
X/Y-Axis Distance Between Guideways	in (mm)	X - 11.81 (300) Y - 23.60 (600)	
X/Y-Axis Encoder Resolutions	-	4 million pulse	
X/Y-Axis Motor	FANUC	a22i	
X/Y-Axis Power	hp (kw)	5.4 (4)	
X/Y-Axis Ball Screw Class	-	C3	
X/Y-Axis Ball Screw Diameter	in (mm)	1.57 (40)	
Z-Axis Box Ways			
Z-Axis Travel	in (mm)	20.7 (525)	
Z-Axis Rapid Traverse	in/min (m/min)	1181 (30)	
Z-Axis Max Cutting Speed	in/min (m/min)	787 (20)	
Z-Axis Distance Between Box Ways	in (mm)	14.6 (370)	
Z-Axis Encoder Resolution	-	4 million pulse	
Z-Axis Motor	FANUC	a22Bi	
Z-Axis Power	hp (kw)	5.4 (4)	
Z-Axis Ball Screw Class	-	C3	
Z-Axis Ball Screw Diameter	in (mm)	1.57 (40)	
Spindle			
Spindle Speed	rpm	15,000	
Spindle Type	Dual Contact	BIG-PLUS CAT 40 Taper	
Spindle Power	hp (kw) Cont. hp (kw) 30 min hp (kw) 15 min	20 (15) 25 (18.5) 30 (22)	
Spindle Torque	ft-lb (nm) Cont. ft-lb (nm) 30 min ft-lb (nm) 15 min	76 (102) 93 (126) 111 (150)	
Spindle Base Speed	rpm	1,400	
Spindle Lube	-	Oil / Air	
Spindle Cooling	-	Chiller	
Spindle Bearings	-	70 mm Ceramic Angular (6)	
Specifications subject to change without notice			

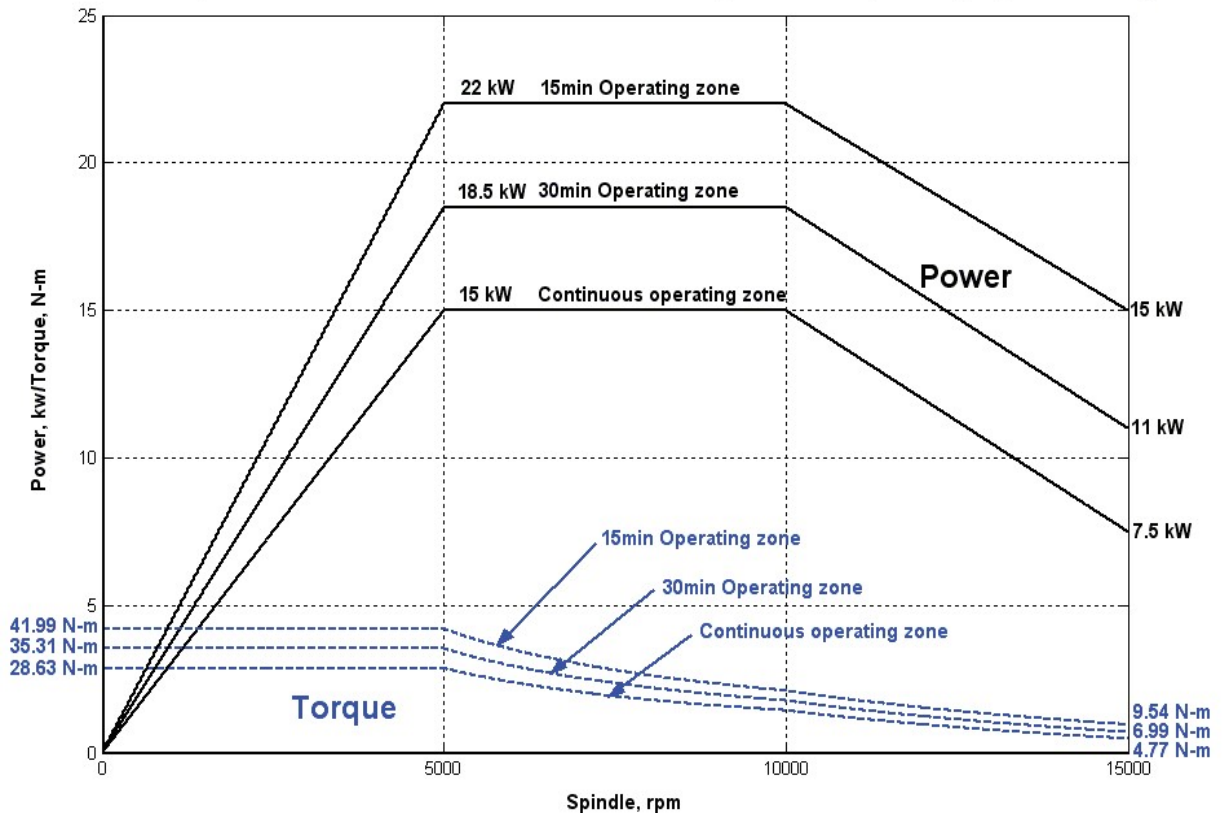
FEATURES	UNIT	MV 800H	MV 1000H
Automatic Tool Changer (Random/Bi-Directional)			
Tool Changer for Big Plus/CAT40 Tool Holders	-	Dual Swing Arm Type	
Maximum Number of Tools	-	24	30
Pull Stud	-	DIN CAT40 A Type	
Maximum Tool Weight	lbs (kg)	15.4 (7)	
Maximum Tool Length	in (mm)	11.8 (300)	
Maximum Tool Diameter	in (mm)	3.1 (80)	
Maximum Tool Diameter - No Adjacent Tool	in (mm)	5.9 (150)	
Tool Changing Time - Tool-to-Tool	sec	1.5	
Tool Holder	-	Big Plus / CAT40	
Tool Clamp Force	lbf (kgf)	2,205 lbf +/- 200 lbf (1000 kgf +/- 100 kgf)	
Accuracies (ISO 230-2) without scale			
X/Y-Axis Positioning Accuracy	in (µm)	.00047 (12)	
X/Y-Axis Repeatability Accuracy	in (µm)	.0002 (6)	
Z-Axis Positioning Accuracy	in (µm)	.00059 (15)	
Z-Axis Repeatability Accuracy	in (µm)	.00027 (7)	
Table			
Table Dimensions	in (mm)	37.4 x 20.5 (950 x 520)	42.2 x 20.5 (1150 x 520)
Spindle Nose to Table Surface	in (mm)	3.94 ~ 24.6 (100 ~ 625)	
Spindle Center to Column Surface	in (mm)	22.4 (570)	
T-Slot Width	in (mm)	.708 (18)	
Number Of T-Slots	qty	5	
Distance between T-Slots	in (mm)	3.937 (100)	
Maximum Load	lbs (kg)	1,102 (500)	
Table Surface to Floor	in (mm)	38.2 (970)	
Dimensions / Weight / Capacities / Power			
Floor Space with Chip Conveyor	in (mm)	136.5 x 109 (3,457 x 2,768.5)	154.3 x 96.3 (3,920 x 2,445.5)
Machine Weight	lbs (kg)	15,101 (6,850)	15,760 (7,150)
Maximum Machine Height	in (mm)	118.01 (2,997.5)	
Coolant Tank Capacity	gal (l)	94 (355)	98 (370)
Coolant Motor (60 hz)	hp (kw)	.74 (.55)	
Coolant Flow (Nozzle)	gpm (l/m)	29 (110)	
Coolant Pressure (Nozzle)	psi (kg/cm ²)	24.2 (1.7)	
Machine Power Capacity	kva / amp	25 / 100	
Machine Voltage & Phase	volts / phase	220 / 3	
Specifications subject to change without notice			

Spindle Power & Torque Diagram

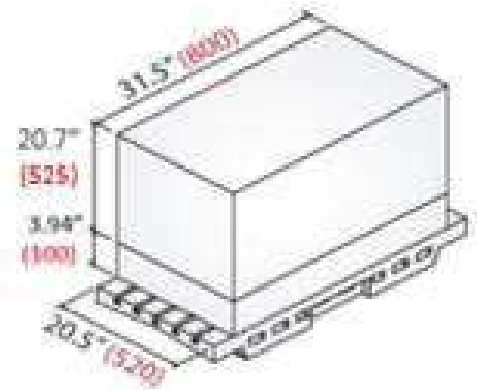
Power/Torque characteristic of FANUC aiT 15/15000 for spindle 15000rpm - Low-speed winding



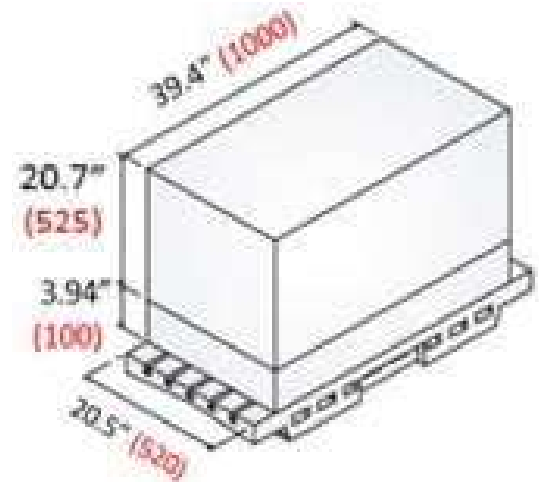
Power/Torque characteristic of FANUC aiT 15/15000 for spindle 15000rpm - High-speed winding



MV 800H Table

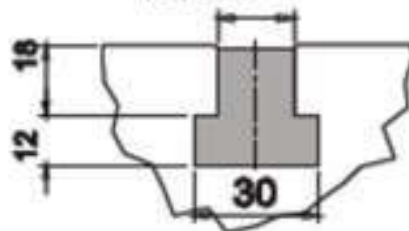


MV 1000H Table



Dim. shown in mm

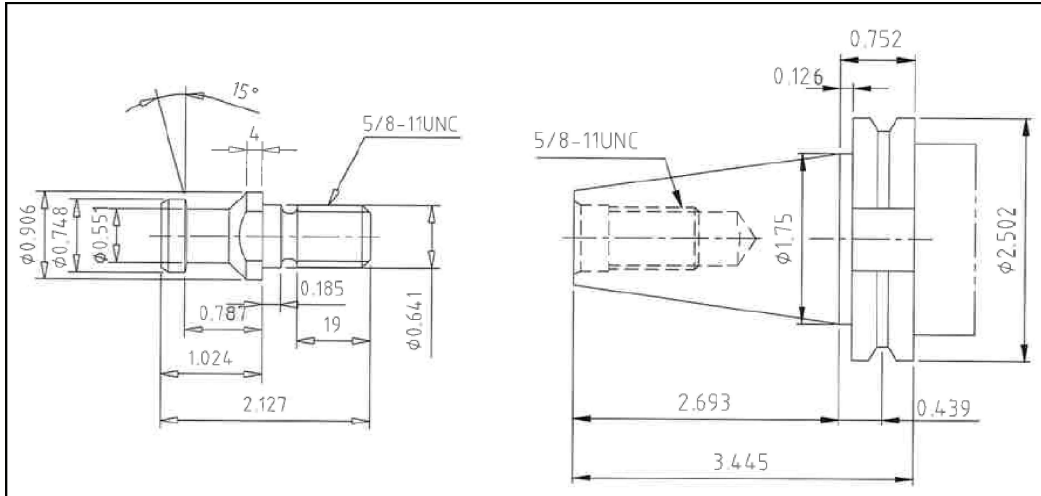
18 H7($\begin{matrix} +0.018 \\ +0.000 \end{matrix}$) / H11($\begin{matrix} +0.110 \\ +0.000 \end{matrix}$)



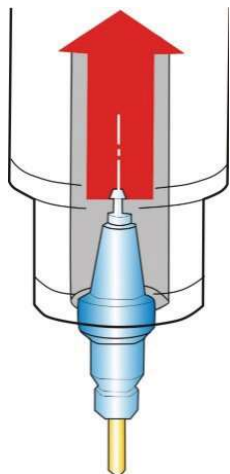
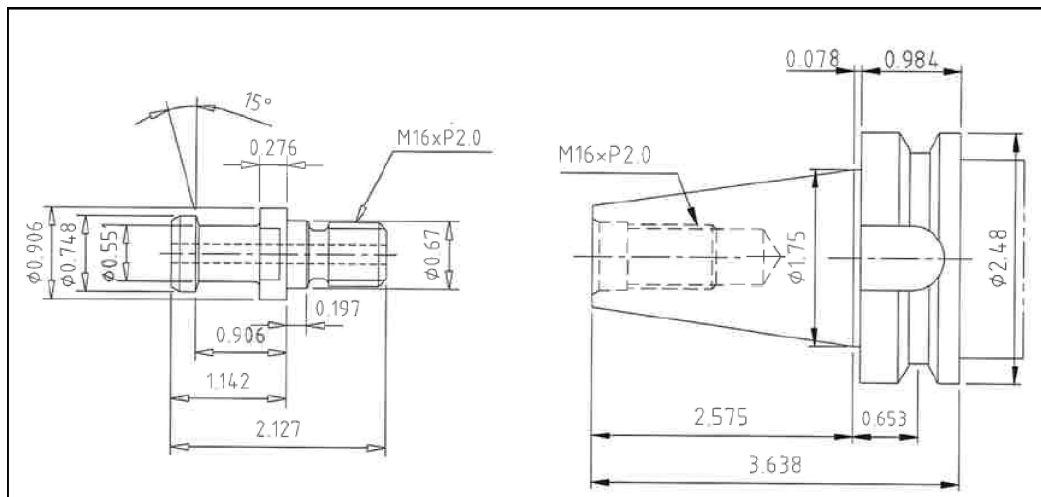
Tooling Diagram

Dim. shown in mm

Big Plus CAT40 Tooling



Big Plus BBT40 Tooling



Tool Clamp Force

2,205 lbf +/- 220 lbf
(1000 kgf +/- 100 kgf)

In Compliance with Quality Assurance Procedures and Standards

- Strict quality standards require that all manufacturing and inspection equipment is calibrated, monitored and controlled using recognized and traceable systems and methods

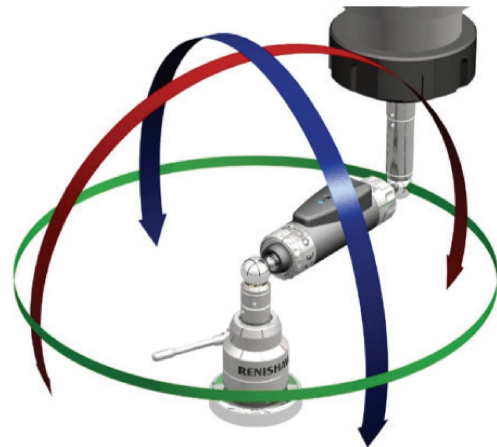
All MV 800H and MV 1000H Machines are fully Lasered and Ballbared

- Laser interferometer and Ballbar measurement systems assess, monitors and can help to improve the static and dynamic performance of the machine
- Ballbar testing provides an important, rapid check of a CNC machine tools positioning performance accuracy as it relates to circularity and circular deviation positioning accuracy. This test is recognized by international standards such as ISO 230-4 and ANSI/ASME B5.54

Laser Interferometer



Ballbar



METHODS MACHINE ACCURACY - WITHOUT SCALE

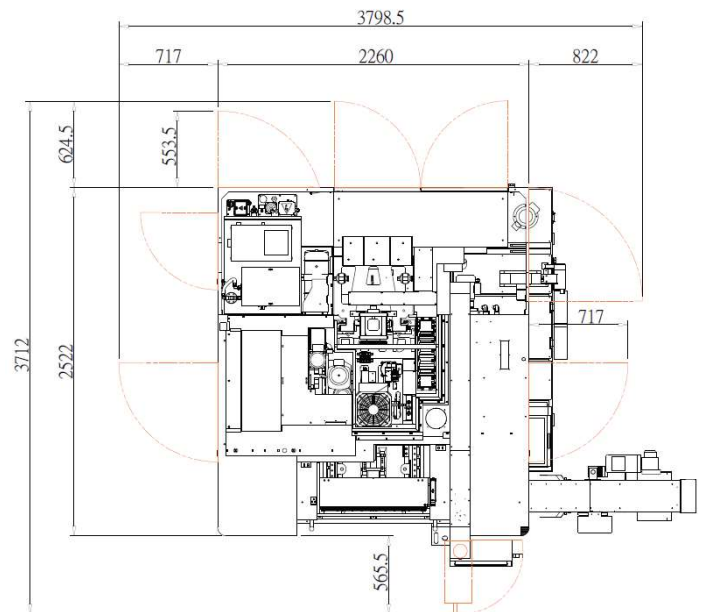
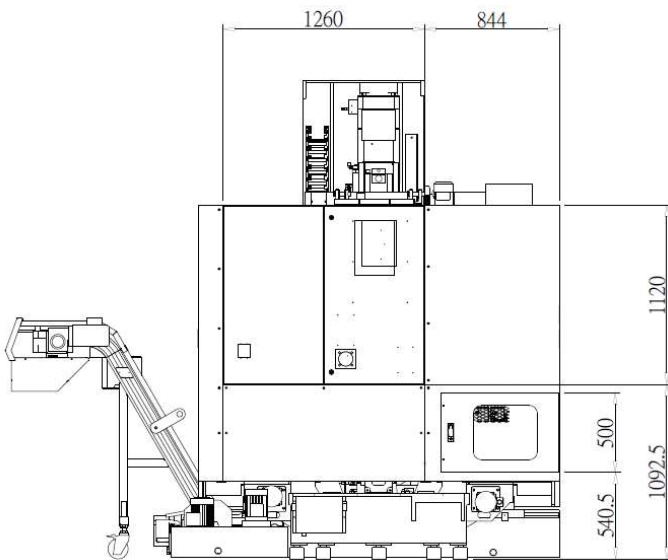
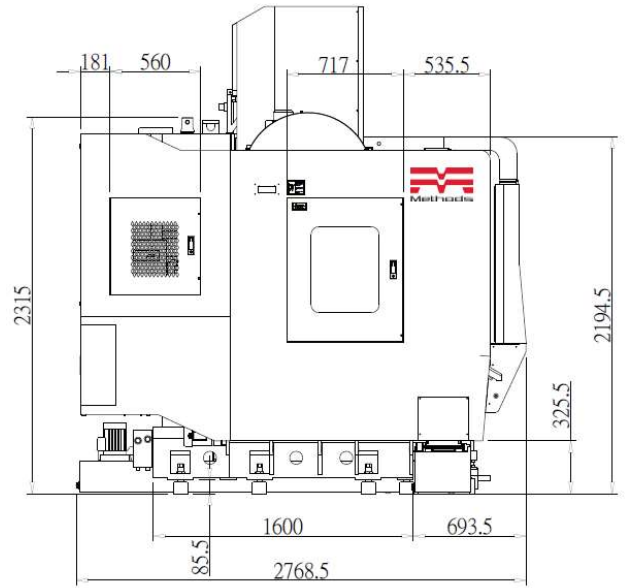
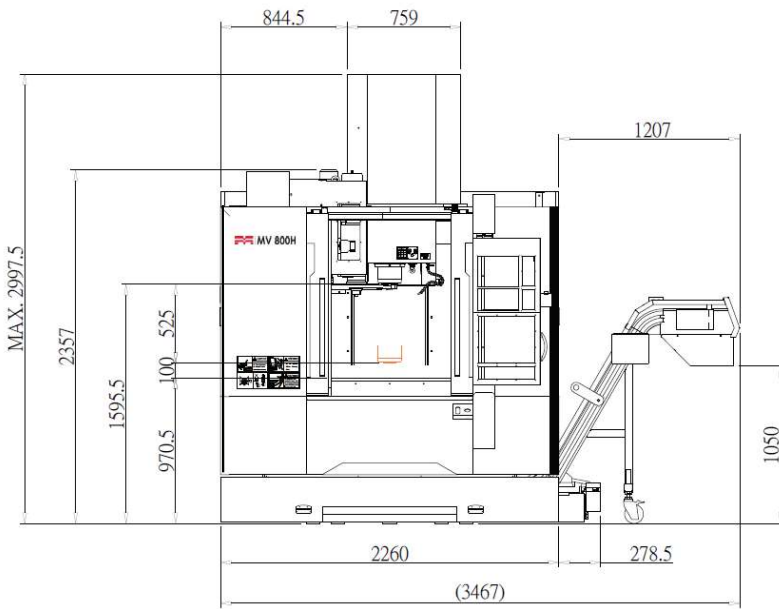
Models	MV 800H ~ MV 2000H (Box Way Z, Linear Roller X/Y)		
Standards	VDI 3441	ISO 1079-4	JIS B66338
		ISO 230-2	
X/Y-Axis Positioning Accuracy	.00047" (12 μm)	.00047" (12 μm)	.0002" / 11.81" (5 μm / 300 mm)
X/Y-Axis Repeatability Accuracy	.0002" (6 μm)	.0002" (6 μm)	± .0001" ± (3 μm)
Z-Axis Positioning Accuracy	.00059" (15 μm)	.00059" (15 μm)	.00022" / 11.81" (5.5 μm / 300 mm)
Z-Axis Repeatability Accuracy	.00027" (7 μm)	.00027" (7 μm)	± .00014" ± (3.5 μm)

FANUC Control Specifications

- 10.4" LCD color display
- AICC 200 Block look ahead
- Controlled axes 4 & 4+1
- 2.0 ms Block processing time
- 1280 meters of memory
- 400 tool offsets
- 3 Simultaneously controlled axes
- HRV 3 control
- Inch / metric conversion
- Machine lock
- Mirror image
- Rigid tapping
- Single direction position
- Exact stop mode
- Tapping mode
- Cutting mode
- Dwell
- Linear interpolation
- Circular interpolation
- Helical interpolation
- Skip function
- High speed skip function
- Reference point return
- Feed per minute
- 2nd reference point return
- Feed rate override
- Jog override
- Program Number search
- Sequence Number search
- Dry run
- Jog feed
- Manual reference return
- Optional block skip
- Program number
- Sequence number
- Absolute/incremental programming
- Plane selection
- Automatic coordinate setting
- Coordinate setting
- Custom macro B
- Programmable data input
- Circular interpolation by program
- Automatic corner deceleration
- Scaling
- Coordinate system rotation
- Canned cycles for drilling
- Tool compensation pairs
- Tool offset memory C
- Tool length compensation
- Cutter compensation C
- Tool life management
- Backlash compensation rapid traverse
- Stored pitch error compensation
- Tool length measurement
- Ethernet 100 mbps, USB, PCMCIA, RS232C
- Current position display
- Program display
- Self-diagnosis function
- Parameter setting display
- Run hour/part count display
- Actual cutting feed rate display
- Operator monitor screen
- Spindle setting screen
- Spindle information screen
- Machine alarm diagnosis
- Alarm history display
- Operator history display
- Graphic function
- Memory card interface
- Additional custom macro variables
- Sub program call
- Extended part program editing
- Additional workpiece coordinate
- Manual Guide i
- Manual absolute on and off
- Auto power off

MV 800H Dimensional Drawings

Dim. shown in mm



MV 1000H Dimensional Drawings

Dim. shown in mm

