



MACHINE DIMENSIONS

VS-1

Turret Milling Machine



Machine Dimensions

1 Machine dimensions

1.1 Basic machine: variable-speed head

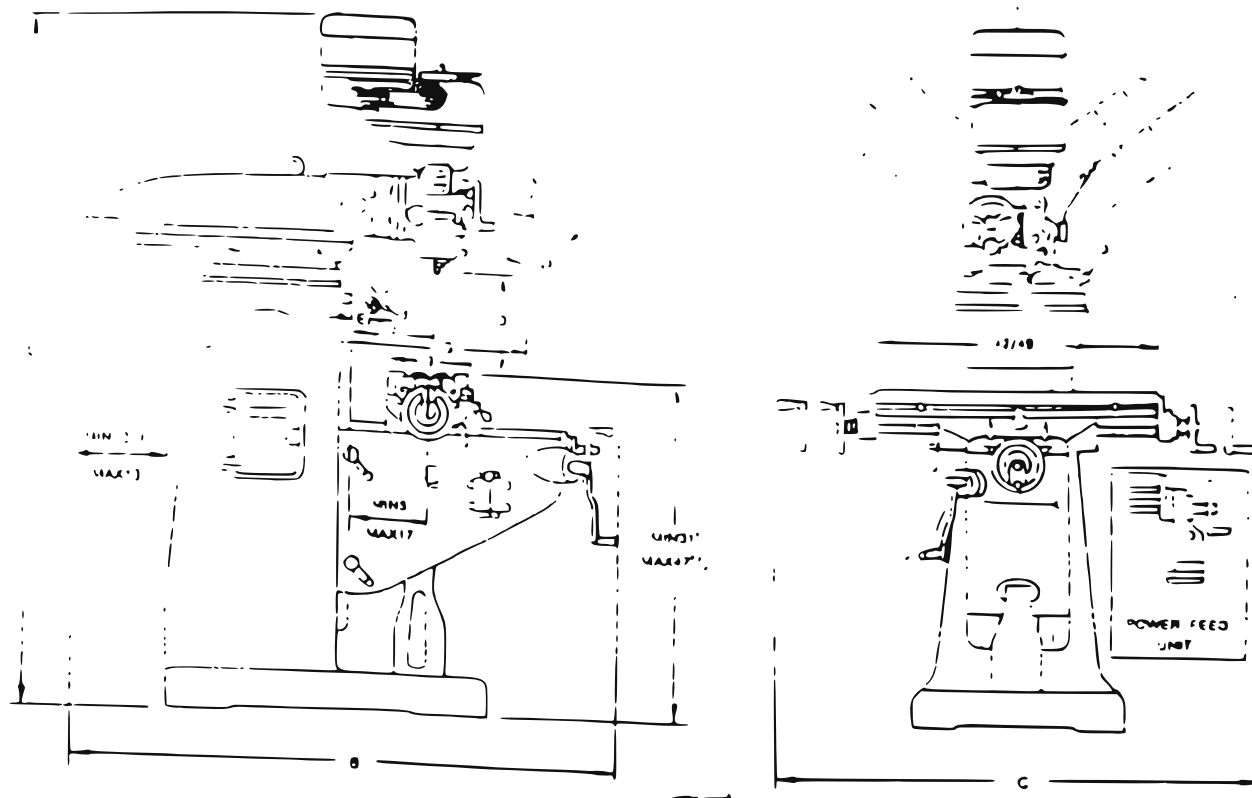


Figure 1-1: Machine outline, side and front elevations (B = overall depth, C = overall width)

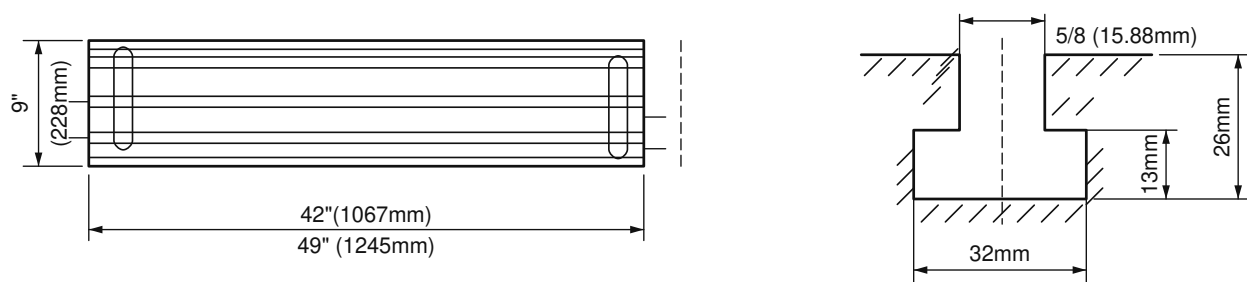


Figure 1-2: Table and T-slot dimensions

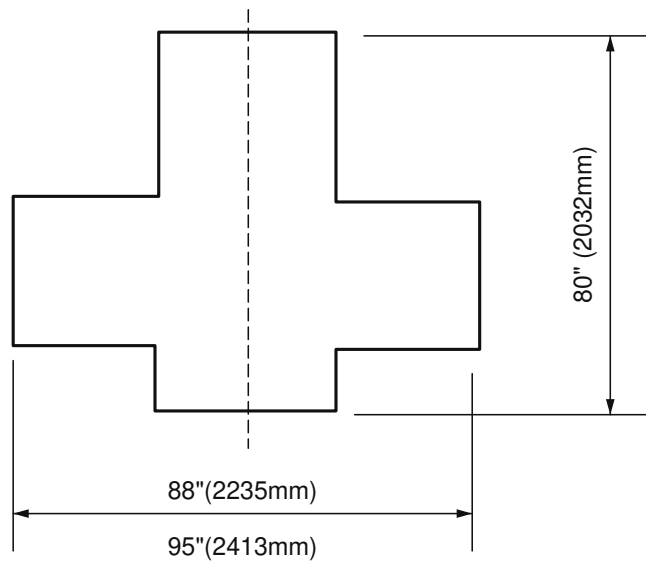


Figure 1-3: Floor area occupied

Table 1-1: Basic machine specification, variable-speed head

Item	in	mm
Table length	48	1219
Longitudinal traverse (manual)	31	787
Longitudinal traverse (power feed)	31	787
Cross traverse	12	304
Vertical traverse	14 1/4"	361
Number of T-slots	3	
T-slot width and centres	5/8" at 2 1/2"	15.88 at 63.5
Ram movement	12	305
Spindle speeds	Infinitely variable	
Spindle speed range	60–4200rpm	
Quill feeds per revolution of spindle	.0015 / .003 / .006	.038 / .076 / .152
Motor (hp)	2	
Overall height	85	2159
Overall depth	64	1625
Overall width	95 / 95	2413 / 2413
Table to spindle gauge line (min–max)	0–18 1/4"	0–463
Head 45° inward (min–max)	0–11 1/4	0–285
Head 90° (min–max)	6 5/8"–20 3/4"	168–527
Head 45° outward (min–max)	14–26	355–660
Floor area occupied	Not stated	Not stated
Case space occupied	Not stated	Not stated
Net weight	2094lb / 2227lb	950kg / 1010kg
Gross weight	2976lb / 3005lb	1350kg / 1363kg

NOTE Where two values are printed in one cell, the original specification sheet does not state which machine each applies to. They are thought to relate to the 42" and 49" table options.

1.2 Basic machine: step-pulley head

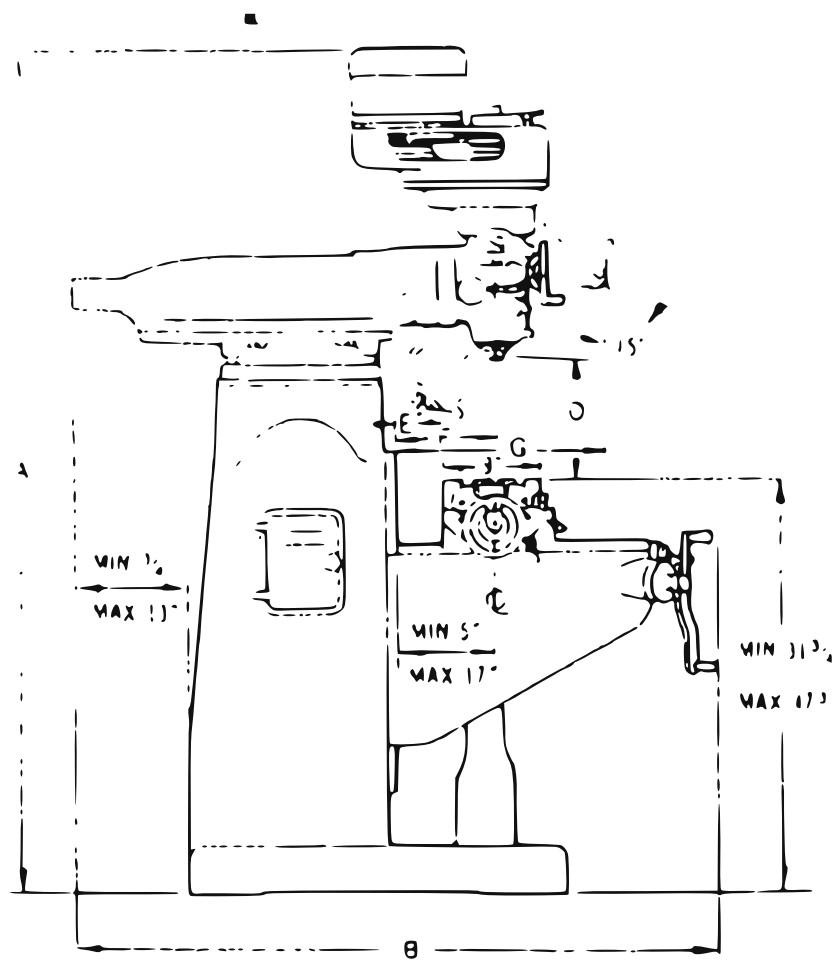


Figure 1-4: Machine side elevation with dimension letters A to G (see Table 2-2)

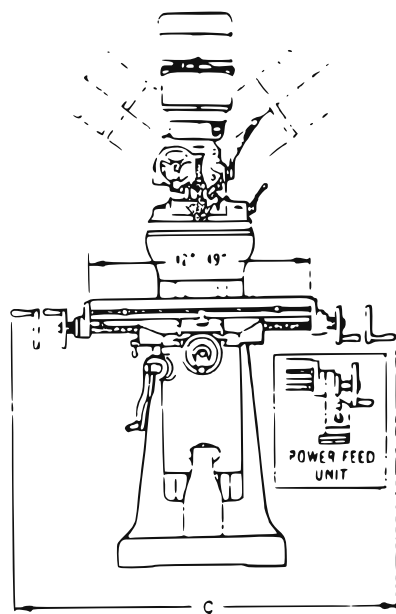


Figure 1-5: Machine front elevation (C = overall width, including power feed unit)

Table 1-2: Basic machine specification, step-pulley head (letters refer to Figures 2-4 and 1-5)

Item	Limit	in	mm
Table length		48	1219
Longitudinal travel (X)		31	787
Longitudinal travel (with power feed unit)		31	787
Cross travel (Y)		12	305
Vertical travel of knee (Z)		14 1/4"	361
A. Overall height		85	2159
B. Overall depth		64	1625
C. Overall width		95	2413
D. Spindle nose to table	min	0	0
	max	18 1/4"	463
E. Head 45° inward	min	0	0
	max	11 1/4	285
F. Head 90°	min	6 7/8"	168
	max	20 3/4"	527
G. Head 45°	min	14	355
	max	26	660
Net weight		2108lb	1016kg

Overall dimensions and weight

Floor space	2.5 x 1.6 m
Machine height	2.15 m
Machine weight	885 kg

2 Installation

2.1 Handling

The machine weighs approximately 2200lb (997kg). Lift it by one of the two methods below.

2.2 Floor plan

Figure 3-3 gives the machine footprint and anchor-bolt positions. Dimension A is the overall width with the table at full travel; Table 3-1 gives its value for each table size.

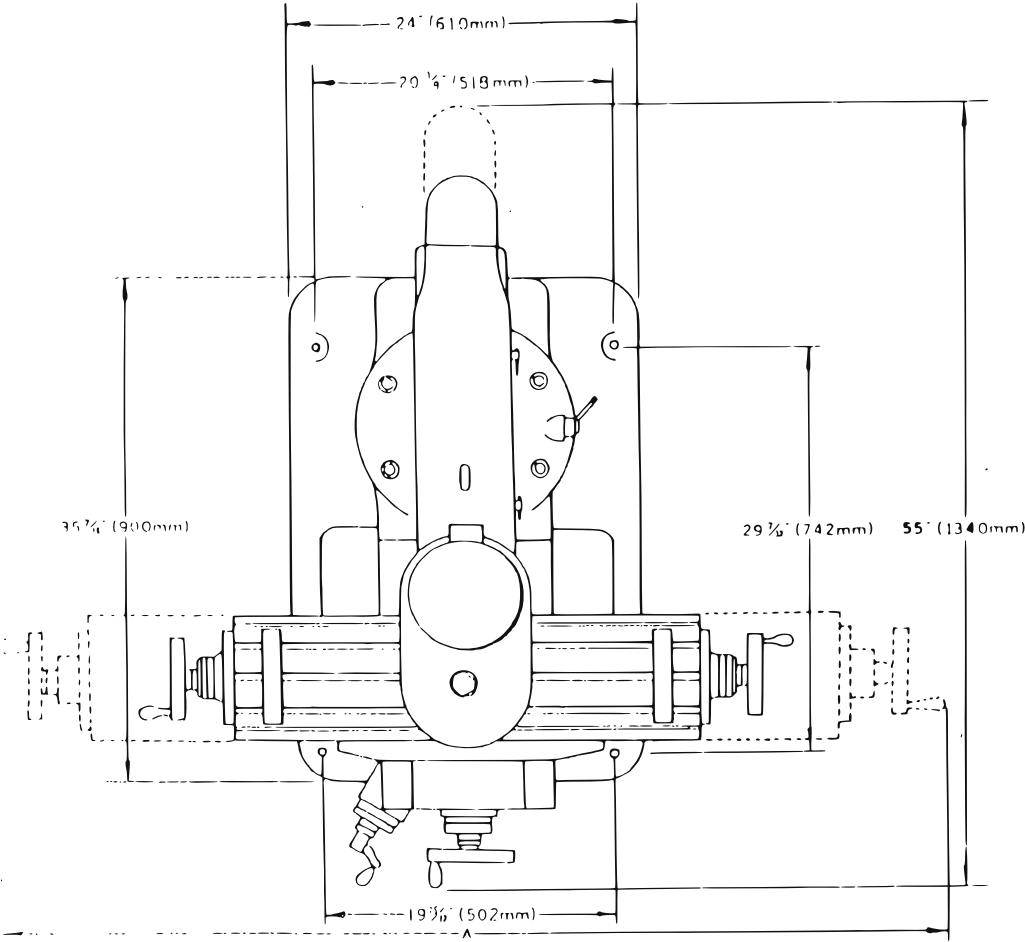


Figure 2-1: Floor plan

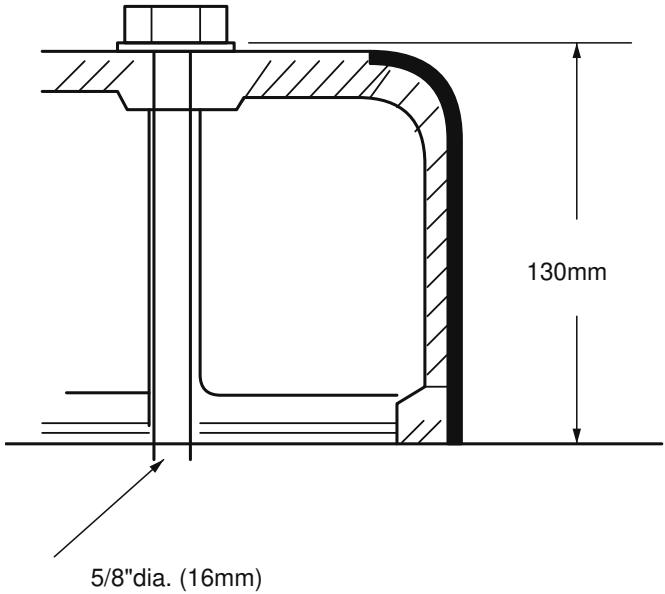


Figure 2-2: Anchor bolt through the base flange

Table 2-1: Dimension A

Table size	Plain machine
42"	95" (2413mm)
49"	107" (2718mm)

2.3 Foundation

Ideally, bolt the machine to a concrete foundation. Otherwise, stand it on a solid, level floor or on anti-vibration pads so that it cannot rock.

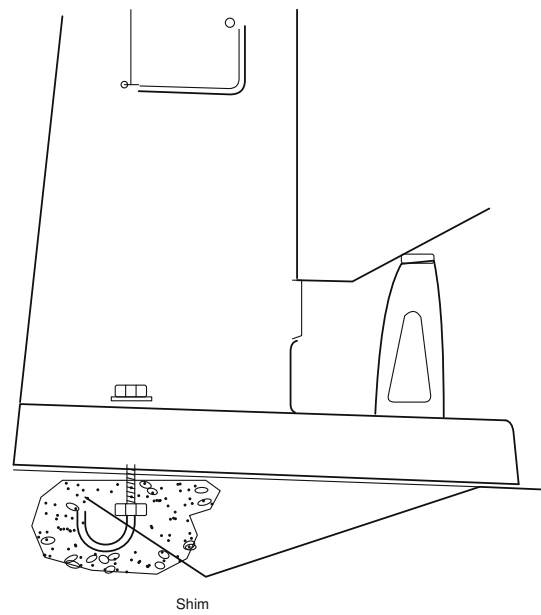


Figure 2-3: Base on the foundation, showing anchor bolt and shim

Build the foundation to the plan and section in Figures 3-6 to 2-6. Table 3-2 gives the dimensions.

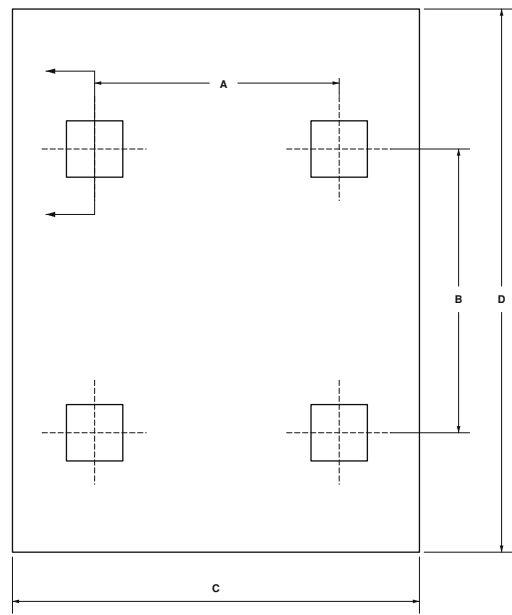


Figure 2-4: Foundation plan

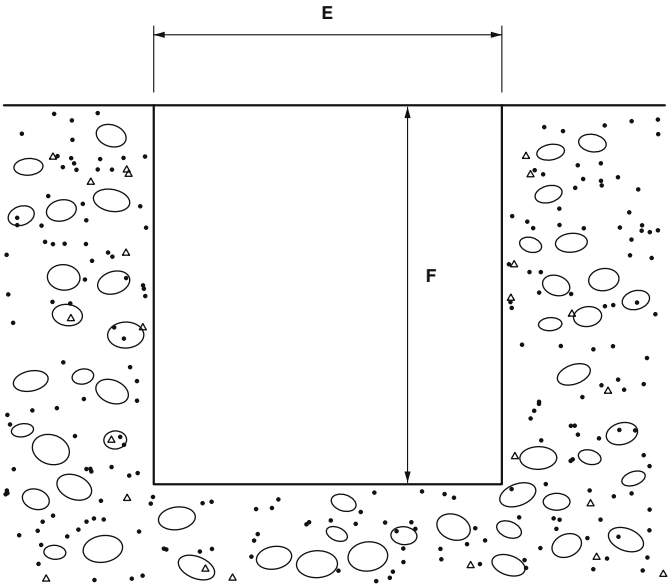


Figure 2-5: Foundation structure, anchor pocket

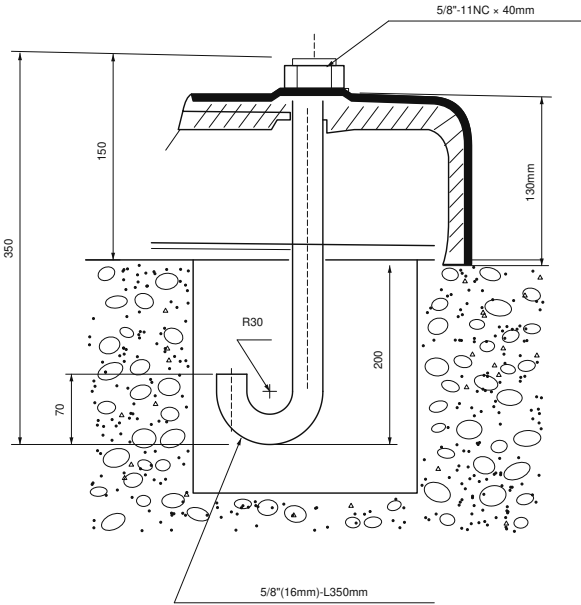


Figure 2-6: Foundation structure, anchor bolt detail

Table 2-2: Foundation dimensions (letters refer to Figures 3-6 and 2-5)

Dimension	Size
A	518mm (20 3/8")
B	742mm (24 7/32")
C	1020mm (40 5/32")
D	1242mm (48 7/8")
E	200mm (7 7/6")
F	250mm (9 27/32")



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