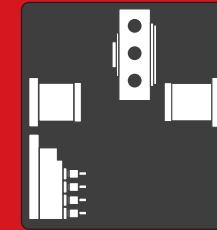


Double Spindle Turret + Gang Tools Multi-Tasking Turning Center



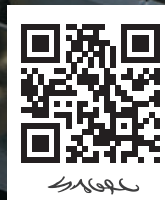
GT42 GT52

-  Aerospace
-  Automotive
-  Electronics
-  Hydraulics
-  Medical
-  Pneumatics



MING YANG
MACHINERY CO., LTD.

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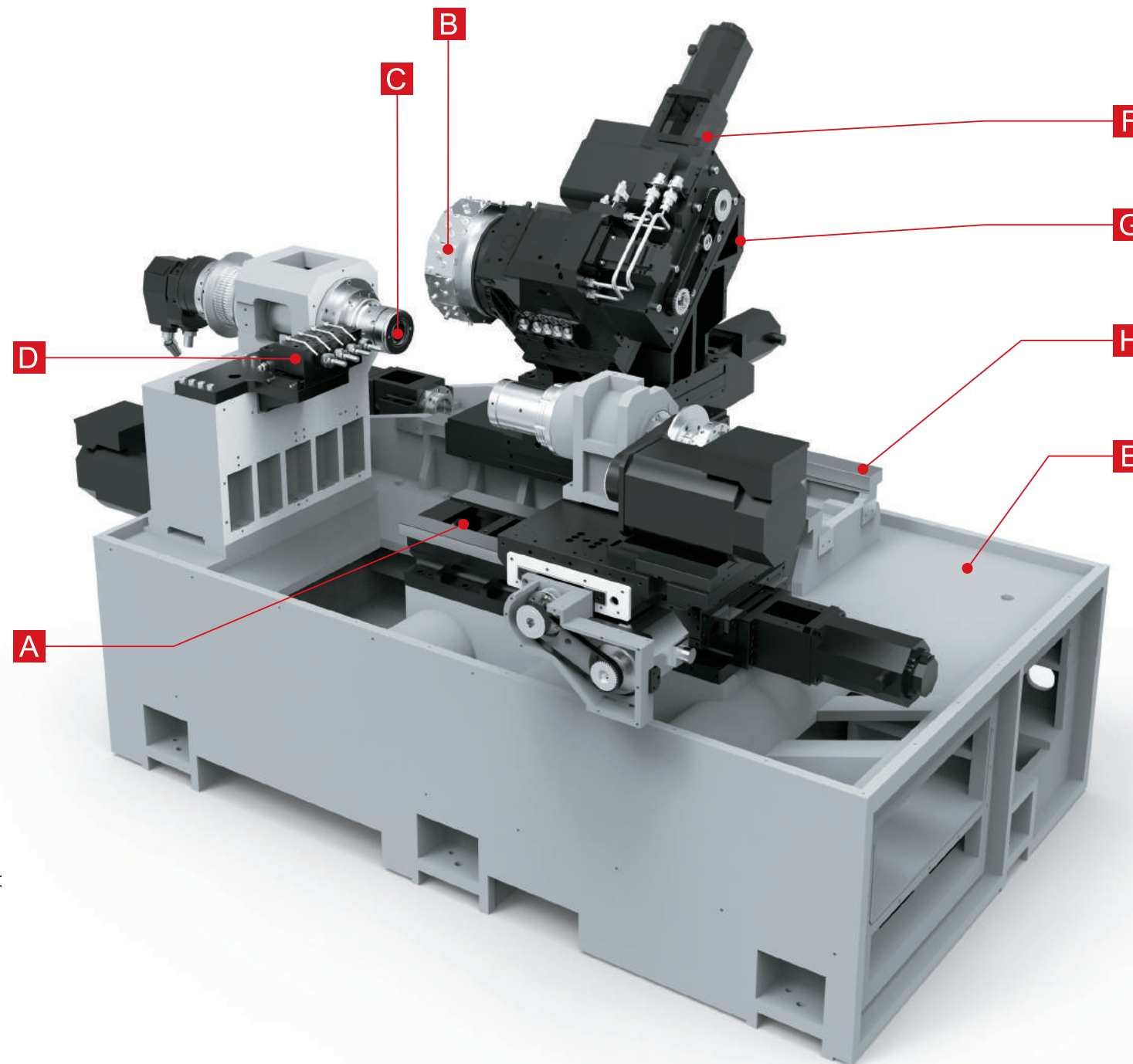
Turning Precision Into Perfection

Front Machining

- BMT 45, 12 Stations
- Up to 24 Tools
- 7.5/11 kW Spindle Power
- 55 mm Through Hole

Back Machining

- GT42: 4 x 20 mm ID Tools
- GT52: 4 x 16 mm ID Tools
- Or 3x 20 mm ID Tools
- Or 3x 25 mm ID Tools

**Key Features**

- A** Boxways on all axes are oversized and precision ground to a near mirror finish for smooth, fast precision movements providing dynamic rigidity & heavy-duty cutting ability
- B** The main turret has 12 stations. With multi-tool holders up to 24 tools can be equipped. Driven tools at all 12 stations are possible.
- C** Heavy-duty precision spindle design for enhanced thermal stability & power
- D** GT42-4x 20mm ID Tools, GT52- 4x 16mm ID Tools, or 3x 20mm or 3x 25mm for complex, fast back machining & superimposed cutting that reduces cycle times.
- E** Meehanite cast material is used and stress relieved to provide the best possible rigidity and vibration dampening base for machining parts with excellent surface finishes
- F** Y1-Axis travel +/- 35mm is supported by two slides, distributing the machining force evenly to ensure accuracy and rigidity
- G** 45 degree wedge design for fast chip flow and removal from the machining area for a thermally stable work platform
- H** Z-axis is equipped with precision high-rigidity 32mm ball screws & all other axes use 28mm ball screws to ensure fast feed rates and extended long-term durability for trouble free machining

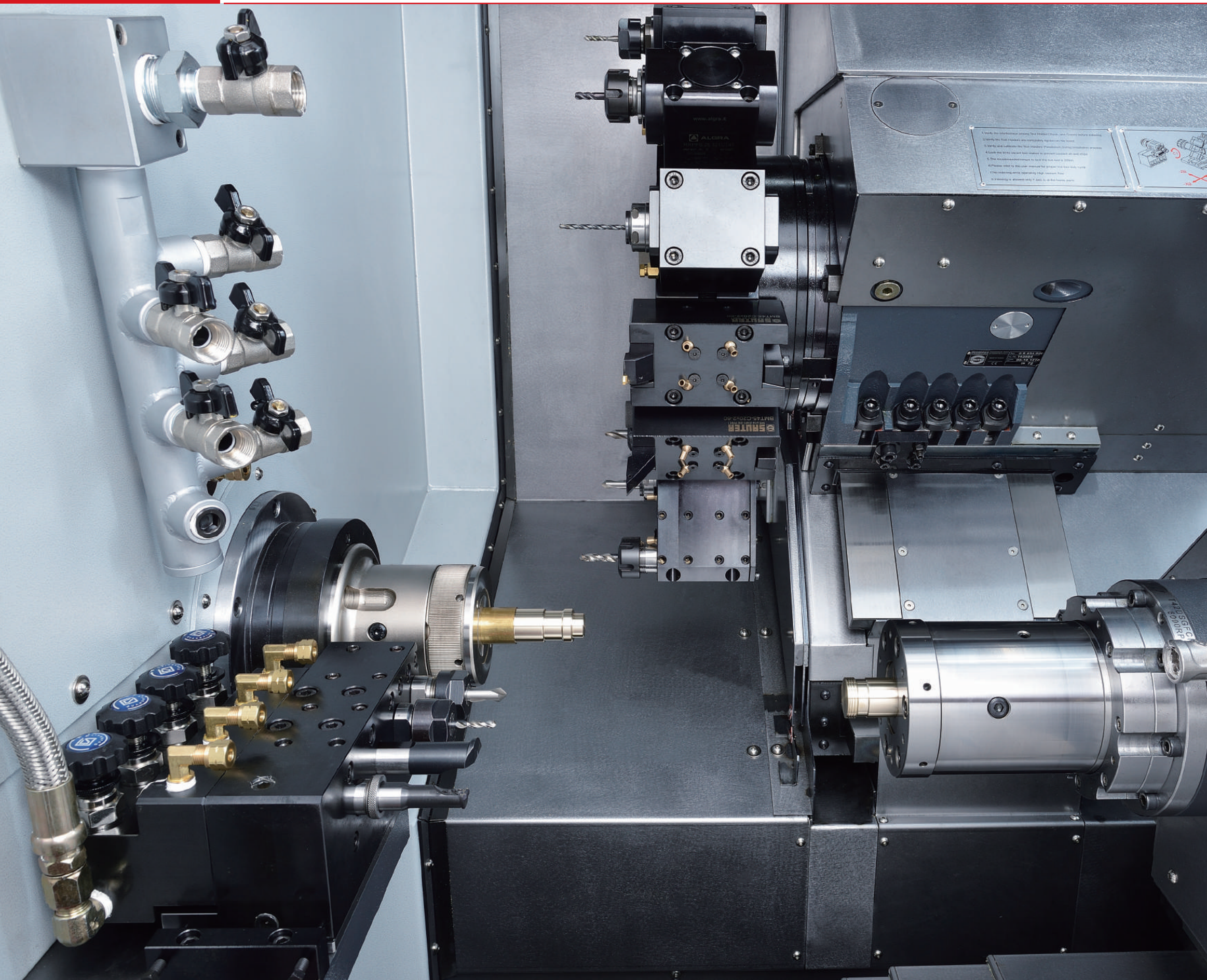
Capabilities

This multi-tasking turning center is an advanced and economical solution designed to process precision complex parts with fast cycle times.

Power & Speed

It has Double Spindles, a BMT 12 station turret and 4 gang tools for economical machining. Coupled with superimposed cutting it's a powerful solution for precision complex workpieces with extremely fast cycle times.





SAUTER BMT45 / VDI 30-12 Stations Main Turret

The main turret has 12 stations, but with multi-tool holders up to 24 tools are possible. Fanuc Alpha 2 motors provide driven tools up to 6000 rpm with high power and speed. Bidirectional turret indexing allows the shortest path to the next tool for faster cycle times. A 20 bar high pressure coolant system provides fast chip removal and longer tool life.

BMT45

- Fanuc Alpha 2 Motor-High torque, resolution & precision
- Driven tools: 2.2/3.75 kW & 23.5 N.m
- Optional 50/100 bar High Pressure Coolant Systems

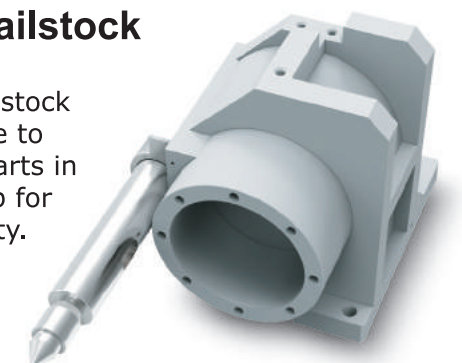
Gang Tool Slide/ Backmachining

For back machining, the 4 gang tools can shorten machining times and provides an economic solution for processing of mass production parts.

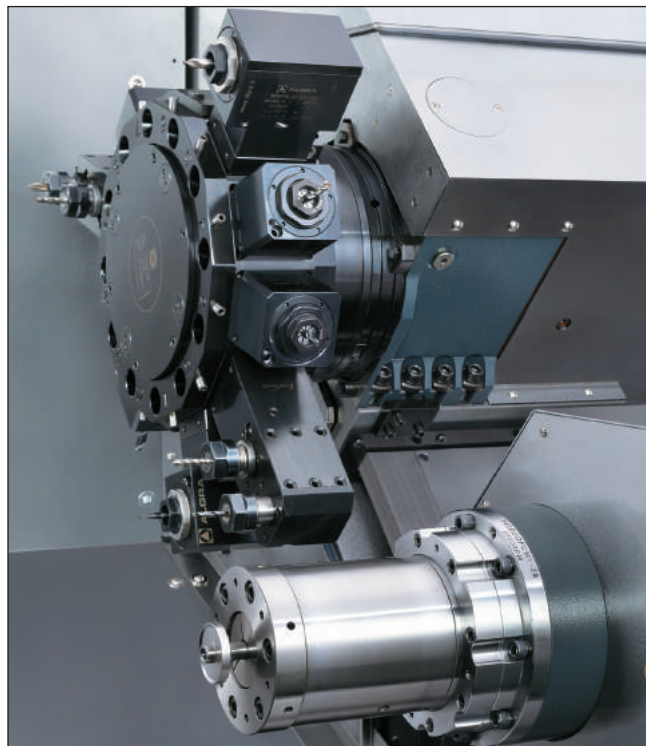
- GT42: 4x 20 mm ID Tools
- GT52: 4x 16 mm ID Tools
- Or 3x 20 mm ID Tools
- Or 3x 25 mm ID Tools

Optional Tailstock

An optional tailstock unit is available to process long parts in the same setup for added versatility.

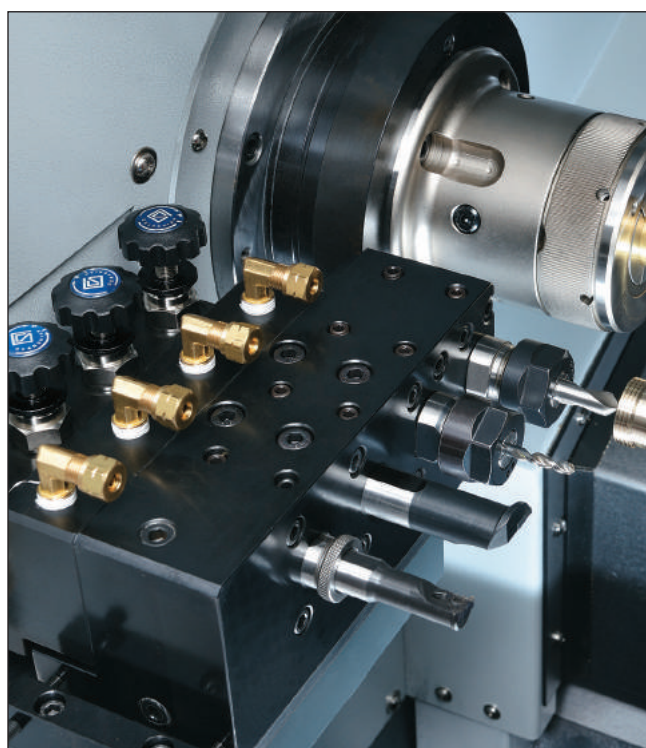


Y-Axis Enhanced Machining Capability in One Setup Speed, Precision & Complex Parts



Sauter BMT 45/VDI 30 Turret (Y1-Axis)

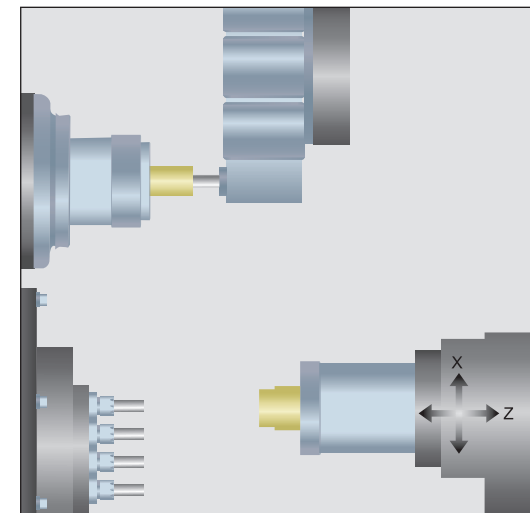
- **24 Tools Possible**-12 station German branded turret for reliable heavy-duty cutting for non-stop production is equipped with half-indexing and fast tool changes of only 0.2 sec.
- **Fanuc Alpha 2** servos for driven tools up to 6000rpm for powerful high-performance cutting of the most difficult materials with ease and speed
- **20 Bar High Pressure Coolant** systems also provides fast chip removal and longer tool life necessary in for prolonged serial production. (Optional 50/100 bar)
- **Y1-axis Travel +/- 35mm**



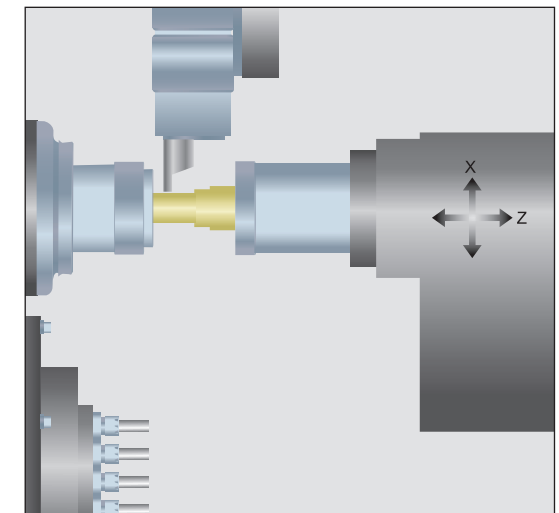
Back Machining Gang Tools

- **4 tools**-For back machining of complex workpieces, the added capability will shorten cycle times significantly.
- **Superimposed Cutting for High Productivity**-Cycle times can be significantly reduced with superimposed cutting

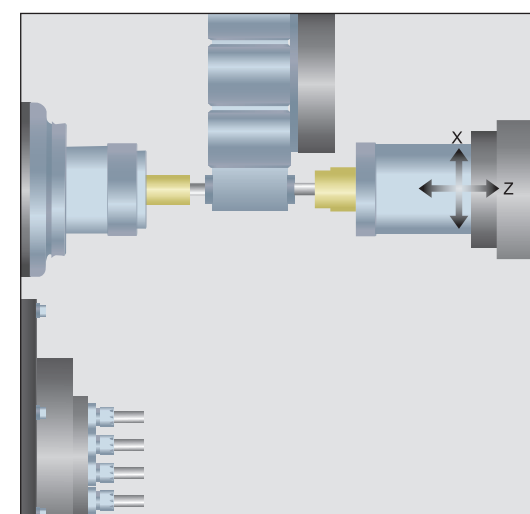
Spindle 1, Turret 1 ID Turning



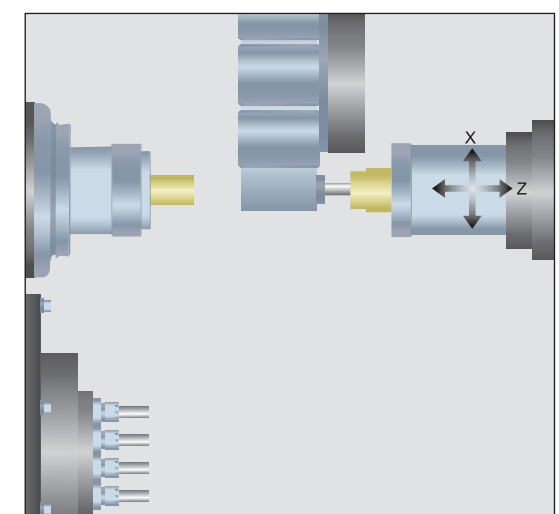
Transfer & Cutoff to Spindle 2



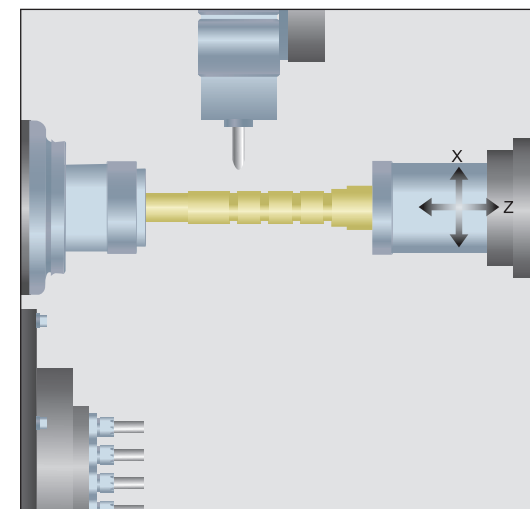
Superimposed Machining



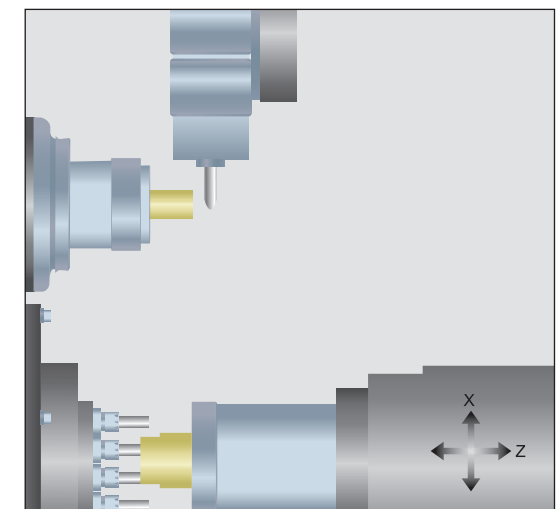
Turret 1 Back Machining



Spindle 1 & 2 Milling

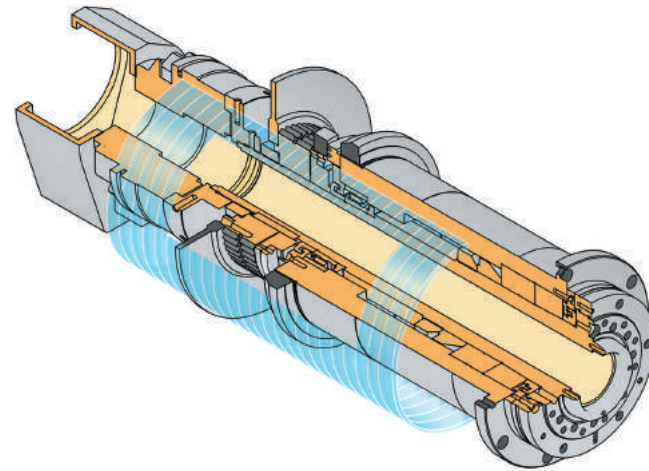


Turret 1 Milling ID Turning

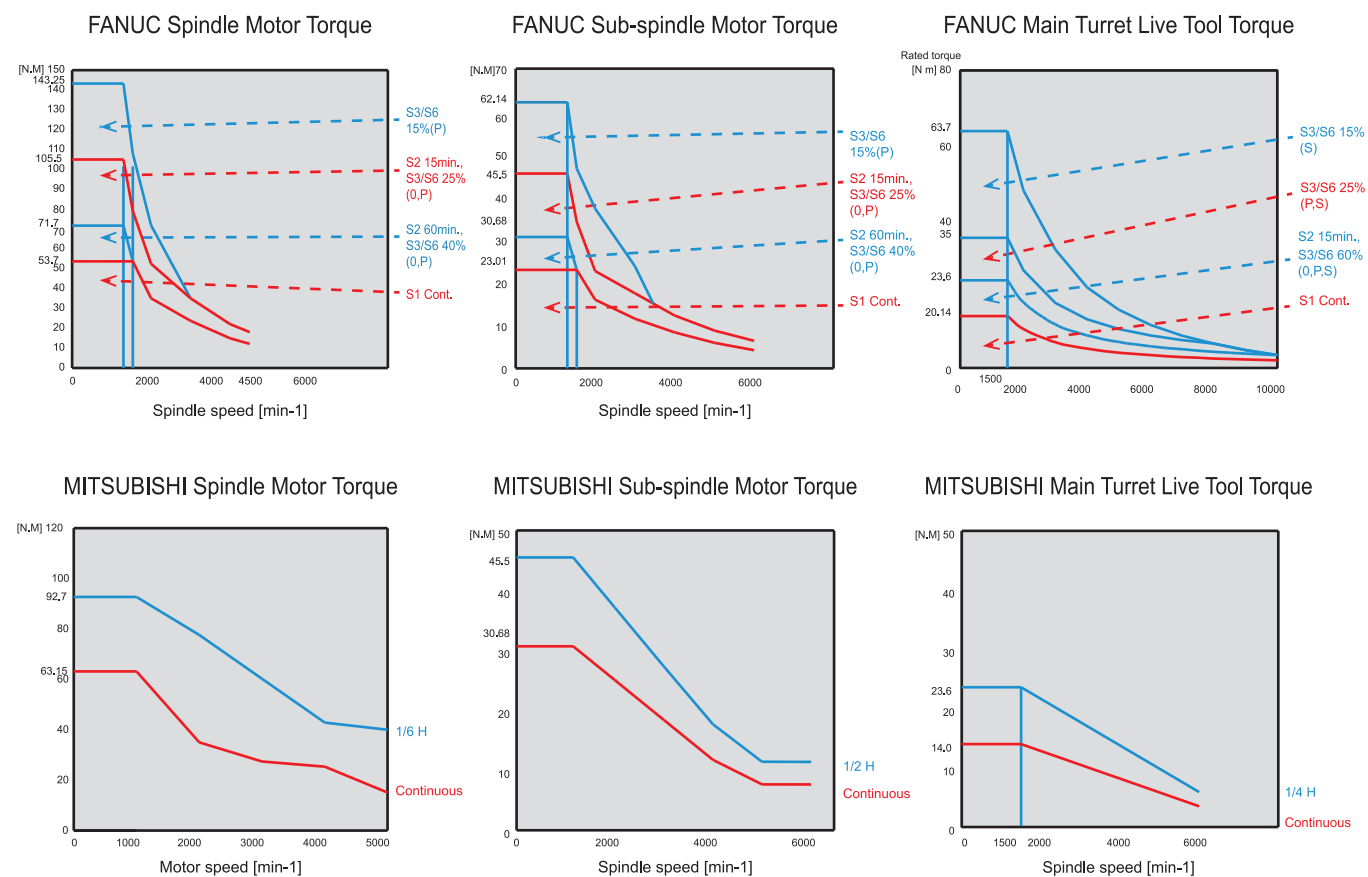


Machine Details

- Extremely rigid main and sub-spindles with purpose built roller bearings on the front and rear to concentrate power directly to the cutting surface and resist axial and radial forces
- Higher speeds and heavy-cuts are possible with this bearing arrangement
- Simultaneous independent machining of the front and back of the workpiece and C-axis with resolution of 0.001 degrees allows for complex contouring of parts

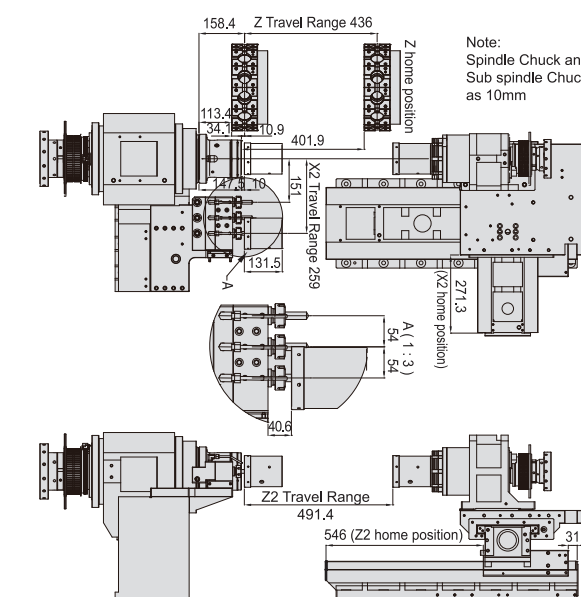


Machine Dimensions

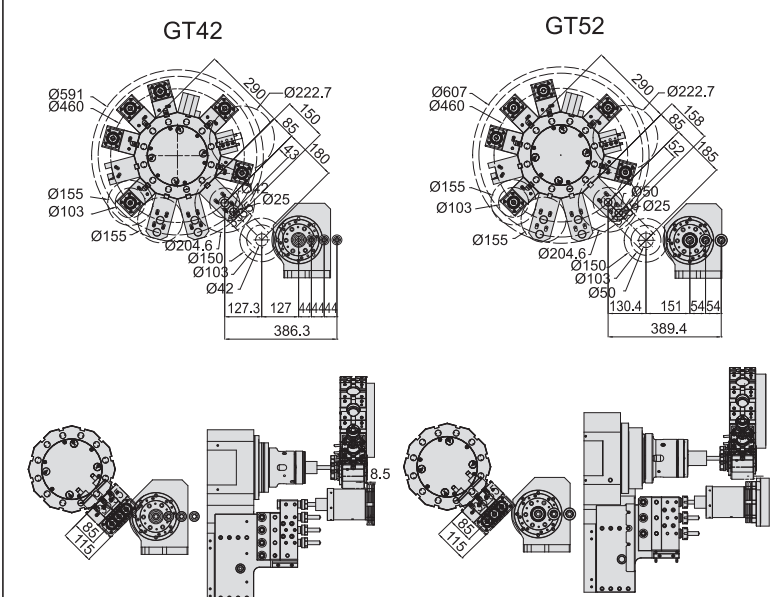


Tool Interference Diagrams

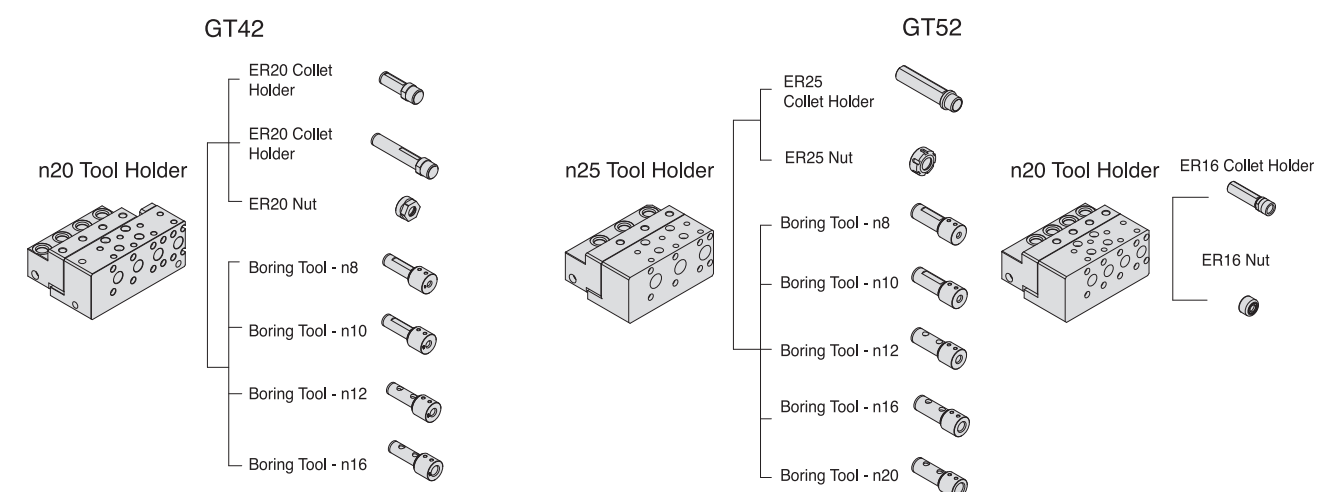
Machining Zone



Tool Interference

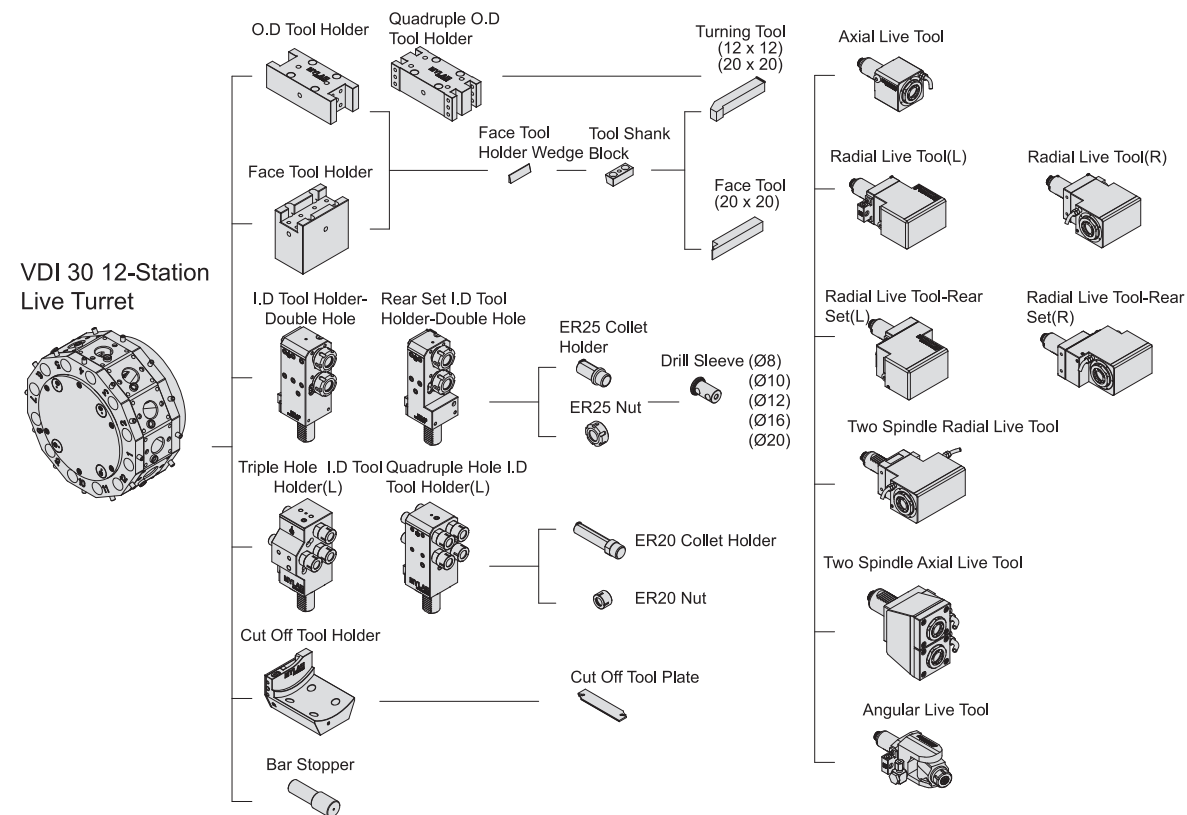


Tooling System

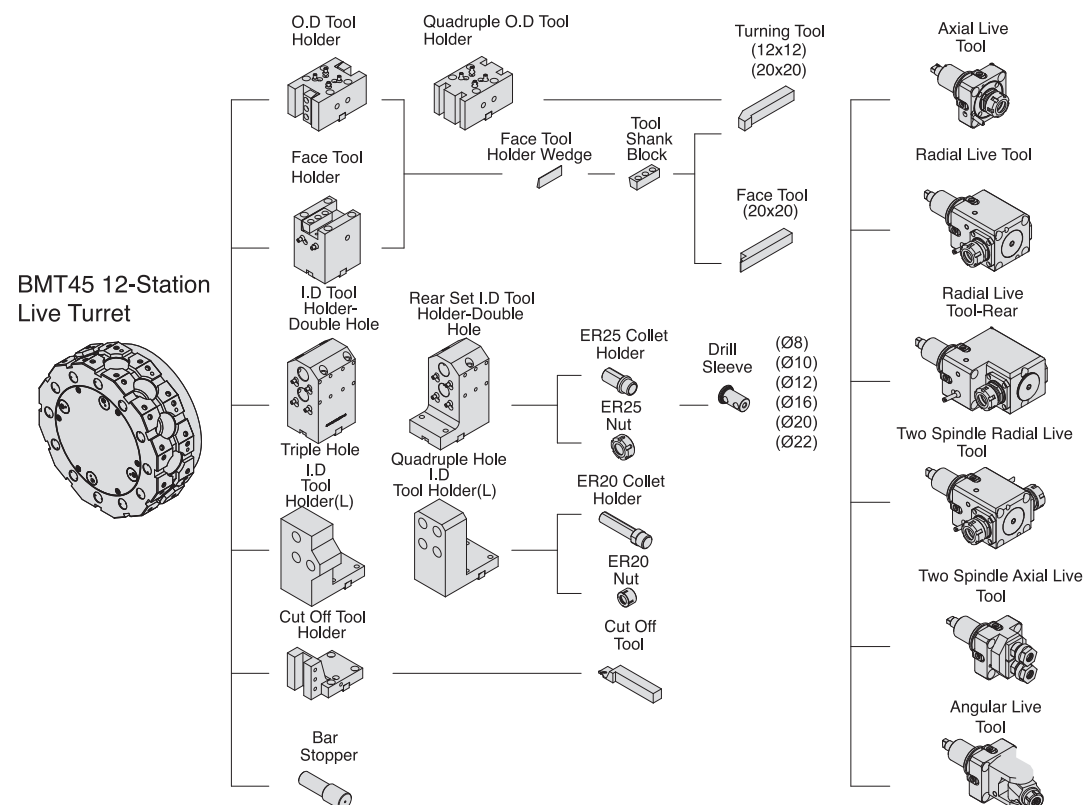


VDI 30.12 Tooling System

Unit:mm



BMT45. 12 Tooling System



Item	Unit	GT42 Main Spindle	GT52 Main Spindle	GT42/GT52 Sub spindle
Capacity	Swing Over Saddle	mm	Ø260	Ø260
	Chuck Type	mm	DIN173E	DIN177E
	Max. Bar Turning Length	mm	135	150
	Max. Turning Length	mm	350	350
	Max. Turning	mm	Ø150	Ø150
Travel	Max. Turning Bar Diameter	mm	Ø42	Ø51
	X1 / X2 Axis Travel	mm	180 (X1)	180 (X1)
	Z1 / Z2 Axis Travel	mm	435 (Z1)	435 (Z1)
	Y1 Axis Travel	mm	±35	±35
	X1 / X2 Axis Rapid Traverse	mm/min	18 (X1)	18 (X1)
Spindle	Z1 / Z2 Axis Rapid Traverse	mm/min	24 (Z1)	24 (Z1)
	Y1 Axis Rapid Traverse	mm/min	18	18
	Spindle Nose	type	A2-5	A2-6
	Hole Through	mm	56	79
	Spindle Speed	rpm	50 - 5000	50 - 4500
Turret	Spindle Motor Type	type	β8 / 12000i	β8 / 12000i
	Spindle Motor (Cont./15min)	kW	7.5 / 11 / 15	7.5 / 11 / 15
	No. of Tool Stations	set	12	12
	O.D. Tool Size	mm	20	20
	I.D. of Boring Bar Holder	mm	25	25
Gang Tool	Turret Indexing	sec	0.1 - 0.3	0.1 - 0.3
	Tool Spindle Speed	rpm	6000	6000
	Tool Spindle Motor Type	type	α2 / 10000i	α2 / 10000i
	Tool Spindle Motor (Cont./15min)	kW	2.2 / 3.7	2.2 / 3.7
	Tool Spindle Torque (Cont./15min)	mm	14 / 23.6	14 / 23.6
Motor Power	Drill Capacity	mm	Ø13	Ø13
	Endmill Capacity	mm	Ø13	Ø13
	Tap Capacity	mm	M8	M8
	No. of Gang Tool	set	4	3 / 4
	Tool Holder of Gang Tool	mm	Ø20	Ø25 / Ø20
Motor Power	Collet Holder of Gang Tool	type	ER20	ER25 / ER16
	Max. Tool Size	mm	Ø13	Ø16 / Ø10
	X1 / X2 Servo Motor	kW	1.8 (X1)	1.8 (X1)
	Z1 / Z2 Servo Motor	kW	1.8 (Z1)	1.8 (Z1)
	Y1 Servo Motor	kW	1.8	1.8
Motor Power	Turret Servo Motor	kW	0.75	0.75
	Coolant Pump	kW	0.9	0.9
	High Pressure Cutting Fluid Pump	kW	0.4	0.4
	Hydraulic Pump	kW	3.75	3.75
	Parts Conveyor Motor	kW	0.03	0.03
Motor Power	Chip Conveyor Motor	kW	0.2	0.2
	Lubrication Pump	kW	0.003	0.003
	Oil Mist Collector	kW	0.75	0.75
	Hydraulic Capacity	Liter	55	55
	Lubrication Tank Capacity	Liter	2	2
Machine Dimension (W x D x H)	Coolant Tank Capacity	Liter	250	250
	Machine Dimension (W x D x H)	mm	2750x1950x2000	2780x1950x2000
	Machine Weight	kg	5000	5100
	Machine Area (W x D)	mm	4950 x 3640	4985 x 3640

Standard Accessories:

- Fanuc Controller
- Collet Chuck
- Workpiece Ejector
- 12-Station Power Turret
- Gang Tool System
- Auto Lubrication System
- Coolant System
- Sub-Spindle Inner Coolant & Air Blow
- Coolant Level Sensor
- Auto Power Shut-Off
- Signal Tower
- High Pressure Coolant System (20 Bar)

Optional Accessories:

- Live Tool Holder
- Static Tool Holder
- 6" Power Chuck for SP1
- 5" Power Chuck for SP2
- Air Blow for SP1/SP2
- High Pressure Coolant System (50 Bar/100 Bar)
- Chip Conveyor
- Oil Mist Collector
- Bar Feeder
- Transformer
- Regulator
- Mitsubishi Controller
- Parts Catcher
- Parts Conveyor
- Tailstock

We reserve the right to modify the above specifications without notice.