



MACHINERY SOLUTIONS, INC.
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Victor 3000DCL Shown
(Same Configuration as 2600DCL)

2600DCL Digital Control Lathe

MACHINE SPECIFICATIONS

- Multiple Function Lathe
 1. Manual Handwheel Operation
 2. Machining Guidance Operation
 3. Teach-in / Playback CNC Operation
 4. Automatic CNC G-Code Operation
- 26" (660 mm) swing over bed
- 14.5" (370 mm) swing over cross-slide
- Ø4.1" (Ø104 mm) diameter hole through spindle
- 60"/ 80"/ 120" distance between centers
- 15.7" (400 mm) X-axis cross-slide travel with front doors opened
- Main casting pieces are by massive Meehanite castings for superior dampening and rigidity
- Headstock gears are made from chromium molybdenum steel (SCM21), hardened by carbonization, and precisely ground to provide smooth and quiet running
- Forced lubrication of headstock gears
- Spindle is supported by three precision bearings to insure accuracy and rigidity during heavy cutting (Suitable for large diameter work-pieces)
- Ribbed bed constructed from an annealed processed casting insures no deformation occurs on the slideways
- Hardened and ground bed ways
- Saddle is coated with TURCITE-B to provide wear resistance
- Rigid construction of the tailstock is able to withstand heavy drilling and cutting
- Automatic force type lubrication system to all sliding surfaces & ballscrews
- Hardware overtravel limit switch for all travel directions
- Tailstock overtravel limit switch to avoid unexpected crashes
- Complete FANUC System with Fanuc AC Brushless Servo Motors & Drives
- Triple electronic handwheels for manual and automatic turning operations
- Dual sliding doors to protect the operator from coolant and chips
- LCD color display CNC control mounted swivel arm for easy access and viewing while control panel conveniently mounted on apron for easy access with door closed (2660DCL model)
- LCD color display CNC control and control panel conveniently mounted on right sliding door (2680DCL/26120DCL models)
- 20 HP Spindle Motor



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MACHINE SPECIFICATIONS (continued)

- Vector control spindle drive - Excellent torque characteristic at all spindle speeds
- Heavy duty, manual tailstock with Inch/Metric graduations
- Tailstock taper: MT #5; Quill diameter: 4.1", Quill Travel : 6"
- Feed rates: 0.01 ~ 200.0 in/min variable by program input
- Rapid traverse: X-axis = 225 in/min, Z-axis = 300 in/min
- Spindle speeds 0 ~ 1,200 RPM variable and programmable through 4 manual ranges
- Spindle Nose: A2-11 (D1-11 Optional)
- Automatic spindle jog during gear changes makes gear shifts easy
- *Aloris Super-Precision Quick Change Tool Post (DA Series)*
- Tool size 1.25" x 1.25" square shank
- Safety interlock switch to prevent unexpected spindle movement (Chuck or Door)
- Fluorescent work light – Fully integrated to allow for CNC control of on/off function
- Coolant System – Fully integrated to allow for CNC control of on/off function
- Removable frontal chip pan under bed
- Set of leveling pads, screws, and nuts
- Set of wrenches for operating machine
- Set of Operating and Machine Guidance manuals
- Floor area: 2660DCL: 160" x 90" / 2680DCL: 180" x 90" / 26120DCL: 220" x 90"
- Full one year parts warranty on machine and CNC control

CONTROL SPECIFICATIONS

- Fanuc 20i-TB ultra-compact CNC integrated with 8.5" LCD display and 44-key keypad
- High quality engineering at FANUC ensures reliable technology and performance
- Fiber Optical Fanuc Digital Servo Amplifiers immune to interference from electrical noise
- Fiber AC Digital Servo System with high resolution absolute encoders
- CompactFlash memory slot for program & data storage (Requires optional PC Card adapter)
- 2-axis (X & Z) digital readout screen
- Simultaneous 2-axis linear and circular interpolation
- Manual operation via handwheels
- Machining guidance operation via handwheels
- Teach-in / Playback operation: manually run 1st part, then Playback for automatic operation
- Automatic Generation of G-code from Geometry data during teach-in operation
- Full CNC G-code, M-code, T-code, and S-code Functions
- Simultaneous multiple M-code processing (Up to 3 M-codes)
- Custom Macro B Programming Language for G-code programming (optional)
- Real time tool path line graphics (Optional 3D solid model tool path graphics available)
- 6 CNC Operation Modes: MEM, EDIT, MDI, Mchn Gdnce, Man/Hndwl, Ref Return
- 6 Auxiliary CNC Modes: M-code Teach Off, Dry Run, Single Block, Optional Blk Skip, M01 Stop, and Manual Handwheel Interrupt
- Manual Interrupt of automatic operations: Handwheel Interrupt and Spindle Interrupt



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CONTROL SPECIFICATIONS (continued)

- Constant Surface Speed (CSS) control for manual and automatic operations (Standard)
- Conversational graphics programming
- Diameter / Radius programming
- Absolute and incremental programming
- Inch / Metric input and display
- On-line calculator function to aid in data input
- On screen tool path graphics to verify part program
- Taper, Chamfer, Radius, Roughing, Grooving, & Drilling in Manual and Automatic modes
- Inch/Metric threading; Straight, Taper, and Multi-lead threading
- X-Area Minus Area Cutting Function (Cutting from backside of part)
- User programmable “Software Travel limits” to limit the travel for X & Z axes
- Intelligent hardware travel limits – only stops movement in the over-travel direction
- Inch / Metric feed rate input: inch/rev and inch/min or mm/rev and mm/min
- Gear indicator lights on status panel
- Auto spindle jog during gear changes
- Spindle load meter: 0% - 180% of rated load
- Lock switch for disabling parameter and program modification
- Conveniently mounted machine controls on apron – E-Stop, Playback, Start, Stop
- Aux. Controls on apron: work lamp, coolant, and CSS on/off
- Spindle control on apron: forward, reverse, stop, and speed dial
- Auto/Jog feedrate override: 0% to 200%
- User selectable Jog / Feedrate override profiles: Linear or Exponential
- Spindle override: 50% to 150%
- Rapid Traverse override: 12.5%, 25%, 50%, & 100%
- Incremental / continuous jog for X & Z axes
- Intelligent Bi-directional home search for X & Z axes
- Triple electronic handwheels for manual and automatic turning operations
- Expert Handwheel configuration: all three handwheels active simultaneously
- Multiplier switch for handwheel sensitivity: 0.0001”, 0.001”, & 0.01”
- CNC “**RUN VERIFY**” by Joystick or handwheel for all automatic operations
- Easy one touch X-Z Part Coordinate System setting
- Full CNC control of coolant & work light on-off functions via M-codes
- Three coordinate systems: Machine, Absolute, & Relative
- Program storage 63 part program storage, 80 meters of paper tape (262 feet)
- Backlash error compensation
- Ballscrew pitch error compensation (from Laser Calibration Data)
- Built-in RS-232 port for loading/unloading of part programs and other CNC data
- 16 Tool Geometry and 16 Tool Wear offsets with tool nose radius compensation
- Self diagnostics with error messages on screen