

Art of **P**recision & **P**erformance

# V TURN

## NP16/NP20/NP26

New & Narrow Lathe with High Performance


- Machine width 1.5/1.93 meters (NP16/NP20)
- Turning length 250/400/610 mm (NP16/NP20/NP26)
- Rapid feeds 30/30 m/min
- Roller guideways
- Servo turret
- One-piece slant bed
- Rear / Right chip disposal
- Ready for unmanned operation



# Pursuit of Productivity

## New & Narrow Lathe NP16/NP20/NP26

- Machine width only 1488 mm / 1930 mm / 2877 mm
- Z-travel 250 mm / 400 mm / 610 mm
- High rapid feed 30 m/min
- 6" / 8" / 10" power chuck
- Rear chip disposal
- Spindle thermal displacement is estimated and compensated by Victor's own PLC.

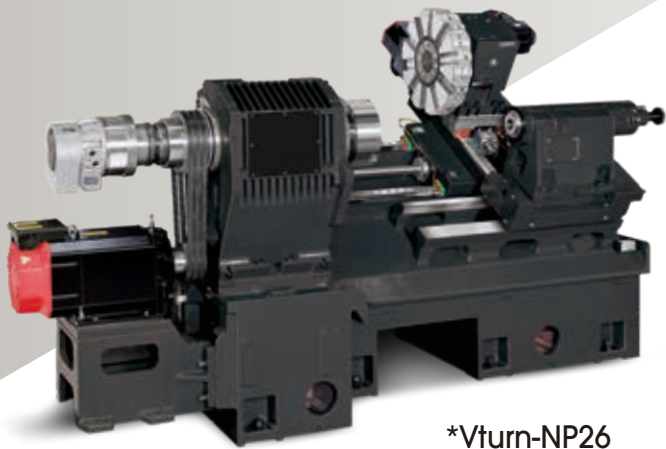


1488 mm (NP16)  
1930 mm (NP20)

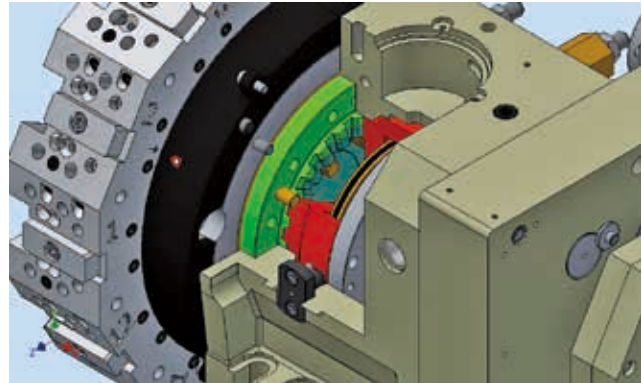


## Servo driven Turret

- 3-piece coupling design without turret disk up/down (2 pieces for NP26) affords high pressure coolants without leakage during indexing.
- Turret indexing time 0.9 (T-T, opposite).
- C-axis option is available with BMT milling turret.

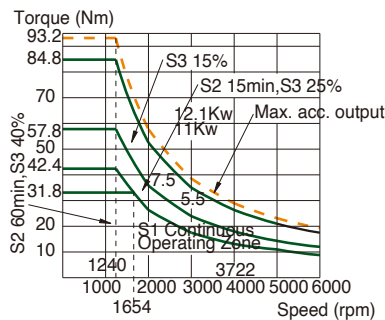
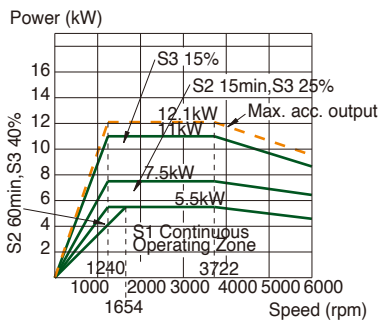


\*Vturn-NP26

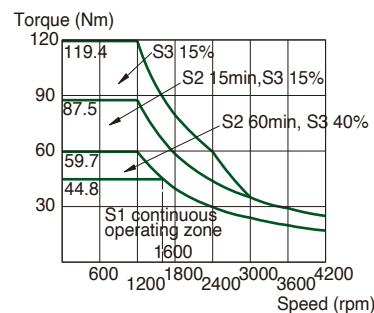
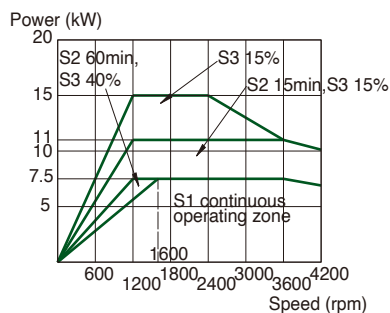


## Victor Taichung's own spindle

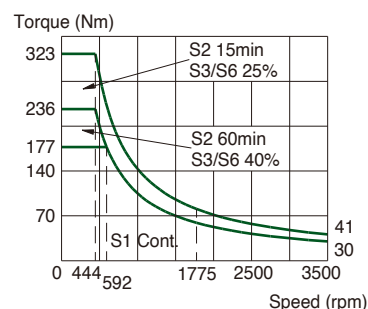
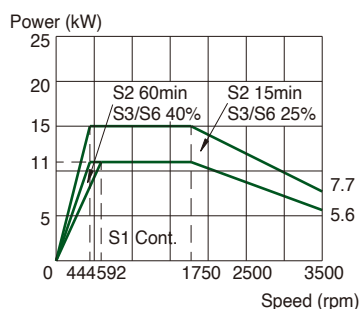
- NP16: Spindle output 11 kW (S3-15%)



- NP20: Spindle output 15 kW (S3-15%)

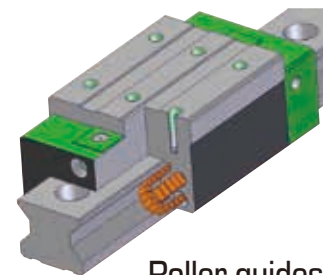


- NP26: Spindle output 15 kW (S3-25%)



## Strong structure

- One piece slant bed
- High rapid feeds 30/30 m/min
- Roller type guideways
- Meehanite casting



Roller guides

**35 mm (X/Z)**



Certificated Casting

**GB300**

# Standard Accessories

## Fanuc Oi-TF Plus (10.4") control + Manual Guide I (MGI)

- Right side for easy operation
- Manual Guide I for easy programming
- Inverter type hydraulic tank reduces the temperature rise



Fanuc Oi-TF Plus (10.4")

## Coolants & chips disposal

- Coolant flush on Z-axis covers.
- Cliff design minimizes chip built-up.
- Rear disposal chip conveyor minimizes machine width.



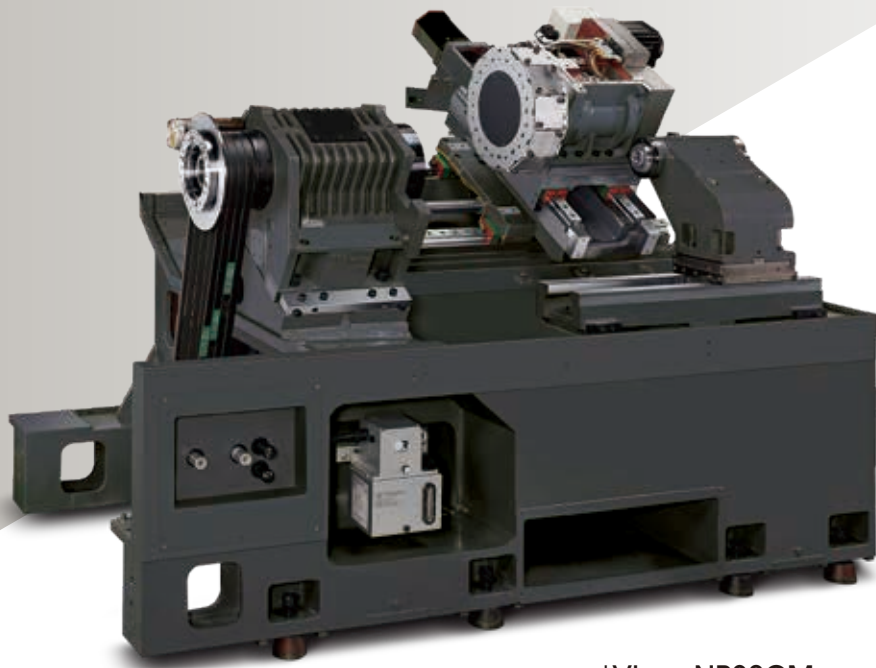
Coolant flush onto covers  
(Photo with opt. pump Grundfos® MTH 4-4/4)



\*Vturn-NP20



Programmable tailstock  
(NP26 only)



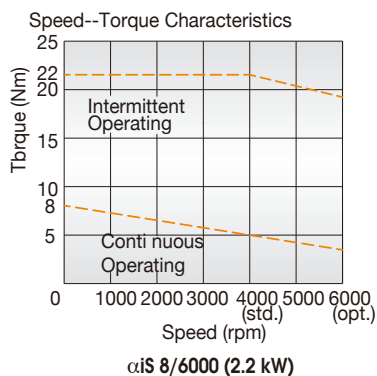
## C-axis Turn Mill (opt.)

- Belt-driven spindle with magnetic speed sensor as position coder to ensure accuracy 0.01°.
- Milling motor by servo motor with spindle control (G96.4) for easy programming with Manual Guide I.
- Milling turret by BMT (bolt mounted tooling) for high static rigidity.
- Milling speed 4000 rpm (opt. 6000 rpm with oil mist lubrication).

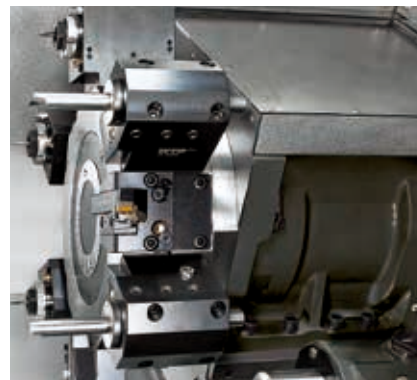
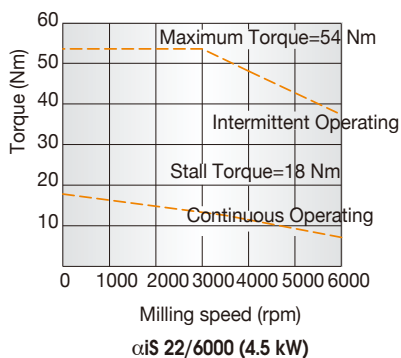
\*Vturn-NP20CM

## Milling Motor Output

Vturn-NP16/NP20CM



Vturn-NP26CM



Manual tailstock (opt. for NP16/NP20)



Tool Presetter & Part catcher (opt.)



Oil skimmer (opt.)



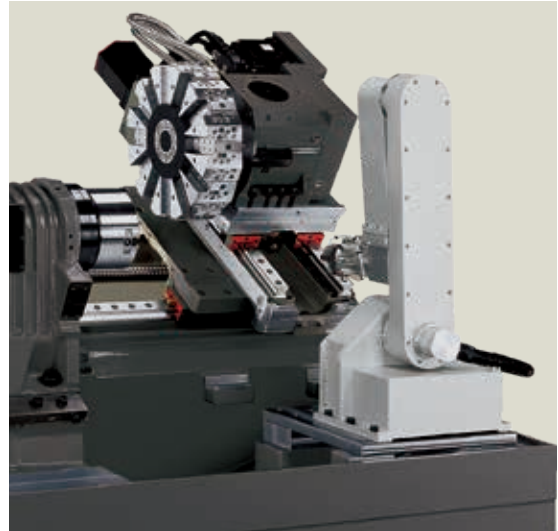
# Built for Unmanned Operation

## Built in articular robot EWR-03 / EWR-10

- Maximum part weight: 3 kg / 10 kg
- Maximum part size: Ø120 x L.100mm (NP16/NP20) / Ø200 x L.150mm (NP26)
- Part loading/unloading time along chuck: 7 seconds / 11 seconds
- Slant-pallet work feeder for easy orientation and high flexibility.



Robot with grippers



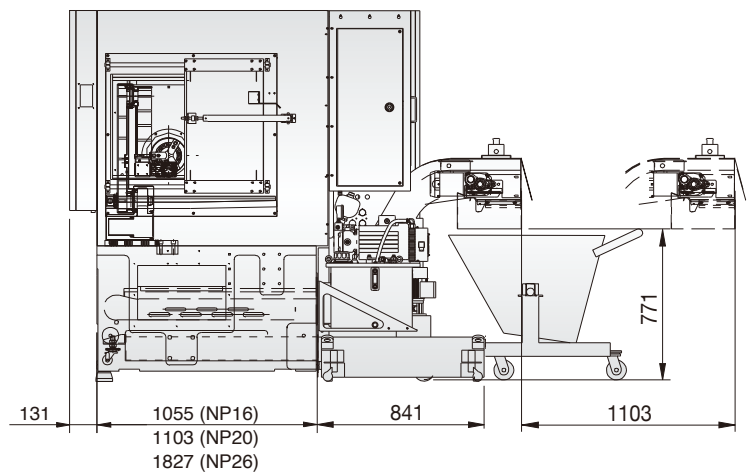
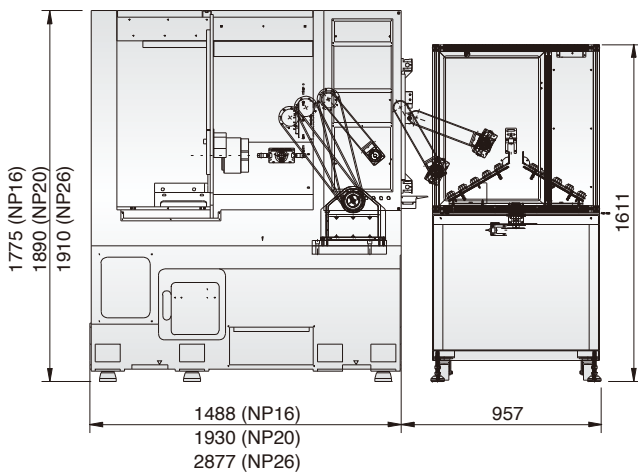
Work feeder (multiple pallets) and Turnover station



Work feeder (single pallet)



Work feeder (vibrator)





# Gantry Robot

- Mounted on machine base composes a compact cell
- Heavier part (>3kg) or bigger part can be loaded:
  - NP16: Ø200 x L.80 mm (by I.D. clamping)
  - NP20: Ø220 x L.100 mm (by I.D. clamping)
- Part changeover time: 15 seconds (including door open/close time)
- One robot can take care two lathes.
- Measuring station can be integrated for on-line inspection.



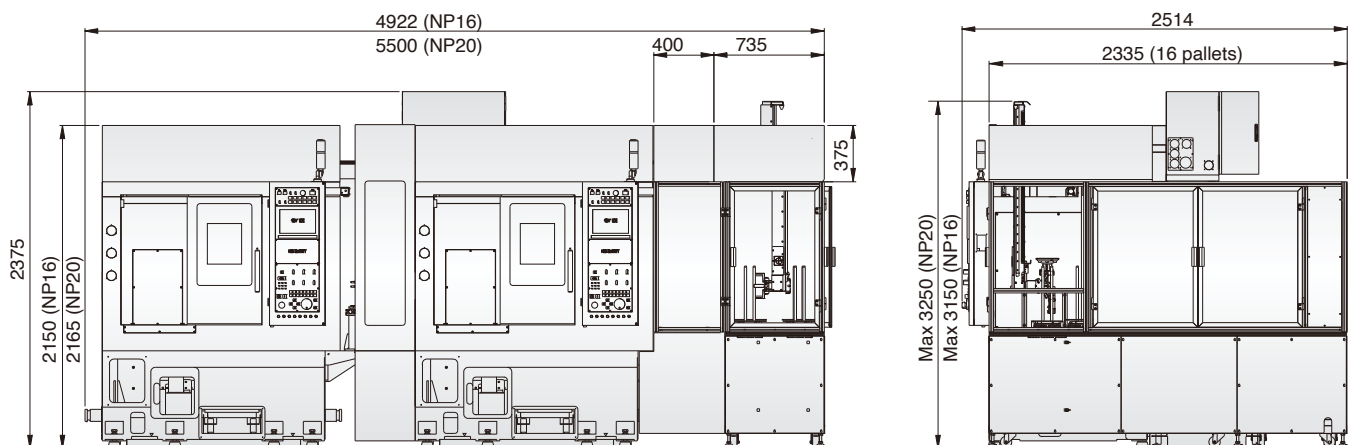
Work feeder (piled up type)



Work feeder (flexible)

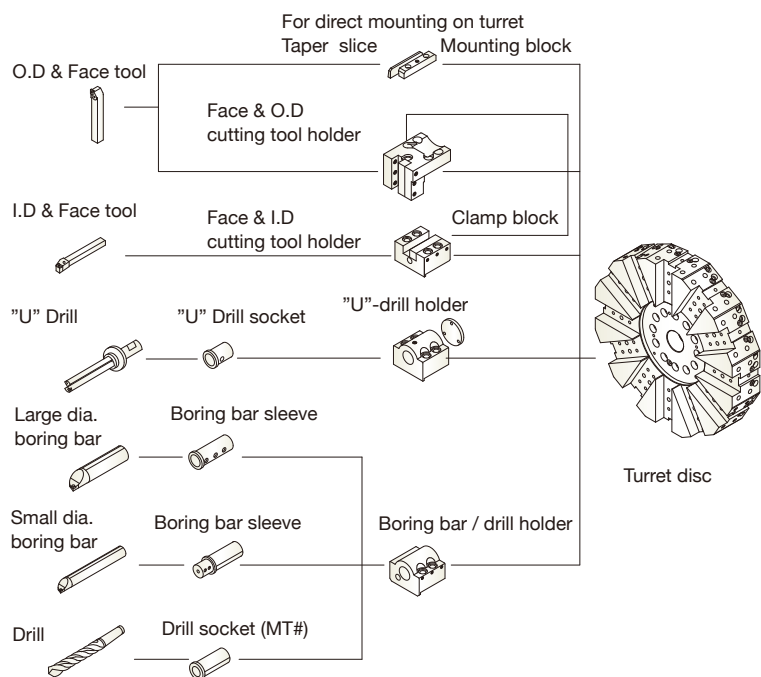


Turnover station



# Tooling accessories (Excl. BMT Turret)

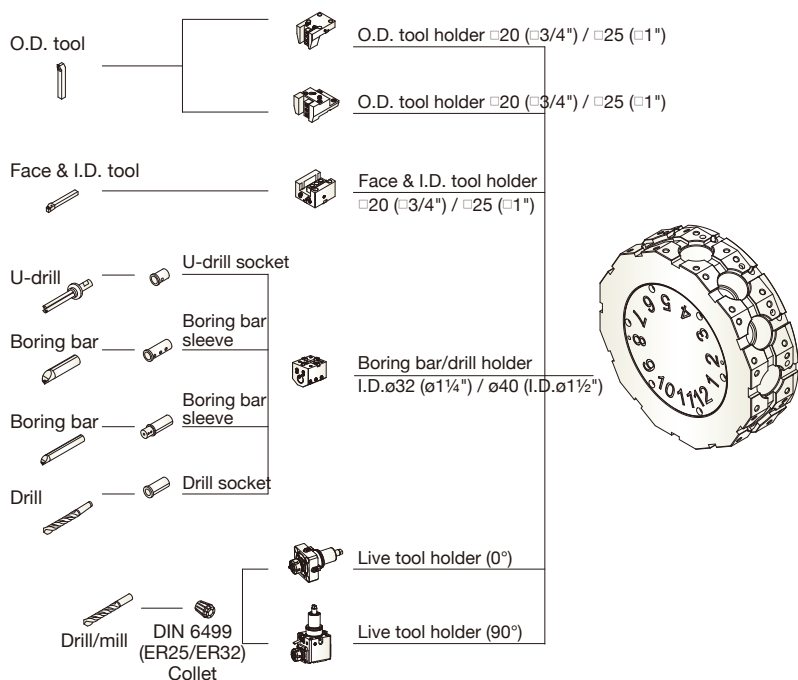
TOOLS \ MODEL	Vturn-NP16	Vturn-NP20	Vturn-NP26
Tool shank for turret disk	20 mm (3/4")	25 mm (1")	25 mm (1")
Maximum boring bar Dia.	32 mm (1 1/4")	50 mm (2")	50 mm (2")
Face + OD cutting tool holder	2	1	1
Face + ID. cutting tool holder	1	1	1
<b>Boring bar holder</b>			
32 mm (1 1/4")	7	-	-
40 mm (1 1/2")	-	7	6
50 mm (2")	-	1	1
<b>Boring bar sleeve</b>			
8 mm (5/16")	1	1	1
10 mm (3/8")	2	2	2
12 mm (1/2")	2	2	2
16 mm (5/8")	2	2	2
20 mm (3/4")	2	2	2
25 mm (1")	2	2	2
32 mm (1 1/4")	-	2	2
<b>Drill socket</b>			
MT1	Opt.	Opt.	Opt.
MT2	1	1	1
MT3	Opt.	1	1
MT4	-	1	1
<b>U drill socket</b>			
20 mm (3/4")	1	Opt.	Opt.
25 mm (1")	1	1	1
32 mm (1 1/4")	-	1	1



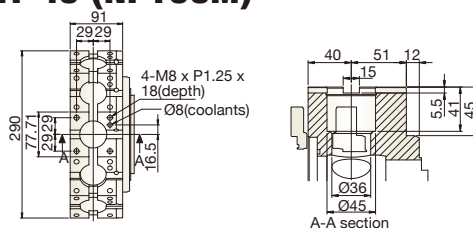
## C-axis Application

### Vturn-NP16CM/NP20CM/NP26CM with BMT-45/55/65

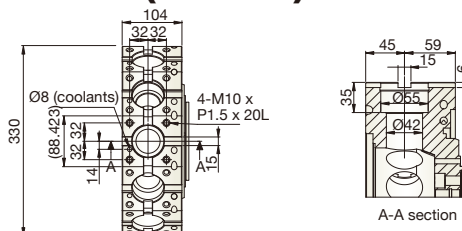
#### Milling Turret (Opt.)



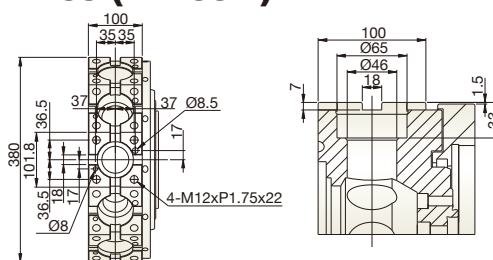
#### BMT-45 (NP16CM)



#### BMT-55 (NP20CM)



#### BMT-65 (NP26CM)





# VICTOR Taichung's FANUC Oi-TF Plus 10.4" Control (Type I) Specifications



## Standard

ITEM/SPECIFICATION	DESCRIPTION
<b>Controlled Axes</b>	
1. Controlled axes	2 Axes (X, Z)
2. Simultaneous controlled axes	2 Axes
3. Least input increment	0.001mm
4. Least command increment	0.0005mm (X) / 0.001mm (Z)
5. Command system	Incremental / Absolute
6. HRV Control	HRV3+
7. Unexpected disturbance torque detection (AIR-BAG)	Std.
8. Backlash compensation	Std.
9. Stored pitch error compensation	Std.
10. External data input (by ETDC: Estimating the Time Displacement for Compensation)	Std.

## Operation & Program Input

1. Input / Output interface	RS-232, PCMCIA Card, USB
2. Tool offset	99 sets
3. Sequence number	N5-digit
4. Program number	O8-digit
5. Program name	31-characters
6. M code function	M3-digit
7. S code function	S4-digit
8. T code function	T4-digit
9. Positioning	G00
10. Linear interpolation	G01
11. Circular interpolation	G02, G03
12. Programmable data input	G10
13. Plane selection	G17-G19
14. Inch / Metric conversion	G20 / G21
15. Reference position return	G28, G30
16. Thread cutting	G32, G34
17. Threading retract	Std.
18. Tool nose radius compensation	G40-G42
19. Work piece coordinate system	G52-G59
20. Macro, Sub program call	G65, M98, M99 (10 folds nested)
21. Multiple repetitive cycle I & II	G70-G76
22. Canned cycle for drilling	G80-G89
23. Canned cycles	G90, G92, G94
24. Program stop / end	M00-M02 / M30
25. Rigid tapping (Spindle)	M29
26. Manual Guide I	Std.
27. Optional blocks skip 2-9	Std.

## Feed Function

1. Manual handle feed rate	X1, X10, X100
2. Rapid traverse rate	F0, 25%, 50%, 100%
3. Cutting feed rate	0-150%
4. Spindle override	50-120%
5. Feed per Minute / Revolution	G98 / G99

## Edit Operation

1. Part Program Storage Length (in total)	5120m / 2MB
2. Number of Registerable programs (in total)	1000
3. Part Program Editing	Std.

## C Axis Function

1. Polar coordinate interpolation	G112, G113
2. Cylindrical interpolation	G107
3. CS contouring control	Std.
4. Spindle control with servo motor	G96.4
5. Coordinate System Rotation	Std.

## OPTIONS

### With hardware included

	Oi-TF Plus
1. Tool life management	<input type="checkbox"/>
2. Program restart	<input type="checkbox"/>
3. Data server (with PCB and CF card 1GB)	<input type="checkbox"/>
4. Ethernet/IP (to be linked to robot)	<input type="checkbox"/>
5. PROFIBUS-DP (to be linked to robot)	<input type="checkbox"/>
6. ProfiNet (to be linked to robot)	<input type="checkbox"/>
7. Fast Ethernet (required for SCADA Web with additional RJ45 port)	<input type="checkbox"/>

### Without hardware included

8. Circular thread cutting (G35,G36)	<input type="checkbox"/>
9. AICC-1 (G5.1 Q1, 40 blocks)	<input type="checkbox"/>
10. AICC-2 (G5.1 Q1, 200 blocks)	<input type="checkbox"/>
11. Helical interpolation (C-axis only)	<input type="checkbox"/>
12. Arbitrary speed threading	<input type="checkbox"/>
13. Memory card program entry count extension (Max. 1000)	<input type="checkbox"/>

## Machine Color Option

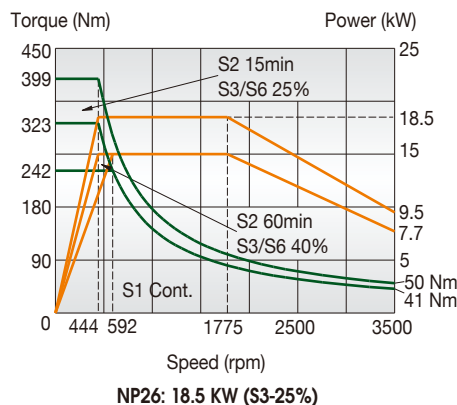
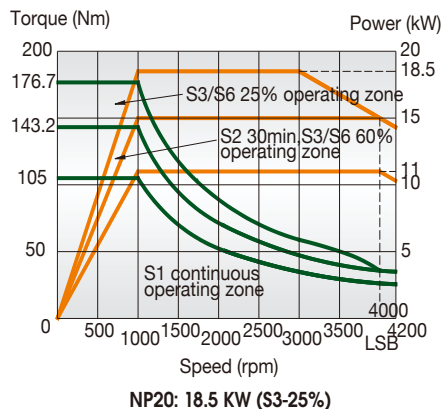


Standard



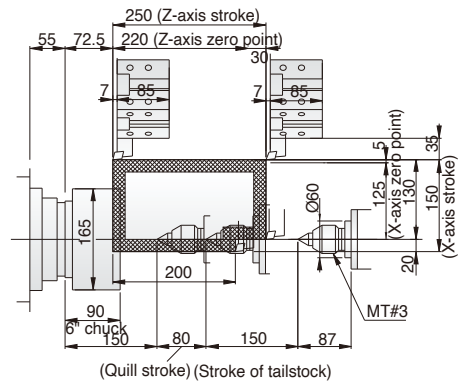
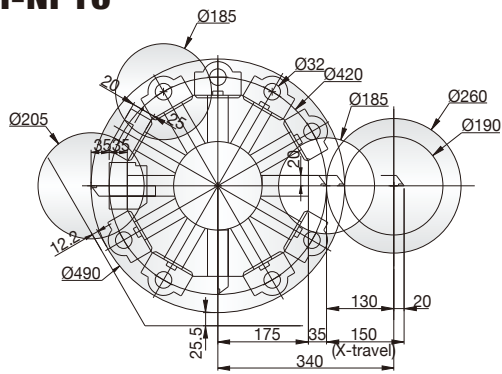
RAL-7024

## Bigger Spindle Output (opt.)

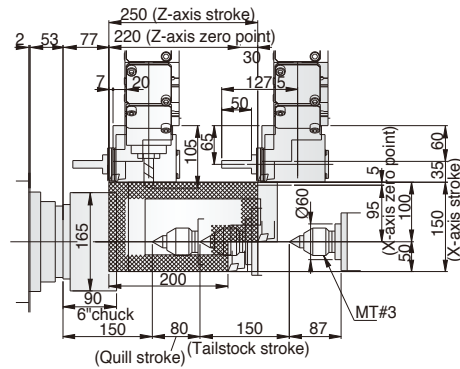
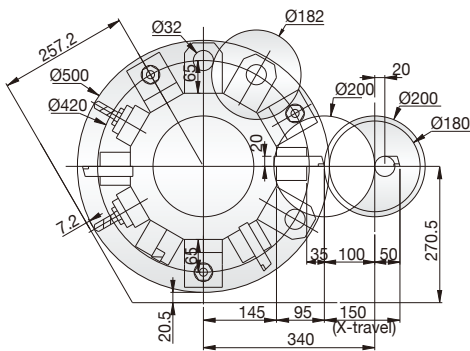


# Technical Drawings

## Vturn-NP16

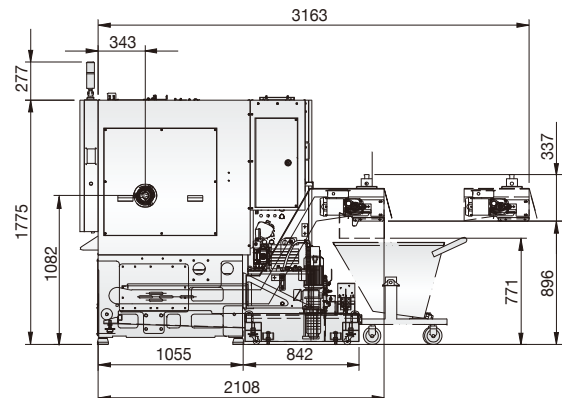
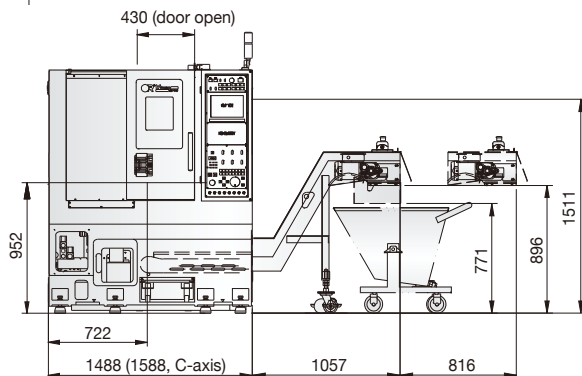
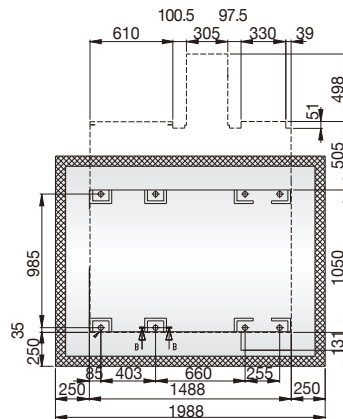
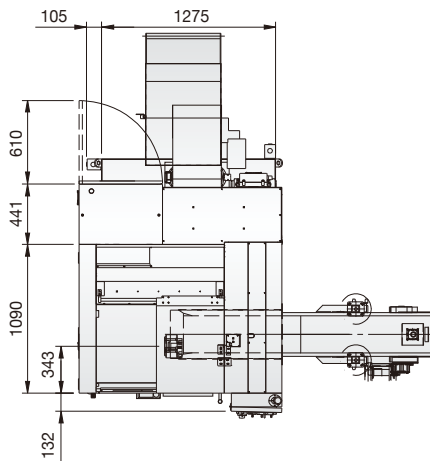


## Vturn-NP16CM



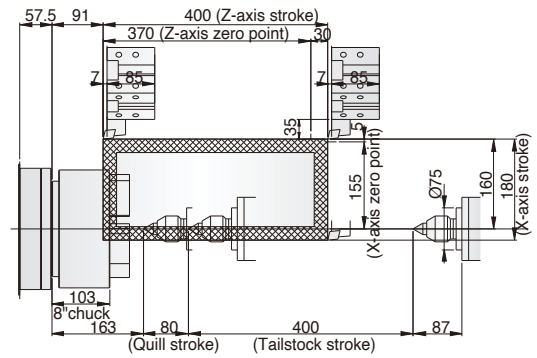
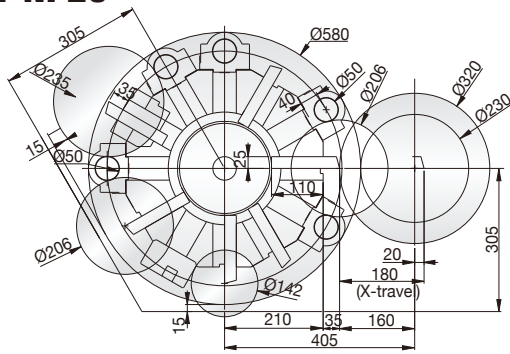
# Machine Layout

## Vturn-NP16

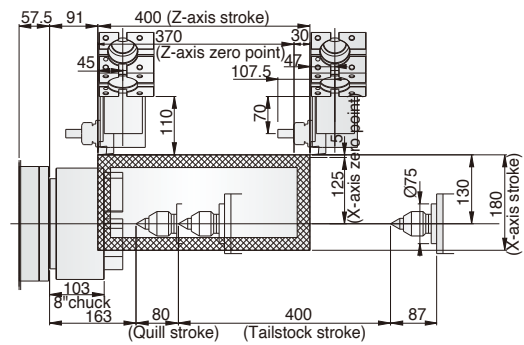
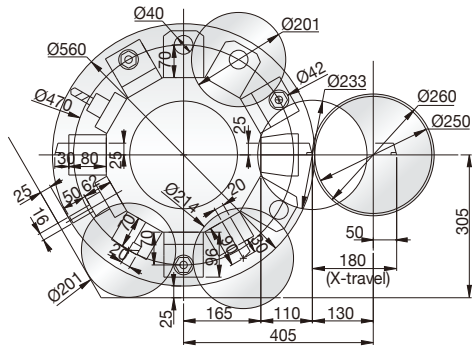


# Technical Drawings

## Vturn-NP20

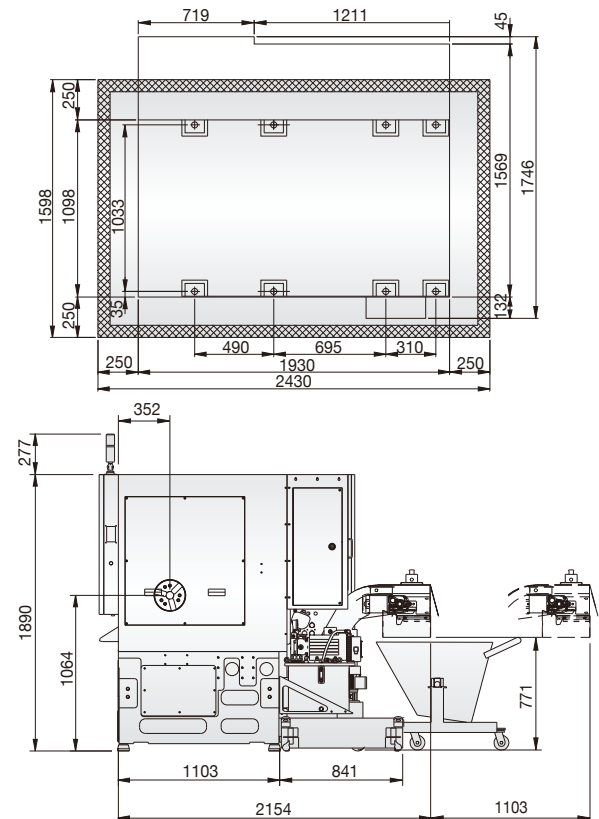
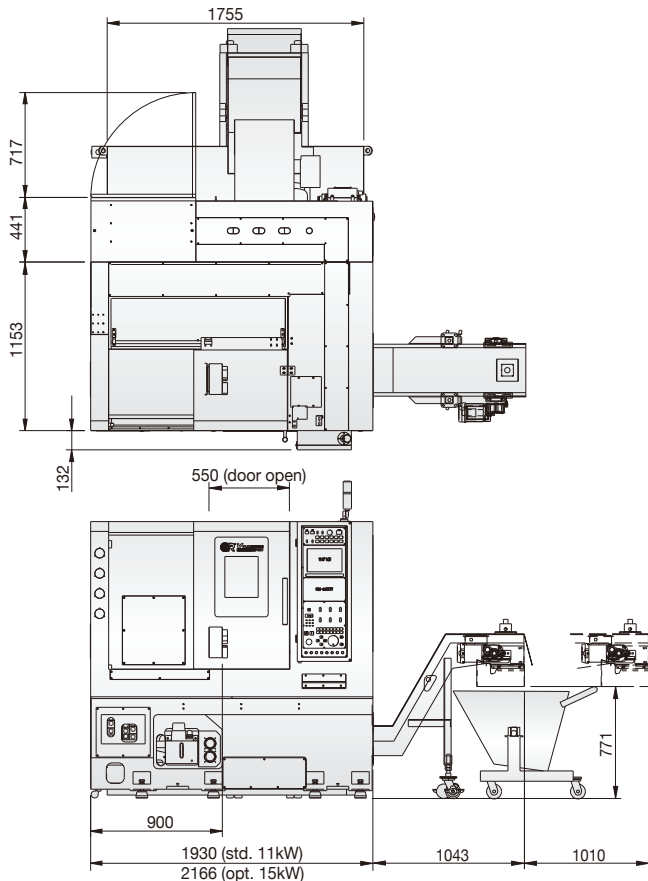


## Vturn-NP20CM



# Machine Layout

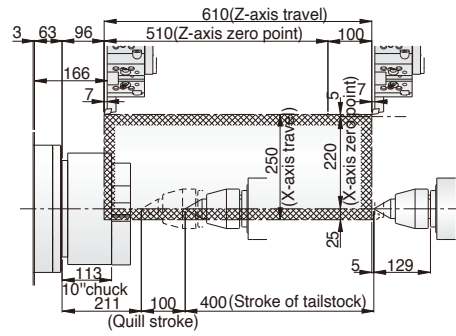
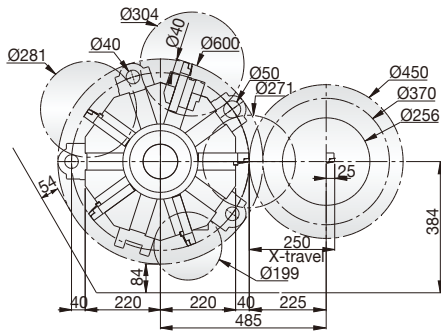
## Vturn-NP20



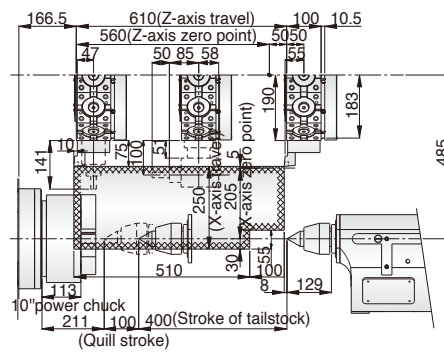
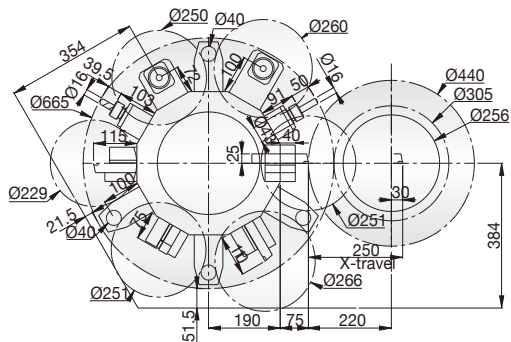
# Technical Drawings



## Vturn-NP26

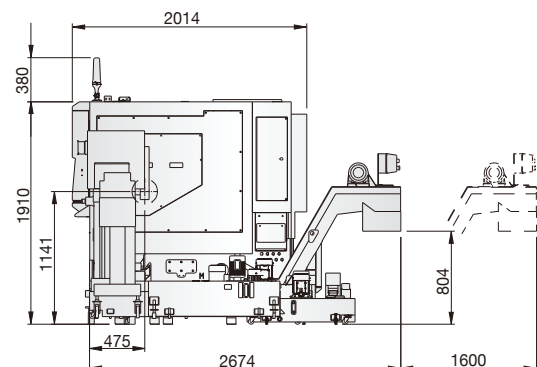
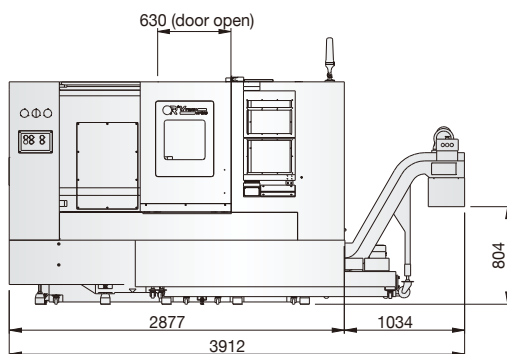
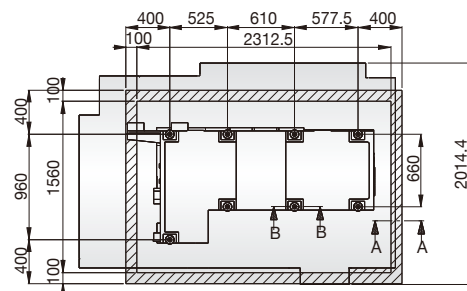
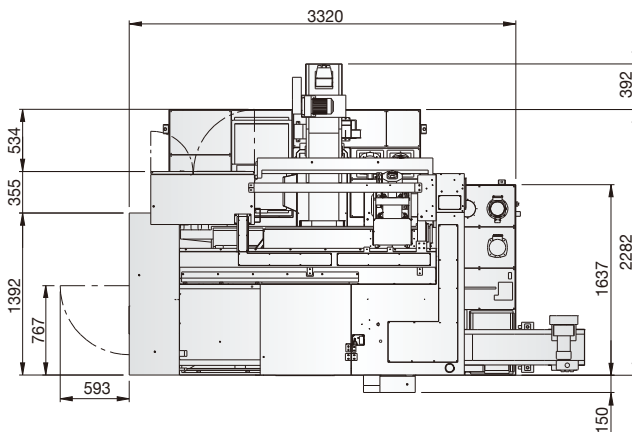


## Vturn-NP26CM



# Machine Layout

## Vturn-NP26



# Machine Specifications

Item	Unit	Vturn-NP16 (CM)	Vturn-NP20 (CM)	Vturn-NP26 (CM)
<b>Capacity</b>				
Swing over bed dia.	mm	Ø570	Ø650	Ø740
Standard turning dia.	mm	Ø185 (Ø200)	Ø206 (Ø233)	Ø271 (Ø266)
Maximum turning dia.	mm	Ø260 (Ø200)	Ø320 (Ø260)	Ø450 (Ø440)
Swing over carriage dia.	mm	Ø325	Ø365	Ø540
Between centers	mm	270	520	640
Bar capacity (Hole thru draw bar)	mm	Ø42	Ø52 (opt. Ø42 SSB, Ø66 LSB)	Ø75 (opt. Ø77)
<b>Axis Feeds</b>				
X axis travel	mm	20+130 (50+100)	20+160 (50+130)	25+225 (30+220)
Z axis travel	mm	250	400	610
Rapid feed - X / Z axis	m/min	30 / 30	30 / 30	30 / 30
Feed motor - X / Z axis	kW	1.8 / 1.8	1.8 / 1.8	3 / 3
JOG feed	mm/min	X/Z: 0~1260	X/Z: 0~1260	X/Z: 0~1260
Ball screw dia. x pitch	mm	Ø25 x P10 (X) Ø40 x P10 (Z)	Ø25 x P10 (X) Ø40 x P10 (Z)	Ø32 x P10 (X) Ø40 x P10 (Z)
Guideway width - X / Z axis	mm	35 / 35	35 / 35	35 / 35
<b>Spindle</b>				
Spindle speed	rpm	6000	4200 (opt. 6000 SSB, 4000 LSB)	3500
Spindle nose (chuck)	inch	A2-5 (6")	A2-6 (8") opt. A2-5 (6", SSB)	A2-8 (10")
Spindle motor power (cont./30min/25%)	kW	5.5 / 7.5 / 11	7.5 / 11 / 15 (opt. 11 / 15 / 18.5)	11 / 15 (opt. 15 / 18.5)
Spindle bearing inside dia.	mm	Ø80	Ø100	Ø130
Spindle bore dia.	mm	Ø52	Ø62 (opt. Ø52 SSB, Ø78 LSB)	Ø87
Spindle taper		1/20	1/20	1/20
<b>Turret</b>				
No. of tools (live)		12 (12)	12 (12)	10 (12)
Tool shank size	mm	□20	□25	□25
Max. boring bar dia.	mm	Ø32 (BMT-45)	Ø40 (BMT-55)	Ø50 (BMT-65)
Exchange time (T-T)	sec	0.9 (opposite)	0.9 (opposite)	0.9 (opposite)
Milling speed	rpm	4000 (opt. 6000)	4000 (opt. 6000)	4000 (opt. 6000)
Milling motor	kW	2.2	2.2	4.5
<b>Tailstock (Opt. VT-NP16)</b>				
Tailstock quill dia.	mm	Ø60	Ø75	Ø110
Quill stroke	mm	80	80	100
Quill taper		M.T. #3	M.T. #4	M.T. #5
<b>Machine</b>				
NC controller	Fanuc	0i-TF Plus (10.4")	0i-TF Plus (10.4")	0i-TF Plus (10.4")
Coolant tank capacity	L	160	240	330
Power requirement	kVA	14.4 (15.1)	16.6 (17.3)	22 (24)
Machine dimension L x W x H (with chip conveyor)	mm	1488 x 2108 x 1855	1930 x 2154 x 1970	2877 x 2674 x 1990
Net weight (incl. standard accessories)	kgs	3700 (3900)	4000 (4200)	5200 (5300)

\* Machine and controller specifications are subject to change without notice.

\*\* Available with CE / UKCA / TS / GB certificates.

## Standard accessories:

- Fanuc 0i-TF Plus (10.4") with Manual Guide i
- Hydraulic chuck with soft jaws
- Chip conveyor (rear disposal)
- Fully enclosed splash guarding
- Tool holders (only for standard turret)
- Coolant flush on Z-axis cover
- 3 step warning light
- Programmable tailstock (for NP26 only)

## Optional accessories:

- Manual tailstock with power quill (for NP16, NP20)
- Chip conveyor (right disposal)
- 15" screen (for NP26 only)
- Manual tool presetter
- Auto tool presetter
- Parts catcher (swing type)
- KITAGAWA® power chuck
- Air conditioner for electrical cabinet
- Higher pressure coolants
- Bar feeder interface
- Air blow
- Oil skimmer
- Oil mist collector
- Hard jaws
- Tailstock center
- Auto door
- Small spindle bore (SSB) for NP20 (Ø42 mm, 6000 rpm)
- Large spindle bore (LSB) for NP20 (Ø66 mm, 4000 rpm)
- C-axis
- Robot system



## ONWARD RISE

To ensure the return on investment, Victor Taichung has invested considerably in setting up a distribution network in terms of global vision local touch for our sales and service supports worldwide. Besides the qualified exclusive agents around the world, Victor Taichung has 7 overseas subsidiaries to provide our customers efficient after-sales service and technical supports.



Vturn-A200 with Y-axis and subspindle



VMT-X400 Multitasking



Vturn-V1000 vertical lathe



THE VICTOR-TAICHUNG COMPANIES



HTL

VTL

VMC

HMC

XMT

PIM

### TAIWAN

<http://www.victortaichung.com>  
E-mail :info@mail.or.com.tw  
Victor Taichung Machinery Works Co., Ltd.  
No. 1, Jingke Central 2nd Rd.,  
Nantun Dist., Taichung 40852,  
TAIWAN, R.O.C.  
TEL : 886-4-23592101  
FAX : 886-4-23593389

### FRANCE

Victor France  
TEL : 33-1-64772000  
FAX : 33-1-64772063

### GERMANY

Victor GmbH  
TEL : 49-2261-478434  
FAX : 49-2261-478327

### SOUTH AFRICA

Victor Fortune (PTY) Ltd.  
TEL : 27-11-3923800  
FAX : 27-11-3923899

### MALAYSIA

Victor Machinery (M) SDN. BHD.  
TEL : 60-3-56337180  
FAX : 60-3-56337191

### THAILAND

Victor CNC (Thailand) Co., Ltd.  
TEL : 66-2-9263735  
FAX : 66-2-9032373

### INDONESIA

PT. Victor Machinery Indonesia  
TEL : +62-21-88958504  
FAX : +62-21-88958513

### USA

Fortune International Inc.  
TEL : 1-732-2140700  
FAX : 1-732-2140701

### CHINA

Victor Taichung  
Machinery (Shanghai)  
TEL : 86-21-59768018  
FAX : 86-21-59768009



was also marketed under the brand names **VICTOR** (outside North America) and **FORTUNE** GB1GE25EG