

The Ultimate in Performance



iT Series

V-30iT/V-32iT
V-20iT/V-40iT/V-60iT
5 Axes Machining Center

LEADWELL
LEADWELL CNC MACHINES MFG., CORP.



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* All performance are based on 220V/3PH/60HZ. Specifications are subject to change without notice.

2022.06

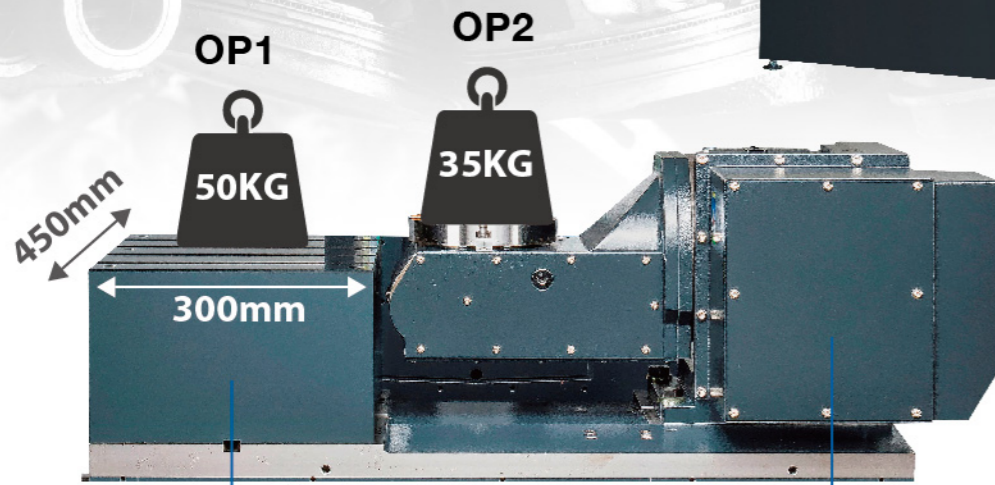
5 AXES MACHINING CENTER

• V-30iT

The rotary table is a compact dual-axil turning table that provides high-speed , accurate positioning for 3+2 and full 5 axis machining of small parts. Its small size and light weight make perfect 5 axis solution for even the smallest machining centers. With fix table design, provides the flexible and dual machining solution.



OP1:Fix table machining
OP2:Rotary table 5 face machining



Mass of workpiece weight:
Level (0°~45°) :35kg
Tilting (45°~90°) :25kg

1. High Rigidity:

- * FEA Analysis
- * High rigidity structure design
- * Roller type guide way
- * 3 Axis ball screw prestressing

2. High Reliability:

- * Roller type motion system
- * 3 Axis absolute motor

3. High Efficiency:

- * High torque spindle motor
- * Rapid feed rate 48/48/36mm
- * Spindle speed 12000 rpm
- * Tool change time TT/CC 1.8/4 sec

4. High Flexibility:

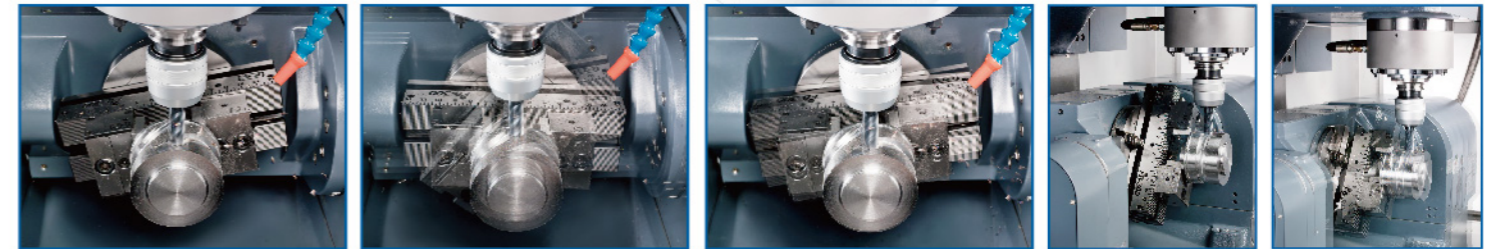
- * 45 axis rotary table available
- * Linear Scale available

FEATURE

- The iT series optimally concentrate the machining process for multiface, intricately shaped parts, and some difficult position of workpiece where 3-axis machines can't overcome, such as under cut.
- For depth mould, the iT series still can keep high efficiency machining by setting a suitable angle of tool, shorten the length of tool holding.
- Avoiding accumulative error from series machining procedure, decreasing total cutting time that substantially achieve the request: High Speed, High Accuracy, High Efficiency.
- 3-axis program still can run under constant position setting for A/C axis (without any cutting interference)

- High rigid cast iron construction with closed type design.
- Machine stable design supporting by big span saddle and foundation screws.
- Without counter weight enhance the accuracy on mold making as well as avoid vibration.
- Z axis transmission end fixed, as well as ball screw pretension, which enable to reduce the temperature.
- Minimal rapid traverse: 36 M/minute.

Parts with odd-angles and complex curved surfaces



Face Cutting

Grip Cutting

Grip Cutting with Swing

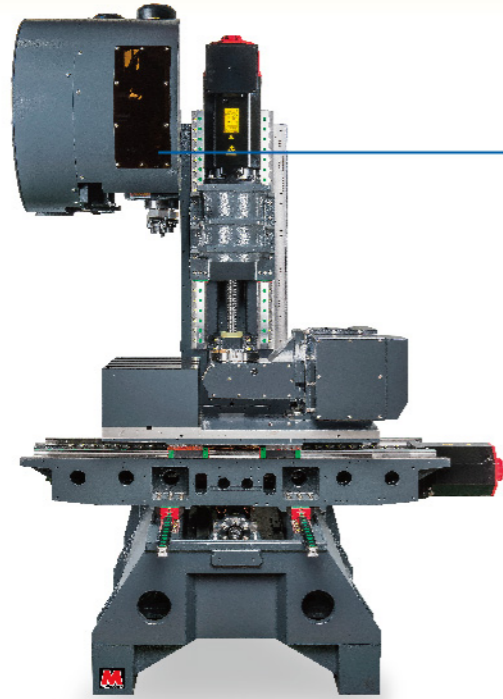
Grip Cutting with Slant

Grip Cutting While rotating

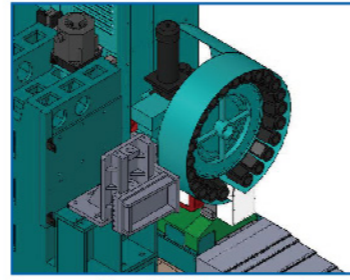
The advantages of 5 axes machining:

- Reduced machining time: By using a flat bottom endmill and maintaining perpendicularity to the complex surface you can step-over the full diameter of the cutter thereby dramatically reducing the required number of passes across a surface. The same principle applies to side mill of angled surfaces.
- Better surface finish: Using a flat bottom endmill to maintain perpendicularity to the complex surface can eliminate ribbing caused by ball-nose endmills.
- Eliminate multiple setups required to re-position the work-piece at complex angles.
- Eliminate costly tooling and fixtures required to hold the work-piece in place.
- Eliminate manual millwork and handwork required to cleanup rough surfaces.
- Machine complex parts that are not otherwise possible, including holes required to be normal to a complex surface.

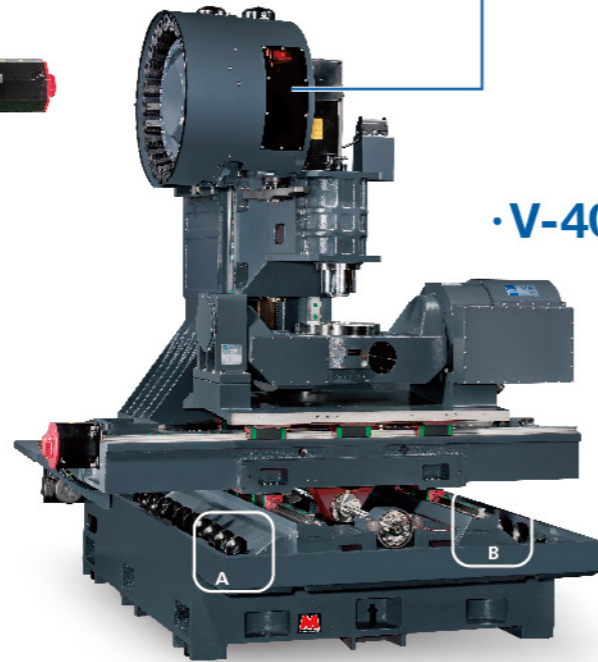
RIGID CONSTRUCTION



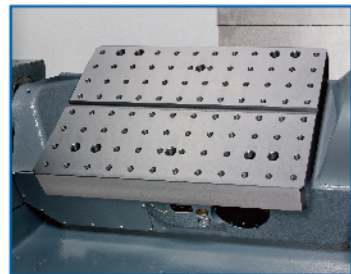
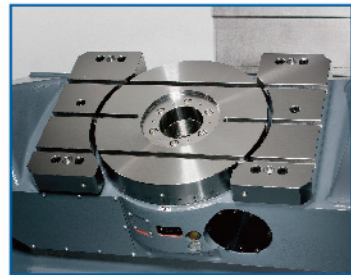
·V-30iT



Lower the ATC magazine for shipment



·V-40iT

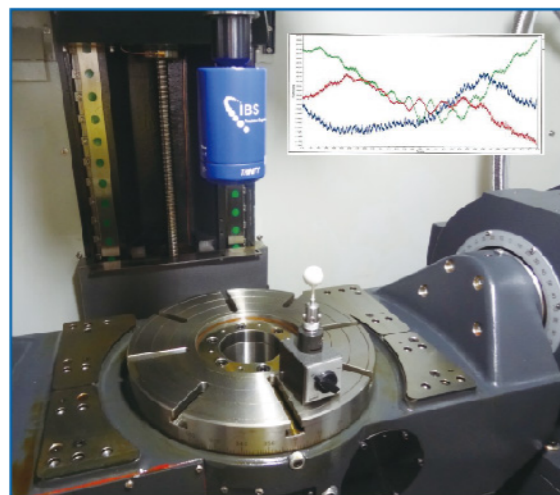


A) Chip Removal

LEADWELL's simple and efficient design uses chip augers on both sides of the machine and provides high volume coolant to wash the chips from the work area.

B) Roller Guide Ways

LEADWELL uses roller guide ways that feature zero clearance and fully-loaded carrying capacity in all directions.



Volumetric Accuracy Control

Leadwell optimizes the parameter data and consequently dominates the total acceptance of the machine.

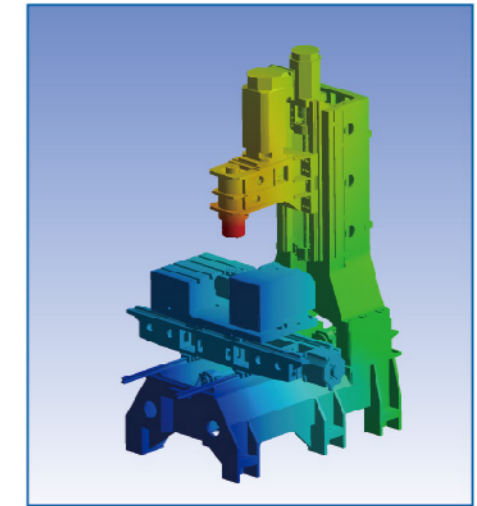
FEA REPORT(Finite Element Analysis)

Optimum

- Section areas
- Moments of inertia
- Torsional constant
- Plate thickness
- Bending stiffness
- Transverse shear
- Vibration reduce

With FEA you can:

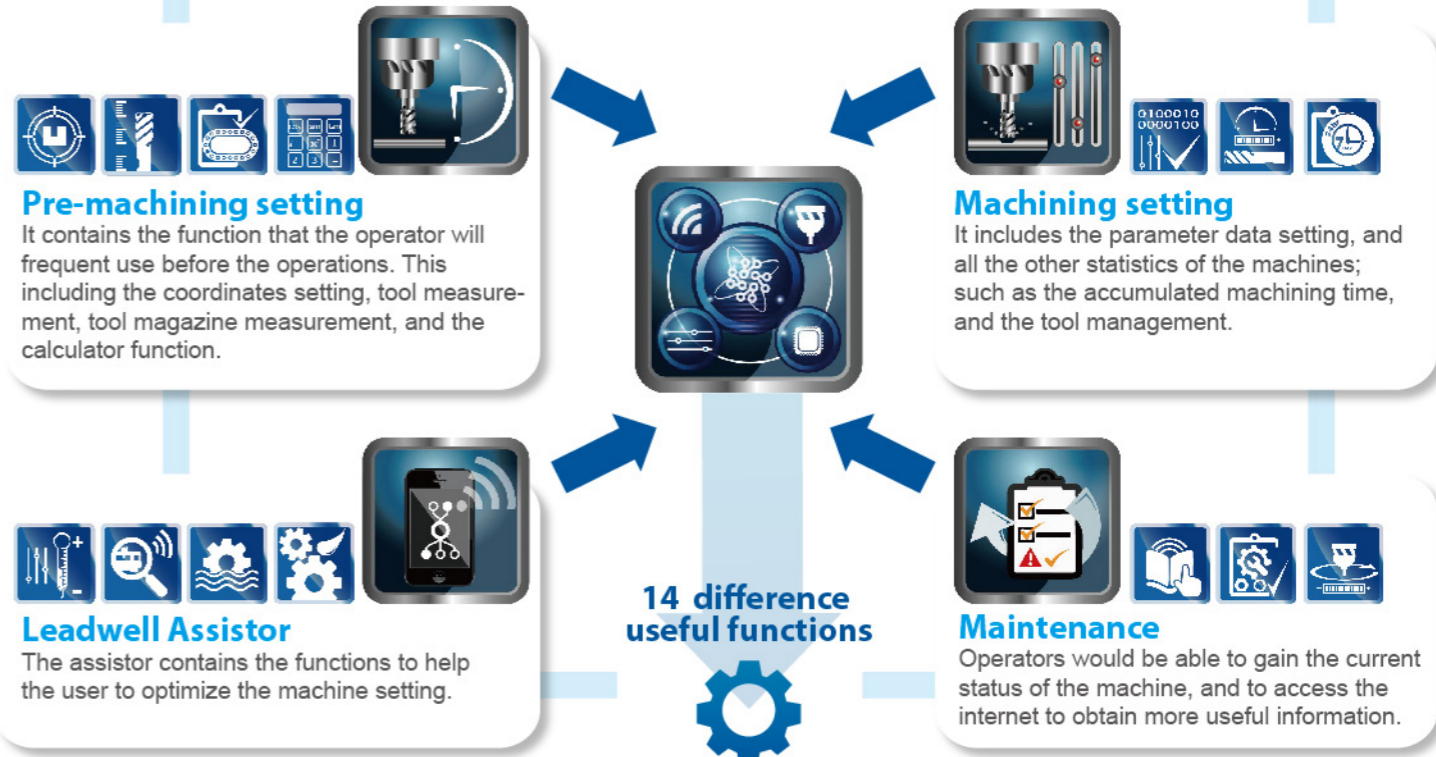
1. Predict and improve product performance and reliability.
2. Reduce physical prototyping and testing .
3. Evaluate different designs and materials .
4. Optimize designs .



LEADWELL SMART PROCESSOR

More than a machine

Leadwell is never simply about building a machine and to launch onto the market. Our years of experience, we learn that the right programs must be developed to ensure the competitiveness of the users.



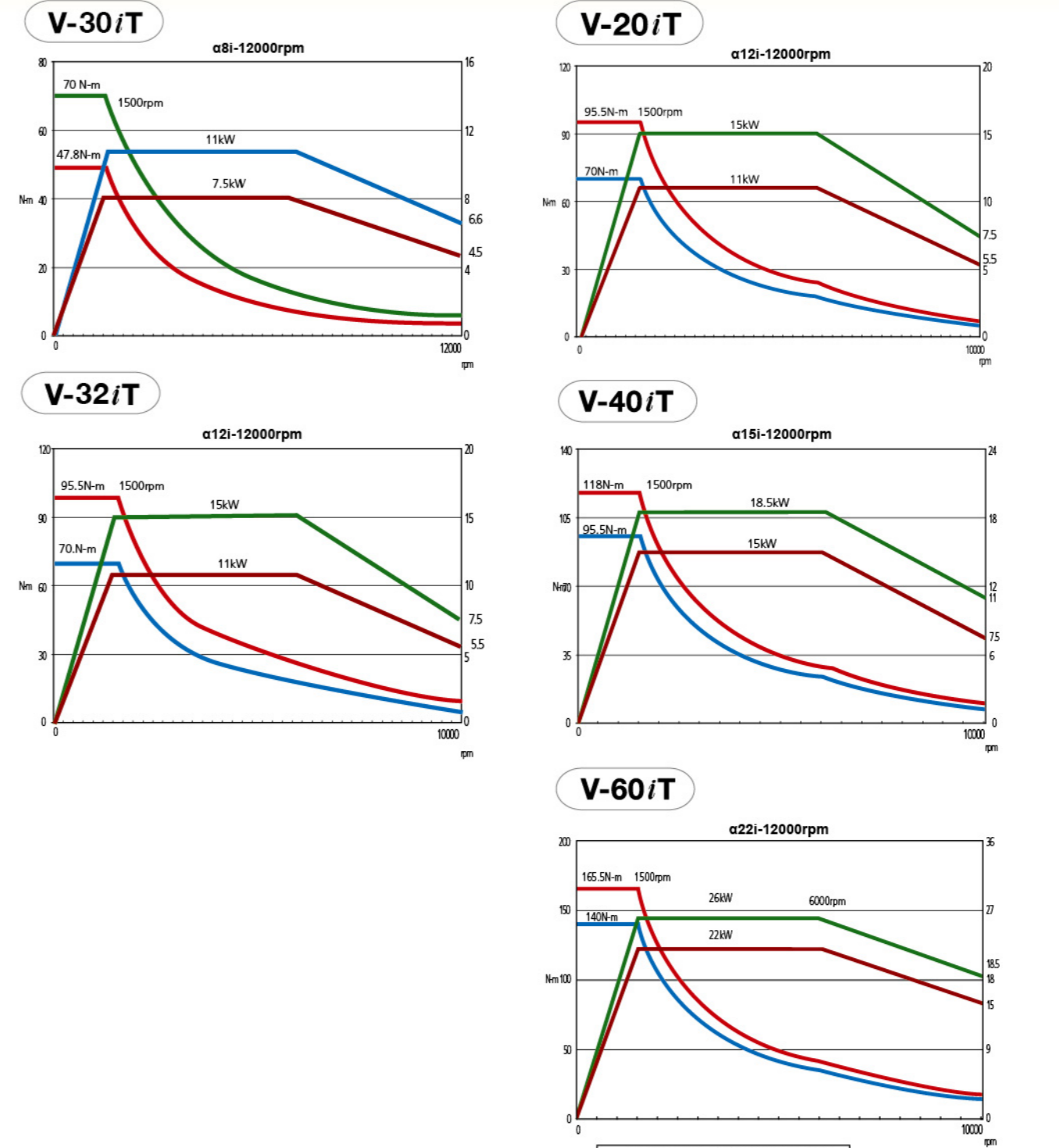
Machined work pieces.

Users' full satisfaction have always been Leadwell's main focus.

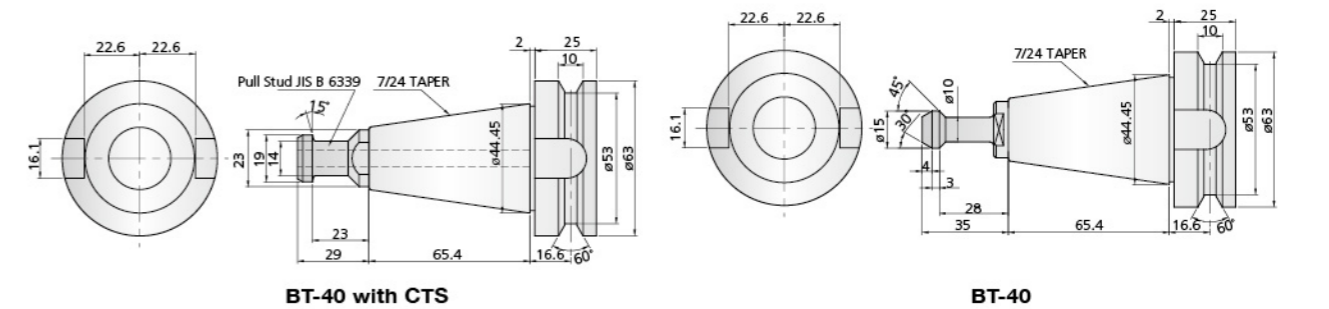
INDUSTRIAL APPLICATIONS



SPINDLE POWER CURVE



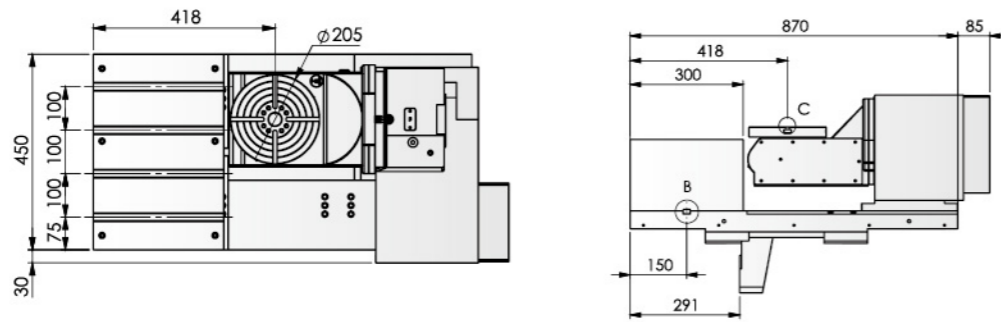
Tool Drawing BT-40 with CTS & BT-40



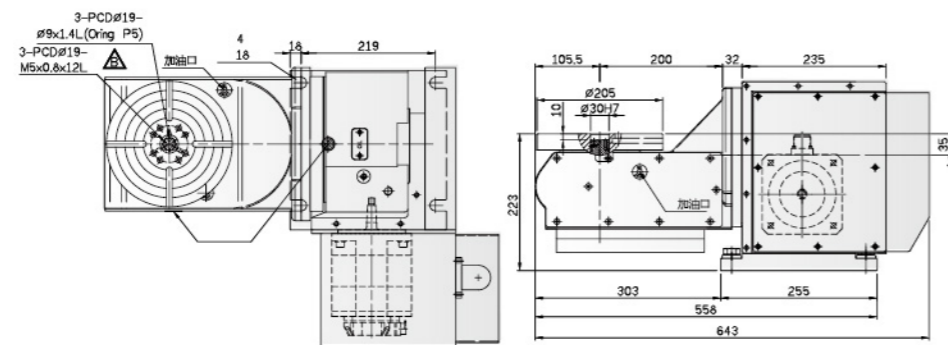
FIXTURE PLATE DIMENSION

V-30iT

STD



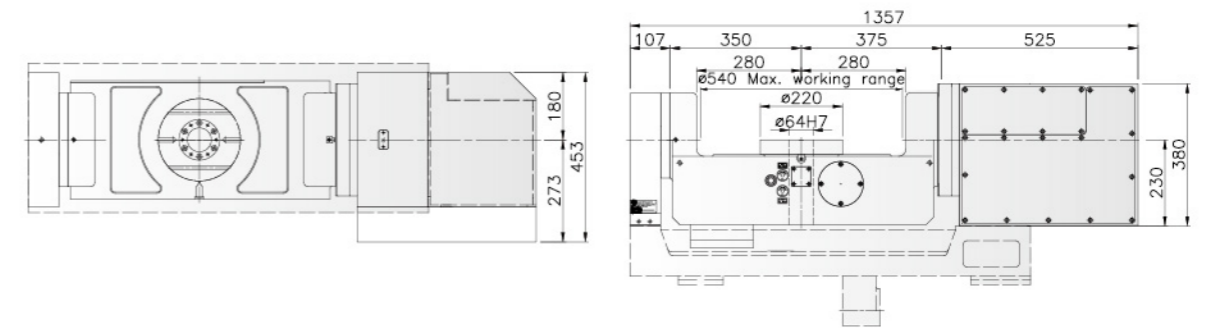
OPT



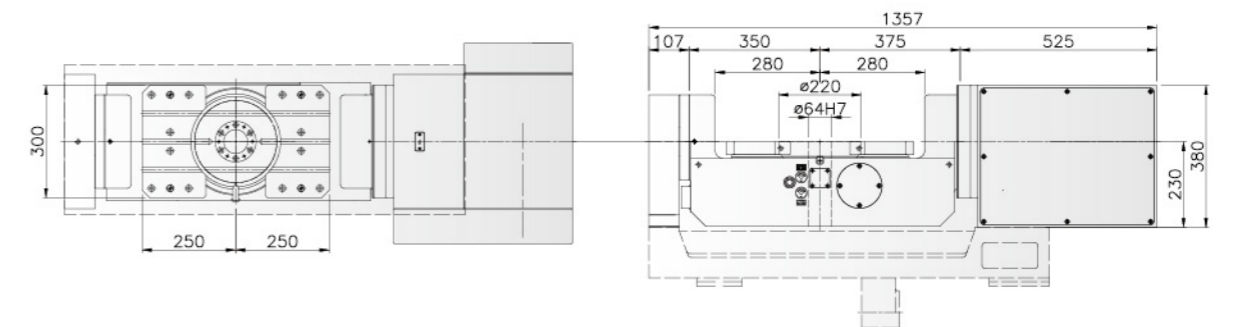
FIXTURE PLATE DIMENSION

V-32iT

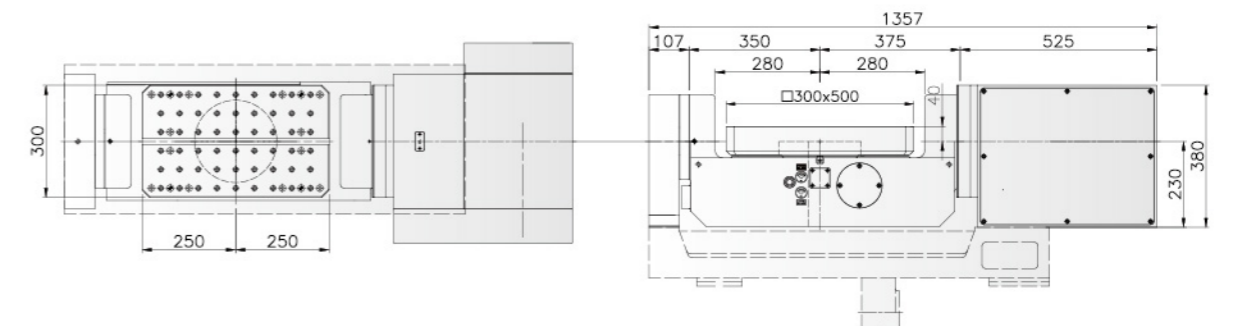
STD



OPT



OPT



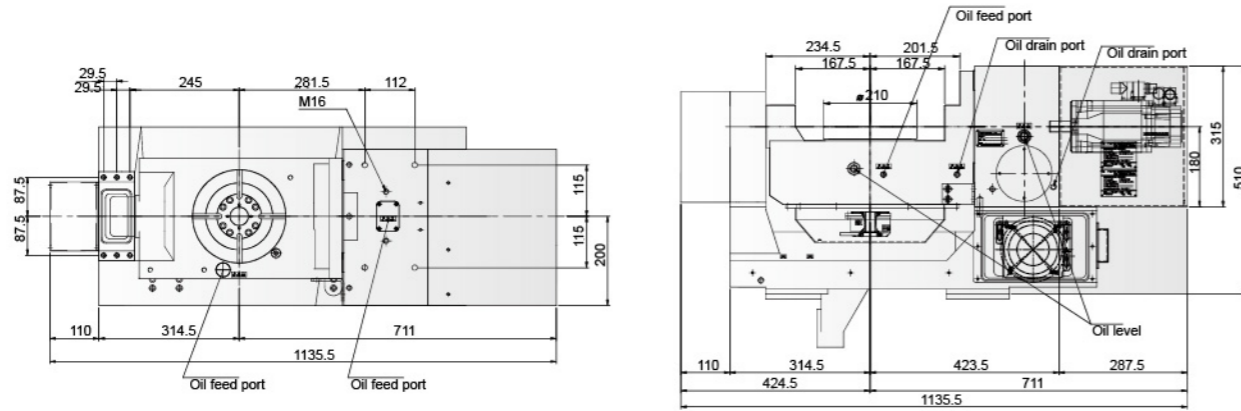
FIXTURE PLATE DIMENSION

FIXTURE PLATE DIMENSION

V-20iT

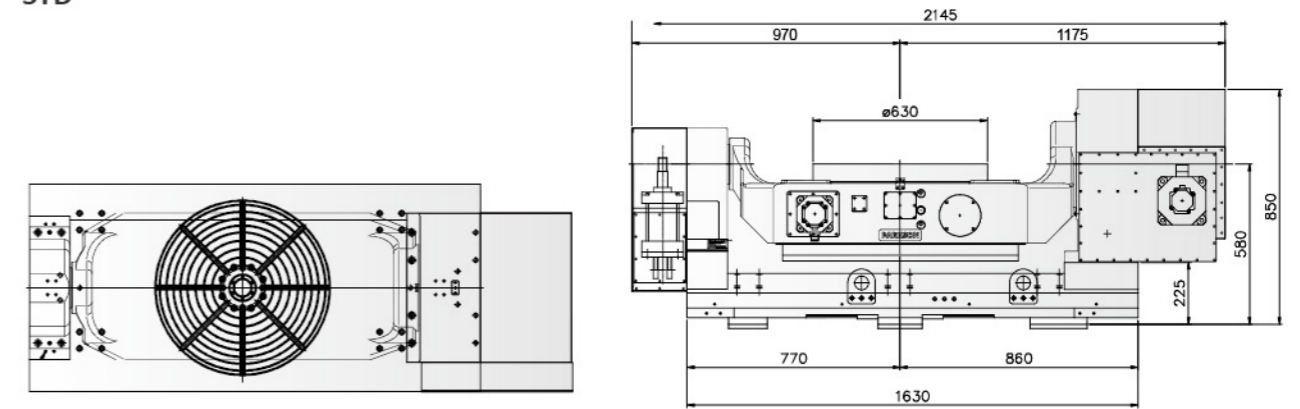
Unit:mm

STD



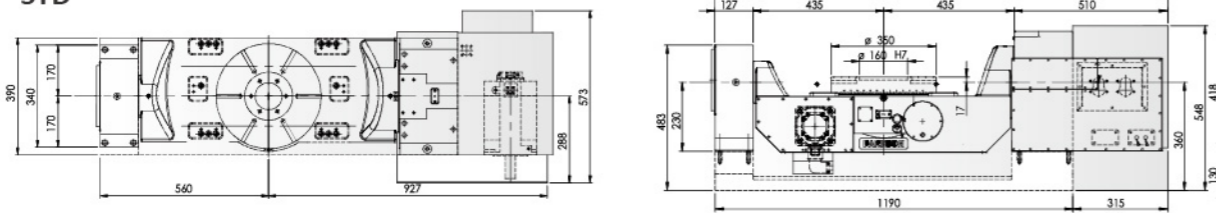
V-60iT

STD

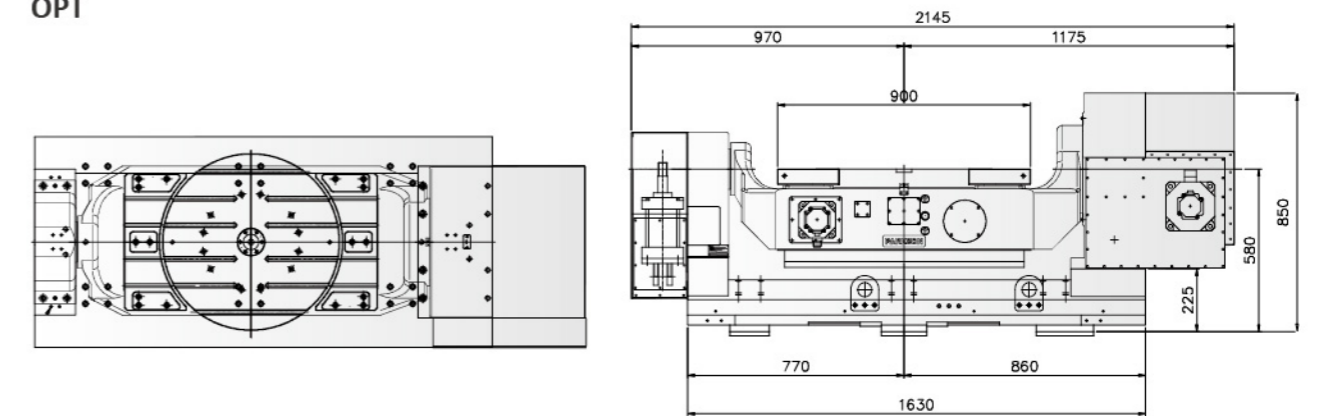


V-40iT

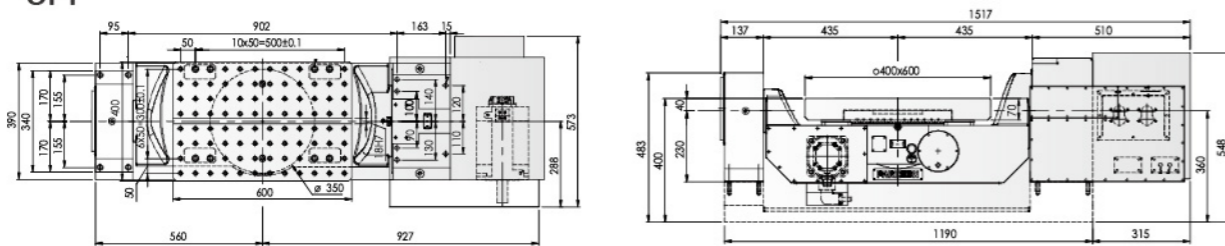
STD



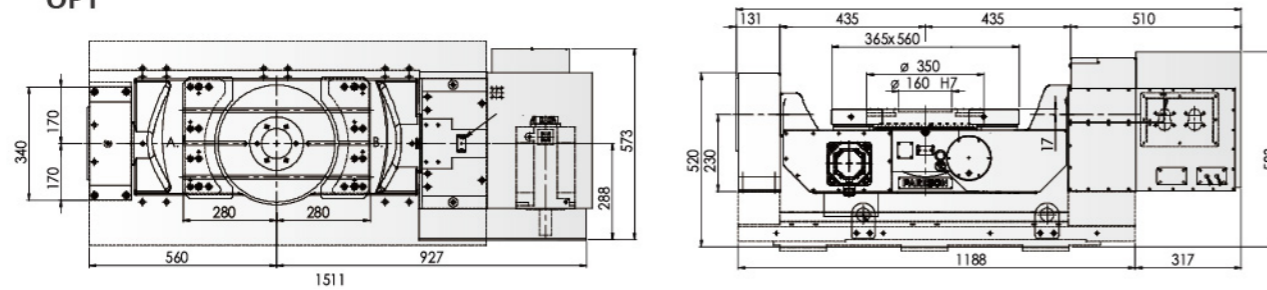
OPT



OPT

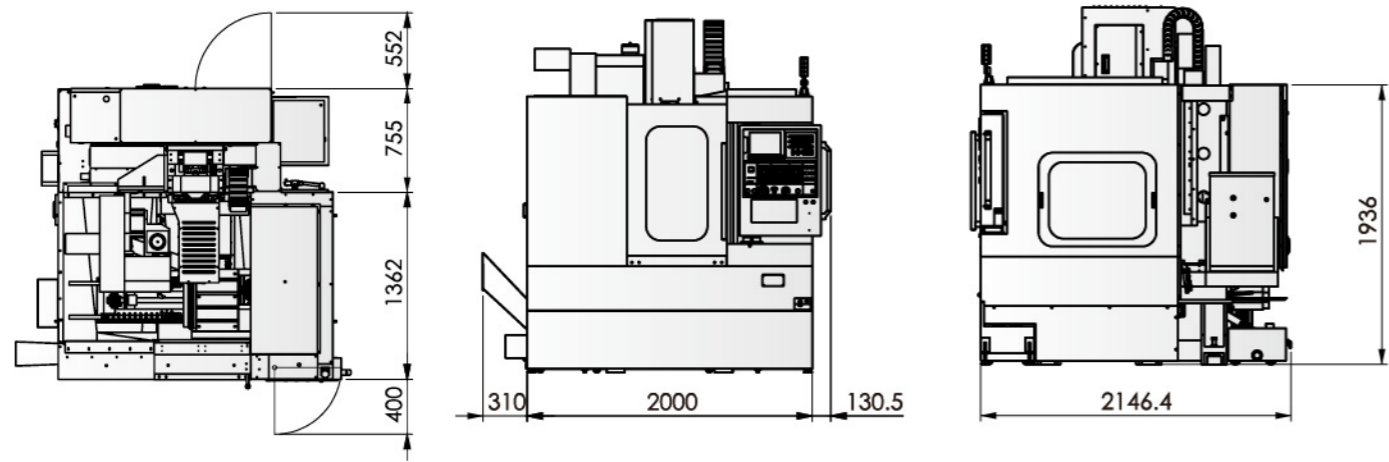


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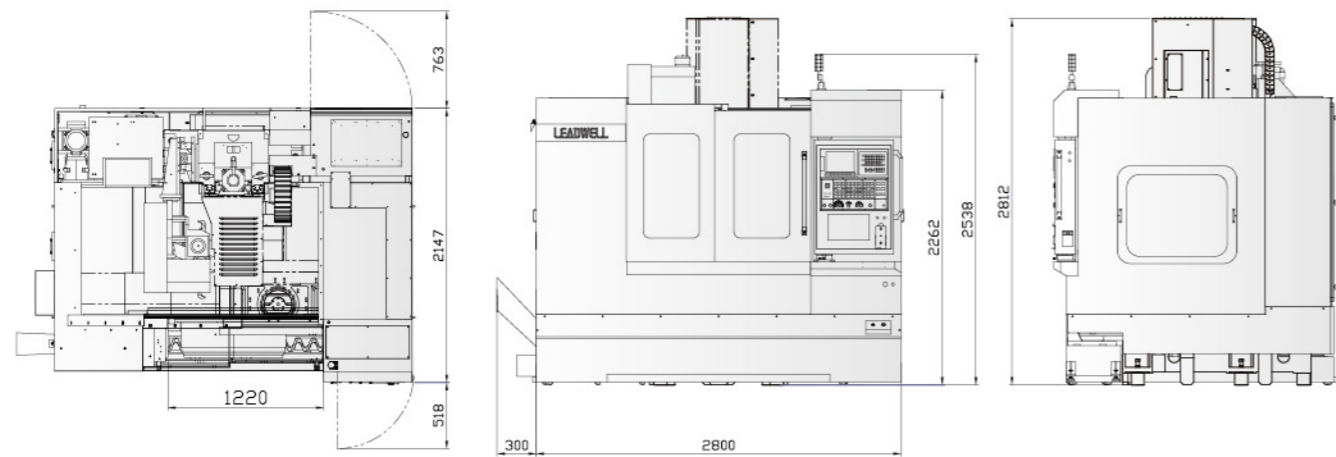


OUTLINE DIMENSION

V-30iT

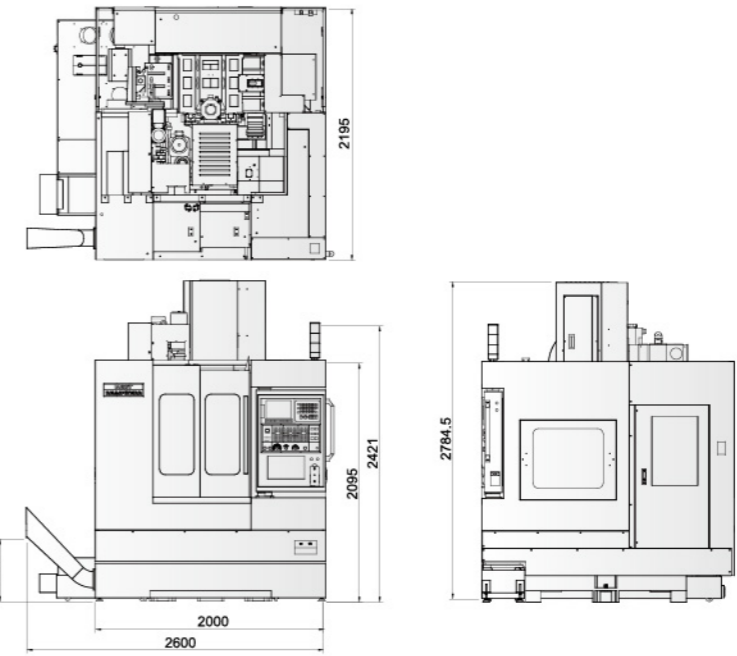


V-32iT

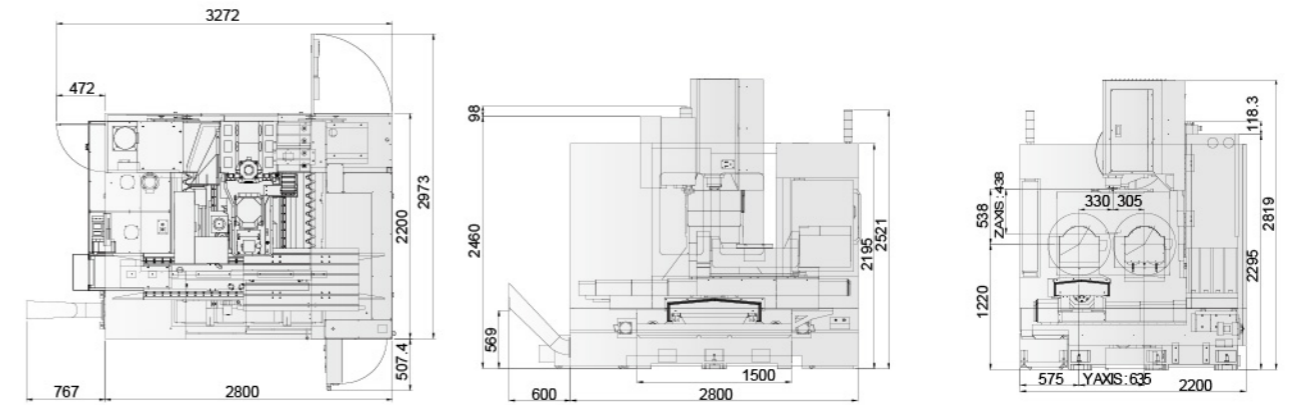


OUTLINE DIMENSION

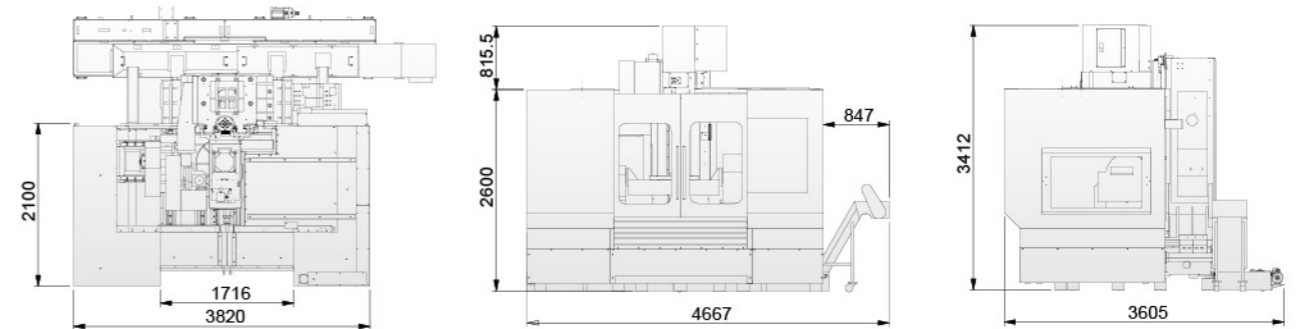
V-20iT



V-40iT

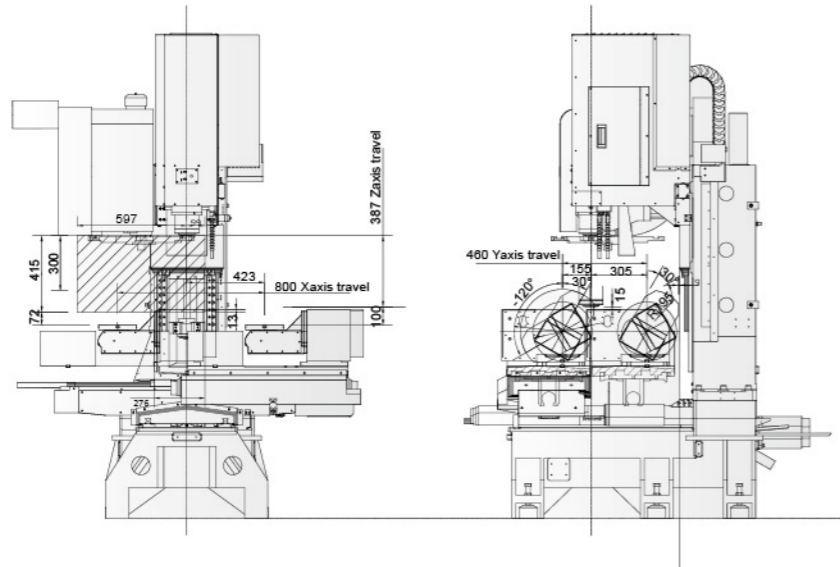


V-60iT



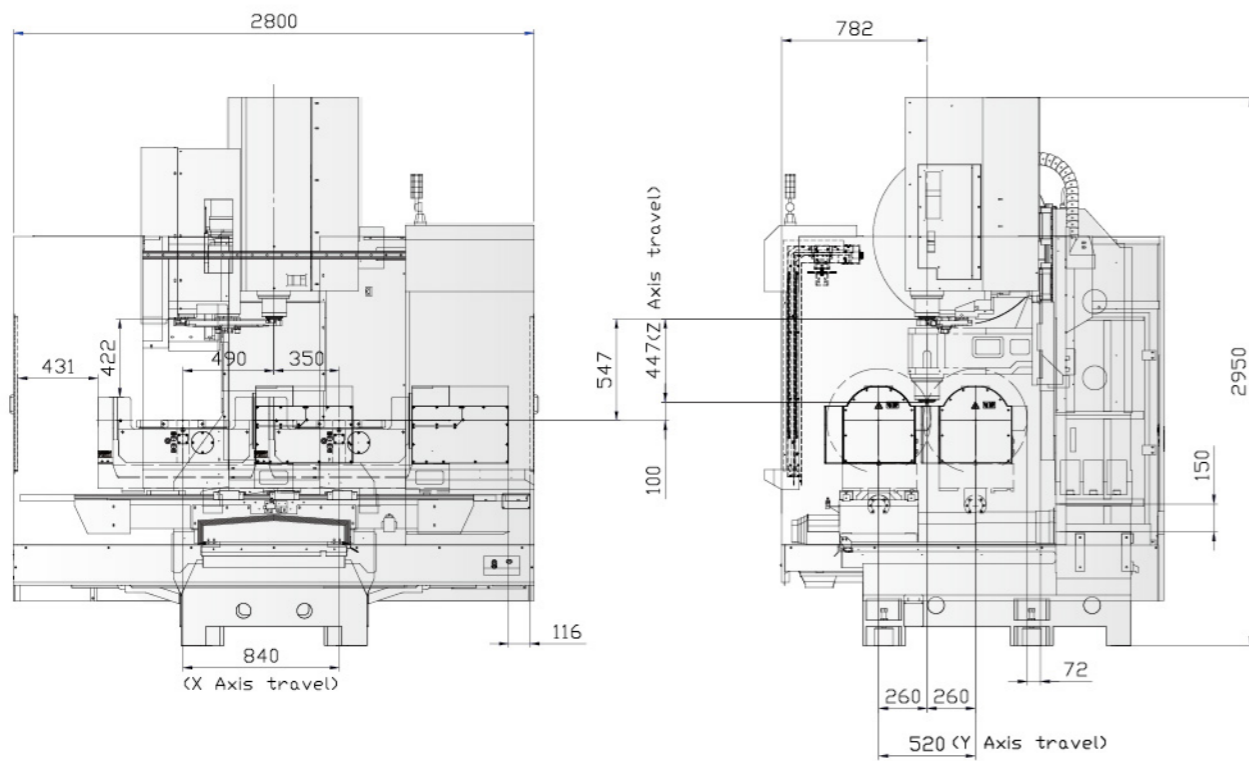
INTERNAL DIMENSION

V-30iT



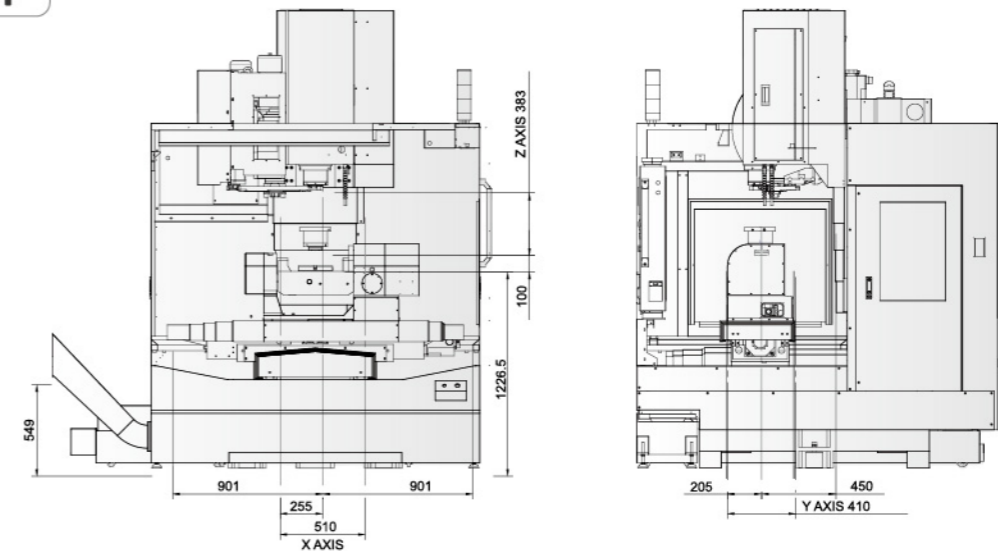
Unit:mm

V-32iT

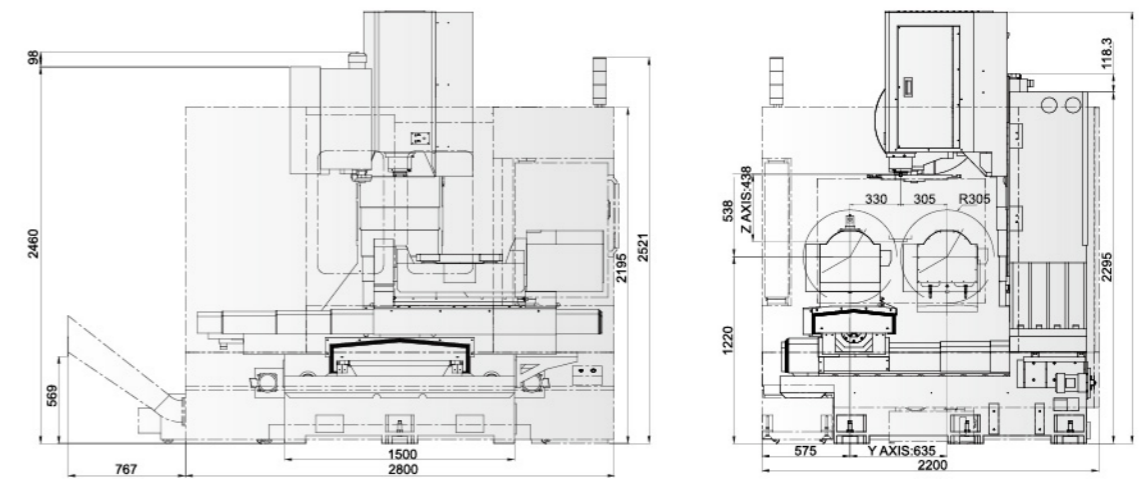


INTERNAL DIMENSION

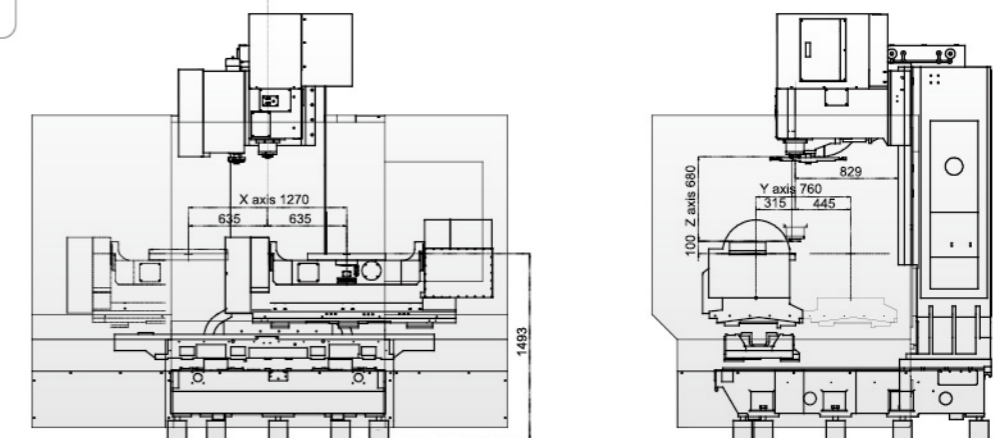
V-20iT



V-40iT



V-60iT



MACHINE SPECIFICATIONS

ITEM	MODEL	V-30iT	V-32iT
A.T.C.	Type	ARM	ARM
CAPACITY	Unit		
X axis travel	mm (in)	800(31.5)	840(33)
Y axis travel	mm (in)	460(18.1)	520(20.5)
Z axis travel	mm (in)	387(15.2)	447(17.6)
Table top to spindle end	mm (in)	100-487(3.9-19.1)	100-547(3.9-21.5)
Column front to spindle center	mm (in)	508(20)	637(25)
TABLE			
Table size (LxW)	mm (in)	φ205(φ8.07)	φ220(φ8.6)
Permissible mass of workpiece	kg	35(0°~45°)/ 25(45°~90°)	150(0°~45°)/ 85(45°~90°)
T-solt size		10	12
SPINDLE			
Spindle speed	rpm	12000	12000
Spindle nose (normal size)	mm	7/24 Taper, NO.40	
Ratios		1:1	1:1
Max.spindle torque	N.M(ft.lbf)	70(51.6)	95.5(70.4)
Transmission		H.T.D Belt	H.T.D Belt
FEED RATE			
Rapid traverse	m/min (IPM)	48/48/36(1890/1890/1417)	48/48/36(1890/1890/1417)
Feed rate	m/min (IPM)	10 (394)	20(787)
A.T.C.			
Tooling shank (nominal size,NO.)		BT-40	BT-40
Tool storage capacity		24	24
Tool change time(T-T)	sec	1.8	1.8
Tool change time(C-C)	sec	4	4
MOTORS			
Spindle motor (30min)	KW (HP)	11(14.7)	15(20.1)
X-axis feed motor	KW (HP)	4(5.4)	4(5.4)
Y-axis feed motor	KW (HP)	4(5.4)	4(5.4)
Z-axis feed motor	KW (HP)	4(5.4)	4(5.4)
MISCELLANEOUS			
Positioning accuracy (P) X、Y、Z VDI(3441)	mm	0.01/1000	0.01/1000
Repeatability (PS) X、Y、Z VDI(3441)	mm	0.007/1000	0.007/1000
MACHINE SIZE			
Height of machine (H)	mm(in)	2480(97.6)	2820(111)
Floor space (LxW)	mm(in)	2440x2117(96x83.3)	3100x2200(122x87)
Total machine weight	Kg(lb)	3800(8377)	6500(14330)
Power requirement	KVA	30	30
Controller	FANUC	Oi-M	

*AVAILABLE CONTROLLER: SIEMENS/FAGOR/HEIDENHAIN

MACHINE SPECIFICATIONS

ITEM	MODEL	V-20iT	V-40iT	V-60iT
A.T.C.	Type	ARM	ARM	ARM
CAPACITY	Unit			
X axis travel	mm (in)	510 (20)	846 (33)	1270 (50)
Y axis travel	mm (in)	410 (16)	635 (25)	800(31.5)
Z axis travel	mm (in)	383 (15)	488(19.2)	680 (26.7)
Table top to spindle end	mm (in)	100-483 (3.9-19)	50-538(1.9-21)	100-780 (3.9-30.7)
Column front to spindle center	mm (in)	450 (17.7)	635 (25)	825 (32.4)
TABLE				
Table size (LxW)	mm (in)	φ210 (φ8.3)	φ350 (φ13.8)	φ630 (φ24.8)
Permissible mass of workpiece	kg	75(0°~45°)/ 50(45°~90°)	200(0°~45°)/ 100(45°~90°)	200(0°~45°)/ 150(45°~90°)
T-solt size		12	12	14
SPINDLE				
Spindle speed	rpm	12000	12000	12000
Spindle nose (normal size)	mm	7/24 Taper, NO.40		
Ratios		1:1	1:1	1:1
Max.spindle torque	N.M(ft.lbf)	95.5(70.4)	118(87)	165.5(122)
Transmission		H.T.D Belt	H.T.D Belt	H.T.D Belt
FEED RATE				
Rapid traverse	m/min (IPM)	36/36/36 (1417/1417/1417)	36/36/36 (1417/1417/1417)	30/30/20 (1181/1181/787)
Feed rate	m/min (IPM)	10 (394)	10 (394)	20(788)
A.T.C.				
Tooling shank (nominal size,NO.)		BT-40	BT-40	BT-40
Tool storage capacity		24	24	24
Tool change time(T-T)	sec	1.8	1.8	1.8
Tool change time(C-C)	sec	4	4	4
MOTORS				
Spindle motor (30min)	KW (HP)	15 (20.1)	18.5 (24.8)	26 (34.9)
X-axis feed motor	KW (HP)	3 (4)	4 (5.4)	7(9.4)
Y-axis feed motor	KW (HP)	3 (4)	4 (5.4)	6 (8)
Z-axis feed motor	KW (HP)	4 (5.4)	4 (5.4)	7(9.4)
MISCELLANEOUS				
Positioning accuracy (P) X、Y、Z VDI(3441)	mm	0.01/1000	0.01/1000	0.015/1000
Repeatability (PS) X、Y、Z VDI(3441)	mm	0.007/1000	0.007/1000	0.01/1000
MACHINE SIZE				
Height of machine (H)	mm(in)	2620(103.1)	2721(107)	3735(147)
Floor space (LxW)	mm(in)	2700x2140(106.3x84.2)	3840x2200(151.2x86.6)	3820x4535(150x178.5)
Total machine weight	Kg(lb)	5200(11464)	7000(15432)	12500(27500)
Power requirement	KVA	35	35	60
Controller	FANUC	Oi-M		

*AVAILABLE CONTROLLER: SIEMENS/FAGOR/HEIDENHAIN

