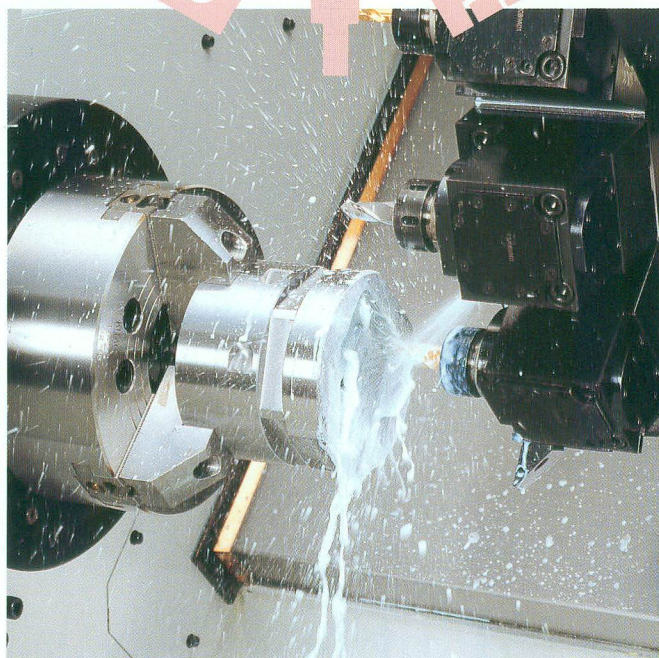
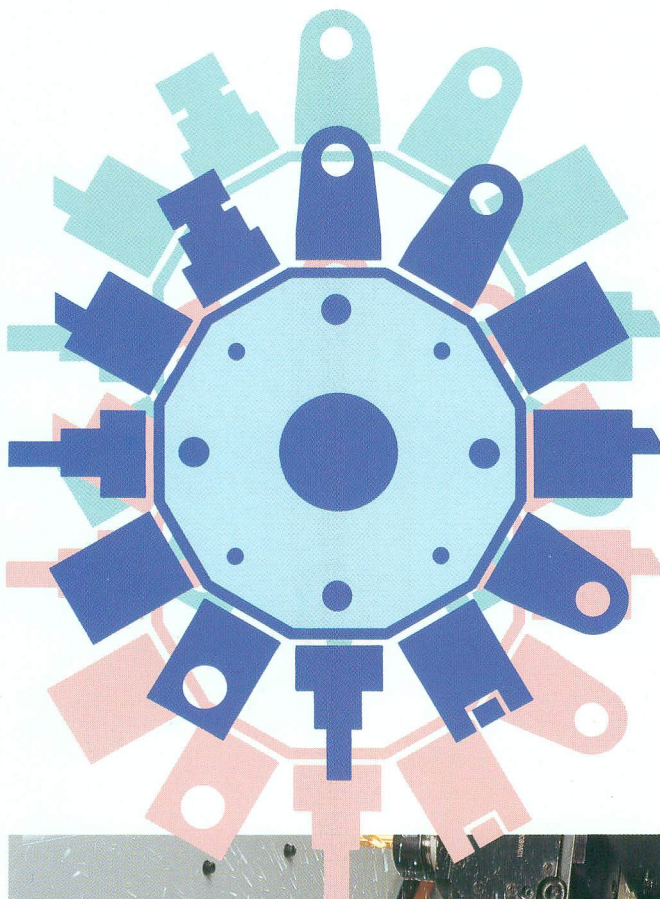


**MORI SEIKI**

**Y-AXIS CONTROL TURNING CENTER**

**SL-25Y  
TL-40Y**

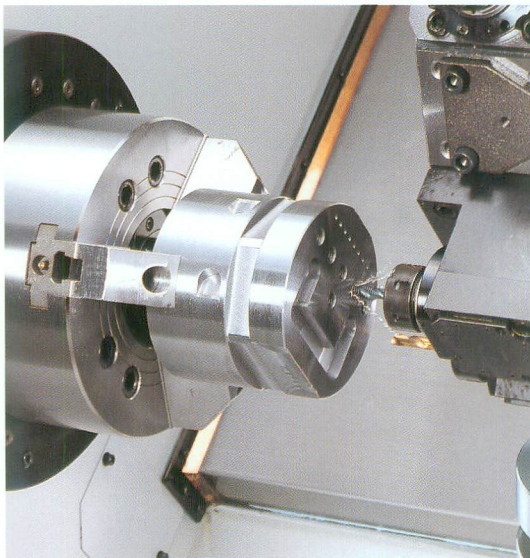
**Y-AXIS CONTROL**



# Y-axis control extends machining capability, A great advance in process integration.

**Y**-axis control promotes process integration. Milling/drilling using C-axis control is no longer a special feature for turning centers. Operations like finishing key-grooves to the specified tolerance and off-center drilling and tapping cannot be covered with C-axis control and special attachments. Secondary operations now require a degree of flexibility that is unattainable with conventional turning centers.

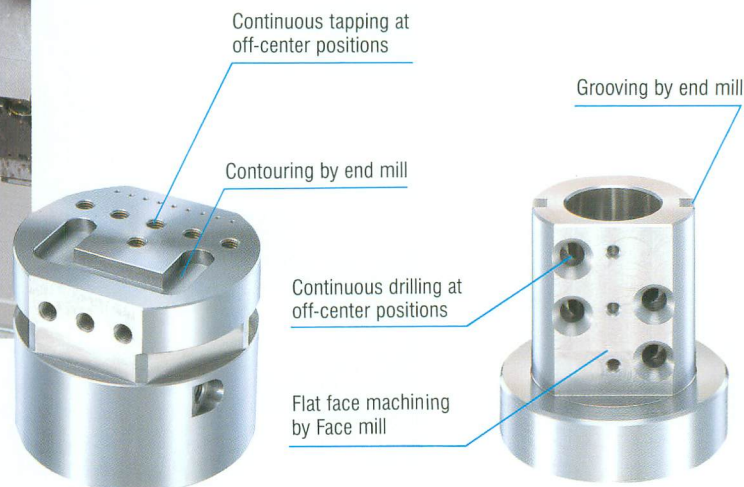
On the SL-25Y and TL-40Y, Y-axis control (in the center height direction) is added to conventional X-axis and Z-axis control, making it possible to accomplish milling jobs that are impossible on conventional turning centers. The Y-axis control feature allows greater process integration on a single machine while sustaining a higher level of accuracy.



For machining workpieces like samples 2 and 3 shown here, a machining center or a drilling machine would normally be required to perform the drilling and milling operations after finishing the turning process on an NC lathe. On a turning center with Y-axis control, all of these processes can be accomplished consecutively in one chucking.

## SAMPLE 1

■ Material: aluminum

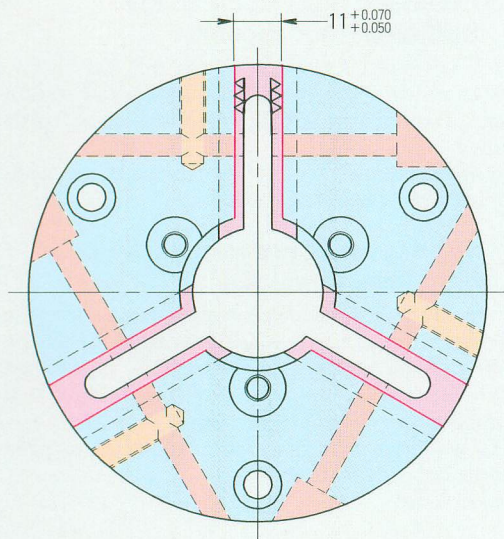


## SAMPLE 2

■ Material: carbon steel (S45C)  
(rigid-tap function is used)

## SAMPLE 3

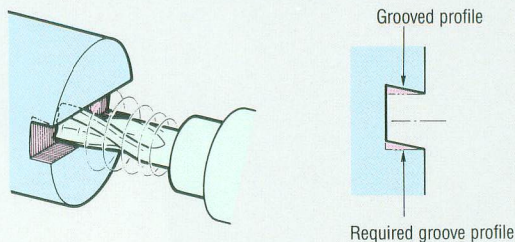
■ Material: carbon steel (S45C)



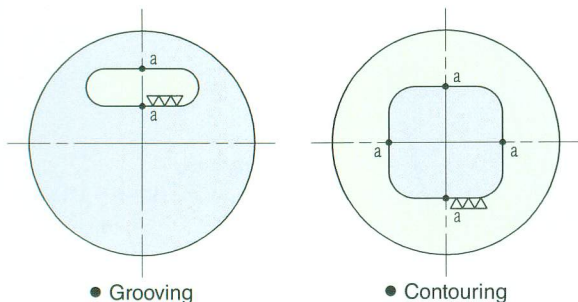
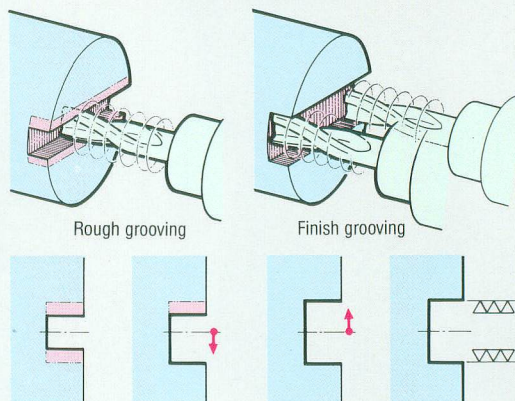
Finishing a groove to the specified tolerance is not easy on a conventional turning center. Tilting or run out of the end mill during cutting makes it difficult to finish the groove to the required accuracy.

On a turning center with Y-axis control, the tool tip can be shifted in the Y-axis direction (center height direction) to compensate for errors. This means that grooving to a required tolerance is not a tough job for a turning center with a Y-axis control function.

## • Grooving on a conventional turning center



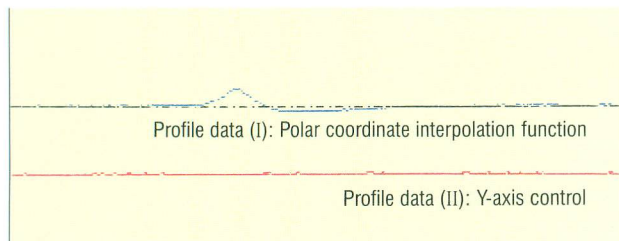
## • Grooving on a turning center with Y-axis control



## Comparison between polar coordinate interpolation and Y-axis control

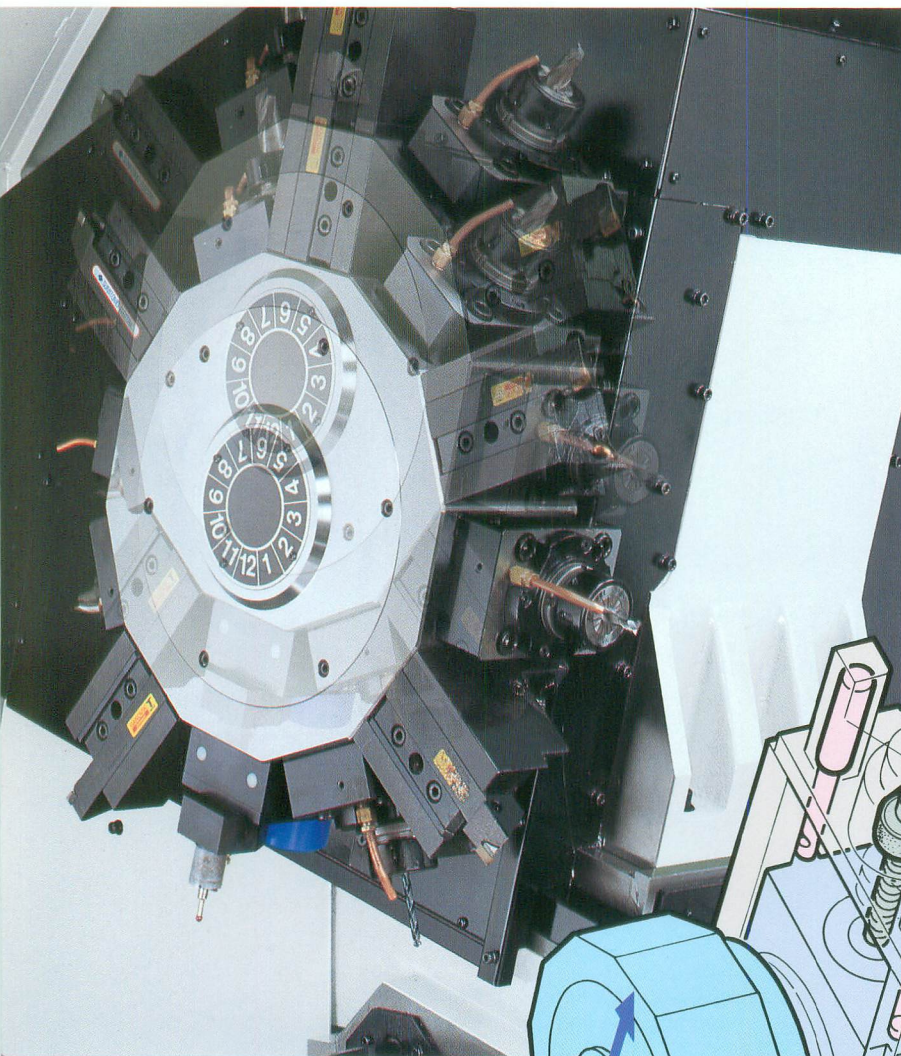
On a conventional turning center, the polar coordinate interpolation function is used for tool motion control during grooving and contouring, as illustrated to the left. In this control mode, however, the C-axis rotation direction is reversed at points "a", the intersections between the workpiece center line and the profile to be machined. Due to this reversal, the cutting conditions change when the tool passes these points, and this tends to generate the type of irregularity shown in profile data (I).

Machining with the Y-axis control function is free of such changes and finished grooving and contouring profiles therefore show the high level of accuracy seen in profile data (II).



Note: Above data may not always be possible due to cutting conditions and environmental conditions at the time of measurement.

**Sophisticated design for advanced functions.  
Rigid enough to guarantee consistently high accuracy.**



●● **Extended machining ability.  
Sufficient tool capacity.**

The Y-axis travel is a generous  $\pm 50$  mm (2.0"). The 12-station turret accepts a rotary tool at any station to give flexibility in milling operations using Y-axis control.

The rigid-tapping function for high-speed, precision tapping comes as a standard feature.

●● **Rigidity and precision back up  
high-level functions.**

Increased rigidity and high cutting power back up the Y-axis control capability. The Y-axis can move during milling. Also, because the turret body is clamped securely to the column during turning, unsurpassed rigidity and repeatability are obtained.

A Direct-Drive Spindle motor\* allows high-speed spindle indexing by  $0.001^\circ$ .

\*Only for SL-25Y.

● **Y-axis travel:  $\pm 50$  mm (2.0")**

Perpendicular to X- and Z-axes.  
Y-axis is clamped at the zero point for turning operation.

● **Reference block for positioning**

For setting and feedback of the Y-axis zero point, where the turret is clamped to carry out turning.

● **Y-axis drive AC servo motor**

Rapid traverse: 6,000 mm/min (236 ipm)

● **Turret clamp mechanism**

Turret clamped for turning operation.  
Turret unclamped during Y-axis movement (milling operation).

● **Y-axis drive**

Large diameter [32 mm (1.3" dia.) ball screw.

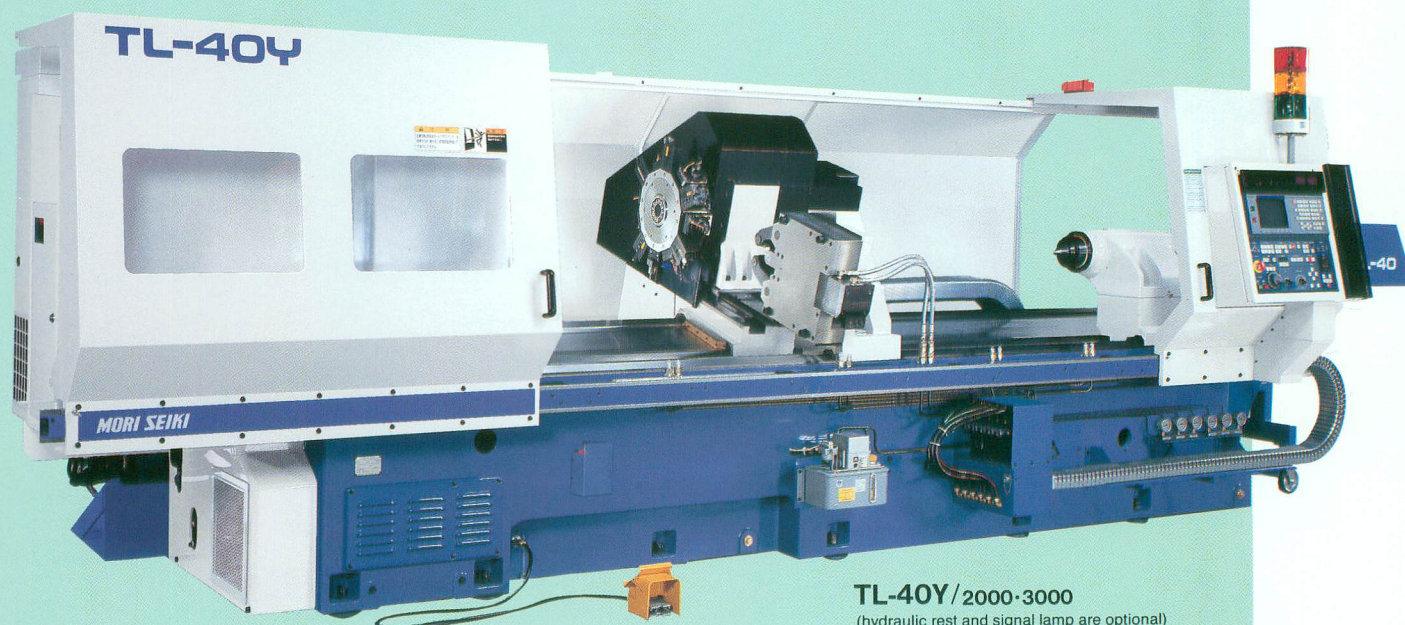
# MECHANISM AND FEATURES

Y-AXIS CONTROL

Mori Seiki's turning center incorporating Y-axis control —  
The leading-edge of multi-process operation.  
Line-up of powerful turning centers to meet your needs.



**SL-25Y/500-1000**  
(The built-in type tailstock shown here is option)

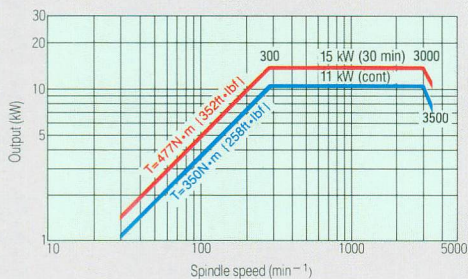


**TL-40Y/2000-3000**  
(hydraulic rest and signal lamp are optional)

# SPINDLE SPEED/OUTPUT DIAGRAM

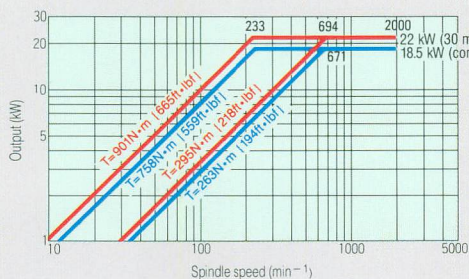
## SL-25Y

- Output: 15/11 kW AC (30 min/cont)
- Spindle speed: 35 – 3,500 min<sup>-1</sup>



## TL-40Y

- Output: 22/18.5 kW AC (30 min/cont)
- Spindle speed: 7 – 2,000 min<sup>-1</sup>



## Rotary tool

(common to SL-25Y and TL-40Y)

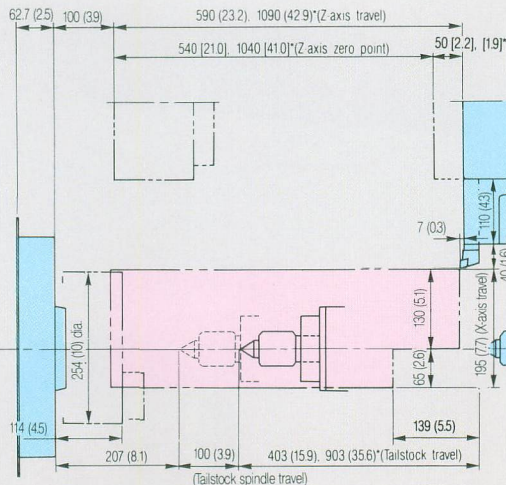
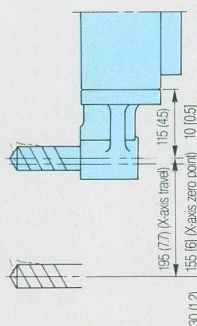
- Output: 3.7/2.2 kW AC (15 min/cont)
- Spindle speed: 100 – 2,000 min<sup>-1</sup>



# AXIS-TRAVEL DIAGRAM

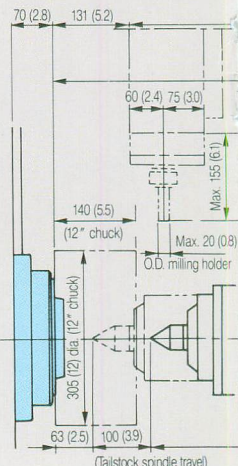
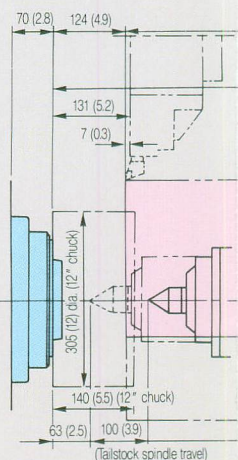
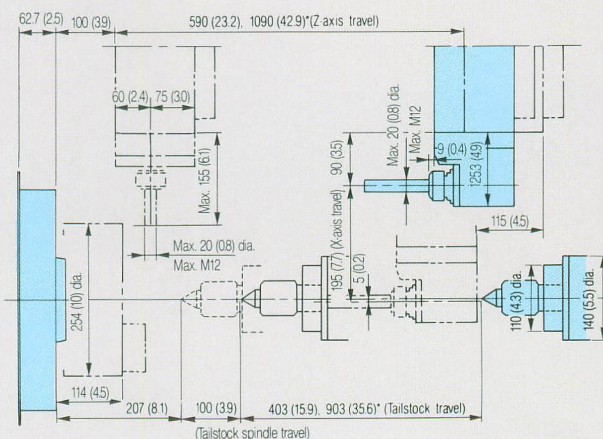
## SL-25Y/500-1000 \*SL-25Y/1000

- For turning tool



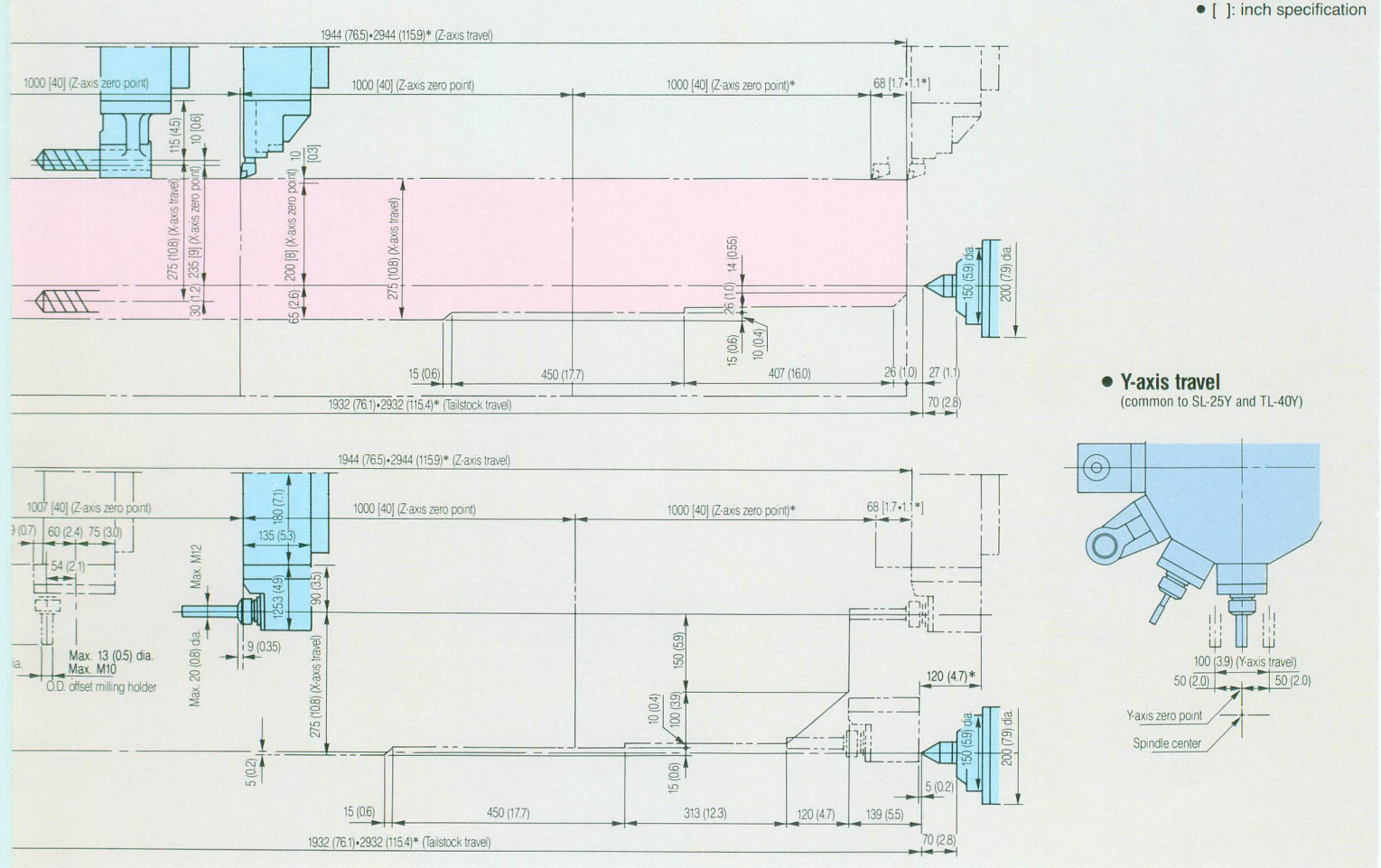
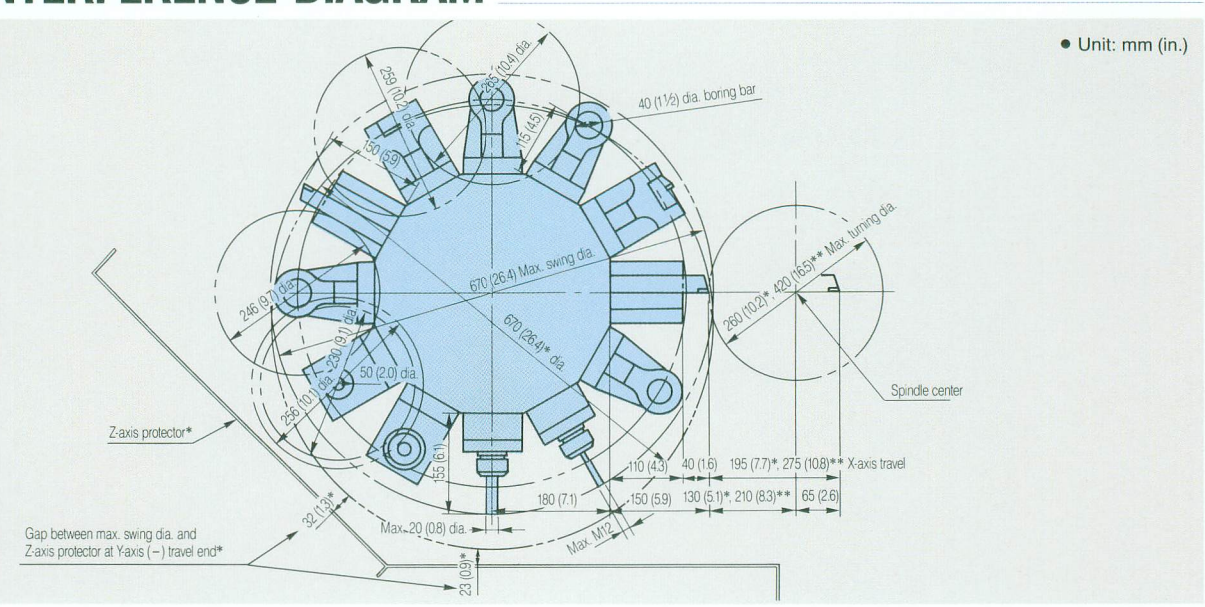
## TL-40Y /2000-3000 \*TL-40Y/3000

- For rotary tool

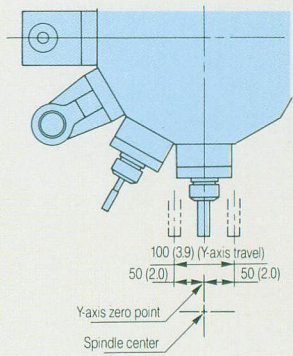


.....

\*\*TL-40Y



- **Y-axis travel**  
(common to SL-25Y and TL-40Y)

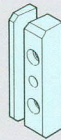


# TOOLING SYSTEM

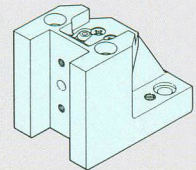
## O.D. and face cutting



25 x 25 mm (1" x 1")  
qualified tool

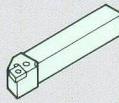


B27007 ⑥  
B27008 [B27009] ⑥

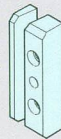


O.D. and face cutting holder  
T00128 [T00129] ⑥

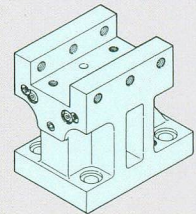
## Face and I.D. cutting



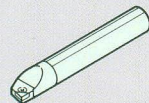
25 x 25 mm (1" x 1")  
qualified tool



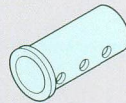
B27007 ①  
B27008 [B27009] ①



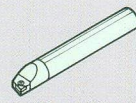
Face and I.D. cutting holder  
T00114 [T00115] ①



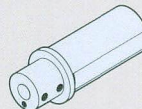
40 mm (1 1/2") dia.  
boring bar



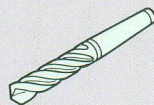
Boring bar sleeve  
T20098 (32 mm dia.) [T20099 (1 1/4") dia.] ①  
T20096 (25 mm dia.) [T20097 (1") dia.] ②  
T20094 (20 mm dia.) [T20095 (3/4") dia.] ①  
T20092 (16 mm dia.) [T20093 (5/8") dia.]  
T20090 (12 mm dia.) [T20091 (1/2") dia.]  
T20088 (10 mm dia.) [T20089 (3/8") dia.]  
T20086 (8 mm dia.)



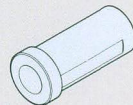
32 mm (1 1/4") dia.  
or less boring bar



Boring bar sleeve  
T20110 (12 mm dia.) [T20111 (1/2") dia.]  
T20108 (10 mm dia.) [T20109 (3/8") dia.]  
T20106 (8 mm dia.)

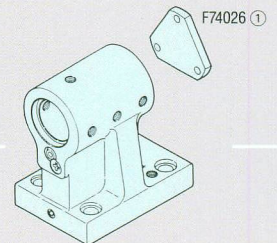


Drill

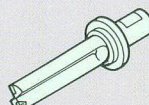


Drill socket  
T22042 [T22043] <MT-3>  
T22046 [T22047] <MT-2>

40 mm (1 1/2") dia.



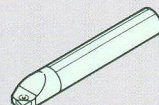
Boring bar holder  
T10064 (40 mm dia.) ④  
[T10065 (1 1/2") dia.] ④



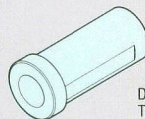
Throw-away drill



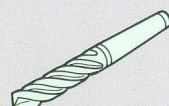
Throw-away drill socket  
T20100 (32 mm dia.) [T20101 (1 1/4") dia.]  
T20102 (25 mm dia.) [T20103 (1") dia.]  
T20104 (20 mm dia.) [T20105 (3/4") dia.]



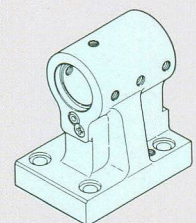
50 mm (2") dia. boring bar



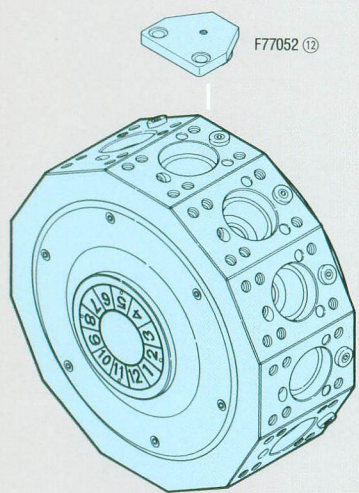
Drill socket  
T22044 [T22045] <MT-4> ①



Drill



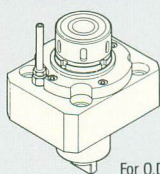
Boring bar holder  
T10068 (50 mm dia.) [T10069 (2") dia.] ①



**Turret Head**  
(12 stations)

○: Standard set numbers  
[ ]: Inch specification

## Rotary tools

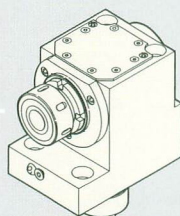


For O.D. cutting  
T32090

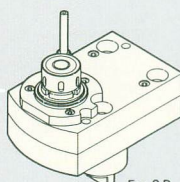
Chuck collet  
Rego-Fix  
Schaublin



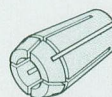
Rego-Fix No.  
ER32-3 - 20  
Schaublin No.  
ESX32-3 - 20



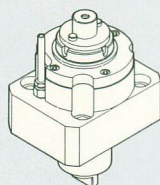
For face cutting  
T32089



For O.D. cutting offset  
T32100

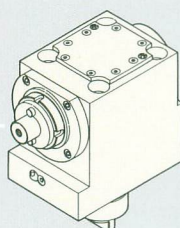


Rego-Fix No.  
ER20-2 - 13  
Schaublin No.  
ESX20-2 - 13



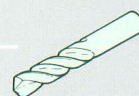
### For O.D. cutting

| Arbor dia. | Holder No.          |
|------------|---------------------|
| 22.225 mm  | T32092 (JIS spec.)  |
| 19.05 mm   | T32094 (Inch spec.) |
| 22 mm      | T32096 (ISO spec.)  |

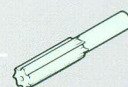


### For face cutting

| Arbor dia. | Holder No.          |
|------------|---------------------|
| 22.225 mm  | T32091 (JIS spec.)  |
| 19.05 mm   | T32093 (Inch spec.) |
| 22 mm      | T32095 (ISO spec.)  |



Drill



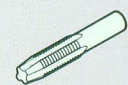
Reamer



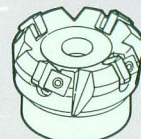
Center drill



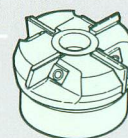
End mill  
Max. 20 mm (0.8") dia.  
T32100: Max. 13 mm  
(0.5") dia.



Tap  
M4, 5, 6, 8, 10, 12  
T32100: Max. M10



Face mill  
50 mm (2") dia.



Shoulder mill  
50 mm (2") dia.

# MACHINE SPECIFICATIONS

| Item          |                                              |                        | SL-25Y/500                                                                                                    | SL-25Y/1000                  | TL-40Y/2000                                                                                                 | TL-40Y/3000                  |
|---------------|----------------------------------------------|------------------------|---------------------------------------------------------------------------------------------------------------|------------------------------|-------------------------------------------------------------------------------------------------------------|------------------------------|
| Capacity      | Swing over bed                               | mm (in.)               | 815 (32.1)                                                                                                    | 679 (26.7)*                  | 870 (34.3)                                                                                                  |                              |
|               | Swing over cross slide                       | mm (in.)               | 620 (24.4)                                                                                                    |                              | 580 (22.8)                                                                                                  |                              |
|               | Distance between centers                     | mm (in.)               | 620 (24.4)                                                                                                    | 1,120 (44.1)                 | 2,115 (83.3)                                                                                                | 3,115 (122.6)                |
|               | Max. turning diameter                        | mm (in.)               | 260 (10.2)                                                                                                    |                              | 420 (16.5)                                                                                                  |                              |
|               | Max. turning length                          | mm (in.)               | 530 (20.9)                                                                                                    | 1,010 (39.8)                 | 1,905 (75)                                                                                                  | 2,905 (114.4)                |
| Travel        | X-axis travel                                | mm (in.)               | 195 < 130+65 >                                                                                                | (7.7 < 5.1+2.6 >)            | 275 < 65+210 >                                                                                              | (10.8 < 2.6+8.3 >)           |
|               | Z-axis travel                                | mm (in.)               | 590 (23.2)                                                                                                    | 1090 (42.9)                  | 1,944 (76.5)                                                                                                | 2,944 (115.9)                |
|               | Y-axis travel                                | mm (in.)               | 100 < ± 50 > (3.9 < ± 2.0 >)                                                                                  |                              |                                                                                                             |                              |
| Spindle       | Spindle speed range                          | mm <sup>-1</sup>       | 35—3,500                                                                                                      |                              | 7—2,000                                                                                                     |                              |
|               | Number of spindle speed ranges               |                        | 1                                                                                                             |                              | 2                                                                                                           |                              |
|               | Type of spindle nose                         |                        | JIS A2-8                                                                                                      |                              |                                                                                                             |                              |
|               | Through spindle hole diameter                | mm (in.)               | 80 (3.1)                                                                                                      |                              | 92 (3.6)                                                                                                    |                              |
|               | Min. spindle indexing angle                  |                        | Least input increment: 0.001°                                                                                 |                              |                                                                                                             |                              |
| Turret        | Spindle bearing inner diameter               | mm (in.)               | 130 (5.1)                                                                                                     |                              | 160 (6.3)                                                                                                   |                              |
|               | Number of tool stations                      |                        | 12 < rotary tools: 12 >                                                                                       |                              |                                                                                                             |                              |
|               | Shank heigh for square tool                  | mm (in.)               | 25 (1.0)                                                                                                      |                              |                                                                                                             |                              |
|               | Shank diameter for boring bar                | mm (in.)               | 50 (2.0)                                                                                                      |                              |                                                                                                             |                              |
|               | Turret indexing time                         | sec.                   | 1.0                                                                                                           |                              |                                                                                                             |                              |
| Rotary tools  | Rotary tool spindle speed range              | min <sup>-1</sup>      | 100—2,000                                                                                                     |                              |                                                                                                             |                              |
|               | Cutting capability of rotary tool            | mm (in.)               | End mill: Max. 20 (0.8) dia. Face mill: Max. 50 (2) dia. Tap: Max. M12                                        |                              |                                                                                                             |                              |
| Feedrate      | Rapid traverse rate                          | mm/min (ipm)           | X-axis: 12,000 (472.4)<br>Z-axis: 15,000 (590.6)<br>< C-axis: 100min <sup>-1</sup> ><br>Y-axis: 6,000 (236.2) |                              | X-axis: 6,000 (236.2)<br>Z-axis: 12,000 (472.4)<br>< C-axis: 20min <sup>-1</sup> ><br>Y-axis: 6,000 (236.2) |                              |
|               | Feed per revolution                          | mm                     | X-axis: 0.001—342<br>Z-axis: 0.001—428<br>< Y-axis: 6,000mm/min (236.2ipm) >                                  |                              | X-axis: 0.001—500<br>Z-axis: 0.001—500<br>< Y-axis: 6,000mm/min (236.2ipm) >                                |                              |
|               | Jog feedrate                                 | mm/min (ipm)           | X, Z, Y-axes: 1,260 (50)                                                                                      |                              |                                                                                                             |                              |
| Tailstock     | Tailstock travel                             | mm (in.)               | 403 (15.9)                                                                                                    | 903 (35.6)                   | 1,932 (76.1)                                                                                                | 2,932 (115.4)                |
|               | Tailstock spindle diameter                   | mm (in.)               | 110 (4.3)                                                                                                     |                              | 150 (5.9)                                                                                                   |                              |
|               | Tailstock spindle travel                     | mm (in.)               | 100 (3.9)                                                                                                     |                              | 100 (3.9)                                                                                                   |                              |
|               | Taper hole of tailstock spindle              |                        | MT-5 < Live center >                                                                                          |                              | MT-5 < Built-in >                                                                                           |                              |
| Motor         | Spindle drive motor (30min/cont)             | kW (HP)                | 15/11 (20/15) AC                                                                                              |                              | 22/18.5 (30/24.8) AC                                                                                        |                              |
|               | Rotary tool spindle drive motor (15min/cont) | kW (HP)                | 3.7/2.2 (5/3) AC                                                                                              |                              |                                                                                                             |                              |
|               | Feed motor                                   | kW (HP)                | X-axis: 1.8 (2.4) AC<br>Z-axis: 1.8 (2.4) AC<br>Y-axis: 0.9 (1.2) AC                                          |                              | X-axis: 0.9 (1.2) AC Z-axis: 3.5 (4.7) AC<br>C-axis: 0.9 (1.2) AC Y-axis: 0.9 (1.2) AC                      |                              |
| Power sources | Electrical power supply                      | kVA                    | 35                                                                                                            |                              | 44                                                                                                          |                              |
|               | Compressed air supply                        | MPa (psi), L/min (gpm) | 0.5 (71), 100 (26.4) < ANR** >                                                                                |                              |                                                                                                             |                              |
| Tank capacity | Coolant tank capacity                        | L (gal.)               | 100 (26.4)                                                                                                    | 140 (37.0)                   | 100 (26.4)                                                                                                  | 150 (39.6)                   |
| Machine size  | Machine height                               | mm (in.)               | 2,060 (81.1)                                                                                                  |                              | 2,011 (79.2)                                                                                                |                              |
|               | Floor space                                  | mm (in.)               | 3,183 x 1,799 (125.3 x 70.8)                                                                                  | 3,885 x 1,797 (153.0 x 70.7) | 5,838 x 2,268 (229.8 x 89.3)                                                                                | 6,975 x 2,268 (274.6 x 89.3) |
|               | Mass of machine                              | kg (lb.)               | 5,400 (11,880)                                                                                                | 6,500 (14,300)               | 8,800 (19,360)                                                                                              | 9,800 (21,560)               |

\*Interference diameter with front cover

\*\*ANR refers to a standard atmospheric state; i.e., temperature at 20°C (68°F); absolute pressure at 101.3kPa (760mmHg); and relative humidity at 65%.

## ■ Standard accessories

| SL-25Y                                                                                                                                                               |                                                                                                                |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> <li>• Front door lock device</li> <li>• Programmable tailstock</li> <li>• Coolant system</li> <li>• Built-in worklight</li> </ul> | <ul style="list-style-type: none"> <li>• Splash guard</li> <li>• Tool holders</li> <li>• Hand tools</li> </ul> |

| TL-40Y                                                                                                                                                                              |                                                                                        |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> <li>• Front door lock device</li> <li>• Chip conveyor</li> <li>• Coolant system</li> <li>• Built-in worklight</li> <li>• Splash guard</li> </ul> | <ul style="list-style-type: none"> <li>• Tool holders</li> <li>• Hand tools</li> </ul> |

## ■ Optional accessories

| SL-25Y                                                                                                                                                                                                                                      |                                                                                                                                                                                                                      |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> <li>• Chip conveyor</li> <li>• Hydraulic chuck</li> <li>• Soft jaws</li> <li>• Rotary-tool holders</li> <li>• Automatic measuring system</li> <li>• Automatic door</li> <li>• Air blow system</li> </ul> | <ul style="list-style-type: none"> <li>• In-machine tool presetter</li> <li>• Signal indicator</li> <li>• Bar feeder</li> <li>• Parts catcher</li> <li>• Live center</li> <li>• Tailstock (built-in type)</li> </ul> |

| TL-40Y                                                                                                                                                                                     |                                                                                                                                     |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> <li>• Programmable tailstock</li> <li>• Hydraulic steady rest</li> <li>• Hydraulic chuck</li> <li>• Soft jaws</li> <li>• Rotary-tool holders</li> </ul> | <ul style="list-style-type: none"> <li>• Automatic door</li> <li>• In-machine tool presetter</li> <li>• Signal indicator</li> </ul> |

• Specifications, accessories, safety devices, and functions are available upon request.

# NC UNIT SPECIFICATIONS

| Item                  |                                               | MF-T6                                                                                                                                                                                                                                                                                                                            |
|-----------------------|-----------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Controls              | Simultaneously controllable axes              | 4 axes: X, Z, C, Y                                                                                                                                                                                                                                                                                                               |
|                       | Least command increment                       | 0.001 mm (0.0001")                                                                                                                                                                                                                                                                                                               |
|                       | Least input increment                         | 0.001 mm (0.0001")                                                                                                                                                                                                                                                                                                               |
| Feed functions        | Feedrate override                             | 0 – 150 % (in 10 % increments)                                                                                                                                                                                                                                                                                                   |
|                       | Dwell                                         | Stop time (sec) command: G04                                                                                                                                                                                                                                                                                                     |
|                       | Zero return                                   | Return to machine zero point: G27, G28, G30                                                                                                                                                                                                                                                                                      |
|                       | Pulse handle feed                             | 0.001, 0.01, 0.1 mm/pulse (0.0001", 0.001", 0.01"/pulse)                                                                                                                                                                                                                                                                         |
|                       | Manual jog feed                               | 0 – 1,260 mm/min (0 – 50"/min) (15 steps)                                                                                                                                                                                                                                                                                        |
|                       | Dry run                                       | Moves at jog feedrate regardless of feed command                                                                                                                                                                                                                                                                                 |
|                       | Rapid traverse rate override                  | F0 (fine feed), 25/50/100 %                                                                                                                                                                                                                                                                                                      |
|                       | Feed per minute/feed per revolution selection | G98/G99                                                                                                                                                                                                                                                                                                                          |
| Tool functions        | Tool function                                 | 4-digit T code                                                                                                                                                                                                                                                                                                                   |
|                       | Tool nose radius offset                       | G40 – G42                                                                                                                                                                                                                                                                                                                        |
|                       | No. of tool offsets                           | 16 sets                                                                                                                                                                                                                                                                                                                          |
|                       | Tool geometry/wear offset                     | Geometry & wear data are separate                                                                                                                                                                                                                                                                                                |
| Programming functions | Absolute/incremental programming              | X, Z, C, Y/U, W, H, V                                                                                                                                                                                                                                                                                                            |
|                       | Multiple canned cycle                         | Type I: G70 – G76                                                                                                                                                                                                                                                                                                                |
|                       | Single canned cycle                           | G90, G92, G94                                                                                                                                                                                                                                                                                                                    |
|                       | Decimal point programming                     | Inputs values with decimal point                                                                                                                                                                                                                                                                                                 |
|                       | Inch/metric conversion                        | G20/G21                                                                                                                                                                                                                                                                                                                          |
|                       | Circular arc radius (R) designation           | Specifying by radius R instead of I, K commands                                                                                                                                                                                                                                                                                  |
|                       | Chamfer and corner R designation              | Chamfer and corner R can be machined                                                                                                                                                                                                                                                                                             |
|                       | Sub-program                                   | Max. nesting level: 4                                                                                                                                                                                                                                                                                                            |
|                       | Threading cycle retract                       | Threading is temporarily stopped, chamfering is executed and the tool returns to start point                                                                                                                                                                                                                                     |
|                       | Work coordinate system selection              | G54 – G59                                                                                                                                                                                                                                                                                                                        |
|                       | Local/machine coordinate system setting       | G52/G53                                                                                                                                                                                                                                                                                                                          |
|                       | Max. programmable dimension                   | ± 99,999.999 mm (9,999.9999")                                                                                                                                                                                                                                                                                                    |
|                       | Miscellaneous function                        | 3-digit M code                                                                                                                                                                                                                                                                                                                   |
|                       |                                               |                                                                                                                                                                                                                                                                                                                                  |
| Tape functions        | Input code                                    | ISO/EIA automatic discrimination                                                                                                                                                                                                                                                                                                 |
|                       | I/O interface                                 | RS-232-C                                                                                                                                                                                                                                                                                                                         |
|                       | Program storage capacity                      | 20 m (65.6')                                                                                                                                                                                                                                                                                                                     |
|                       | Registered programs                           | 63 programs                                                                                                                                                                                                                                                                                                                      |
|                       | Search function                               | Sequence number search, program number search, address search                                                                                                                                                                                                                                                                    |
| Other functions       | MDI/CRT unit                                  | 9" CRT, data entry keyboard, soft-key                                                                                                                                                                                                                                                                                            |
|                       | Stored Stroke check 1                         | Detecting overtravel by software                                                                                                                                                                                                                                                                                                 |
|                       | Background editing                            | Editing and memory are possible in background during automatic operation                                                                                                                                                                                                                                                         |
|                       | Help function                                 | Explanations & instructions when alarm occurs                                                                                                                                                                                                                                                                                    |
|                       | Running time/parts number display             | Running time and parts number under automatic operation is displayed                                                                                                                                                                                                                                                             |
|                       | Load meter display                            | On-screen load-meter for servo-motor is displayed                                                                                                                                                                                                                                                                                |
|                       | Self diagnosis                                | Self-check by NC unit                                                                                                                                                                                                                                                                                                            |
|                       | Extended tape editing                         | Copy, move, insert and change of NC program                                                                                                                                                                                                                                                                                      |
| Options               | Synchronized tapping                          | Rigid tapping function                                                                                                                                                                                                                                                                                                           |
|                       | Addition of control axes                      | Max. 8 (total value)                                                                                                                                                                                                                                                                                                             |
|                       | Part program storage capacity                 | 40 m (131.2')/80 m (262.5')/160 m (525.0')/320 m (1,049.9')/<br>640 m (2,099.8')/1,280 m (4,199.7')                                                                                                                                                                                                                              |
|                       | Registered programs                           | 125/200/400                                                                                                                                                                                                                                                                                                                      |
|                       | No. of tool offsets                           | 32 sets                                                                                                                                                                                                                                                                                                                          |
|                       | Stored stroke check                           | 2/3                                                                                                                                                                                                                                                                                                                              |
|                       | Others                                        | <ul style="list-style-type: none"> <li>• Variable lead thread cutting • Tool life management</li> <li>• Additional optional block skip • Stored pitch error compensation</li> <li>• Playback • High-speed skip function • Program restart</li> <li>• Multiple canned cycle: Type II • Manual handle feed interruption</li> </ul> |

- Figures in inches are converted from metric measurements.
- Design and specifications subject to change without notice.
- Mori Seiki is not responsible for differences between the information in the catalog and the actual machine.

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