

# FEELER and Methods

These **ALL NEW** machines feature  
*extensive design and engineering by*  
*Methods Machine Tools, Inc.*

## Turning Centers

- HT-Series: Milling Lathes
- FTC-Series: Linear Guideways
- FT-Series: Boxway Lathes

## VMC's

- HV-Series: High Performance
- VB-Series: Heavy Duty Boxways
- VMP-Series: Linear Guideways

## Bridge Mills

- FV-Series Bridge Mills:  
40 Taper /15,000RPM and  
50 Taper /6,000RPM Models

## HBM's

- FBM-Series: Moving Column  
Horizontal Boring Mills



**An ALL NEW Lineup of Machine Tools  
with Unsurpassed Performance and Value!**



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# FEELER by METHODS • PERFORMANCE : VALUE

TURNING CENTERS	HT-SERIES	FTC-SERIES	FT-SERIES
	HT-30MC HT-30Y HT-30SY	FTC-150 FTC-200L	FT-200A FT-250A FT-350L FT-350AL FT-500 FT-500XL
<b>WORKING RANGE</b>			
Swing Over Bed	36.4"	21.7" / 23.6"	17.7" ~ 35.4"
Maximum Turning Diameter	14"	11.8" / 13.8"	12.6" ~ 31.5"
Maximum Turning Length	27.8"	12.2" / 26"	19.7" ~ 118.3"
Bar Capacity	3" (1.7" Sub)	2" / 2.6"	2.6" ~ 6.4"
<b>TRAVEL RANGE</b>			
X-Axis Travel	7" + 3.2"	5.9" + .8" / 6.9" + 1"	6.3" + .4" ~ 15.7" + 1"
Y-Axis Travel (Where Applicable)	3.9" ± 2"	-	-
Z-Axis Travel	31.3"	13.8" / 27.6"	21.3" ~ 122"
<b>TAILSTOCKS</b>			
Quill Diameter	3.1"	2" / 2.8"	3" ~ 6.1"
Quill Inside Taper	MT5	MT-3 / MT-4	MT4 ~ MT6
<b>SPINDLE RANGE</b>			
Spindle Motor (Sub. Where Applicable)	30HP (15HP Sub.)	15HP / 25HP	20HP ~ 50HP
Chuck Diameter (Sub. Where Applicable)	10" (6" Sub.)	6" / 8"	8" ~ 18"
Spindle Speed (Sub. Where Applicable)	3,500 RPM (6,000 RPM Sub.)	6,000 / 4,500 RPM	1,500 ~ 5,000 RPM
Spindle Nose (Sub. Where Applicable)	A2-8 (A2-5 Sub.)	A2-5 / A2-6	A2-5 ~ A2-11
<b>TURRETS</b>			
Number of Tools	12	10 / 12	12
Shank Height for Square Tool	1"	.8" / 1"	.8" ~ 1.3"
Shank Diameter for Boring Bar	1.25"	1" / 1.6"	1.3" ~ 2"
<b>CONTROL</b>			
Fanuc	18i-TB	0i-TD	0i-TD

Specifications subject to change without notice.



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VMC'S HORIZONTAL BORING MILLS BRIDGE MILLS	HV-SERIES VMC'S	VB-SERIES VMC'S	VMP-SERIES VMC'S	FBM-SERIES HBM'S	FV-BRIDGE MILLS
	HV-800 HV-1000	VB-900 VB-1100 VB-1300 VB-1400 VB-1650 VB-1900 VB-2200	VMP-580 VMP-580apc VMP-800 VMP-800apc VMP-1100 VMP-1100S	FBM-110 FBM-110R FBM-130 FBM-130R	FV-2214 FV-2218 FV-3214 FV-3218 FV-3224 FV-4214 FV-4218 FV-4224 FV-4233 FV-4240
<b>TRAVEL RANGE</b>					
X-Axis	31.5" / 39.4"	35.4" ~ 86.6"	22.8" ~ 43.3"	85" ~ 165"	85" ~ 284"
Y-Axis	20.5"	24" ~ 37.8"	16.5" ~ 24"	71" ~ 118"	55" ~ 158"
Z-Axis	19.9"	23.6" ~ 31.5"	19.9" ~ 23.6"	67"	35.4" (47.2" Optional)
<b>TABLE SIZE RANGE</b>					
Table Dimensions	37.4" / 45.3" X 20.5"	45.3" ~ 94.5" X 23.6" ~ 37.8"	16.5" ~ 23.6" X 25.6" ~ 47.2"	79" ~ 158" X 55" ~ 67"	79" ~ 236" X 55" ~ 118"
Maximum Load	1,100 lbs.	2,200 ~ 5,940 lbs.	660 ~ 3,300 lbs.	13,200 ~ 26,400 lbs.	13,000 ~ 52,000 lbs.
Pallet/Rotary Table Dimensions	-	-	580apc: 16.1" x 22.8" 800apc: 19.7" x 27.6"	FBM-110R: 55" x 63" FBM-130R: 79" x 71"	-
Pallet/Rotary Table Maximum Load	-	-	264 lbs. / 440 lbs.	15,400 / 33,000 lbs.	-
<b>SPINDLE RANGE</b>					
Spindle Taper BT40/CAT50 (CAT40/BT50 optional)	40	40/50	40	50	40/50
Spindle Speed	15,000 RPM	6,000 ~ 8,000 RPM	10,000 ~ 15,000 RPM	2,000 ~ 2,500 RPM	15,000 / 6,000 RPM
Spindle Power	30 HP Direct Drive	15HP ~ 30HP	15HP ~ 30HP	35HP	30HP/35HP
<b>FEEDRATE</b>					
X-Axis Rapid	2,362"	591" ~ 1,181"	1,417" ~ 1,890"	472"	394" ~ 590"
Y-Axis Rapid	2,362"	591" ~ 1,181"	1,417" ~ 1,890"	472"	472" ~ 590"
Z-Axis Rapid	1,181"	472" ~ 945"	945" ~ 1,890"	472"	472"
<b>ATC</b>					
Maximum Number of Tools	30 (50 Optional)	30	24 ~ 30	40 (up to 120 Optional)	32 (up to 120 Optional)
Pull Stud	JIS B 6339	JIS B 6339/JIS B 6339-50P	JIS B 6339	JIS B 6339-50P	JIS B 6339/JIS B 6339-50P
Maximum Tool Weight	17.6 lbs.	17.6 ~ 33 lbs.	17.6 lbs.	55 lbs.	17.6 / 39.6 lbs.
Maximum Tool Length	11.8"	11.8"	11.8"	15.7"	11.8" / 13.8"
Maximum Tool Diameter	3.1"	3.1" ~ 5"	3.1"	4.9"	3" / 4.9"
Maximum Tool Dia. - No Adjacent Tool	5.9"	5.9" ~ 7.9"	5.9"	9.8"	5.1" / 7.9"
Tool Changing Time - Tool to Tool	1.9 sec.	1.9 ~ 3.5 sec.	1.9 sec.	15 sec.	8 sec.
<b>CONTROL</b>					
Fanuc	18i-MB	0i-MD	0i-MD	18i-MB(A)	18i-MB(B)/18i-MB(A)

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