

Methods

Methods MV 1100B Performance Machining Center



Designed for productivity and efficiency

Methods Brand 3-Axis Vertical Machining Center are made to Methods design and engineering standards by Litz Hitech Corp., a reputable, well-established, quality machine tool builder and are fully backed by Methods industry-leading technical service and parts support. Methods Machining Centers are affordable, mid-range, best-in-class products providing durability, accuracy and long term reliability.

Key Design Features

Machine structure features
19 precision hand
scraped joints

Powerful 47.6 hp direct
drive hollow shaft spindle
motor w/1000 psi
CTS prep

30 Tool ATC with fast 2.9
sec. Tool-to-Tool time

Chiller cooled spindle
motor plate minimizes
heat migration

Thermal compensation utilizes
(3) thermo-couples for actual
temperature feedback

10,000 rpm Big Plus/CAT50
spindle with oil-air lubrication

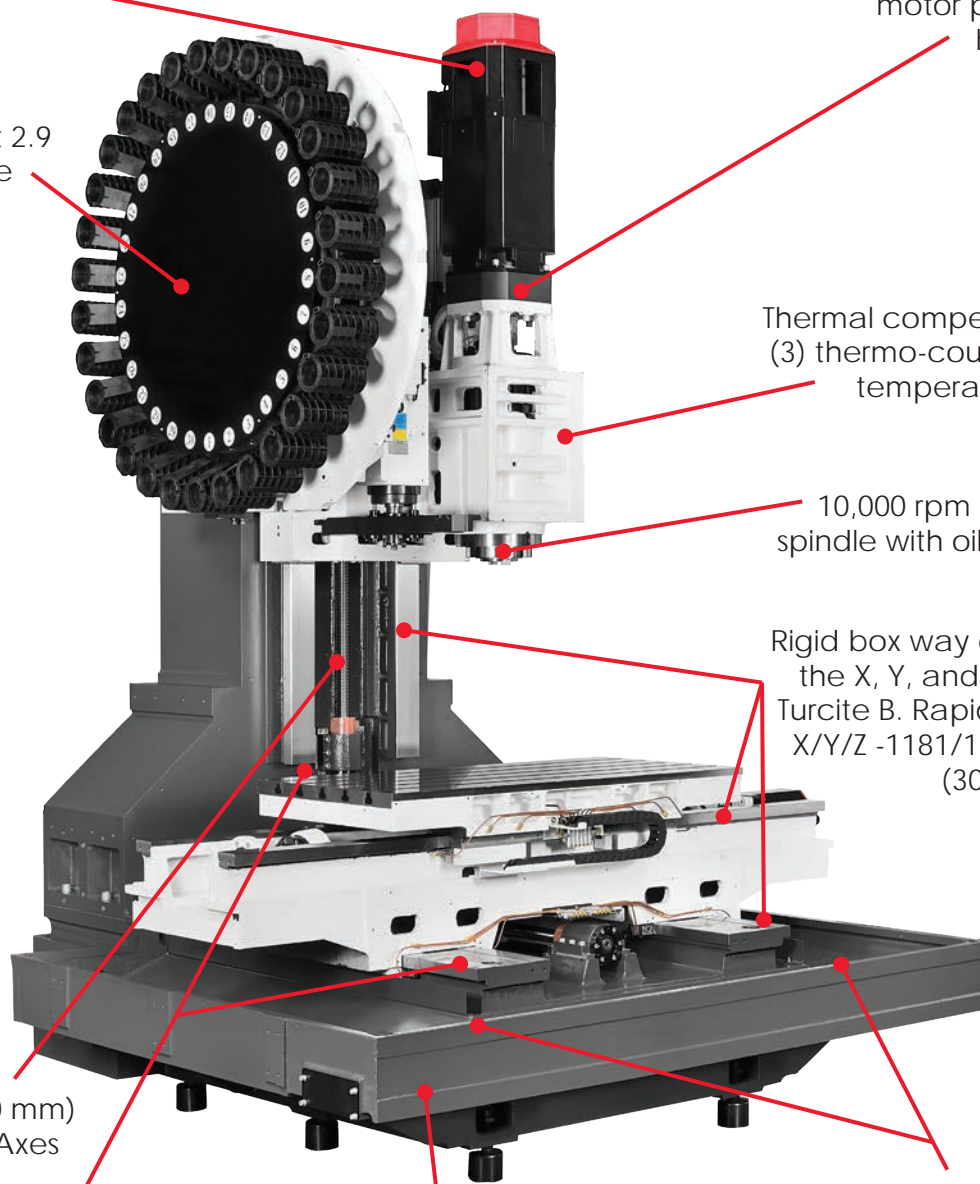
Rigid box way construction in
the X, Y, and Z Axes utilizing
Turcite B. Rapid Traverse rate
X/Y/Z -1181/1181/945 in/min
(30/30/24 m/min)

Fixed pre-tensioned,
double-nut 1.57" (40 mm)
ball-screws in X/Y/Z Axes

Includes dual chip screws,
chip conveyor, coolant
wash down, and coolant
flush gun

Auto oil lubrication
system for all axes

Machine design qualified
using FEA (Finite Element
Analysis) techniques to
provide superior machining
performance. All castings
are MEEHANITE certified



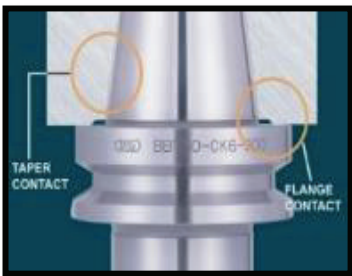


FANUC is the Industry Benchmark for Quality and Reliability. We are not FANUC compatible, we are FANUC. The FANUC 0iMF control with 10.4" LCD screen include Manual Guide i, AICC II, 2.0 ms Block Processing Time (BPT) and 200 Block Look Ahead, Ethernet 100 mbps, USB, RS-232C. This package is well suited for industries such as medical, aerospace, automotive and job shops. The Pendant mounted control can be rotated up to 77 degrees for ease of use. The remote MPG hand-wheel allows for easy workpiece set-up.



10,000 rpm Big Plus/CAT50 Taper Spindle with oil-air lubrication and spindle chiller provides power, speed, stiffness, required for the most adverse machining applications while providing long spindle life, thermal stability and overall machining accuracy.

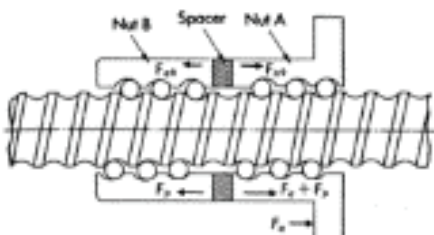
Powerful Direct Drive 47.6 hp (15 min), Hollow Shaft Spindle Motor allows machining of tough-to-machine materials with fine surface finishes and the ability to add Coolant Through Spindle (CTS) easily. A standard spindle chiller and cooled spindle-motor-plate minimizes heat migration from the spindle motor and spindle, to the headframe for added thermal stability.



BIG-PLUS Dual Contact Spindle provides a stiffer interface between both the spindle surface and tool holder flange surface, & spindle taper and tool holder taper. This design provides higher rigidity, stiffness, longer tool life, and improved accuracy when performing high-speed and difficult to machine applications when compared to traditional 50 Taper Tooling. Tool retention force is a superior 3,968 lbf (1800 kgf).



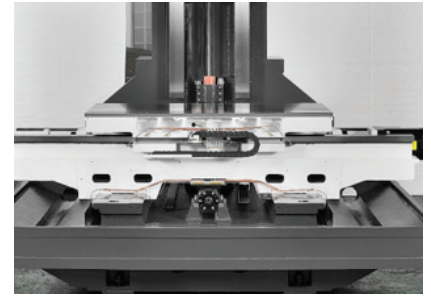
CAM Type Automatic Tool Changer provides fast, reliable 2.9 sec. Tool-to-Tool Time and includes both Heavy Tool & Big Tool Functions. This designed incorporates an inverter type cam-box-motor for easy ATC recovery in the event of a mishap. ATC capacity is 30 Tools on the MV 1100B. Brushes mounted near the ATC opening minimize chip contamination in the tool storage area.



Fixed, Pre-Tensioned 1.57" (40 mm) Double-Nut Ball-Screws are featured in the X, Y & Z Axes. This design minimizes thermal growth, enhances rigidity, stability, and precision of the machine. The X & Y-Axis feature an impressive 1,181 ipm (30 m/min) rapid rate reducing non-cutting time.

Features & Benefits

Heavy Duty ALL Box-Way Construction in the X, Y, & Z-Axes Utilizing Turcite B. Turcite B was specifically developed for the Machine Tool Industry providing superior rigidity, low friction coefficient, reduced vibration, and superior damping characteristics without stick-slip. This design ensures both cutting performance and machining accuracy. In addition Turcite B also has a very high wear resistance extending the life of the product. Castings are all MEEHANITE certificated.



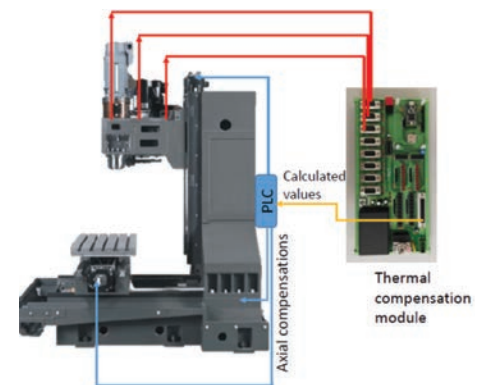
Larger Robust Frame is an impressive 19,642 lbs. (9,000 kg) providing superior stiffness, rigidity and cutting capability. Featuring 43.3" (1,100 mm) of X-Axis travel, 24" (610 mm) of Y-Axis travel, and 23.6" (600 mm) of Z-Axis travel allowing for longer tools, longer/taller parts and/or 4th axis applications. The MV 1100B is an impressive 3,218 lbs (1,550 kgs) heavier than the MV 1100H.



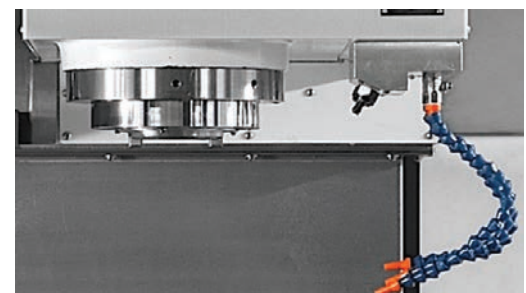
Machine Structure Features 19 Precision Hand Scraped Joints for increased structural rigidity, maximum stiffness, and optimum cutting performance. Proper hand scraping techniques improve the overall machine geometry, and minimizes the amount of electronic compensation required on the machine. For example, ball-screw bearing housings can be aligned to closer tolerances, improving all axes laser interferometry results and minimizing required electronic compensation. Proper scraping improves all axes straightness squareness and tram, also limiting the effects of roll, pitch and yaw.



Thermal compensation utilizes (3) Thermo-Couples for actual temperature feedback. This feedback then allows the proprietary software to accurately compensate for thermal growth, greatly minimizing the impact of overall thermal movement. Thermal compensation combined with spindle chiller, chilled motor plate, oil-air lubrication, and fixed, pre-tensioned double-nut ball-screws provide a thermally stable machine.



Efficient Chip and Coolant Management featuring Spindle Coolant Ring (4-ports on the spindle face) Spindle Flushing (3-adjustable ports right side of spindle) Spindle Air Blast (2-lock lines right side of spindle) Coolant Wash Down System (base chip wash-down), Coolant Wash-down Gun, Dual Chip Screws, and Hinge Type Chip Conveyor with 41.34" (1050 mm) drop height provides efficient chip and coolant evacuation and management.



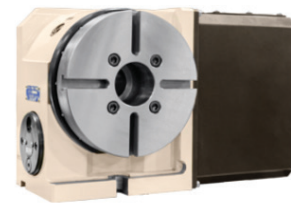
Standard Features

- Fanuc 0i-MF Control, 10.4" LCD, MGI, AICC II, 2.0ms BPT, 200 block look ahead, Ethernet 100 mbps, PCMCIA, USB, RS232C
- 10,000 rpm, Oil-Air Lubricated Spindle
- Big Plus/CAT50 Taper
- aillT22 Direct Drive, 47.6 hp (15 min), Hollow Shaft Spindle Motor
- Spindle Chiller, Motor Plate Cooling, Spindle Air Dryer, and Thermal Compensation
- 30 Tool Drum Type, Dual Swing Arm ATC w/2.9 sec. Tool-to-Tool time
- 1280 meters of memory (512 K), Custom macro B, 400 tool offsets, Helical Interpolation, Rigid tapping, Auto power off
- Remote manual pulse generator (MPG) hand-wheel
- Extra set of 8 M-Code functions (4 on, 4 off)
- Chain/Hinge Chip Conveyor 41.3" (1050 mm) Drop-off Ht. Speed - 55 ipm (1400 mm/min)
- Dual chip augers
- Prepped for 1000 psi (70 bar) coolant through spindle (does not include pump)
- Pre-wired for 4th axis (does not include drives, or motors)
- Fixed pre-tensioned 1.57" (40 mm) double-nut ball-screws in the X/Y/Z-Axes
- X/Y/Z Travel at 43.3" x 24" x 23.6" (1100 mm x 610 mm x 600 mm)
- X/Y/Z-Axes Box Ways with Turcite B
- X/Y/Z Rapid Travel at 1181/1181/945 in/min (30/30/24 m/min)
- Automatic oil lubrication system with gravity waste-oil recovery tank
- Fully enclosed splash guard
- Dust-proof electrical cabinet with Heat Exchanger
- Coolant System includes Spindle coolant nozzles (3), Spindle coolant ring nozzles (4), Spindle air blast nozzles (2), Coolant chip flush wash down, and Coolant flush gun
- Bright interior work lights
- 3-color signal light
- Air gun
- Tool kit
- Methods Safety Spec (CE Mark Modified)
- Machine Operating Manual & Control Manual (CD)
- 2-Year Machine and Control Warranty



Options

- Heidenhain Linear Scales in X/Y/Z Axes*
- Tool and Part Probe Measurement
- High Pressure Coolant Through Spindle (up to 1000psi)
- MIDACO Pallet Changers
- 4th Axis Rotary Tables
- CT to BT Arm
- Oil/Coolant Separator
- Filter Mist Collector
- Electrical Cabinet Air Conditioner*
- Transformer

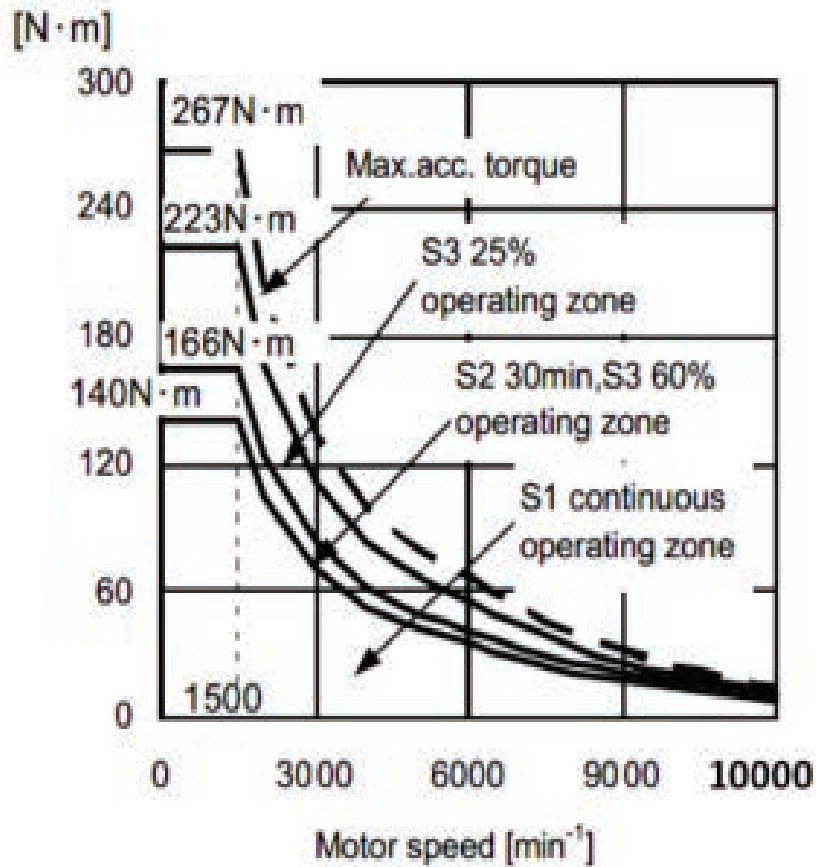
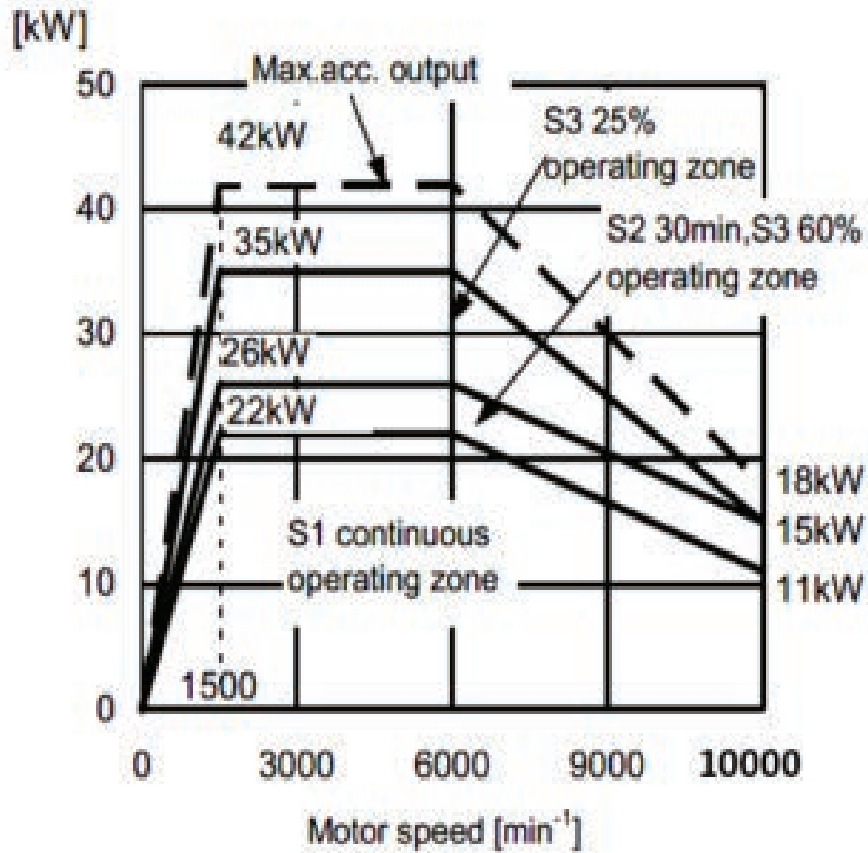


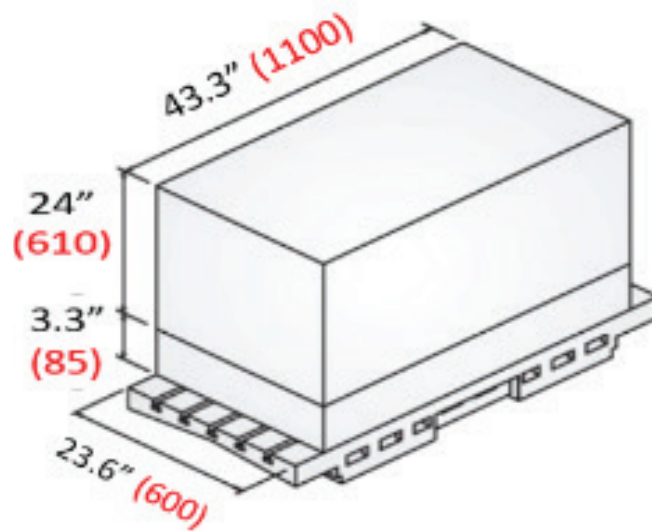
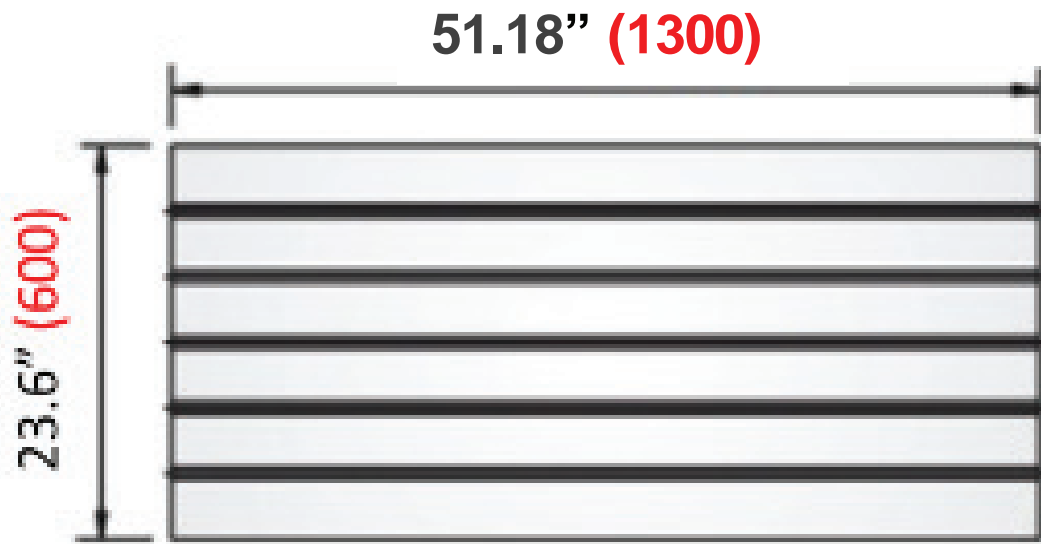
Specifications

FEATURES	UNIT	MV 1100B
X/Y-Axis Box Ways		
X/Y-Axis Travel	in (mm)	X - 43.30 (1100) Y - 24.02 (610)
X-Axis Rapid Traverse	in/min (m/min)	1,181 (30)
X/Y-Axis Max Cutting Speed	in/min (m/min)	591 (15)
X-Axis Distance Between Box Ways	in (mm)	17.8 (452)
Y-Axis Distance Between Box Ways	in (mm)	45.7 (1,060)
X/Y-Axis Encoder Resolutions	-	4 million pulse
X/Y-Axis Motor	FANUC	a22i
X/Y-Axis Power	hp (kw)	5.4 (4)
X/Y-Axis Ball Screw Class	-	C3
X/Y-Axis Ball Screw Diameter	in (mm)	1.57 (40)
Z-Axis Box Ways		
Z-Axis Travel	in (mm)	23.6 (600)
Z-Axis Rapid Traverse	in/min (m/min)	945 (24)
Z-Axis Max Cutting Speed	in/min (m/min)	591 (15)
Z-Axis Distance Between Box Ways	in (mm)	19.29 (490)
Z-Axis Encoder Resolution	-	4 million pulse
Z-Axis Motor	FANUC	a22Bi
Z-Axis Power	hp (kw)	5.4 (4)
Z-Axis Ball Screw Class	-	C3
Z-Axis Ball Screw Diameter	in (mm)	1.57 (40)
X/Y/Z Axes Lubrication	-	Auto Oil
Spindle		
Spindle Speed	rpm	10,000
Spindle Type	Dual Contact	BIG-PLUS CAT 50 Taper
Spindle Power	hp (kW) Cont. hp (kW) 30 min hp (kW) 15 min	30 (22) 35 (26) 47.6 (35)
Spindle Torque	ft-lb (nm) Cont. ft-lb (nm) 30 min ft-lb (nm) 15 min	103 (140) 122.4 (166) 164 (223)
Spindle Base Speed	rpm	1,500
Spindle Lube	-	Oil / Air
Spindle Cooling	-	Chiller
Spindle Bearings	-	90 mm Ceramic Angular (4)
Specifications subject to change without notice		

FEATURES	UNIT	MV 1100B
Automatic Tool Changer (Random/Bi-Directional)		
Tool Changer for Big Plus/CAT50 Tool Holders	-	Dual Swing Arm Type
Maximum Number of Tools	-	30
Pull Stud	-	DIN CAT50 A Type
Maximum Tool Weight	lbs (kg)	33 (15)
Maximum Tool Length	in (mm)	12 (305)
Maximum Tool Diameter	in (mm)	4.7 (120)
Maximum Tool Diameter - No Adjacent Tool	in (mm)	5.9 (150)
Tool Changing Time - Tool-to-Tool	sec	2.9
Tool Holder	-	Big Plus / CAT50
Tool Clamp Force with CTS	lbf (kgf)	3,307 lbf +/- 220 lbf (1,500 kgf +/- 100 kgf)
Tool Clamp Force without CTS	lbf (kgf)	3,968 lbf +/- 220 lbf (1,800 kgf +/- 100 kgf)
Accuracies (ISO 230-2) without scale		
X/Y/Z Axes Positioning Accuracy	in (µm)	.00059 (15)
X/Y/Z Axes Repeatability Accuracy	in (µm)	.00027 (7)
Table		
Table Dimensions	in (mm)	51.2 x 23.6 (1,300 x 600)
Spindle Nose to Table Surface	in (mm)	4.9 ~ 28.5 (125 ~ 725)
Spindle Center to Column Surface	in (mm)	25.98 (660)
T-Slot Width	in (mm)	.708 (18)
Number Of T-Slots	qty	5
Distance between T-Slots	in (mm)	3.937 (100)
Maximum Load	lbs (kg)	2,205 (1,000)
Table Surface to Floor	in (mm)	38.7 (983)
Dimensions / Weight / Capacities / Power		
Floor Space with Chip Conveyor	in (mm)	174.5 x 104 (4,431 x 2,643)
Machine Weight	lbs. (kg)	19,642 (9000)
Maximum Machine Height	in (mm)	128 (3,253.5)
Coolant Tank Capacity	gal (l)	109.9 (416)
Coolant Motor (60 hz)	hp (kw)	.74 (.55)
Coolant Flow (Nozzle)	gpm (l/m)	29 (110)
Coolant Pressure (Nozzle)	psi (kg/cm ²)	24.2 (1.7)
Machine Power Capacity	kva / amp	25 / 100
Machine Voltage & Phase	volts / phase	220 / 3
Specifications subject to change without notice		

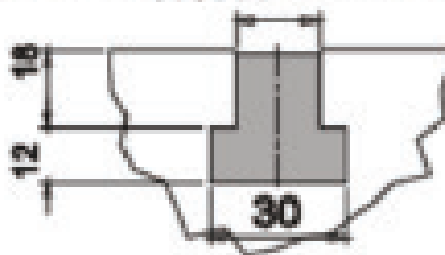
Spindle Power & Torque Diagram





Dim. shown in mm

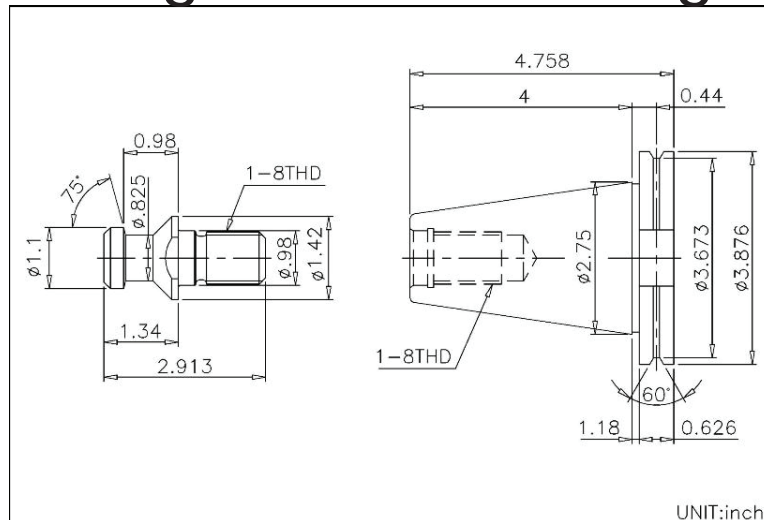
18 H7($\begin{smallmatrix} +0.018 \\ +0.000 \end{smallmatrix}$) / H11($\begin{smallmatrix} +0.110 \\ +0.000 \end{smallmatrix}$)



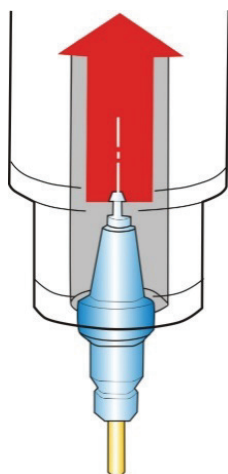
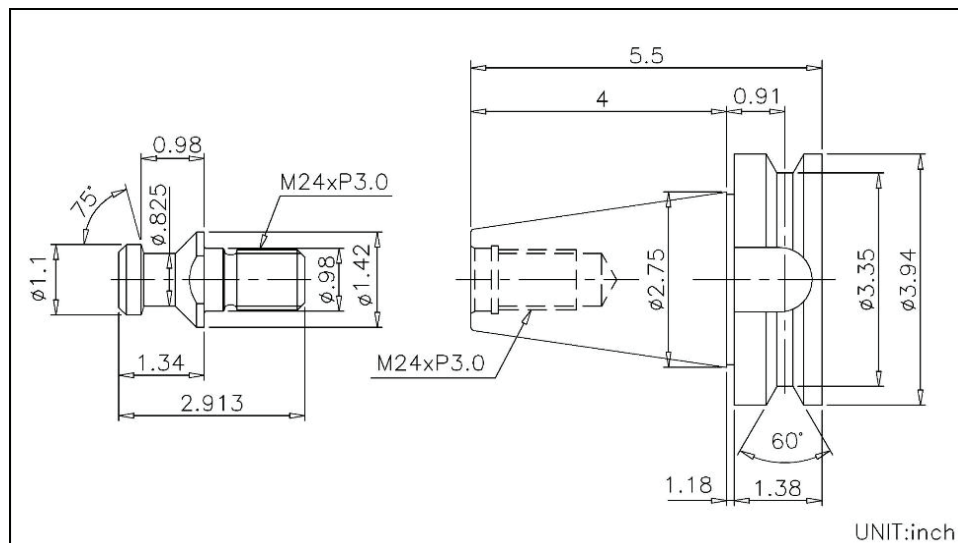
Tooling Diagram

Dim. shown in mm

Big Plus CAT50 Tooling



Big Plus BBT50 Tooling



Tool Clamp Force With CTS

3,307 lbf +/- 220 lbf
(1,500 kgf +/- 100 kgf)

Tool Clamp Force Without CTS

3,968 lbf +/- 220 lbf
(1,800 kgf +/- 100 kgf)

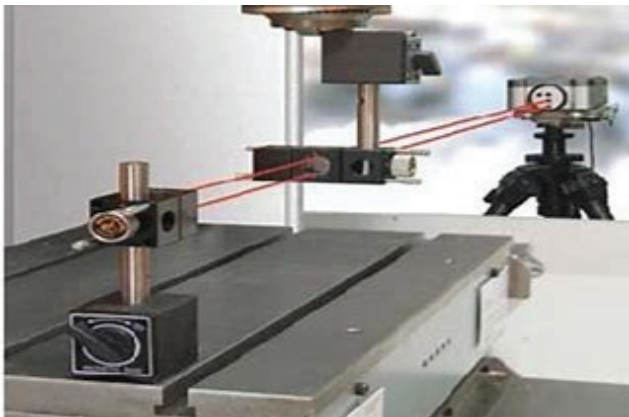
In Compliance with Quality Assurance Procedures and Standards

- Strict quality standards require that all manufacturing and inspection equipment is calibrated, monitored and controlled using recognized and traceable systems and methods

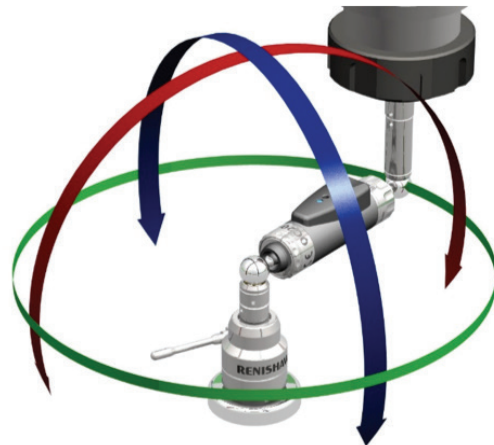
All MV 1100B Machines are fully Lasered and Ballbared

- Laser interferometer and Ballbar measurement systems assess, monitors and can help to improve the static and dynamic performance of the machine
- Ballbar testing provides an important, rapid check of a CNC machine tools positioning performance accuracy as it relates to circularity and circular deviation positioning accuracy. This test is recognized by international standards such as ISO 230-4 and ANSI/ASME B5.54

Laser Interferometer



Ballbar



METHODS MACHINE ACCURACY - WITHOUT SCALE

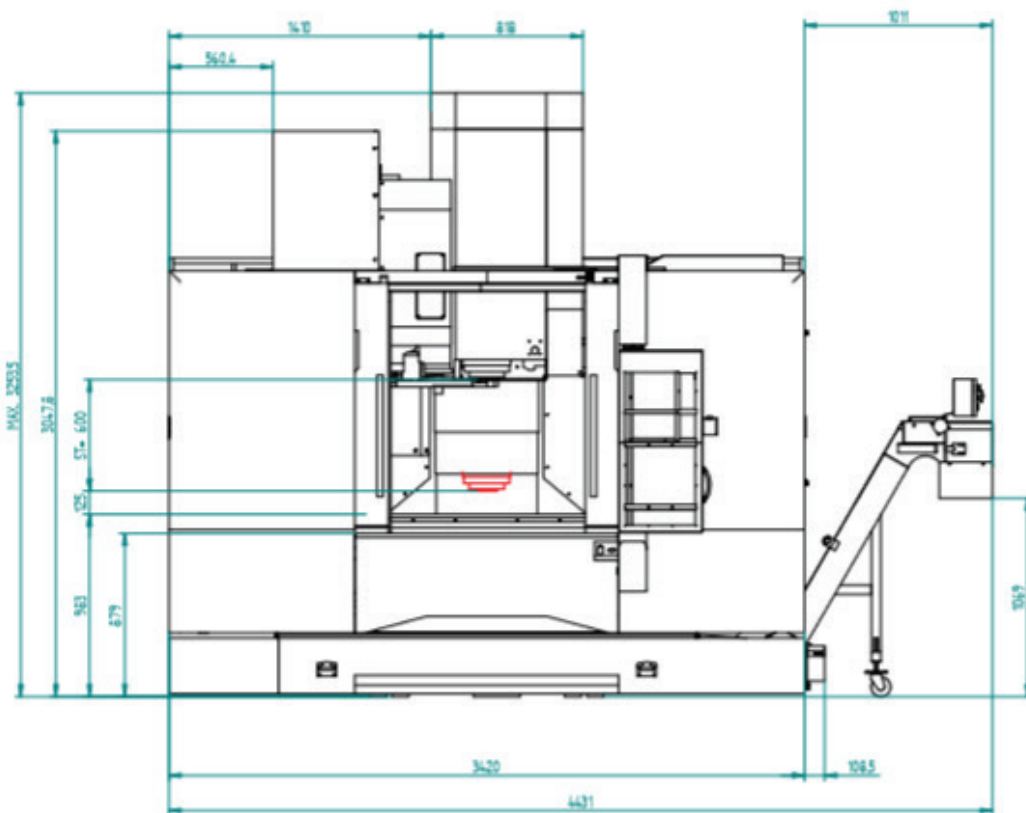
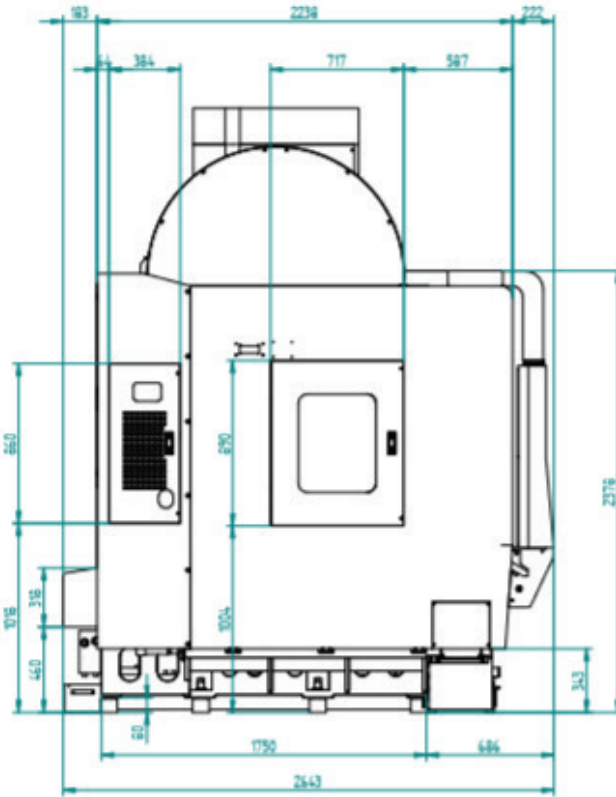
Models	MV 1100B (Box Way Z, Linear Roller X/Y)		
Standards	VDI 3441	ISO 1079-4	JIS B66338
		ISO 230-2	
X/Y/Z Axes Positioning Accuracy	.00059" (15 μm)	.00059" (15 μm)	.00022" / 11.81" (5.5 μm / 300 mm)
X/Y/Z Axes Repeatability Accuracy	.00027" (7 μm)	.00027" (7 μm)	± .00014" ± (3.5 μm)

FANUC Control Specifications

- 10.4" LCD color display
- AICC 200 Block look ahead
- Controlled axes 4 & 4+1
- 2.0 ms Block processing time
- 1280 meters of memory
- 400 tool offsets
- 3 Simultaneously controlled axes
- HRV 3 control
- Inch / metric conversion
- Machine lock
- Mirror image
- Rigid tapping
- Single direction position
- Exact stop mode
- Tapping mode
- Cutting mode
- Dwell
- Linear interpolation
- Circular interpolation
- Helical interpolation
- Skip function
- High speed skip function
- Reference point return
- Feed per minute
- 2nd reference point return
- Feed rate override
- Jog override
- Program Number search
- Sequence Number search
- Dry run
- Jog feed
- Manual reference return
- Optional block skip
- Program number
- Sequence number
- Absolute/incremental programming
- Plane selection
- Automatic coordinate setting
- Coordinate setting
- Custom macro B
- Programmable data input
- Circular interpolation by program
- Automatic corner deceleration
- Scaling
- Coordinate system rotation
- Canned cycles for drilling
- Tool compensation pairs
- Tool offset memory C
- Tool length compensation
- Cutter compensation C
- Tool life management
- Backlash compensation rapid traverse
- Stored pitch error compensation
- Tool length measurement
- Ethernet 100 mbps, USB, PCMCIA, RS232C
- Current position display
- Program display
- Self-diagnosis function
- Parameter setting display
- Run hour/part count display
- Actual cutting feed rate display
- Operator monitor screen
- Spindle setting screen
- Spindle information screen
- Machine alarm diagnosis
- Alarm history display
- Operator history display
- Graphic function
- Memory card interface
- Additional custom macro variables
- Sub program call
- Extended part program editing
- Additional workpiece coordinate
- Manual Guide i
- Manual absolute on and off
- Auto power off

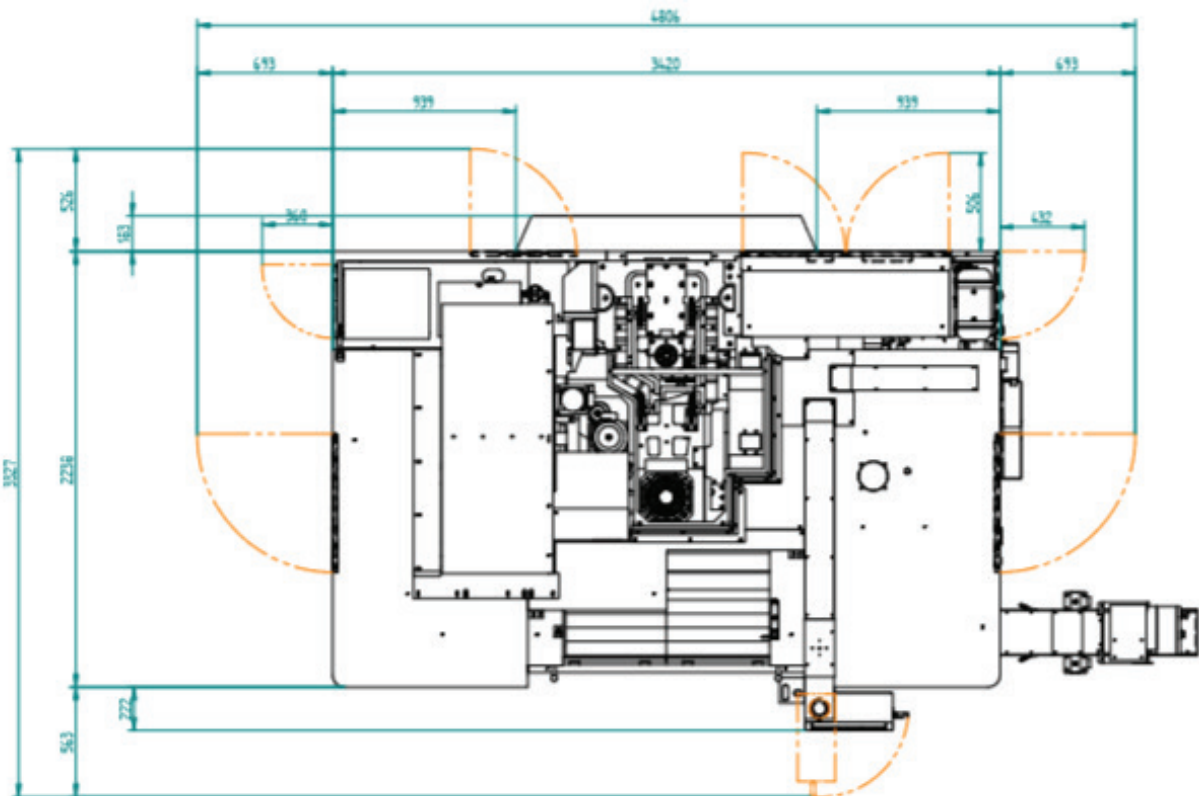
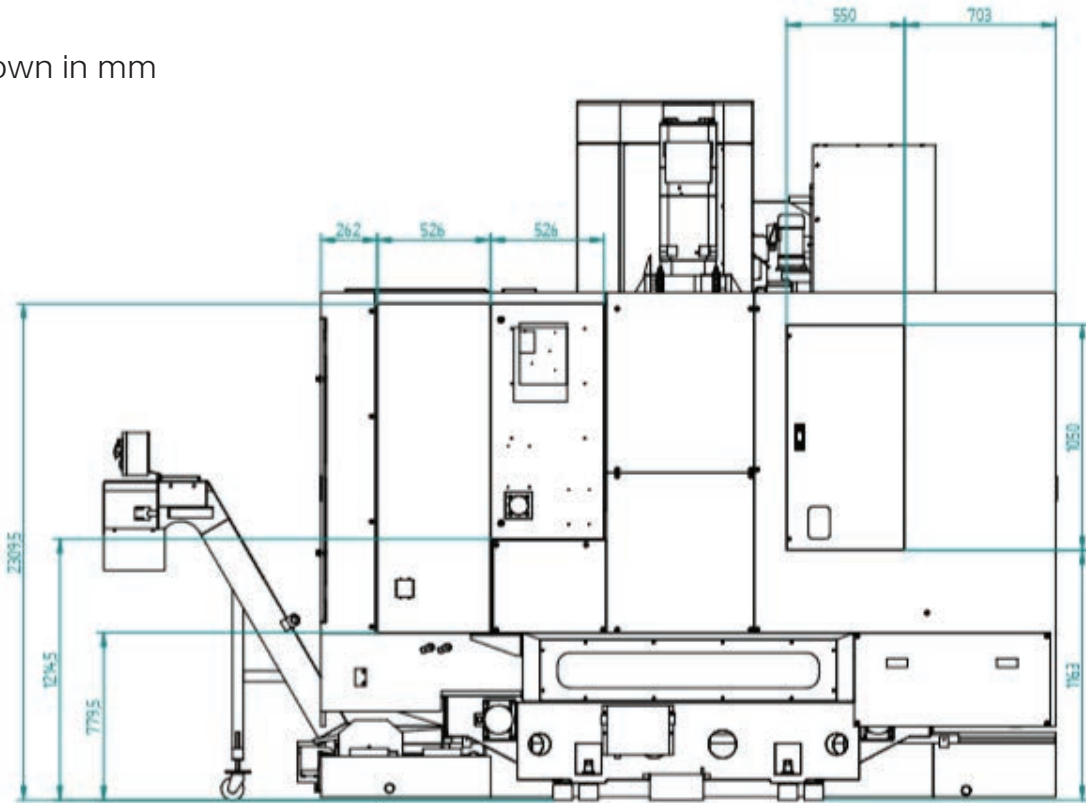
MV 1100B Dimensional Drawings

Dim. shown in mm



MV 1100B Dimensional Drawings

Dim. shown in mm



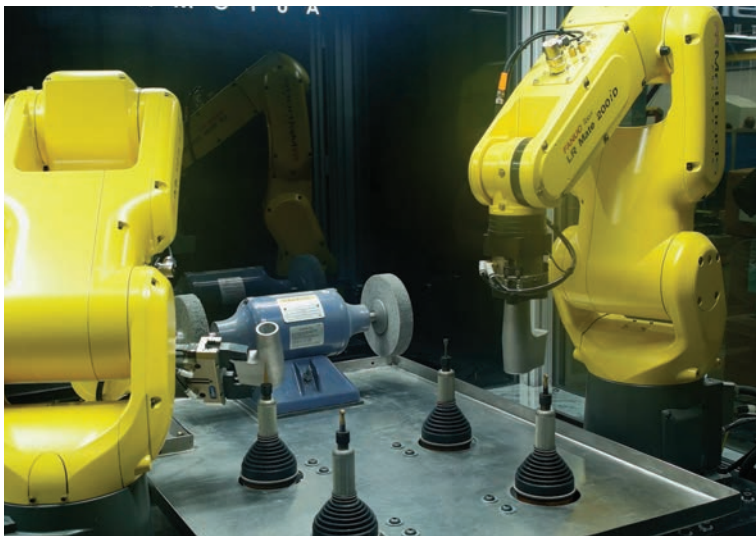
Parts

Methods is a one stop supplier with the expertise and inventory to keep business running 24/7. The parts distribution center is 16,000 square feet and has a dedicated team of employees for parts and tooling across the United States. The company has one of the largest parts inventories in North America and maintains \$35 million within their spare parts department.



Service

To make sure every problem finds a quick solution, Methods has developed an 'umbrella' of support services. Methods sales and support centers work with an extensive national network of distributors and EDM dealers to offer the technology solutions demanded by machine shop owners. The unique blend of seasoned engineers and young talent and a 15 year average level of experience guarantees the service department's high level of customer satisfaction.



Automation

Automated processing offers the highest potential for increased productivity. Methods automation department has automation engineers nationwide and provides highly innovative machine tool automation solutions. Methods automation group includes design engineers, control engineers, fluid engineers, integration/assembly engineers, field service/installation engineers, electrical/mechanical engineers and machinists.

METHODS

MACHINE TOOLS



Achieve More with Methods

Founded in 1958, with three employees and a few refurbished machines, Methods Machine Tools, Inc. has grown into one of the largest, most innovative precision machine tools importers in North America. With over 300 employees, eight sales and technology centers, and over 40,000 machines installed throughout the United States, Canada and Mexico, Methods supplies leading-edge precision machine tools and solutions. The founder Mr. Clement McIver, Sr., established principles from the company's beginning that continue to set Methods apart from conventional importers or distributors. "Anyone can sell a machine," said the company's late founder, "but not everyone provides the extra effort that makes a difference in the company's bottom line."