

Vertical Machining Centers

VECTOR 1400 M SI

SKU : 181427

The Vector 1300/1400 series is the perfect solution for machining very large and heavy workpieces. The innovative design of the machine base made of high-quality Meehanite casting with a low center of gravity, and the use of only the highest quality components guarantee the consistently high precision even in multi-shift production. Thanks to a wide range of accessories, the machining centers become a tailor-made complete solution for specific applications. KNUTH also offer automation solutions for this series, with which you can increase your productivity even more.

- Available with Siemens or Heidenhain controller
- Spindle on multiple bearings ensures minimal vibrations
- 30-bar CTS to ensure optimum machining quality
- Designed for multi-shift operation
- Many customization and automation possibilities
- 2-year standard warranty



TECHNICAL SPECS

WORKING AREA

Table dimensions	59 in x 28 in
Table load capacity	3300 lbs
Workpiece weight (max.)	3300 lbs
Spindle nose-to-table surface distance	6 in - 33 in
Number of T-slots	6 positions
T-slot (width x spacing)	0.71 in x 3.94 in

TRAVELS

Travel X-axis	55.1 in
Travel Y-axis	28 in
Travel Z-axis	28 in

HEADSTOCK

Spindle speed	10000 rpm
Spindle mount	SK 40 ISO 7388-1 (DIN 69871)

RAPID FEED

X-axis rapid feed	78.48 fpm
Y-axis rapid feed	78.48 fpm
Z-axis rapid feed	78.48 fpm

FEED

Work feed X-axis	0.004 in/min - 0.394 in/min
Work feed Y-axis	0.004 in/min - 0.394 in/min
Work feed Z-axis	0.004 in/min - 0.394 in/min

TOOL HEAD

Number of tool stations	24 positions
Tool size Ø x L (max.)	3.15 in x 11.81 in
Tool-changing time chip/chip	3.9 sec
Tool-change time tool/tool	1.8 sec

ACCURACIES

Positioning accuracies	± 0005/ 0,0002" in
Repeatabilities	± 0003 / ± 0,00012" in

DRIVE CAPACITY

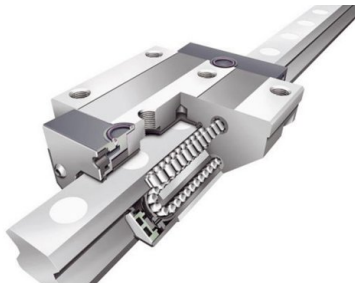
Main drive, continuous load	22.8 Hp
Motor rating X-axis	7.4 Hp
Motor rating Y-axis	7.4 Hp
Motor rating Z-axis	7.38 Hp

CONTROL

Control	Siemens
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MEASURES AND WEIGHTS

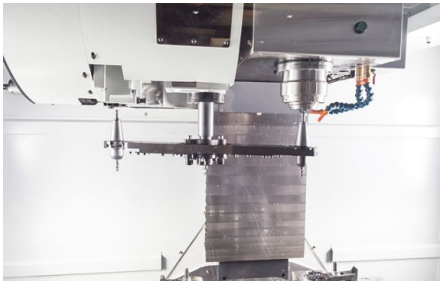
Weight	20900 lbs
Overall dimensions (length x width x height)	150 in x 103 in x 130 in



Linear-roller guides for super quiet operation



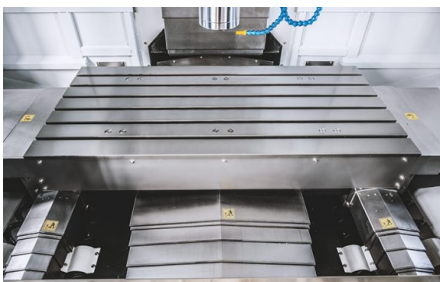
Siemens Sinumerik 828D with ShopMill



Tool changer with double-arm and BT40 spindle



Wide opening front doors



Additional guides for even more load capacity and increased stability

PRODUCT DETAILS

- The large VECTOR Series is perfectly equipped for large jobs and can be ordered with customized accessories to provide flexible solutions for constantly expanding requirements

Machine Design

- The extra-wide column base and large guide distances ensure the necessary rigidity for fast machining processes requiring high precision
- During the development of this series, modern FEM analysis tools were used for the simulation of countless load conditions in order to guarantee superior stability of the machine frame in real-world applications, which now exceeds all expectations for this class of machines
- All axes move on premium, fully enclosed linear roller guideways and precision ball screws and are driven by dynamic servo-motors

Extra-rigidity at all the right places

- The VECTOR features larger guideways that are equipped with additional guide carriages for even higher load capacities, more rigidity and higher speeds during heavy-duty machining operations
- Preloaded ball screws with larger and additional bearings ensure superior efficiency and longer life

Spindle

- Main spindle runs on multiple bearings to ensure excellent absorption and dissipation of forces during machining
- The advanced design of our spindles ensure low heat accumulation under load
- Large preloaded bearings ensure radial stability during heavy-duty machining operations
- High-temperature lubricants ensure optimum lubrication at any operating temperature and a long tool life
- Clamping the tool between contact surfaces at the taper and workpiece flange ensures maximum hold of the tool in the spindle

Tool Changer

- The VECTOR is equipped with the best tool changer to allow full utilization of the machining center's capacity
- With only 1.8 seconds tool changing time, the dual-arm gripper also is one of the fastest tool changers on the market

Handling

- The totally enclosed workspace features a large door and side doors for easy access, safety and cleanliness
- Electrical equipment is divided into separate control cabinets for high and low voltage systems, which results in a significant reduction of heat accumulation and noise
- An electronic hand-wheel simplifies machine set-up
- The automatic central lubrication system ensures proper lubrication of all lube points

CONTROLS & SOFTWARE

Siemens 828D control with Shopmill

SINUMERIK 828 D – The workhorse in the compact class of CNCs

Highlights

- Compact, robust, maintenance-free control panel-based CNC
- Comfortable program and parameter input via QWERTY keyboard
- Maximum machining precision
- Intelligent kinematic transformations for machining of cylindrical parts, and for angled workpiece levels
- SINUMERIK MDynamics with the new Advanced Surface feature: for perfect part surfaces and shortest machining times in mold making applications
- ShopMill: shortest programming time for single parts and small batch productions
- ProgramGUIDE: fastest machining time and maximum flexibility for large series productions
- Unique spectrum of technology cycles - from milling contours with residual material recognition to process measurements
- Animated Elements: unique operation and programming assistance with animated sequences
- Modern data transfer options via USB stick, CF card and network (Ethernet)
- Easy Message: maximum machine availability due to process monitoring per texting (SMS)

CNC hardware

- Control-panel based high-performance CNC Control
- Robust front control panel made of magnesium die-casting
- Integrated full-size QWERTY keyboard
- Maintenance-free design (no buffer battery required)

CNC performance data and functions

- SINUMERIK MDynamics package with Advanced Surface for mold making applications
- Dynamic feed-forward control
- 4-axis simultaneous interpolation (X, Y, Z and rotary axis)
- Linear, circular and helical interpolation
- Tapping without compensating chuck, plus thread cutting
- Oriented spindle holder
- Toggle between inch and metric units
- FRAME concept for individual coordinate transformations, rotations, scaling and mirroring
- 100 adjustable zero offsets
- Synchronous actions and quick help function output

CNC technology cycles

- Technology cycles for programGUIDE and ShopMill work step programming are available
- Large selection of drilling cycles
- Large selection of milling cycles for standard geometry
- Large selection of position patterns for drilling and milling operations
- High-speed settings for mold making applications
- Geometry calculator for free contour input
- Machining cycle for contour pockets / contour spigots with isolated contours

Graphic features

- Animated Elements: input help for machining parameters with animated sequences
- Graphical online help system, similar to PC system
- Graphical CNC simulation with level display

CNC tool management

- Display of tool and magazine data on one screen
- Tool management with plain-text tool names
- Loading/unloading feature for easy magazine assignment
- Tool management with tool life monitoring
- 10.4" TFT color monitor
- Jerk-limited acceleration

STANDARD EQUIPMENT

Siemens 828D control with Shopmill
Coolant flow through spindle, 30 bar with double filter
24-station tool changer with dual-arm

ST 40 mount
 Spindle oil cooler
 Chain-type conveyor with chip container
 Electronic hand-wheel
 Oil skimmer
 Automatic central lubrication
 Coolant gun
 Chip flushing system
 Heat exchanger for electric control cabinet
 Telescoping axis cover
 Prepared for Renishaw TS 27
 USB port
 CF card reader
 Totally enclosed work space
 Work lamp
 3-color signal lamp
 Coolant system
 Adjustable machine feet
 Operating tools
 Operator instructions

OPTIONAL EQUIPMENT

- Renishaw OMP 40 workpiece measuring, SKU : 252820
- Connection for 4th axis (wiring only and axis chart), SKU : 253019
- Siemens Function: P25: 3D Simulation, SKU : 253378
- Siemens Function: P13: Residual Material Detection, SKU : 253379
- Siemens Function: P22: Simultaneous Recording, SKU : 253380
- Renishaw TS27R tool measuring system, SKU : 253386
- Siemens measuring cycles, SKU : 253438
- Renishaw OTS wireless tool setter (OTS), SKU : 253598
- Ø210mm 4th axis (4th axis, servo motor, driver, air brakes)(Si), SKU : 253606
- Ø250mm 4th axis (4th axis, servo motor, driver, air brakes)(Si), SKU : 253607
- Prepared for Renishaw OMP40, SKU : 253613
- Manual tailstock ST-210T for rotary table, SKU : 253619
- Manual chuck, 8", for rotary table, SKU : 253623
- Upgrade from 10.4" to 15" Touchscreen (Si) for Vector, SKU : 253674
- Renishaw OMP 60 workpiece measuring system (BT40), SKU : 253681
- 7.87" diam. 4th & 5th axis for Vector 650/850/1000 (Si), SKU : 253682
- Spindle speed upgrade to 12000 rpm, belt-type, SKU : 253781
- Top cover for Vector 1300-1600, SKU : 253783
- Upgrade from 828D PPU260 to 840DSL IPC447E 10.4" for Vector, SKU : 253835