

M218, M320, M422W, M526, M632, M218, M320, M422W, M526, M632, M218, M320

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TRUMP MACHINING CENTER

ATRUMP MACHINERY INC.



M218



M320



M422W

INTRODUCTION

ATRUMP'S "M" SERIES MACHINING CENTERS ARE DESIGNED AND BUILT TO DELIVER HIGH MATERIAL REMOVAL RATES, INCREASE POSITIONING ACCURACY AND REPEATABILITY AND PRODUCE THE MAXIMUM MILL PERFORMANCE FOR TODAY'S MOST POPULAR MILLING APPLICATIONS.

THEY ALL FEATURE HEAVY, MASSIVE CAST-IRON, HARDENED AND GROUND BOX WAYS WITH TURCITE COATING. ONE PIECE 4 BOX WAYS DESIGN AND REINFORCED RIBS CONSTRUCTION FOR THE MACHINE'S RIGIDITY AND STABILITY TO REDUCE CUTTING VIBRATION AND SUPPORT MACHINE LONG-TERM OPERATION.

FEATURES

- * POWERFUL CENTROID M-400 CONTROL (MADE IN U.S.A) OR FANUC OI-MB CONTROL. (MADE IN JAPAN)
- * RIGID MEEHANITE CAST-IRON WITH REINFORCED RIB CONSTRUCTION.
- * ALL CASTINGS ARE HEAT TREATED AND ACCURATELY ANNEALED TO RELIEVE STRESS AND STABILIZE MOLECULAR CONFIGURATIONS.
- * HARDENED AND GROUNDED WAYS WITH TURCITE COATING.
- * ONE-PIECE BED DESIGN WITH 4 BOX WAYS.
- * EXTRA LONG X, Y AND Z-AXES TRAVELS.
- * PRECISION TOUGH STEEL ALLOY SPINDLE WITH 3 SETS (6 PCS.) ABEC-CLASS 7 (P4) BEARING WITH SPINDLE OIL CHILLER TO MINIMIZE THERMAL EXPANSION. THIS INSURES SPINDLE RUNOUT LESS THAN 0.0001"
- * AUTOMATIC TOOL CHANGER UMBRELLA OR ARM TYPE. (OPTIONAL)
- * 8,000 RPM SPINDLE (STANDARD) 12,000 RPM SPINDLE. (OPTIONAL)



M526

TURNING CENTER MACHINING CENTER



M526



M632



M320
■ COLUMN



■ INSIDE CASTING
CONSTRUCTION (RIBS) M218



M320
■ SADDLE

THE MASSIVE CAST-IRON WITH ENFORCE RIBS DESIGN TO MINIMIZE CUTTING VIBRATION
AND ENSURE MACHINE'S ACCURACY AND RELIABILITY.

CNC MACHINING

CNC MACHINING

SPINDLE ▶

THE SPINDLES ARE DROP FORGED FROM TOUGH STEEL ALLOY AND PRECISION MACHINED GROUND THEN EQUIPPED WITH 3 SETS (6 PCS.) ABEC-CLASS 7 BEARINGS. THIS INSURES THE SPINDLE RUNOUT LESS THAN 0.0001".



BED ▶

M320

ONE-PIECE BED WITH 4-BOX HARDENED AND GROUNDED WAYS TO SUPPORT THE MACHINE'S STABILITY OF LONG-TERM OPERATION.



BALLSCREW ▶

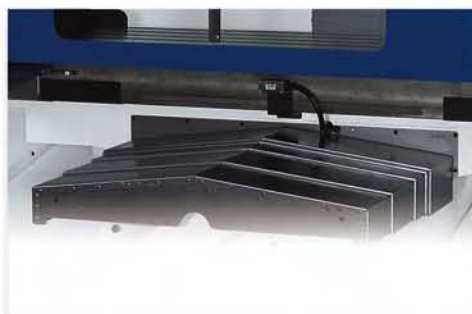
M320

PRE-TENSION PRECISION HARDENED AND GROUND BALL SCREW.

STANDARD ACCESSORIES



■ AIR AND COOLANT GUN



■ TELESCOPING METAL WAY COVER

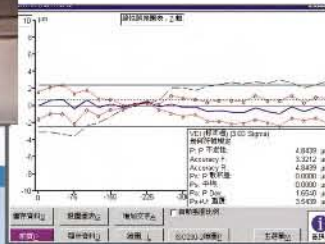


■ ARMLESS TOOL CHANGER

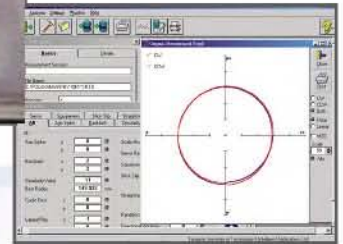
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LASER TEST PICTURE



BALLBAR TEST PICTURE



M320

HEAD

THE SPINDLE HEAD IS DESIGNED AND BUILT BY ONE PIECE CASTING WITH HARDENED AND GROUND WAYS.



CONTROL

POWERFUL CENTROID M-400 CONTROL (Built in the USA) FEATURES HIGH SPEED 3D CONTOURING, CONVERSATIONAL PROGRAMMING, DXF IMPORT, DIGIZITING, ENGRAVING AND 4TH AXIS CAPABLE.



■ AUTOMATIC LUBRICATION SYSTEM



■ HIGH PRESSURE COOLANT WITH 4 WATER NOZZLES AND 1 AIR



■ OIL CHILLER

OPTIONAL ACCESSORIES



■ FANUC OR MIT. CONTROL



■ ROTARY TABLE



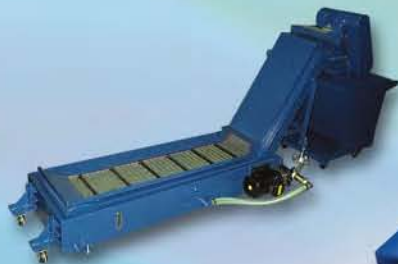
■ COOLANT THROUGH SPINDLE SYSTEM



■ SWING ARM TOOL CHANGER



■ HIGH VOLTAGE TRANSFORMER

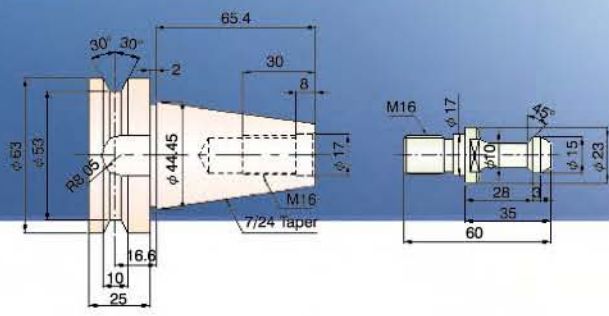


■ CHIP CONVEYER OR CHIP AUGER

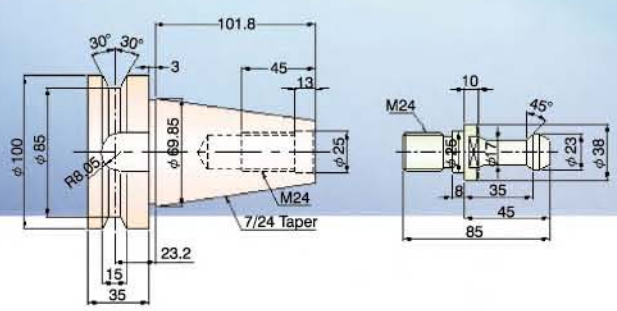


TOOL SHANK AND PULL STUD

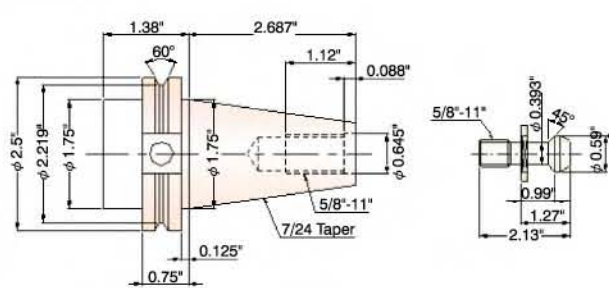
BT#40



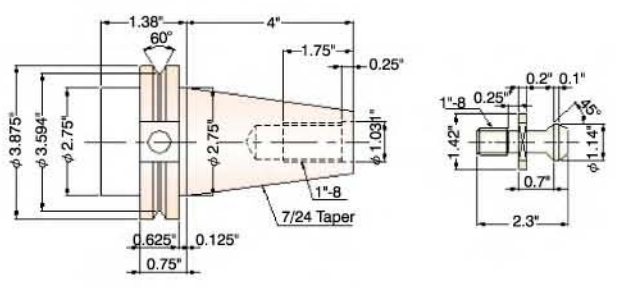
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CAT#40

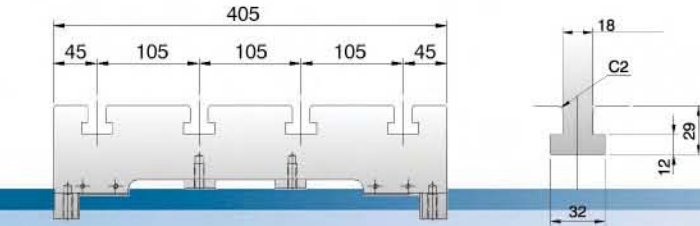
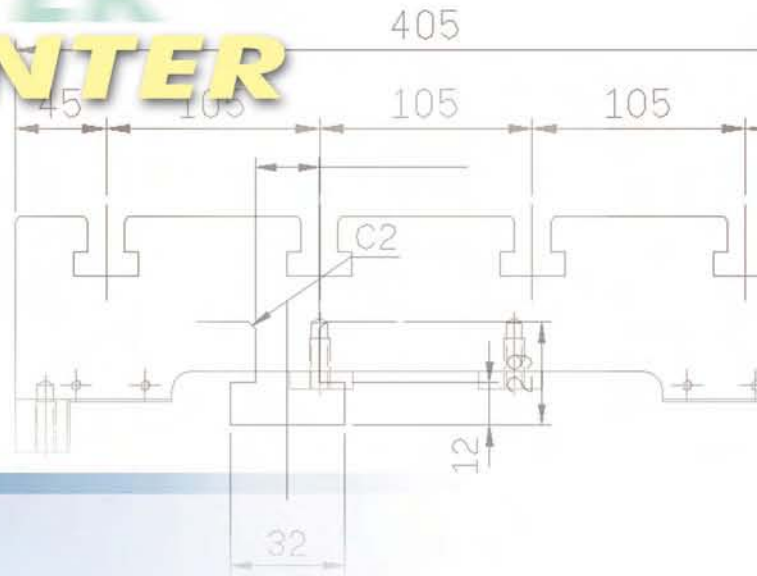


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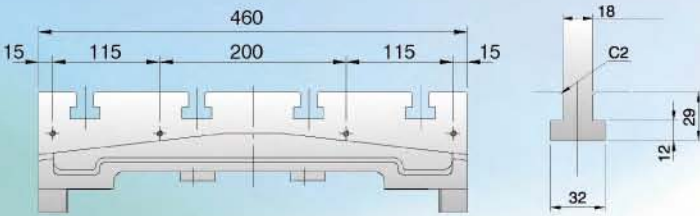


TURNING CENTER MACHINING CENTER

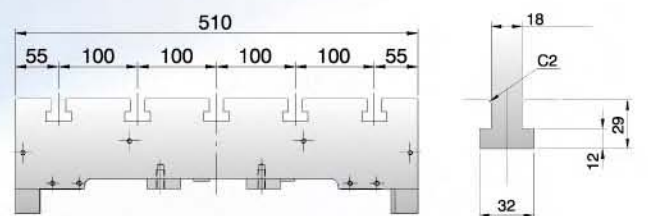
TABLE T-SLOT



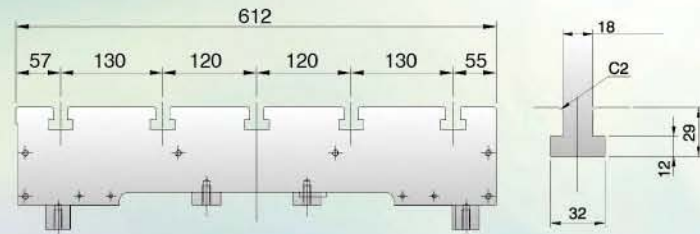
M218



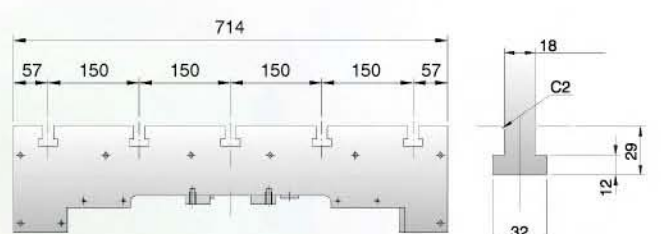
M320



M422W

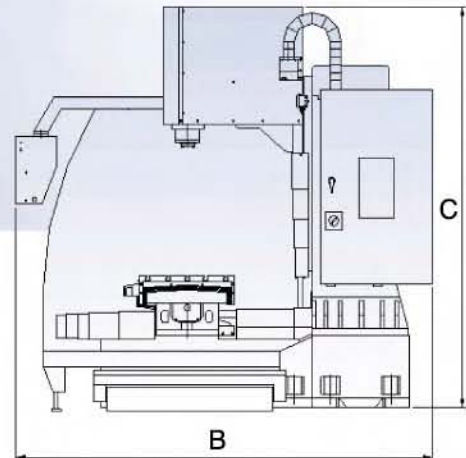
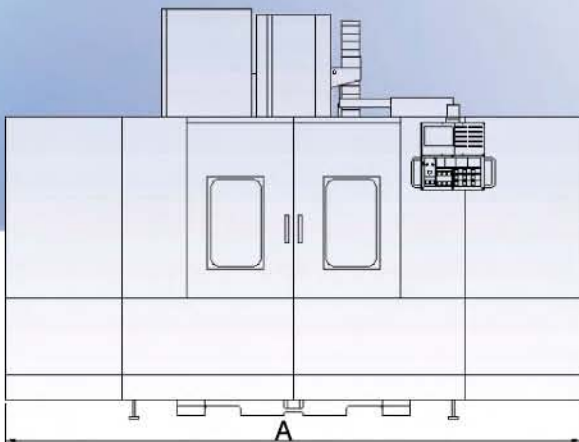


M526



M632

DIMENSIONS



Item	Model	M218	M320	M422W	M526	M632
Dimension A		86.5" (2,200 mm)	100" (2,550 mm)	125.5" (3,180 mm)	145" (3,680 mm)	169.5" (4,300 mm)
Dimension B		82.5" (2,100 mm)	87.5" (2,220 mm)	105" (2,660 mm)	113" (2,865 mm)	130" (3,300 mm)
Dimension C		98.5" (2,490 mm)	98.5" (2,490 mm)	100" (2,540 mm)	101" (2,565 mm)	113" (2,865 mm)

SPECIFICATIONS

ITEM	MODEL	M218	M320	M422W	M526	M632
Table size		32.6"x16" (830x405mm)	36.6"x18" (930x460mm)	49.6"x20" (1,260x510mm)	60"x24" (1,520x612mm)	71"x28" (1,800x714mm)
Table T-slot (WxN)		0.71"(18mm)x4	0.71"(18mm)x4	0.71"(18mm)x5	0.71"(18mm)x5	0.71"(18mm)x5
Max. table load (Center)		1,200lbs(545kgs)	2,000lbs(909kgs)	2,200lbs(1,000kgs)	3,000lbs(1,364kgs)	4,000lbs(1,818kgs)
X travel		26"(660mm)	34"(860mm)	43"(1,100mm)	52"(1,320mm)	63"(1,600mm)
Y travel		18"(460mm)	20"(510mm)	24"(610mm)	26"(660mm)	31.5"(800mm)
Z travel		24"(610mm)	24"(610mm)	27.5"(700mm)	27.5"(700mm)	31.5"(800mm)
Spindle nose to table surface		4.7"~28.7"(120~730mm)	4.8"~28.8"(122~732mm)	5"~32.6"(128~828mm)	4.9"~32.4"(124~824mm)	8.1"~39.6"(207~1,007mm)
Spindle center to column		19.7"(500mm)	21.7"(550mm)	25.6"(650mm)	27.6"(700mm)	33.3"(845mm)
Table surface to floor		33.1"(840mm)	34.3"(870mm)	33.3"(845mm)	34.1"(865mm)	36.5"(926mm)
Spindle speed #40		8,000RPM (Opt.10,000rpm)	8,000RPM (Opt.10,000rpm)	8,000RPM (Opt.10,000rpm)	8,000RPM (Opt.10,000rpm)	4,500RPM (Opt.6,000rpm)
Spindle speed #50		—	—	—	6,000RPM (Opt.8,000rpm)	—
Spindle motor		10HP	15HP	15HP	20HP 25HP	25HP
Spindle taper		CAT or BT#40	CAT or BT#40	CAT or BT#40	CAT or BT#40 CAT or BT#50	CAT or BT#50
Spindle pulling forc		#40:1,870lbs(850kgs) ± 10%	#40:2,200lbs(1,000kgs) ± 10%	#40:2,200lbs(1,000kgs) ± 10%	#50:3,960lbs(1,800kgs) ± 10%	#50:3,960lbs(1,800kgs) ± 10%
Spindle belt				8YU belt		
Ball-screw diameter		φ 1.26"(32mm)	φ 1.26"(32mm)	φ 1.57"(40mm)	φ 1.57"(40mm)	φ 1.97"(50mm)
Pitch of ball-screw X,Y/Z		0.3"/0.2" (0.3" centroid is opt.)		0.3"/0.2" (0.3" centroid is opt.)		0.2"
X & Y axis rapid feed		640ipm(16M)min	640ipm(16M)min	640ipm(16M)min	400ipm(10M)min	360ipm(9M)min
Z axis rapid feed		480ipm(12M)min	480ipm(12M)min	480ipm(12M)min	320ipm(8M)min	288ipm(7.2M)min
Cutting feed		300ipm(7.5M)min	300ipm(7.5M)min	300ipm(7.5M)min	240ipm(6M)min	240ipm(6M)min
ATC type			Armless type (Arm type is opt.)			Arm type
Tool storage capacity		16 tools	16 tools	20 tools	24 tools	24 tools
Max. tool diameter		φ 3.5"(90mm)	φ 3.5"(90mm)	φ 3.5"(90mm)	φ 3.5"(90mm)	φ 4.9"(125mm)
Max. tool weight		15lbs(7kgs)	15lbs(7kgs)	15lbs(7kgs)	15lbs(7kgs) 33lbs(15kgs)	33lbs(15kgs)
Positioning accuracy		± 0.0002"	± 0.0002"	± 0.0002"	± 0.0002"	± 0.0002"
Repeatability accuracy		± 0.0001"	± 0.0001"	± 0.0001"	± 0.0001"	± 0.0001"
Coolant pump				TPH2T2K		TPH4T2K
Machine weight (Approx)		7,370lbs(3,350kgs)	10,010lbs(4,550kgs)	12,980lbs(5,900kgs)	16,940lbs(7,700kgs)	25,080lbs(11,400kgs)
Packing size (machine)		94.5"x90"x90" (2,400x2,280x2,280mm)	98.5"x90"x90" (2,500x2,280x2,280mm)	106.5"x90"x98.5" (2,700x2,280x2,500mm)	124"x90"x98.5" (3,150x2,280x2,500mm)	119"x90"x102" (3,000x2,280x2,580mm)
(side cover)			43.5"x24"x43.5" (1,100x600x1,100mm)	71"x43.5"x43.5" (1,800x1,100x1,100mm)	71"x63"x43.5" (1,800x1,600x1,100mm)	98.5"x51.5"x83" (2,500x1,300x2,100mm)

★M632 is belt drive on axis.

★The above data are base on Centroid control system.

★We reserve the right to change design, color or specification without notice.



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