

Absolute Machine Tools & AccuteX EDM Ohio Grand Opening



(l-r) Courtney Ortner, Absolute Machine Tools, Inc.; Gertrude Whitaker, District Director for Ohio Congresswoman Jean Schmidt; Steve Ortner, President, Absolute Machine Tools, Inc.; Ray Liang, President, AccuteX EDM; and Don Prince, Mayor of Mason, OH.

Absolute Machine Tools, Inc. and AccuteX EDM officially opened the doors of its new 44,000 sq. ft. Technical Center in Mason, OH, with a Ribbon Cutting Ceremony. About 200 well-wishers comprised of customers, employees, machine tool partners, distributors, suppliers, and city, state and federal officials, witnessed the event.

"I'm grateful and thankful to be standing here today," said Steve Ortner. "When this company started in 1988 in half of a two-car garage in Elyria, OH with two people, and one of them was me, I never dreamed I'd be standing here today in front of this magnificent facility. While I would like to take credit for all of this, I did the

easy part; I just wrote the checks. A company is only as good as its people. I am blessed to have a wonderful group of over 40 of the hardest-working, most dedicated people on the planet. Without them, we wouldn't be here today." Mr. Ortner also thanked the city of Mason, the company's international partners: AccuteX Technologies, Tongtai Machine and Tool Co., Ltd., Johnford Roundtop Machinery Industries Co., Ltd. and You Ji Machine and Industrial Co., Ltd. Several representatives from those companies travelled from Taiwan to participate in the Grand Opening.

The event also included remarks by the Mayor of Mason, OH, Don Prince, who formally welcomed the companies and their employees to the city. Mrs. Ortner read a proclamation delivered by Ohio Governor John R. Kasich and Lieutenant Governor Mary Taylor. She also read a welcoming letter from Ohio State Senator Shannon Jones. Congresswoman Jean Schmidt, representing the 2nd District of Ohio also prepared a certificate for the companies, which was presented by Gertrude Whitaker, District Director. A festive Oktoberfest and Open House followed the ceremony.

Turning Centers & Machining Centers Demonstrated

Johnford HT-60CX-2D: The large swing, heavy-duty 4-axis turning center features a 39.4" swing over the bed, 31.5" over the cross slides and 48" turn length. The spindle motor is 50 HP with a 4-speed gearbox. Equipped with a 24" chuck, the 45,000 lb. heavy machine bed with 45 degree slant bed design featured rigid box ways and twin (upper / lower) 12-station bi-directional turrets and included a fully programmable tailstock with built-in live center and a FANUC 18iT-B dual path control.

Johnford Hi-Net SHV-1000: The high speed vertical machining center with ram head design, 24,000 RPM Weiss/Siemens HSK-63A 31 HP spindle, Schneberger roller type linear ways on all axes with 4 roller guides in the Y-axis and large 1.77" diameter pre-tensioned ballscrews provided 41" x

24" x 20" travels. The Fanuc 18iM-B control with AI NANO HPCC 64 bit RISC processor and 600 block look ahead is designed for high speed. The part demonstrated high speed, hard milling of mold and die parts.

Johnford SL-500-2SY+C: The heavy-duty slant bed turning center with sub spindle, C axis on both spindles, and Y-axis featured a 10" chuck, 3" bar capacity, 30 HP on the main spindle. The sub spindle was 15 HP, 8" chuck with 2" bar capacity. The 7.5 HP live 12 station bi-directional servo VDI-40 turret produces .2 second indexing. The machine has a true Y axis that is perpendicular to X and Z, rigid 45 degree slant bed casting with box ways and FANUC 18iT-B control. The demonstration was turning, milling and subspindle part making with barfeeder.

Johnford DMC-1600H: The double column machining center with 63" x 51" x 32" travels, one-piece cast bridge and column assembly weighs 45,000 lbs. The spindle motor is 35 HP, 6,000 RPM, 50 taper with 2-speed gear box. The arm-type ATC holds 40 tools and the machine features 1,000 PSI coolant through the spindle. The FANUC OiM-D control with Manual Guide i is conversational. The demonstration was heavy milling of a large still block and high speed drilling with high pressure coolant using Allied Machine & Engineering drills.

Johnford SL-300: The turning center features high speed box way with a bar feeder package, 8" chuck, 2" bar capacity, 4,500 RPM, 20 HP spindle. The 12-station bi-directional servo turret with .2 second indexing produces 944 IPM rapids. For productivity the SL-300 was shown with a Johnford/Pro 1500 5' magazine barfeeder, parts catcher and external parts conveyor. The FANUC OiT-D control with 10.4" color LCD has Manual Guide i conversational programming.

Johnford SV-40: The heavy-duty box way 40 taper vertical machining center produces 1,181 IPM on X & Y axes, has a high speed 24 tool arm-type ATC, 15 HP 10,000 RPM spindle with 2 speed gearbox and spindle cooler. It is fully equipped with chip flushing system, caterpillar type chip conveyor, and is coolant-through-the-spindle ready. The FANUC OiM-D control is a



Jamie Schwarz, National Sales Manager, CNC Indexing & Feeding



(l-r) George Kuehn, Senior Account Manager; Ken Reedy, Senior Account Manager, Kennametal.



Scott Harding, Sales, Fastech Inc., Reseller for Mastercam.



Robb Powell, OEM Sales Manager, Allied Machine & Engineering.

10.4" color LCD and Manual Guide i full conversational control.

Johnford SL-800B: The super slant bed turning center with 28" swing over the bed and 22" over the cross slide by 80" turn length, 35 HP spindle motor, 4 speed gear box, 18" chuck, features a 45 degree one piece slant bed design with rigid box ways and large 12 station turret. It has a fully programmable tailstock with built-in live center. The control is a FANUC OiT-D. The part cutting demonstration was heavy cutting and turning of steel.

Tongtai TNL-120AL2S: The high speed, high precision turning center produces 1,181 IPM, features 30 HP A2-8 3,500 RPM spindle, 10" 3-jaw chuck with 2.5" bar capacity, full C-Axis, 12 station bi-directional servo live turret with .2 second indexing, 7.5 HP and 4,000 RPM. For productivity it included a chip conveyor, parts catcher and parts conveyor. It has a FANUC OiT-C control.

Tongtai HB-500: The high performance, heavy duty 50-taper horizontal machining center with rotary type pallet changer features a 10,000 RPM 50 taper 30 HP integral spindle with cooler, 500mm pallets with full B axis and pallet change time of 14 seconds. Specifications include 32" x 28" x 28" travels, 31,000 lbs. and 1,969 IPM rapid traverse. The integral spindle reaches maximum RPM in 4 seconds while deceleration to 0 is in .9 seconds. Features include a 60 station ATC with 2.1 seconds tool to tool, a FANUC 31iMB control, dual level chip conveyor with fines separator, 1,000 PSI coolant through the spindle and hydraulic fixture interface. High speed and heavy drilling with Allied Machine & Engineering drills using steel was demonstrated.

Tongtai TMV-510 APC: This is a high-speed milling and tapping center with a rotary pallet changer, 1,890" IPM rapid traverse, 20" x 14" x 12" travels, 14 station ATC with tool change time of 1.5 seconds tool to tool, 12,000 RPM 7.5 HP BT-30 spindle with 4,000 RPM rigid tapping and FANUC OiM-C control. High speed milling, drilling, and tapping of aluminum was the cutting demonstration.

Quicktech DT-42: The high speed, high production 6 axis turning center featured two turning spindles, 2 HP live milling spindle with Y-axis, C-axis

on both spindles, 42mm bar capacity on the 15 HP main spindle, sub-spindle 5 HP with 30mm bar capacity, 3-axis gang tooling with 27 total tools, 7,040 lbs., barfeeder, parts catcher, parts conveyor, chip conveyor and Mitsubishi M70A control. The part being cut showed production multi-task turning and milling with sub spindle operation using aluminum or brass.

Quicktech IT-60 ROBO: The high speed, auto-loaded 4-axis turning center with integrated 6-axis Mitsubishi pick and place robot was designed for productivity. With a 60mm bar capacity on 15 HP main spindle, 3-axis gang tool slide each with X, Y, and Z axes, a main spindle tool post featuring 16 tools and a chip conveyor, and Mitsubishi M70B control. The part demonstration included auto loading and unloading of parts using the integrated Robot.

EDM Machines Demonstrated

AccuteX SP-300i: The Windows-based wire EDM featured axis travels of 13.8" x 9.8" x 8.7" and a maximum work piece of 30.1" x 21.1" x 8.5" and 1,150 lbs. The demonstration showed a Hirschmann rotary table (0-1,250 RPM) small diameter turning.

AccuteX SP-500i: The Windows-based wire EDM with optional W-axis has axis travels of 19.7" x 11.8" x 11.8" and maximum work piece of 38.4" x 22.6" x 11.6" and 3,400 lbs. The demonstration was with an AccuteX index/rotary table showing turn and burn.

AccuteX SP-600i: The Windows-based wire EDM featured axis travels of 23.6" x 15.8" x 15.8", maximum work piece of 39.1" x 24.4" x 15.6" and 3,800 lbs. The demonstration featured tall part cutting.

AccuteX DS-5040: The Windows-based sinker EDM featured axis travels of 19.7" x 15.7" x 15.7", maximum work piece of 49.2" x 25.6" x 15.4" and 3,080 lbs capacity.

AccuteX HP-300: The manual hole driller EDM is designed with axis travels of 11.9" x 10.0" x 13.8" and has maximum work piece of 880 lbs.

TOPEDM WSH-10: This CNC hole driller EDM with

7-position electrode changer and 2-position guide changer produces XYZ travels of 17.7" x 13.8" x 14.6". The part demonstrated small hole drilling and tool changing.

TOPEDM TSH-600V: The CNC hole driller EDM featured a 21 position electrode changer, 5 position guide changer, A/B indexing table and U axis tilt head +/- 35 degrees and produced XYZ travels of 23.6" x 15.7" x 14.6".

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(l-r) Courtney Ortner and Steve Ortner, President, Absolute Machine Tools, Inc., with the Tongtai HB-500 heavy-duty 50-taper horizontal machining center with rotary type pallet changer.



(l-r) Jeff Finch, Business Development Manager; Dale Reliford, Productivity Engineer, Sandvik Coromant.



James Wolf, Sales & Marketing, MMK Matsumoto Corp., exhibited rotary tables designed especially for EDM.



Gary Kinsey, Regional Sales Manager, Hirschmann Engineering, featured tooling for EDM machines.



Gary Schneer, Precision Tool, exhibited tooling for EDM Machines.



John Roskos, Vice President-Sales, System 3R, featuring palletization and automation for machine tools including EDM.