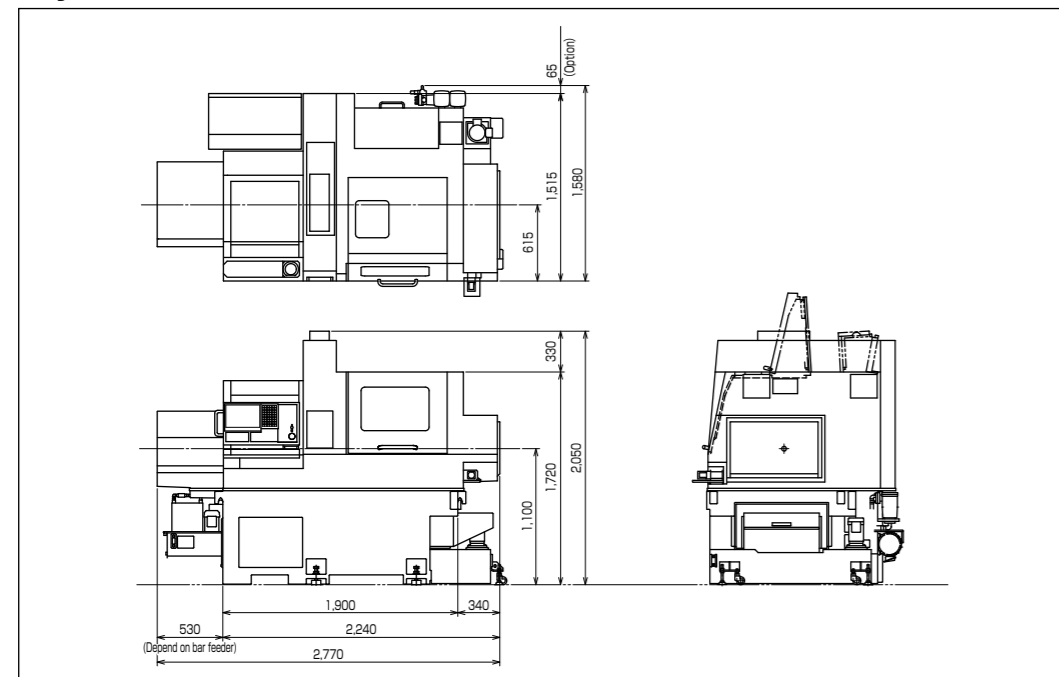


Standard Specifications of Machine

Item	B0385-III	B0386-III	B0385L-III	B0386L-III
	B0385V-III	B0386V-III	B0385LV-III	B0386LV-III
Working barstock diameter	φ8 to φ38 mm			
Max. machining length	320 mm Direct-drive rotary guide bushing 70 mm (Guide bush less) *1		100 mm (Exclusive guide-bushless machine)	
Main spindle speed	200 to 6,000 min <sup>-1</sup>			
Back spindle speed	200 to 7,000 min <sup>-1</sup>			
Rotary guide bushing speed	200 to 6,000 min <sup>-1</sup>			
Tool spindle speed	200 to 5,000 min <sup>-1</sup> *2 (Rated speed: 4,000min <sup>-1</sup> )			
Total tool storage capacity	Opposed gang-tool post	26	29	26
	Vertical tool post	21	24	21
Tool size	16 mm x 16 mm x 125 mm, 20 mm x 20 mm x 125 mm (Cut-off only)			
Rapid traverse rate	32 m/min (X1,Y1,Z1,Y2: 24 m/min)			
Controlled axes (linear axes)	5-axis	6-axis	5-axis	6-axis
Main spindle	7.5/11 kW			
Back spindle	3.7/5.5 kW			
Axis	X1,Y1,Z1,X2,Z2: 0.75 kW Y2: 0.5 kW (Y2-axis is 6-axis machine only)			
Cross drill	Cross drills on opposed front tool post: 1.0 kW Cross drills on opposed rear tool post: 1.4 kW (Option)			
	Cross drills on vertical tool post: 1.4 kW			
	Back live tool: 1.4 kW			
Coolant pump	0.4 kW			
Lubricating oil pump	3 W			
Net weight	4,850 kg			
Power source requirement	22.5 kVA			
Compressed air requirement	0.4 MPa or above			
Air discharge rate	100 NL/min			
Coolant tank capacity	190 L			
Width x depth x height	2,240 x 1,515 x 2,050 mm			

\*1 Guide-bushless and direct-drive rotary bushing are optional.  
\*2 When this device is used at rated speed 4,000 min<sup>-1</sup> or above, the operation time has to be short.

Layout



Export permission by the Japanese Government may be required for exporting our products in accordance with the Foreign Exchange and Foreign Trade Law. Please contact our sales office before exporting our products.

The specifications of this catalogue are subject to change without prior notice.

NC Specifications

	B0385-III/B0385V-III	B0386-III/B0386V-III
	B0385L-III/B0385LV-III	B0386L-III/B0386LV-III
NC unit	FANUC Oi-TF	FANUC 32i-B
Controlled axes	X1,Z1,Y1,X2,Z2,Y2,C1,C2 (Y2-axis is 6-axis machine only)	
Least input increment	Opposed spec 0.001 mm (X1/X2 axis in diameter)	
	Vertical spec 0.001 mm (X1/X2/Y1/Y2 axis in diameter)	
Least command increment	Opposed spec X1, X2 axis: 0.0005 mm, other axes: 0.001 mm	
	Vertical spec X1, X2, Y1, Y2 axis: 0.0005 mm, other axes: 0.001 mm	
Maximum programmable value	±8 digits	
Interpolation method	Linear, circular	
Feedrate	1 to 6,000 mm/min	
Feedrate override	0 to 150 % in 10 % increments	
Dwell	G04 0 to 99999.99	
ABS/INC command	X,Y,Z,C: absolute, U,V,W,H: Incremental	
Tool offset pairs	Main: 64, Back: 64	Main: 99, Back: 99
LCD/MDI	10.4" color LCD	
Display language	English	
Part program storage size	1 Mbyte (equivalent to 2,560 m tape length)	64 kbyte (equivalent to 80 m for each path system)
	800	63
Registerable programs	*sum of main and back spindle NCs	*sum of main and back spindle NCs
Miscellaneous functions	Main: M5-digits	Back: M3-digits
Spindle function	S5-digits	
Tool function	T4-digits	

TSUGAMI  
CNC Precision Automatic Lathe  
**B038-III Series**

Opposed gang-tool post spec **B0385-III/B0386-III**  
**B0385L-III/B0386L-III**  
Vertical tool post spec **B0385V-III/B0386V-III**  
**B0385LV-III/B0386LV-III**



Versatile on the compact body  
Enhanced variation and rich options covers diversified workpieces

Wide variety of specifications including  
tool post selection

Guide-bush type or guide-bushless  
type is selectable according  
to workpieces.  
(L type is exclusive  
guide-bushless machine)



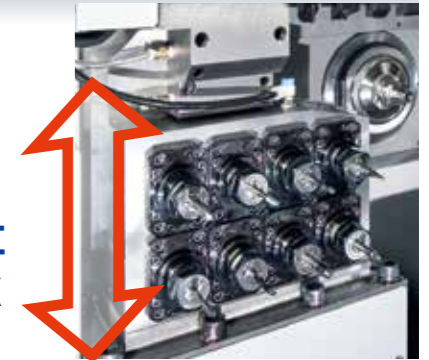
**TSUGAMI CORPORATION**

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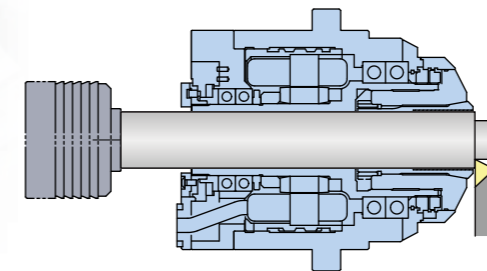
# Wide variety of specifications including tool post selection. Complicated workpieces with variable types and variable amounts can be handled.



On B0386-III, B0386L-III, B0386V-III and B0386LV-III simultaneous machining including milling such as off-center drilling, off-center tapping, endmilling, or cross drilling on back side is possible by adding Y-axis on the back tool post. Flexibly respond to workpieces requiring complex back machining.



Optional direct-drive rotary guide bushing realizes high speed and accurate machining. Geometrical accuracy, dimensional accuracy and surface roughness are improved in quiet operation even in high speed machining.

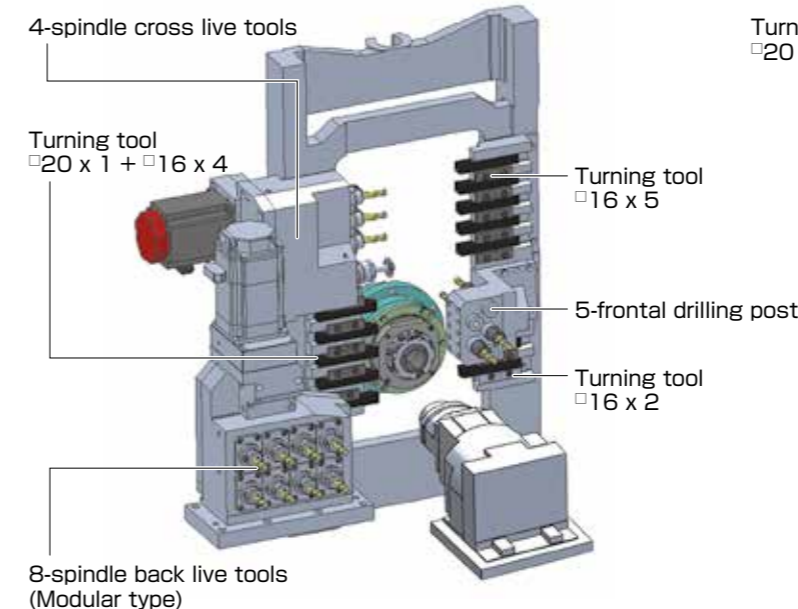


Max. machining length	320 mm
Max. speed	6,000 min <sup>-1</sup>
Motor power	1.5/3.0 kW
Remnant length	230 + α (Workpiece size) mm

- Machining capability is improved with increased rigidity of the machine body
- Two types of tool post can be selected: Opposed gang-tool post spec or Vertical tool post spec.
- Completely simultaneous processings are possible between main and back spindles for complex machining thanks to the Y-axis of back tool post. (6-axis machine)
- Modular type live tools can be arranged onto the rear tool post and the back tool post. The suitable tools and position can be selected according to the workpiece.
- Optional direct-drive rotary guide bushing provides high speed and accurate machining.
- Guide-bush type or guide-bushless type is selectable.
- Software is fully installed as standard for simplified operation.
- Automatic programming software is prepared as standard.

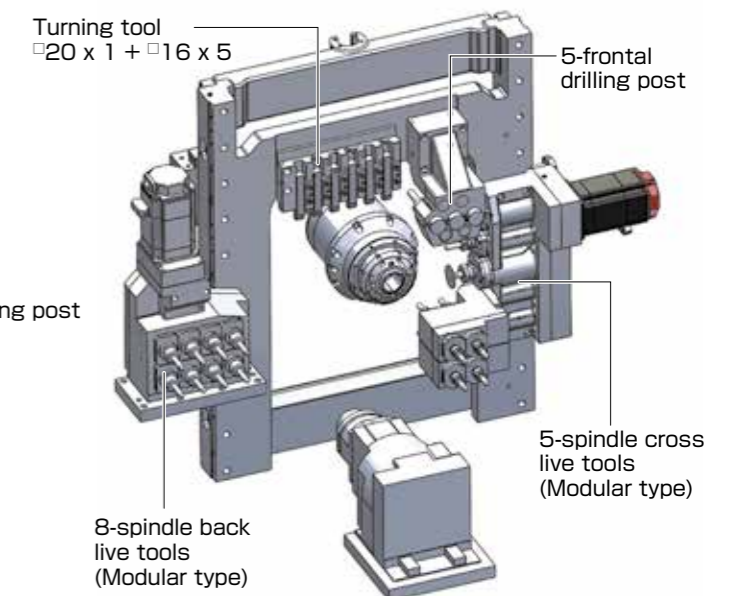


### Opposed gang-tool post spec



B0386-III/B0386L-III

### Vertical tool post spec



B0386V-III/B0386LV-III