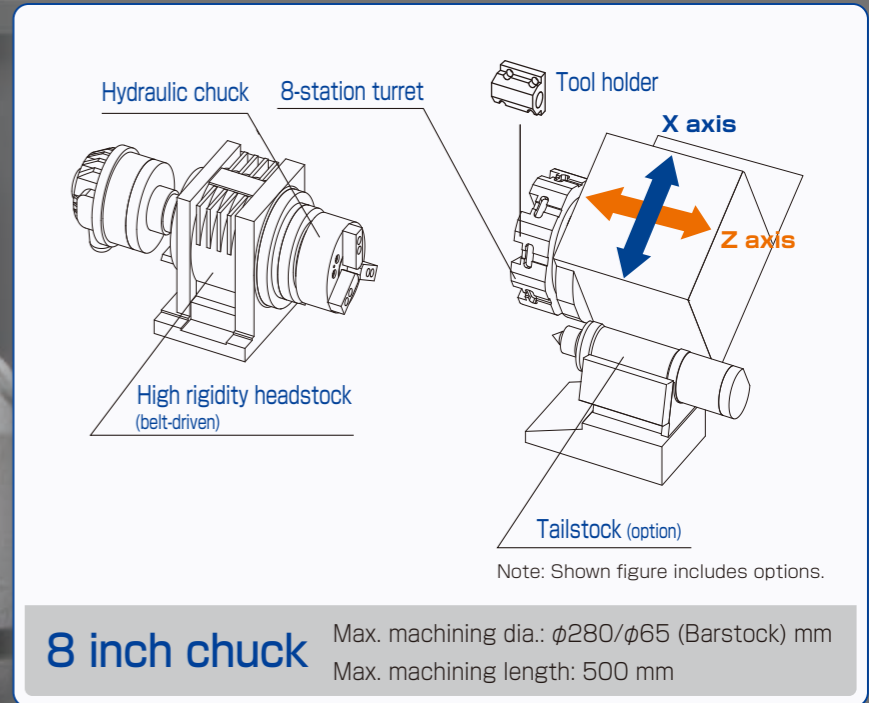
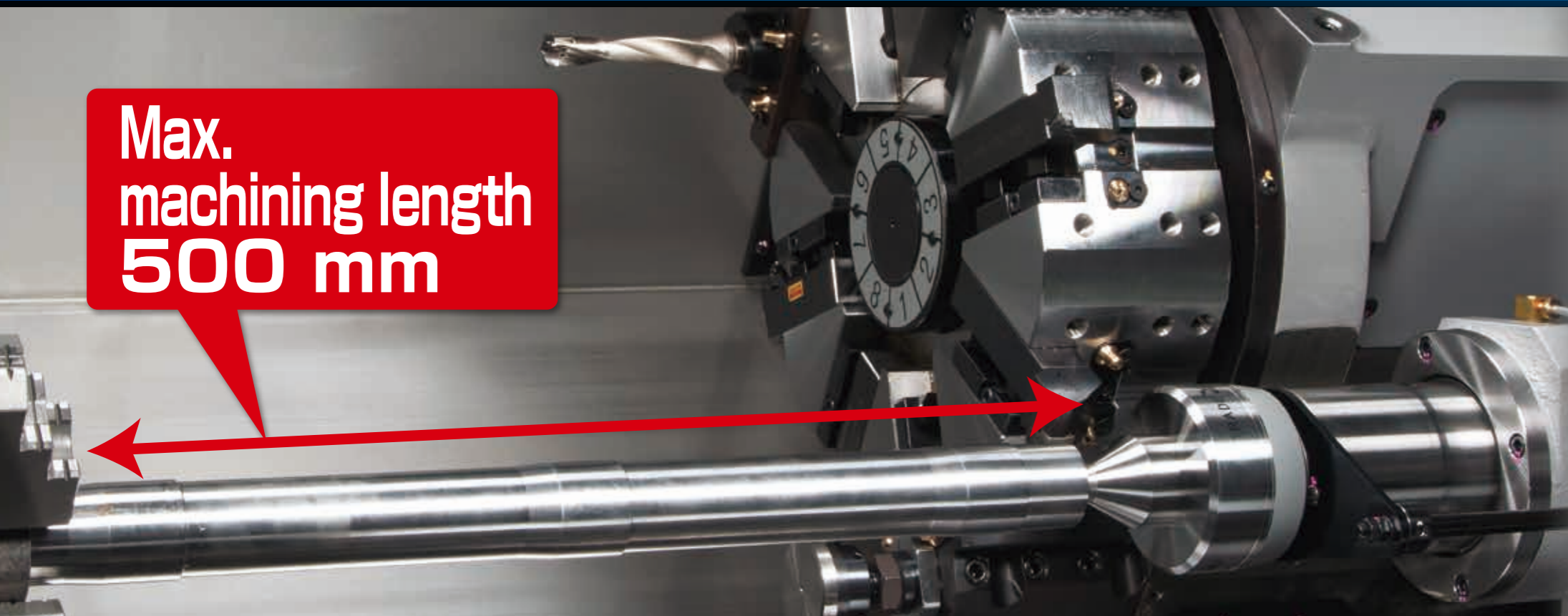


Max. machining length 500 mm



8 inch chuck Max. machining dia.: $\phi 280/\phi 65$ (Barstock) mm
Max. machining length: 500 mm

Long stroke basic machine for turning, drilling and boring

Machining capability

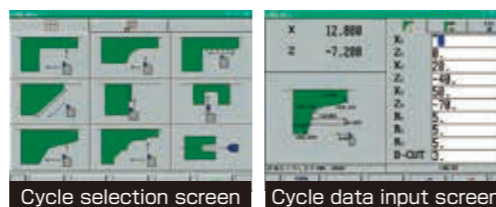
- Enables turning, drilling, and boring
- Realizes heavy-duty cutting by rigid basic structure
- Realizes high-productivity by excellent machining capability
- Pullout type coolant tank facilitates chip cleaning, and additional isolated tank is available as option.
- Standard coolant tank capacity: 145L



8-station turret

Simple operation

- Enables to create program simply by the optional interactive programming software on-board (FANUC: TURN MATE i).
- Safety set up by interference prevention function at debug mode
- Minimizes the damage to the machine with the retraction function by an abnormal load detection



Cycle selection screen

Cycle data input screen

Tool post for turning

- 25 mm square tools can be mounted on the turret directly, and it enables high efficiency machining.

Item	Specifications
Total number of tools	8
Square tool shank size	□25 mm
Boring bar shank size	$\phi 40/32$ mm

High-accuracy machining

- Realizes high-accuracy machining by the thermal displacement compensation
- Optional built-in motor spindle is selectable.

Overwhelming cost performance

- Overwhelming cost performance to enable big profit by small investment

Correspond to a long workpiece

- The tailstock (option) is prepared for a long workpiece or a workpiece with less clamping length.



Item	Specifications
Taper of center	MT No.5
Quill diameter	$\phi 80$
Quill stroke (by hydraulic)	100 mm
Stroke of tailstock position (by manual)	345 mm
Max. thrust force of quill	600 kgf/2.0 MPa

Machining capability to achieve high productivity (Material: JIS: S45C)

Standard type		Low speed spec. (Option)	
Turning (Cutting area)	Drilling	Turning (Cutting area)	Drilling
1.6 mm ² Machining dia.: $\phi 70$ mm Cutting depth: 3.2 mm Surface speed: 150 m/min Feed: 0.5 mm/rev	$\phi 30$ mm Surface speed: 150 m/min Feed: 0.2 mm/rev	2.0 mm ² Machining dia.: $\phi 100$ mm Cutting depth: 4.0 mm Surface speed: 150 m/min Feed: 0.5 mm/rev	$\phi 30$ mm Surface speed: 150 m/min Feed: 0.2 mm/rev
<p>Belt-driven spindle (Standard)</p>		<p>Belt-driven spindle (Low speed spec.) (Option)</p>	

High rigidity

- High-rigidity box slide is equipped for X axis to enable heavy-duty cutting.

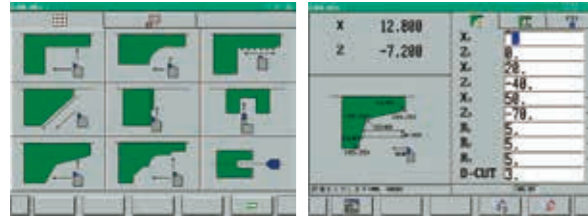
LED illumination light (Standard)

- Environmentally-friendly LED internal illumination light is provided as standard.

Control function

Automatic programming software (Option)

Preparing the optional interactive programming software on-board TURN MATE i (FANUC)



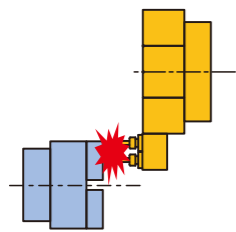
Cycle selection screen

Cycle data input screen

- Entering data according to the map that is displayed on the screen. Processing without NC program is possible.
- Continuous operation of the processing cycle (up to 20 pcs)
- ISO program conversion function from the processing cycle. Can be converted to the ISO program from the "TURN MATE i" dedicated program.

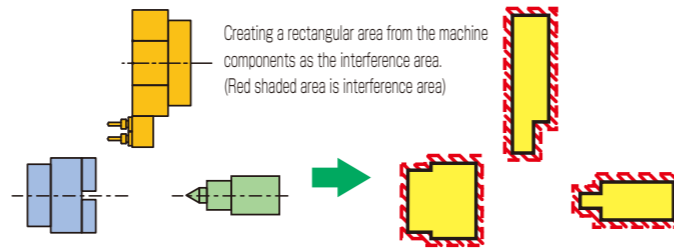
Retraction function by an abnormal load detection (standard)

When load level exceeds the setting level that is set based on the data such as the collision and cutting tool breakage, an alarm will occur, and make the slide to move to the retracting direction immediately to minimize damage to the machine.

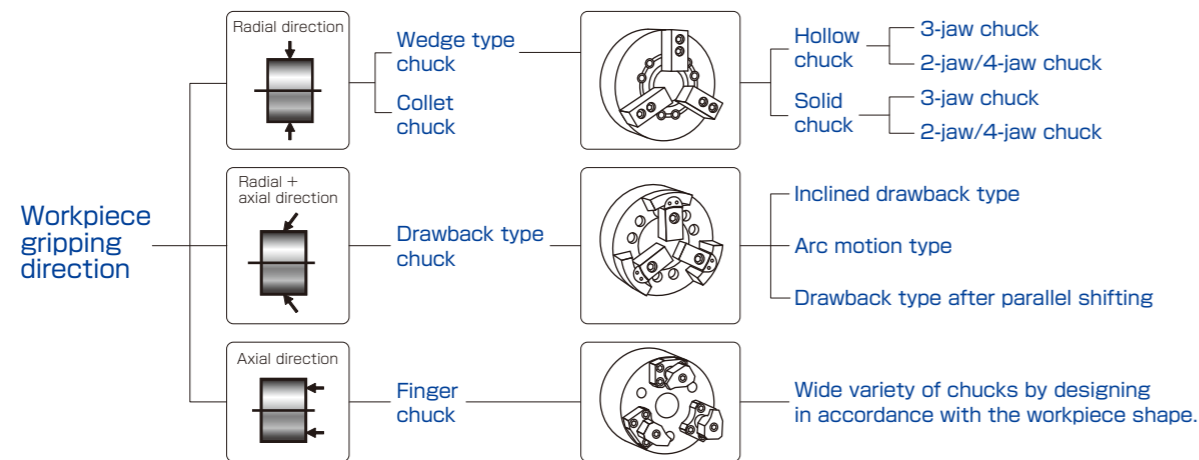


Interference prevention function at debug mode (standard)

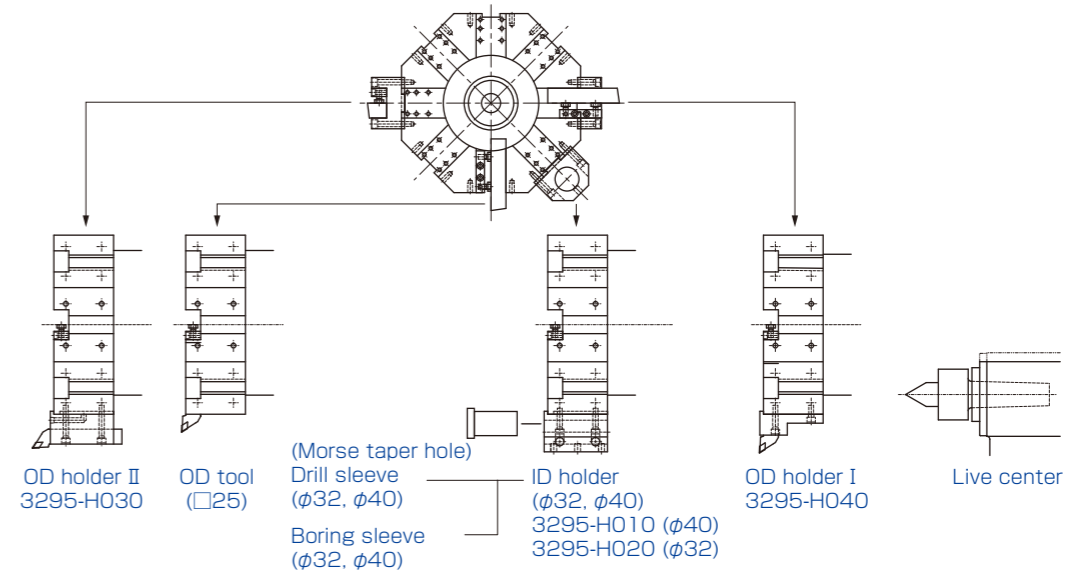
When the machine enters into the interference area in debug mode, the axis stops moving and the alarm occurs.



Chuck system (Option)



Tool holder (Option)




Option

Chip conveyor

Installed direction can be selected

Enables to be selected either from the machine right side or the machine rear side. Appropriate machine layout can be selected.

Name	Hinge type
Material	For steel (general purpose type)
Features	For long swarf
Shape	 Hinge plate

Tailstock

Processing for a long workpiece or a workpiece with less clamping length can be possible by this tailstock.



Tool setter

Tool offset is set automatically by touching the tool to the stylus.



High pressure pump

A pump unit supplying coolant with high pressure.



Foot switch

This foot switch is used to clamp or unclamp the main spindle chuck.



Signal indicator (Triple)

Three color lamp lights and it informs of the state of the machine.



Specifications

Machine specification

Item	M08JL5-II
Max. machining dia.	φ280/φ65 (Barstock) mm
Max. machining length	500 mm
Chuck size	8 inch
Max. spindle speed	4,000 min ⁻¹ (Standard spec.)/ 1,500 min ⁻¹ (Low speed spec.)/(Option)
Shape of spindle end	JIS A2-6
Main spindle bore	φ73 mm
Spindle bearing ID	φ100 mm
Number of stations	8
OD tool shank	□25 mm
Drill holder hole dia.	φ40 mm
Main spindle motor	9/11 kW
Stroke X/Z	X: 160 mm Z: 560 mm
Rapid traverse rate X/Z	X: 24 m/min Z: 27 m/min
Power source requirements	27 kVA
Compressed air requirement	0.5 MPa
Air discharge rate	100 NL/min
Size (Width x depth x height)	1,970 x 1,673 x 1,600 mm
Weight	3,430 kg (Machine with tailstock: 3,630 kg)

●Precaution: Always use the water soluble coolant.

NC unit

Item	M08JL5-II
NC unit	FANUC Oi-TF
Controllable axes	X,Z
Least input increment	0.001 mm (Diameter value of X axis)
Maximum commandable value	± 8 digits
Interpolation method	Linear/circular
Cutting feed rate	1 to 6,000 mm/min
Feed rate override	0 to 150 %, 10 % step
Dwell	G04, 0 to 99999.999
Absolute/incremental command	X, Z: Absolute U, W: Incremental
Tool offset pairs	64 pairs
LCD/MDI	8.4" color LCD
Display language	English
Part program storage size	512 KB (equivalent to tape length 1,280 m)
No. of registerable programs	400
Miscellaneous function	M4 digits
Spindle function	S4 digits
Tool function	T4 digits

Standard accessories

Item	Item	Item
Internal illumination light	Standard tools	Thermal displacement compensation
Door interlock	Plate, leveling bolt	Over-spindle coolant nozzle
Turret-through coolant	Transit clamps	
Hydraulic cylinder unit	Spindle air purge	

Machine options and NC accessories

Machine options

Item
Hydraulic chuck spec.
Tool holder
Tailstock
Live center: MT No.5
Work conveyor
NC gantry loader
Tool setter
Chip conveyor ^{*note1}
Collet chuck
Ecorich spec. (Inverter controlled hydraulic unit)
Automatic door (M code command) ^{*note2}
Both-hand start button
Dry cut spec.

NC accessories

Item	M08JL5-II	Item	M08JL5-II
Chasing function	Standard	Direct drawing dimension input	Standard
Continuous thread cutting	Standard	Inch/metric conversion	Standard
Manual pulse generator	Standard	Canned cycle for drilling	Standard
Memory card I/O interface	Standard	Rigid tapping	Standard
RS232C I/O interface	Option	Abnormal load detection	Standard
Back ground editing	Standard	Manual handle retrace	Standard
Run time/parts number display	Standard	Variable-lead thread cutting	Standard
Custom macro	Standard	Thread cutting cycle retract	Standard
Constant surface speed control	Standard	RAPID button	Standard
Tool geometry / wear offset	Standard	Spindle override	Option
Chamfering and corner R	Standard	Program edit key switch	Option
Multiple repetitive cycle	Standard	TURN MATE i	Option
Expanded program editing	Standard		

*Note 1: Right discharge or rear discharge
*Note 2: If the automatic door is opened and closed by M code command, it requires the installation of area sensor together.

Packaged options

Select options according to the machining system and shape of workpieces.

Packaged options		Chucker spec.		Chucker spec. (Automation)		Bar spec.		
		A	B	C	D	E	F	
Workpiece shape		Flange shape	Shaft shape	Flange shape	Shaft shape	Bar work		
Option	Tailstock	—	○	—	○	—	○	
	Automation	2-axis NC loader	—	—	○	○	—	—
		Work stocker (flange)	—	—	○	—	—	—
		Work stocker (shaft)	—	—	—	○	—	—
		Work catcher with conveyor	—	—	—	—	○	○
	Spindle chuck	3-jaw hollow (Large ID) 8 inch	○	○	○	○	○	○
		3-jaw solid 8 inch	—	—	—	—	—	—
		Collet chuck	—	—	—	—	○	○
	Tooling kit		○	○	○	○	○	○
		OD holder I (Offset holder)	2	2	2	2	2	2
		OD holder II (End face holder)	2	2	2	2	2	2
		ID holder (φ40)	4	—	4	—	4	—
		ID holder (φ32)	—	4	—	4	—	4
		Drilling sleeve (40) (MT No.2)	1	—	1	—	1	—
		Drilling sleeve (32) (MT No.2)	—	1	—	1	—	1
		Boring sleeve (φ40 x φ16)	2	—	2	—	2	—
		Boring sleeve (φ40 x φ20)	2	—	2	—	2	—
		Boring sleeve (φ32 x φ16)	—	2	—	2	—	2
		Boring sleeve (φ32 x φ20)	—	2	—	2	—	2
	Live center (MT5)	—	1	—	1	—	1	
Chip conveyor	Hinge type	○	○	○	○	○	○	
Tool setter	Manual swiveling type	—	—	—	—	—	—	
Foot switch		○	○	—	—	—	—	
Signal indicator (triple)		○	○	○	○	○	○	
Bar feeder interface		—	—	—	—	○	○	
Work stopper		—	—	—	—	○	○	