

## 2. Machine Dimensions

(UNIT : mm)

For this machine has free traveling , the min. space for the machine need is  $2452 \times 3105 \times 2411$  mm (width  $\times$  deep  $\times$  height) . For your safety , keep anything away the space . And we suggest you to keep 1 meter(min .) width around the machine space .

### 2.1 BM-23VDB

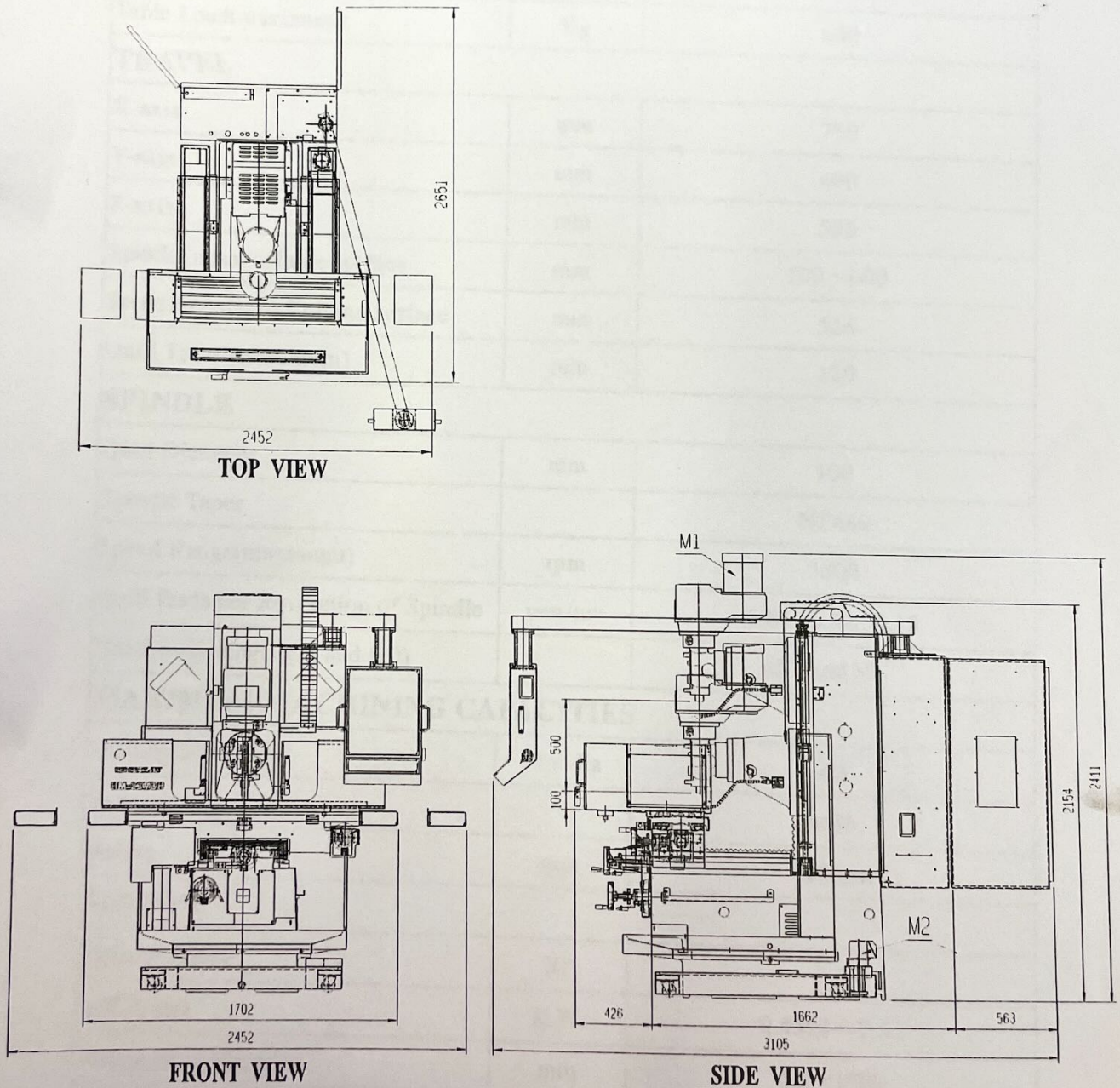


Figure 2.1

(UNIT : mm)

## 2.2 Machine Specifications

ITEM	UNIT	BM-23VDB
<b>TABLE</b>		
Table size	mm	320x1270
Tee slots (W x No. x Pitch)	mm	16x4x63
Table Load(maximum)	Kg	600
<b>TRAVEL</b>		
X-axis	mm	750
Y-axis	mm	400
Z-axis	mm	500
Spindle nose to Table surface	mm	100~600
Spindle center to Column surface	mm	526
Quill Travel(maximum)	mm	120
<b>SPINDLE</b>		
Quill Diameter	mm	100
Spindle Taper		NT#40
Speed Range(maximum)	rpm	3800
Quill feeds per Revolution of Spindle	mm/rev	0.04 , 0.08 , 0.15
Head Swiveling(right and left)		45° and 90°
<b>MAXIMUM MACHINING CAPACITIES</b>		
Drilling Mild Steel	Mm dia	40
Tapping		M36
Boring	mm	120mm
<b>MOTOR</b>		
Spindle motor	HP	7.5
X,Y,Z axis	K.W.	0.85x3=2.55
Footprint of Machine	mm	610x1100
Weight(approximate) net	Kg	2100
Weight(approximate) shipping	Kg	2200

## 2.3 Machine Description

### 2.3.1 BM-23VDB

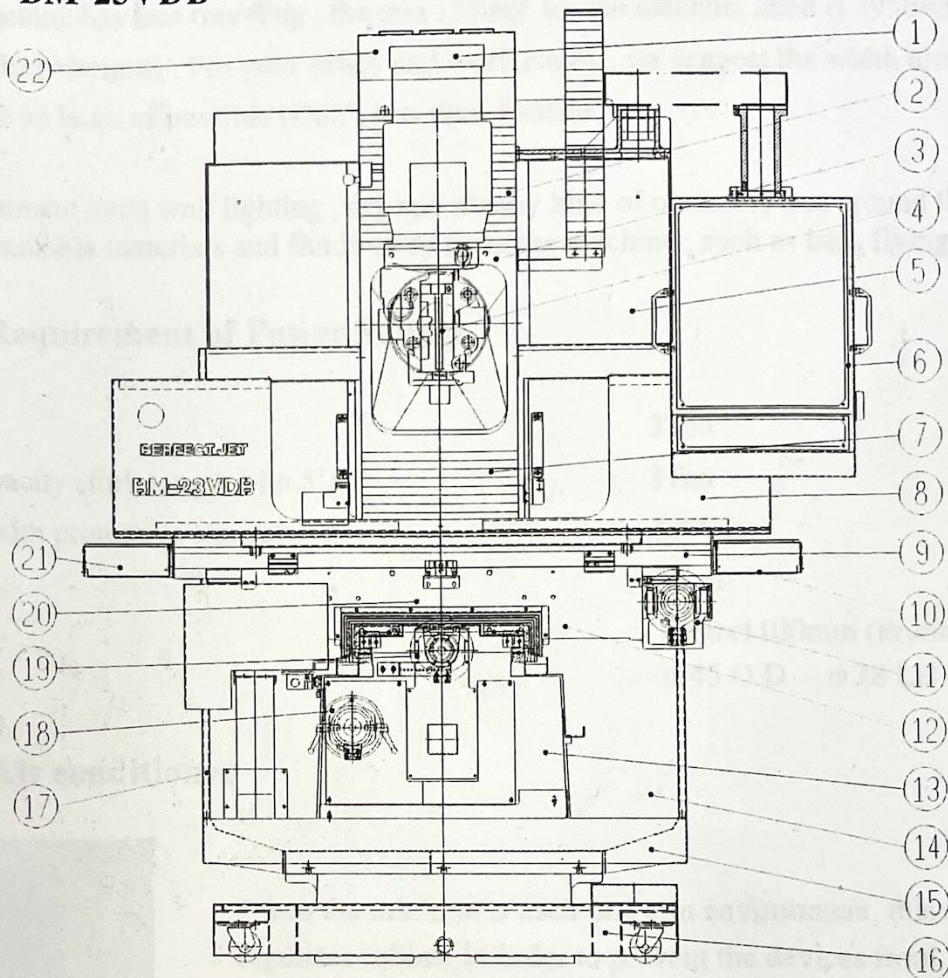


Figure 2.2

NO.	Name	NO.	Name
1	Motor	12	Saddle
2	Column	13	Base
3	Head Slideway	14	Right Plate
4	Head	15	Front Recover Plate
5	Electric Box	16	Tank
6	Operation box	17	Left Plate
7	Rubber Chip Guard	18	Hand Wheel(Z-Axis)
8	Table Cover	19	Hand Wheel(Y-Axis)
9	Table	20	Iron Chip Guard(Y-axis)
10	Iron Chip Guard(x-Axis)	21	Iron Chip Guard(x-Axis)
11	Hand Wheel(X-Axis)	22	Column Dust Guard

### 3.4.1 Transportation by Fork-Lift Truck

1. Capacity of lift-truck
2. Keep machine's balance and move slowly.
3. Make Sure there is no obstacle or personnel on the move path and nothing unnecessary left on the machine.
4. Only an authorized technician should perform work with machine lifting.

### 3.4.2 Illustration of forklift truck

#### WARNING !

The lift truck must have sufficient lifting capacity(3 tons) and be equipped with suitably long forks .

#### CAUTION !

The machine weights approximately 2200kg . Proper equipment of sufficient capacity must be used when lifting and /or moving the machine

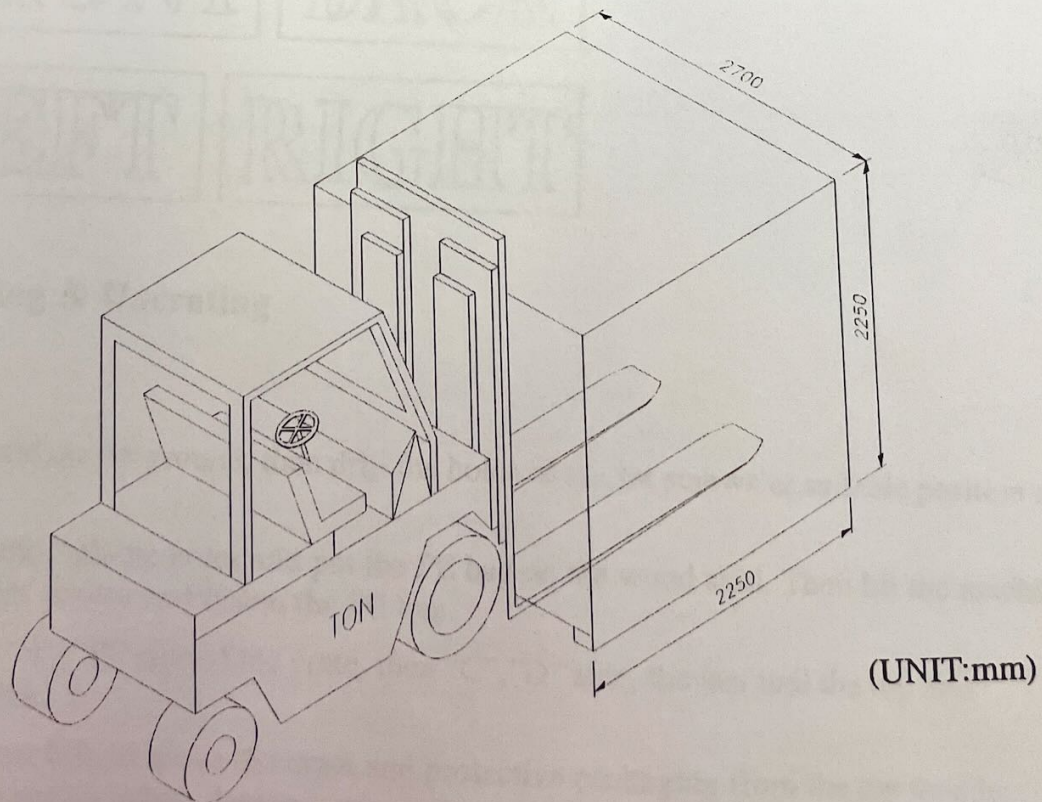


Figure 3.2

3.7 Method of fixing counterweight

(Refer to Fig 3.4)

1. Adjust the holes of counterweight to fit the column channels by bending the sleeve screw tube, then insert a steel bar through.
2. Move head up until all cable in length is in position and lock the sleeve with gib lock.
3. When operating, please release the sleeve and lock.
4. Lower the head slowly until the cable between the pulley and counterweight is tight.
5. Lower a little further until the two support cables are loose. Release the two steel rods and store them for future when maintenance is needed.

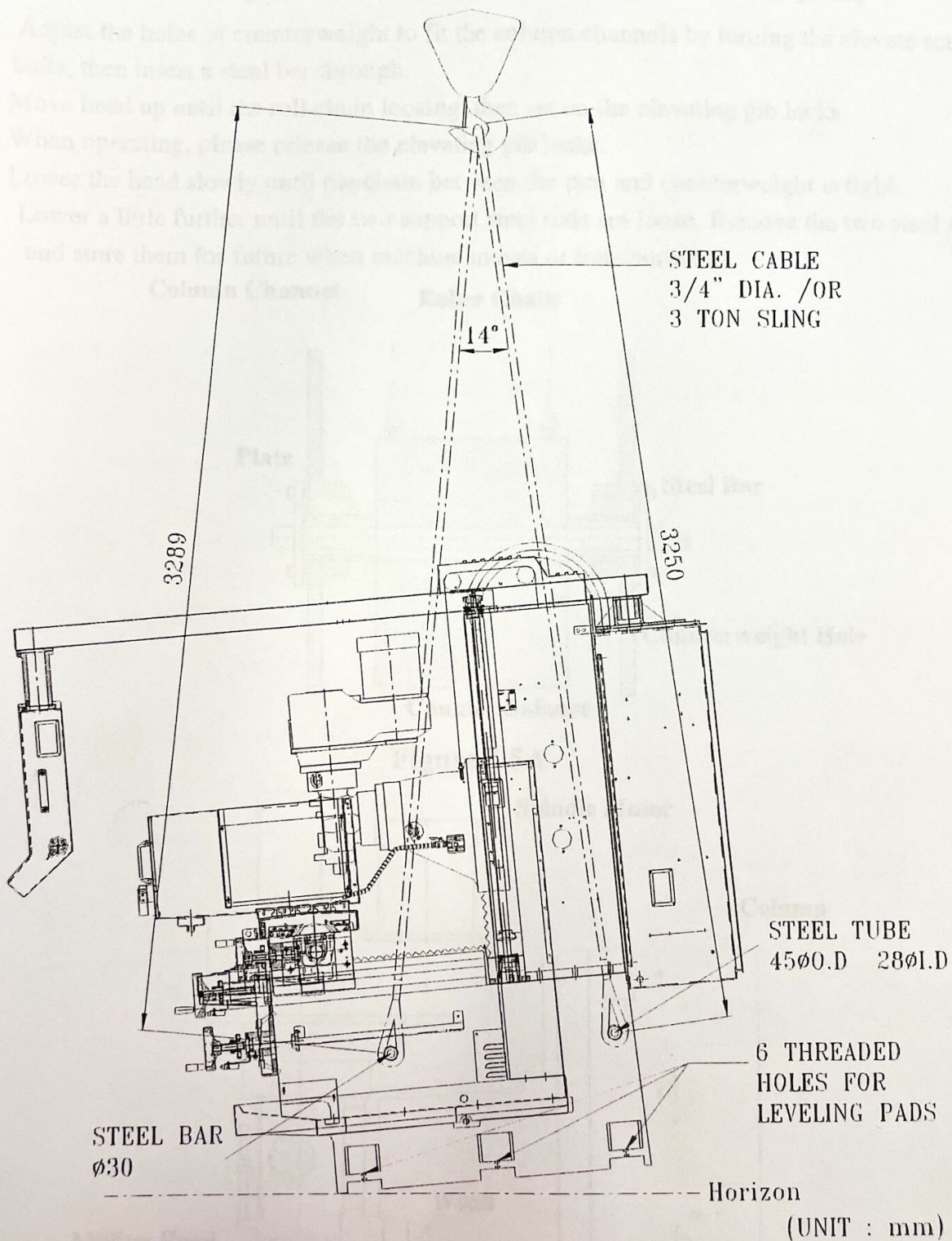


Figure 3.4

### 3.7 Method of fixing counterweight (Refer to Fig 3.5)

1. Adjust the holes of counterweight to fit the column channels by turning the elevate screw bolts, then insert a steel bar through.
2. Move head up until the roll chain loosing, then set on the elevating gib locks.
3. When operating, please release the elevating gib locks.
4. Lower the head slowly until the chain between the ram and counterweight is tight.
5. Lower a little further until the two support steel rods are loose. Remove the two steel rods and store them for future when machine moves or transportation.

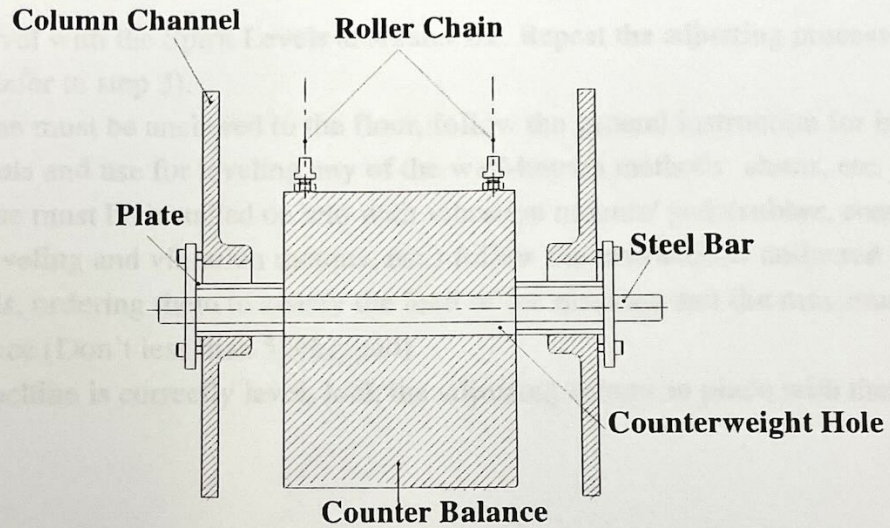


Figure 3.5A

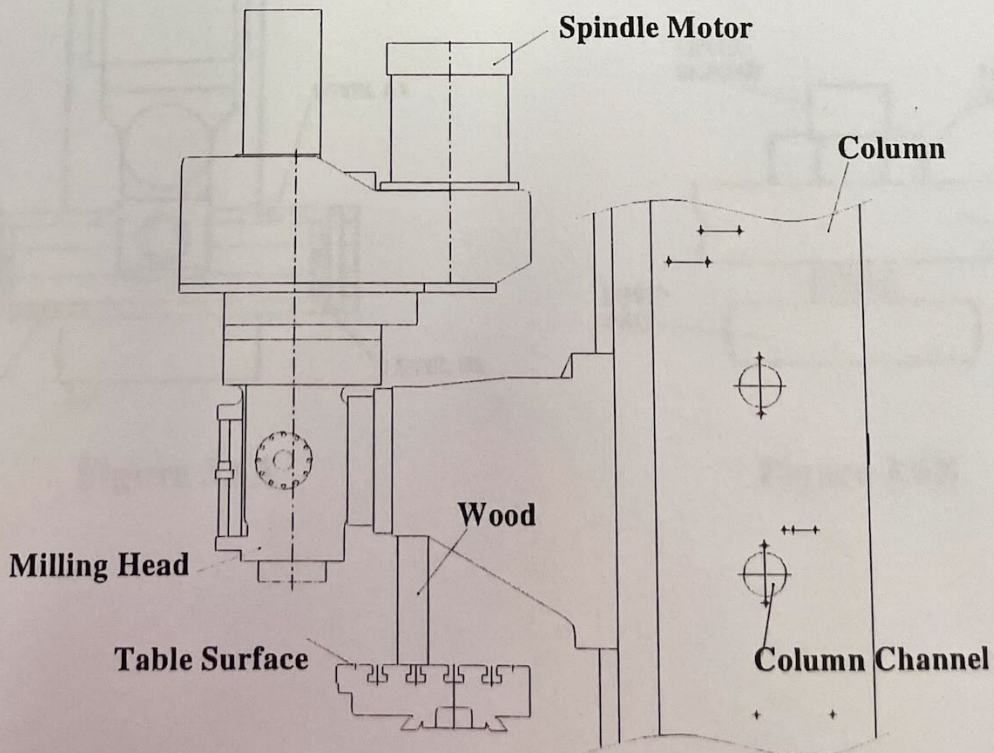


Figure 3.5A