

CNC TURNING LATHE

VT-27 VT-28

POWERFUL CUTTING

- ▶ 45° Slant Bed Design
- ▶ Large Spindle Bore 3.43"
- ▶ 3500 rpm Spindle
- ▶ 35 hp / 50 hp Motor



*Ideal for the
Toughest Hard
Turning Jobs*

VIPER



VT-SERIES

27

28

FORTEX

www.alex-tech.com

Superior Performance

Powerful Universal CNC Turning Center



→ Alex-Tech design patent pending
VDI-40/ Block Tool Combination Turret

SOLID CONSTRUCTION

Rigid, one-piece Meehanite cast-iron-bed. Viper turning center construction provides the ultimate in machine tool accuracy and reliability.

A 45° slant bed design for our **VT-27G** and **VT-28** gives Viper its exceptional cutting stability facilitating optimal chip removal. Cutting reaction forces are minimized resulting in a high degree of precision.

Both X and Y axes on Viper turning centers are supported by oversized

hardened and ground box type ways which facilitates exceptionally fast cutting rates.

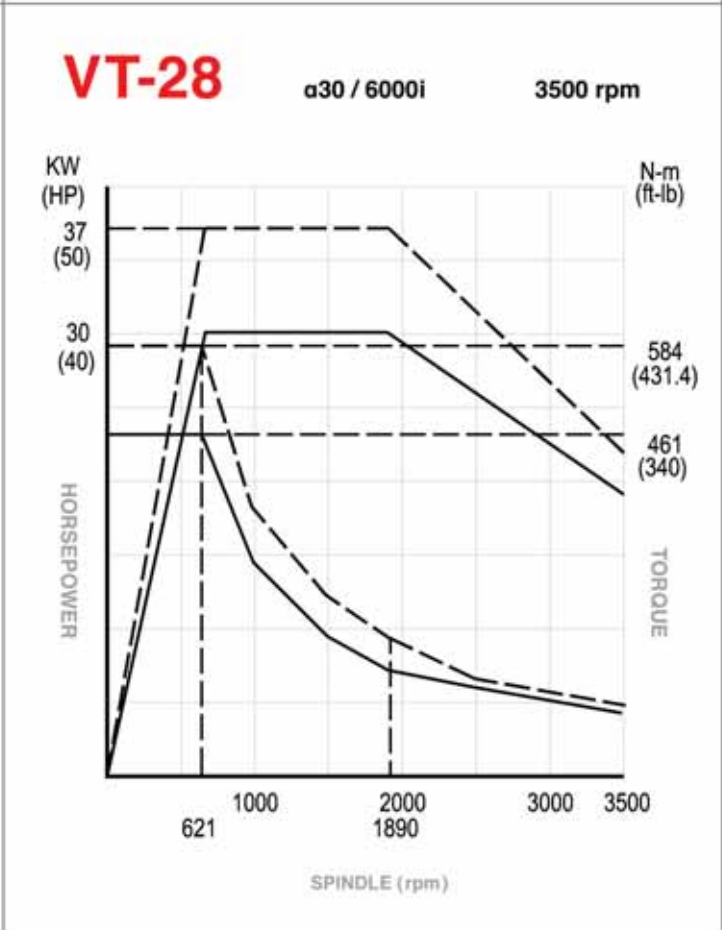
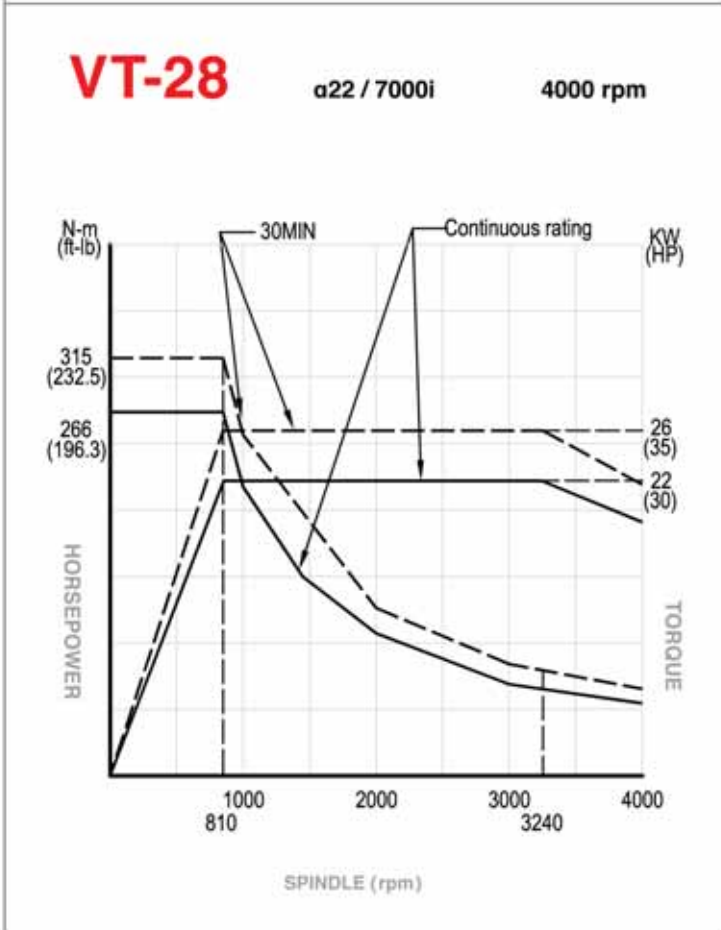
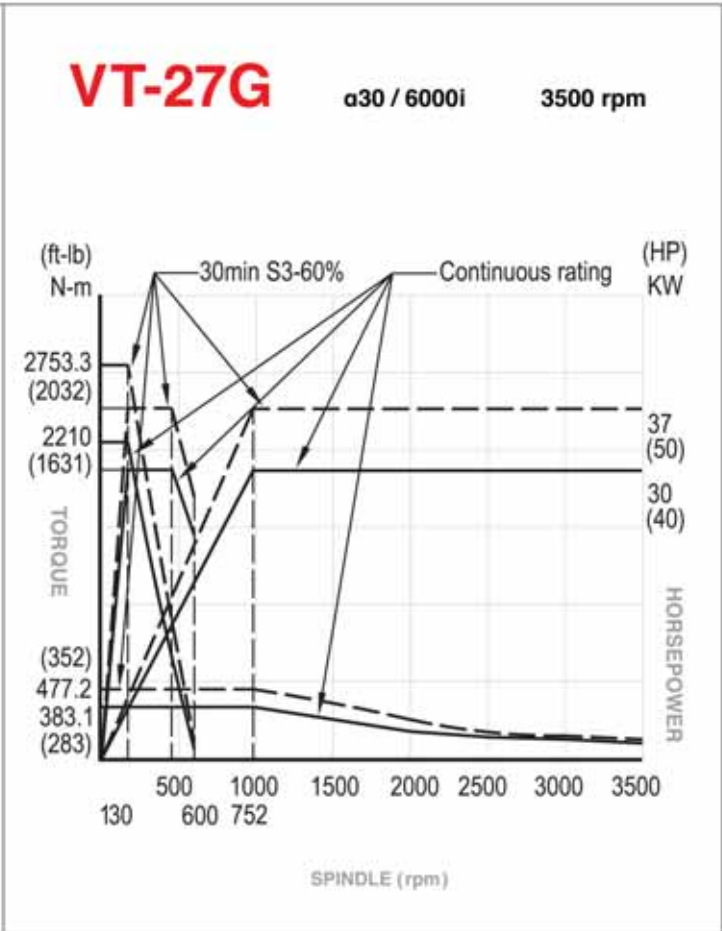
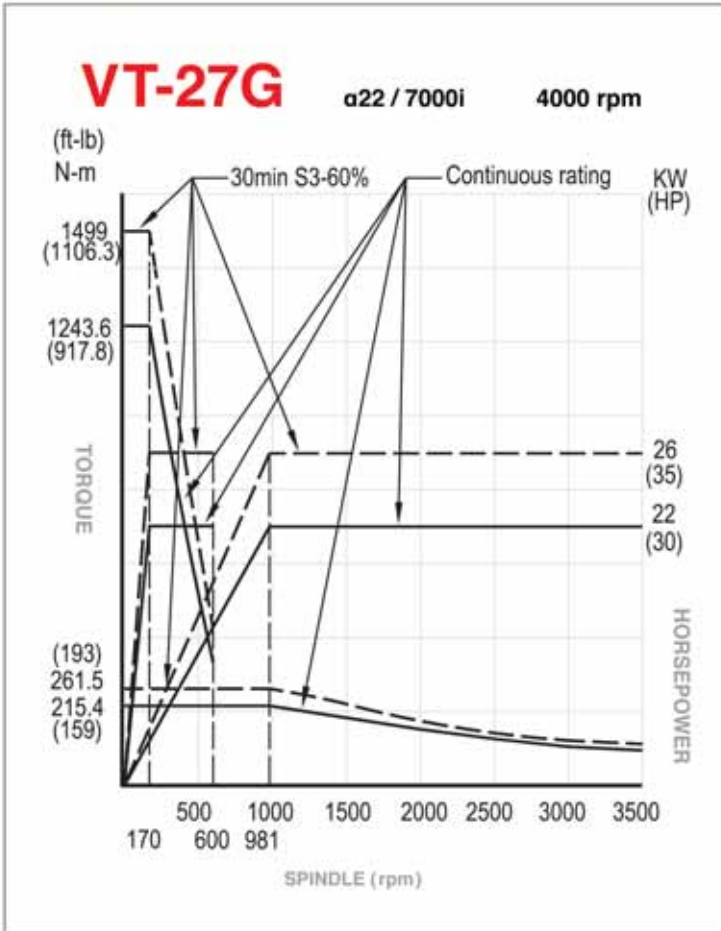
PERFORMANCE FEATURES

- Live Milling and Sub-Spindle
- Main Spindle 35 hp / 50 hp*
- Fully Conventional Programming
- VDI-40 Live Turret

*Optional accessory.

TORQUE CHARTS

Legend ■ 30 Min. Rating = (- - -) | Continuous Rating = (—)



PERFORMANCE OPTIONS



TORQUE LIMITER CLUTCH

The clutch disengages when pre-set limiting torque is exceeded and axial movement stops immediately.

A fitted limit switch detects the clutch disengaging movement and signals the drive off. After removal of the overload, the clutch re-engages automatically.

SELF-CENTERING STEADY REST(SMW AUTOBLOCK)

Easy installation, Steady Rest consist of four bolts (M16x120mm) and two positioning pins (Ø10 mm).



HEAVY PARTS LOADER

An Alex-Tech design, a large capacity parts loader that picks up and unloads parts up to 12" (300mm) / 25 lbs (11kgs).

Available for machines with a chuck size range of 10" (250mm) to 15" (375mm).



TOOL PRESETTER

With its tool presetter system, Viper is an ideal machine for both short-run and high production environments.



Its tool presetting system assists in reducing set-up time, changing tools and ensures accurate measurement of tool offsets.

The tool presetter allows for various checkpoints throughout the program to obtain optimal part accuracy and finish. These tool offsets are quickly and accurately measured by the tool presetter probe system.



Centering range without chip guard:

- **SLU3** Ø12 ~ Ø152 (0.47" ~ 5.98")
- **SLU3.1** Ø20 ~ Ø165 (0.79" ~ 6.49")
- **SLU3.2** Ø50 ~ Ø200 (1.96" ~ 7.87")

Steady Rest optional equipment

- Swarfguard — Spring loaded, self adjusting guard to protect arm rollers against chips.
- Large capacity steady rest may require wider full length splash guard.
- Stroke control (no proximity switch).
- Central oil lubrication for heavy duty cutting.
- Safety valve

BAR FEEDER**

IEMCA Servo Driven

Units = inch (mm)

Model	Bar Capacity	Stroke
V66E	2.59" (65mm)	..49" (1244mm)
V66EL	2.59" (65mm)	..61" (1550mm)
VIP-80	3.15" (80mm)	..61" (1550mm)
VIP-100	3.93" (100mm)	63" (1600mm)

**Factory order with machine only.



AUTOMATIC DOOR

Push button efficiency, open or close door automatically. The **VT-27G** and **VT-28**, may be equipped with auto door function.



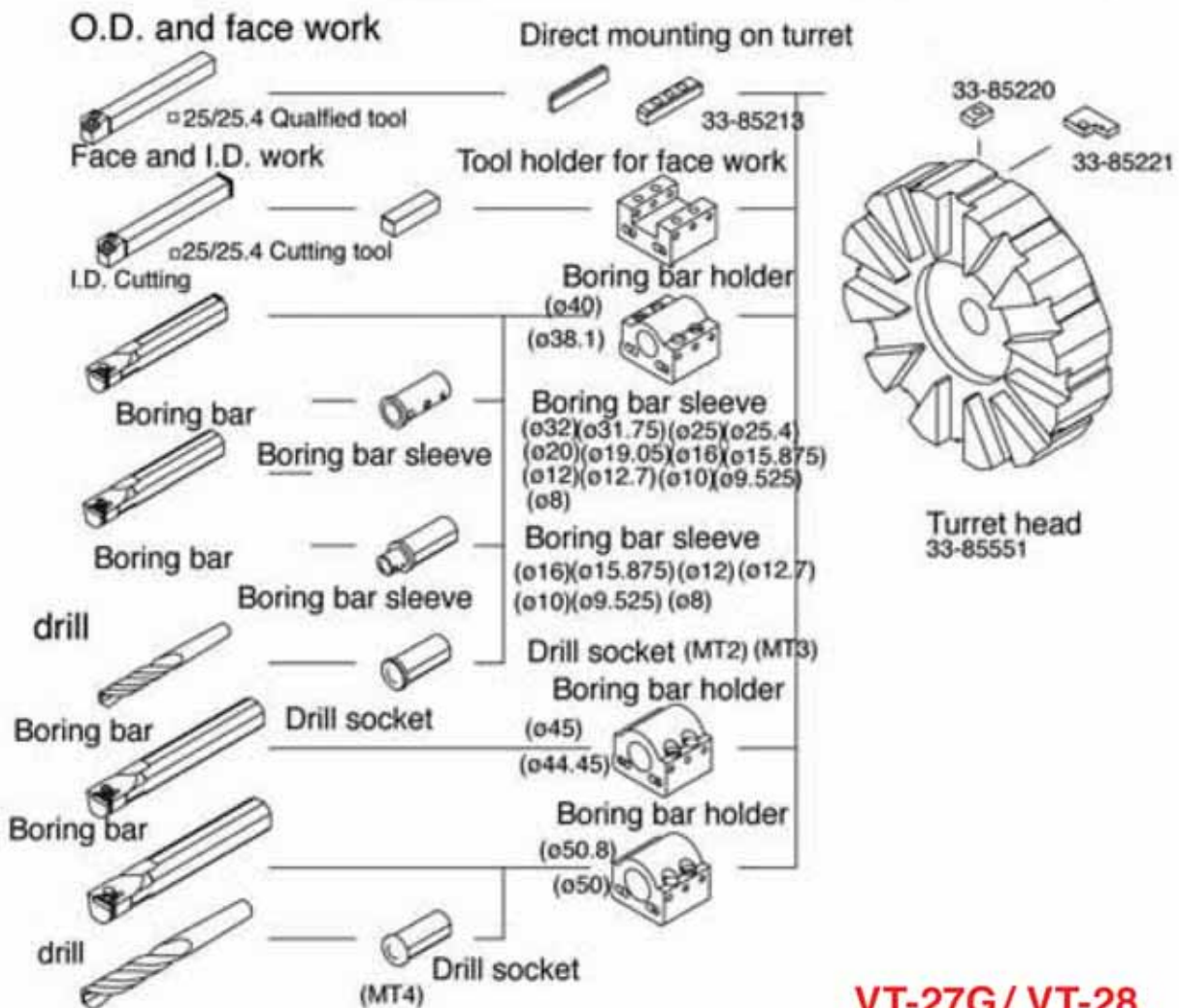
Patent pending door design.

Available on models with extended Z-axis travel of 62.6" (1590mm) and 82.2" (2090mm). Maximum door opening is 65" (1650mm) and 85" (2159mm) wide.

MORE OPTIONS

- Air Chuck
- Automatic gantry loading and unloading system
- Collet chuck, 3", A2-8 S-30
- Glass scale XY-axes
- High pressure coolant pump and large capacity coolant tank
- Interior diameter (I.D.) tool socket sleeve
- Interior diameter (I.D.) tool holder
- 1000 PSI coolant through the tool
- VDI-40 Live Turret

Turret Tooling

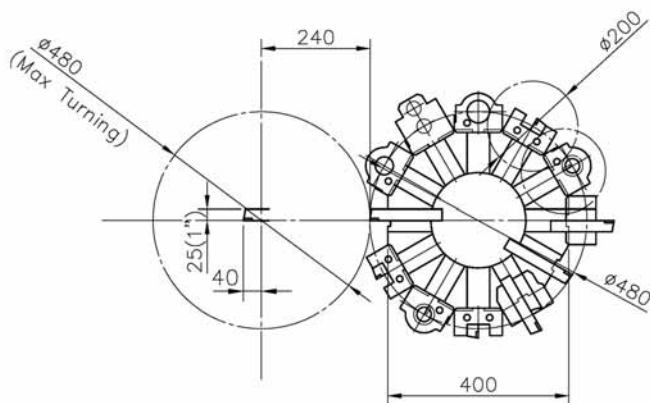


VT-27G/ VT-28
Static Block Tools

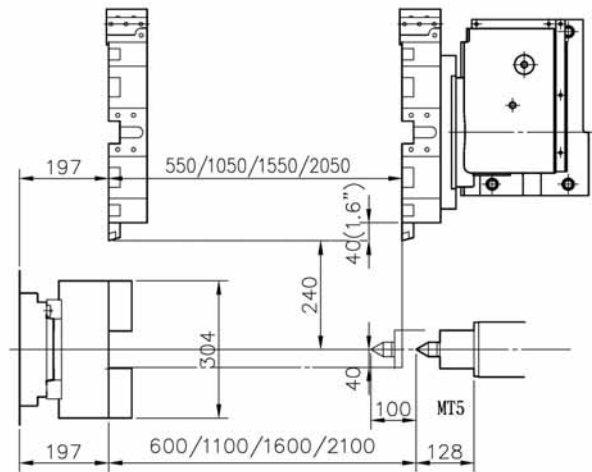
TURRET INTERFERENCE DRAWING

VT-27G / VT-28

Static Block Tool



(VT-27)
(VT-28)
A2-8
12"

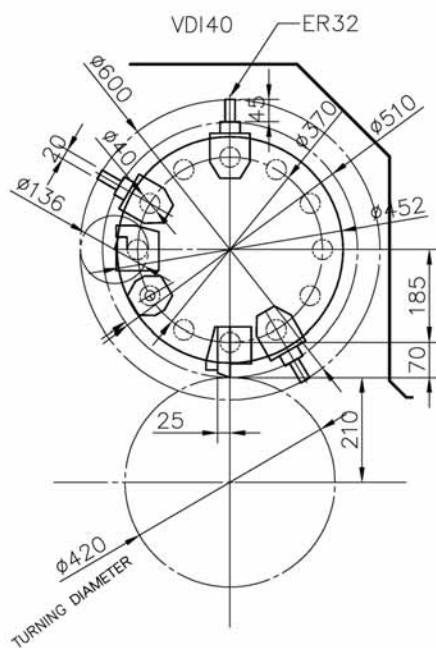


Spindle Nose
ISO A2-8

Units = mm (inch)

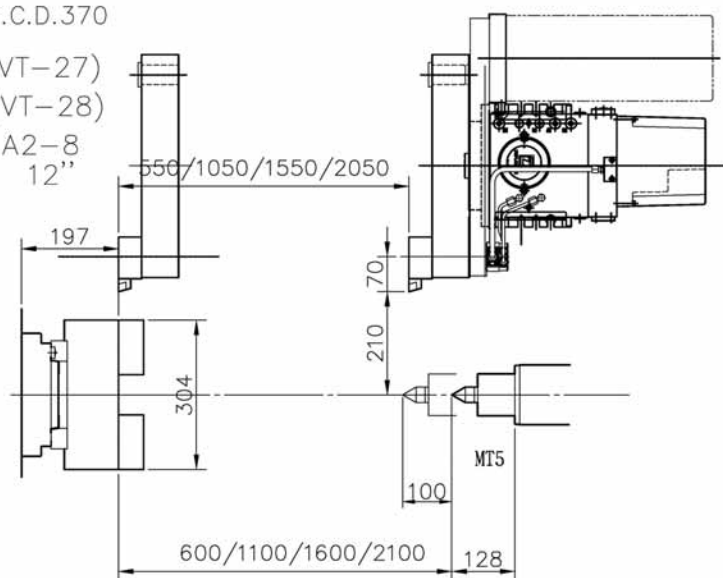
VT-27G / VT-28

Live VDI-40



SAUTER VDI40 axial live turret
0.5.436.220/12
P.C.D.370

(VT-27)
(VT-28)
A2-8
12"

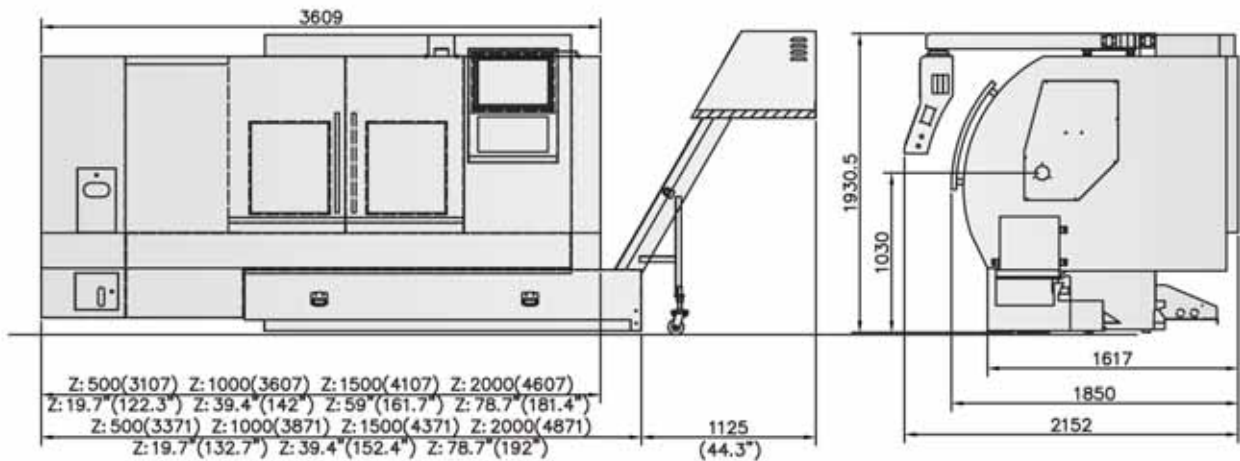
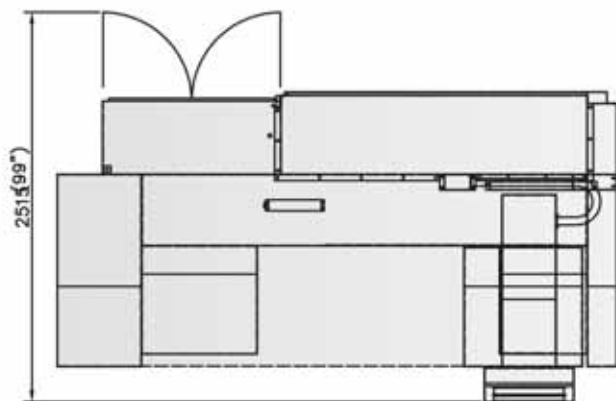


Spindle Nose
ISO A2-8

MACHINE DIMENSIONS

VT-27 ■ VT-28
CNC Turning Center
Full Guarding • Chip Conveyor

Top View



Front View

Side View

Units = mm (inch)

Machine Specifications

ITEMS	UNIT	VT-27G 500 / 1000 / 1500 / 2000		VT-28B 500 / 1000 / 1500 / 2000	
CAPACITY		STANDARD	SUB-SPINDLE (S)	STANDARD	SUB-SPINDLE (S)
Swing Over Z Way Cover	inch (mm)	26.8 (680)			
Max. Turning Diameter	inch (mm)	18.9 (480)			
Swing Over Cross Slide	inch (mm)	18.9 (480)			
Distance Between Centers	inch (mm)	21.65 (550) / 41.3 (1050) / 61.0(1550) / 80.7 (2050) / 120(3050)			
Max. Turning Length	inch (mm)	21.65(550) / 41.3 (1050) / 61.0 (1550) / 80.7 (2050) / 120(3050)			
Slideway Slant Angle	degree	45			
TRAVEL					
X-Axis Travel	inch (mm)	9.4 (240) + 1.57 (40)			
Z-Axis Travel	inch (mm)	23.2 (590) / 42.9 (1090) / 62.6 (1590) / 82.3 (2090) /121.7(3090)			
W-Axis Travel (Sub Spindle)	inch (mm)	41.3 (1050) L=1000 / 80.7 (2050) L=2000			
MAIN SPINDLE					
Type of Spindle Nose	ISO	A2-8		A2-8	
Chuck Diameter & Type	inch (mm)	12 (305)		12 (305)	
Main Spindle Bearing Inner Diameter	inch (mm)	5.11 (130)		5.11 (130)	
Main Through Spindle Hole Diameter	inch (mm)	3.43 (87)		3.43 (87)	
Main Through Bar Capacity	inch (mm)	3.03 (77)		3.03 (77)	
Main Spindle Motor (cont. /30 min.)	hp (kW)	35 (26) / 50 (37)*		35 (26) / 50 (37)*	
Main Spindle Speed Range	rpm	1 ~ 600, 600 ~ 3500		3500	
SUB SPINDLE		For 1000 and 1500 bed lengths			
Sub-Spindle Nose	ISO	—	A2-6	—	A2-6
Standard Chuck Size	inch (mm)	—	8 (200)	—	8 (200)
Sub-Spindle Motor (cont. /30 min.)	hp (kW)	—	15 (11)	—	15 (11)
Sub-Spindle Speed range	rpm	—	4000	—	4000
Sub-Spindle Through Bar Capacity	inch (mm)	—	2.0 (51)	—	2.0 (51)
TURRET					
Number of Tool Stations	—	12(SW=400)/10*			
Turret Type	—	STATIC			
Turret Type (Optional)	—	Live VDI-40*			
Turret Indexing Time	sec	0.9 (Hydraulic) / 0.15 (Servo Driver)*			
Shank Height of Square Tool	inch (mm)	1.0 (25)			
Shank Diameter for Boring Bar	inch (mm)	2 (50)			
FEEDRATE					
Rapid Traverse Rate X-Axis	ipm (M/min.)	787 (20)			
Rapid Traverse Rate Z-Axis	ipm (M/min.)	944 (24)			
Ballscrew Diameter of X-axis	inch (mm)	1.26(32)			
Ballscrew Diameter of Z-axis	inch (mm)	1.58(40)			
TAILSTOCK					
Tailstock Travel	inch (mm)	23.6 (600) 43.3 (1100) 63 (1600) 82.7 (2100) 122(3100)			
Tailstock Spindle Diameter	inch (mm)	4.33 (110)			
Tailstock Spindle Travel	inch (mm)	4.0 (100)			
Taper Hole of Tailstock Spindle	—	MT-5			
REMARKS					
Coolant Pump Motor	hp (kW)	0.75 (0.6)			
Coolant Tank Capacity	gal (L)	75 (286) / 91 (345) / 106 (403) / 112 (462)			
Floor Space	inch (mm)	L = 185.2(4704)/204.88(5204)/144.88(5704)/244.25(6204) x W = 85 (2152)			
Machine Weight	lbs (kg)	VT-27 = 15,620 (7100) / 16,940 (7700) / 18,260 (8300) / 19,580 (8900) VT-28 = 14,960 (6800) / 16,280 (7400) / 17,600 (8000) / 18,920 (8600)			

Design and specifications are subject to change without prior notice. I *Optional Accessory. I **Factory order only.

Optional Accessories

- Auto Door (L1500 or L2000)
- Bar Feeder: IEMCA V66e (5')
- Collect Chucks, 3" A2-8 S-30: Royal Accu-Length CNC
- Coolant Through Turret, High Pressure 300 psi (4GPM)
- Coolant Through Turret, High Pressure 1000 psi (8GPM)
- Glass Scale X and Y axes: Heidenhein, 5 Micron
- Manual Tool Presetter
- Manual Steady Rest, Roller Bearing Style, 1.97" ~ 9.84" range or 9.84" ~ 15.75" range
- Mounting Bracket and Hydraulic Control Kit for SLU-B-Z-3
- Programmable Tailstock and Programmable Quill
- Side Mounted Cylinder, Central Lube, with Mounting Bracket and Hydraulic Kit: SMW SLU-B-Z-3, gripping range 0.473" to 5.98" **
- Steady Rest Bracket with Hydraulic Clamp and Unclamp Solenoid Valve
- Upgrade Spindle Motor: 50 hp
- Upgrade Control: Siemens 828D with Shopturn

Standard Features

- Auto Lubrication System
- Cooling System
- Chip Conveyor
- Foot Switch for Spindle
- Fluid Bearing Way System
- Hard Jaw (1-Set)
- Heat Exchanger for Electrical Cabinet
- Hydraulic Adjustment System
- Lubrication Monitor System
- Soft Jaws (1-Set)
- Tool Box
- Work Lights



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