In 1992 EMAG was the first manufacturer to build a vertical turning machine with an inverted work spindle that traveled the main axes. EMAG continues to turn the traditional processes on their head! Every machine in the VSC series is a production cell where the pick-up spindle ensures the machine loads itself. Another advantage for the customer is that the machines of the VSC series can be customized to suit individual production requirements.
VSC – multifunctional production centers.

Machining + automation + measuring: the machines of the VSC series are configured for individual production requirements. The patented design of the VSC machines guarantees the shortest travel times between the pick-up station and the machining area, reducing idle times to a minimum. The MINERALIT® polymer concrete machine base and the twin-wall construction have an excellent vibration damping effect and offer outstanding thermal stability.

A large selection of technology modules ensures the VSC machines can be configured for customer-specific production requirements, while the availability of a variety of automation components ensures easy integration into production lines.
The VSC Series – its advantages.

- Every machine is a production cell that utilizes its pick-up spindle to load itself
- Short machining travel times and equally short workhandling times
- Multifunctional production tool: turning, drilling, milling, grinding and other processes
- The workpiece travels, while the tooling systems remain stationary
- Ideal chip flow conditions, because the tools are located below the workpiece
- The work spindle with hydro-static guideway in Z-axis (optional) ensures outstanding component quality and a high tool life for soft and hard machining operations
- All accuracy defining machine assemblies are fluid-cooled
- Safe, wear resistant, maintenance free machining area envelope
- Dry machining is easy with the VSC, because work spindle and tools are perfectly positioned
Overhead slide
Hydrostatic guideway (optional)
Pick-up station
Turret
Machine base made with MINERALIT® polymer concrete
The workpieces are transported to the pick-up station and inserted into the chuck jaws.

Twin-track loading for a quicker workpiece change.

The twin-gripper collects a raw part from each feeder band and places them on the conveyor belt.

Automation for stand-alone machines: transport the workpieces to the pick-up position and remove the machined components.
A flexible workpiece flow reduces footprint and costs.

The pick-up spindle ensures that the machines of the VSC series load themselves. Whether the workpiece is loaded or unloaded from the left or the right, the direction of the workpiece flow – and thus the position of the machines in the production line – is optional. Advantages: the footprint is smaller and link-up costs are considerably lower. Integration into manufacturing systems is guaranteed by the availability of a variety of automation components.
All machine assemblies are extremely sturdy and vibration resistant.

As the main spindle and its workpiece travel in the primary axes X, Y and Z, very sturdy tooling systems can be used to suit individual machining requirements. These tooling systems are fully integrated into the machine base, giving them great static and dynamic rigidity.

The inverted work spindle (with the inverted workpiece), with the tools being positioned below it, offers the best possible chip flow conditions.

Pick-up position: workpiece automatically picked up and put down

Machining position: turning, drilling, milling

Measuring position: workpiece being measured
MINERALIT® polymer concrete – the material that makes production dreams come true.

The machine base of all VSC vertical pick-up turning machines is made of MINERALIT® polymer concrete, a material that is characterized by damping properties eight times better than those of cast iron.

The advantages:

- Great vibration damping effect, resulting in extended tool life and superb surface finishes
- MINERALIT® polymer concrete is thermally stable which ensures constant production results.
Heavy machining made easy.

A constant temperature is required for consistent quality. The spindle motor, main spindle and quill, turret and machine base are all fluidcooled. A dual-circuit cooling unit holds the machine temperature within tight limits of the ambient temperature.

Even for jobs as hard as this one, the VSC is highly reliable in the application of its multifunctional operations: soft and hard machining, interrupted cuts, turning, drilling and milling.

All accuracy defining machine components are connected to the fluid-cooling circuit.
The EMAG turret.

The fast acting 12-station disc-type turret is known for its short indexing times. All 12 stations can be equipped with driven drilling or milling tools. The EMAG turret’s gearbox combines high speeds with great performance and minimal space requirement.

- Very high speed
  - Very fast indexing times
  - High speeds for driven tools
- High capacity
  - Small size and a high torque rate
- High precision
  - A high degree of rigidity is firmly embedded in the machine base
  - High degree of repeat accuracy due to indexing from tool position to tool position
- Maximum availability
  - Inured to collisions, owing to the use of torque motors
  - Turret does not lift off during indexing, thus preventing the ingress of dirt and chips

Machine integral quality management.

Measuring also forms an integral part of these machines. On the way from the machining to the unloading position the workpiece is measured by a probe located outside the machining area. This ensures that the results are not affected by the presence of dirt or chip particles. The measurements are also taken with the component still in the chuck.
## Technical data.

<table>
<thead>
<tr>
<th></th>
<th>VSC 250</th>
<th>VSC 400</th>
<th>VSC 400 DD</th>
<th>VSC 500</th>
</tr>
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<tbody>
<tr>
<td><strong>Capacity</strong></td>
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<td></td>
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<tr>
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<td>315 / 400</td>
<td>315 / 400</td>
</tr>
<tr>
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<td>in</td>
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<td>12.4 / 15.8</td>
<td>12.4 / 15.8</td>
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<td>420</td>
<td>420</td>
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<td></td>
<td>in</td>
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<td>16.5</td>
<td>16.5</td>
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<td>13.4</td>
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<tr>
<td>Travel in Y</td>
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<td>–</td>
<td>315</td>
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<td></td>
<td>–</td>
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<td>12.4</td>
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### Loading time

**Depending on workpiece**

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### Main spindle

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<table>
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### Main drive

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<td></td>
<td>48 / 37</td>
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<tr>
<td></td>
<td>61 / 45</td>
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<tr>
<td></td>
<td>71 / 45</td>
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<td></td>
<td>hp</td>
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<td></td>
<td>51 / 38</td>
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<td></td>
<td>64 / 50</td>
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<td></td>
<td>82 / 60</td>
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<td></td>
<td>95 / 60</td>
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<table>
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<td></td>
<td>760 / 600</td>
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<tr>
<td></td>
<td>650 / 480</td>
</tr>
<tr>
<td></td>
<td>750 / 480</td>
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<tr>
<td>ft-lb</td>
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<td></td>
<td>560 / 443</td>
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<td></td>
<td>480 / 354</td>
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<td>553 / 354</td>
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### Feed drive

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<table>
<thead>
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<th>m/min</th>
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<table>
<thead>
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<td>Large diameter</td>
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<tr>
<td>lbf</td>
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<td></td>
<td>2,473</td>
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<table>
<thead>
<tr>
<th>Ball screw X / Y / Z</th>
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<tr>
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<td>50 / –/ 40</td>
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<td>50 / 40 / 40</td>
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<tr>
<td>dia. in inch</td>
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<td></td>
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<td>2.0 / 16 / 16</td>
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<tr>
<td>Disc-type turret</td>
<td>VSC 250</td>
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<tr>
<td>------------------</td>
<td>---------</td>
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<tr>
<td>Tool receptors</td>
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<tr>
<td>for cylindrical shanks to DIN 69 880 Qty</td>
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<td>ft-lb</td>
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<tr>
<td>Full power at speed of rpm</td>
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<tr>
<td>Turret indexing time s</td>
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<td>Electrical equipment</td>
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<td>Max. equipment specification kW</td>
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<td>hp</td>
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<td>Lead fuse, min. / max. A</td>
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<td>Control system</td>
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<tr>
<td>SIEMENS SINUMERIK 840 D / Dsl</td>
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<tr>
<td>Bosch Rexroth MTX</td>
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Subject to technical changes
Technical data.

Floor plan VSC 250

Dimensions in mm
Floor plan VSC 400 / 500

Dimensions in mm

<table>
<thead>
<tr>
<th>Measurements</th>
<th>VSC 250</th>
<th>VSC 400</th>
<th>VSC 400 DD</th>
<th>VSC 500</th>
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<tr>
<td></td>
<td>in</td>
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<td>Dimension b</td>
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<td>in</td>
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<td>1,100</td>
<td>1,100</td>
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</tr>
</tbody>
</table>

Subject to technical changes
At home in the world.

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