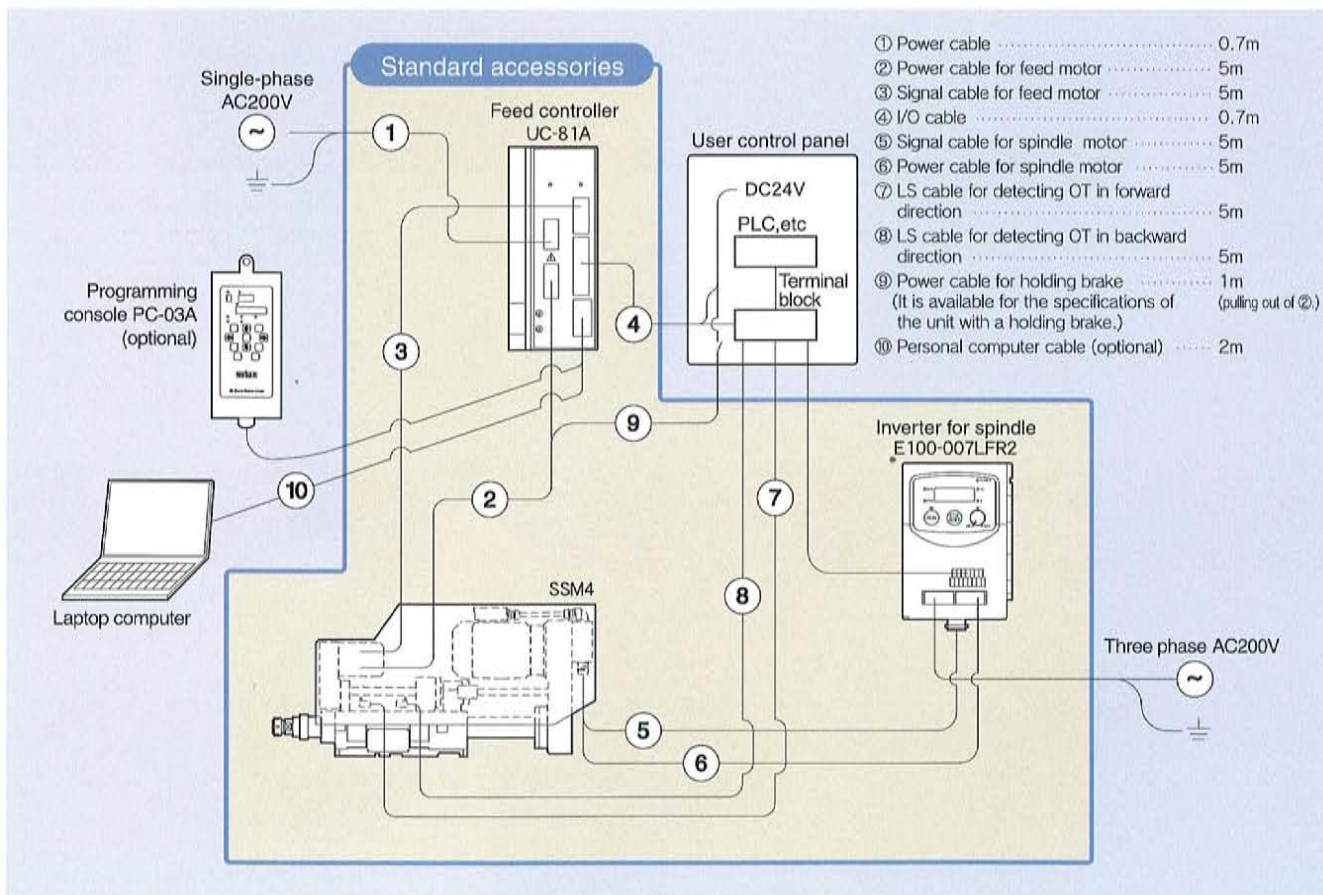


## ▶ Electric system diagram

All the electric parts supplied as standard are indicated in   box.  
The purchaser is responsible for and needs to have the other cables and units.



Notes 1. Feed controller and the inverter for spindle motor are available as standard.

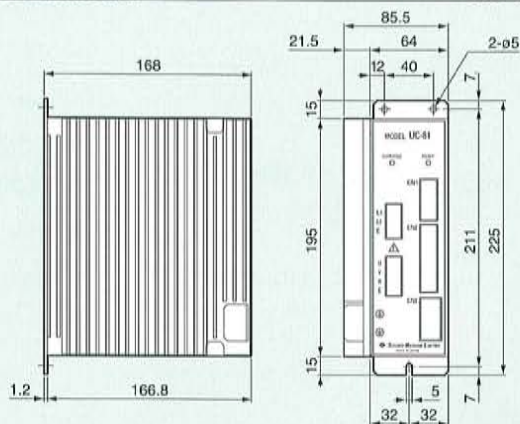
2. The programming console is optionally available.

3. Programming from a computer is possible using a computer cable. In such case, a dedicated computer monitoring software is required. Working environment: OS Window 95/98, Communication interface RS232C-port.

## ► Dimensions of standard accessories (mm)

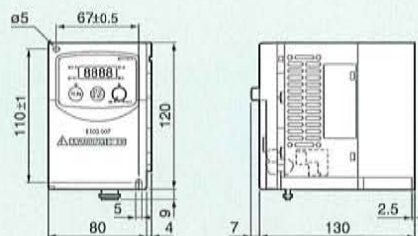
Feed controller

UC-81A



Inverter for spindle

E100-007LFR2



## ► Process patterns

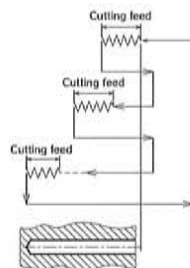
13 process patterns included in the UC-81A Controller. Reduce the cycle time with the pattern conforming to the processing specifications.

Pattern No.	Function
01	Drilling
02	High-speed deep hole drilling (Step feed drilling)
03	Deep hole drilling (Step feed drilling)
04	Quill pipe drilling (Skip feed drilling)
05	Drilling Counterboring
06	Drilling (with inching feed)
07	High-speed deep hole drilling (with inching feed)
08	Deep hole drilling (with inching feed)
09	Quill pipe drilling (with inching feed)
10	Drilling Counterboring (with inching feed)
11	Back chamfering
12	Quill pipe multi-step drilling (with inching feed)
13	2-step front/rear chamfering

### Example of process patterns

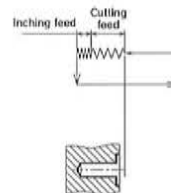
#### No.03 Deep hole drilling (Step feed drilling)

Applied for Deep hole drilling, generally referred to as Step drilling. Cutting oil is firmly delivered to edge of drill bit because the drill bit is pulled out of workpiece in each step motion.



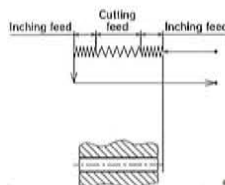
#### No.05 Drilling Counterboring

Applied to perform counterboring after drilling. Also applied to reduce burrs on the rear surface at through hole drilling.



#### No.06 Drilling (with inching feed)

Applied to reduce burrs on the both front and rear surface.



#### No.09 Quill pipe drilling (with inching feed)

Capable of inching feed for process pattern No.4 when drill biting and through-hole are performed. Helps to reduce burrs.

