

September 14, 2020

**PINEHILL MACHINING LTD.**

4405 Lobsinger Line  
RR#1 St. Clements, Ontario  
N0B 2M0

Attention: Mr. Manoah Martin

**LEADWELL T6-SMY TURNING CENTRE**  
**WITH Y-AXIS ROTARY TOOL TURRET AND MAIN + SUB-SPINDLE**

Dear Manoah,

Thank you for the opportunity to quote a **LEADWELL T6-SMY TURNING CENTRE WITH SINGLE SLIDE ORTHOGONAL Y-AXIS ROTARY TOOL TURRET AND MAIN + SUB-SPINDLE** for your facilities in St. Clements, Ontario.





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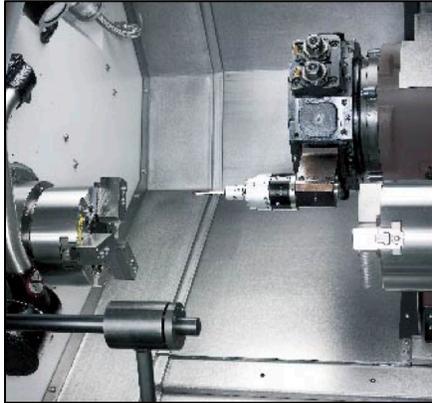
The **LEADWELL T-6SMY MULTI-TASKING MILL-TURNING CENTRE** incorporates an innovative design for outstanding performance such as:

**extra X-axis travel:**

The large X-axis travel allows for **larger maximum diameter turning / machining capacity (380mm)**.

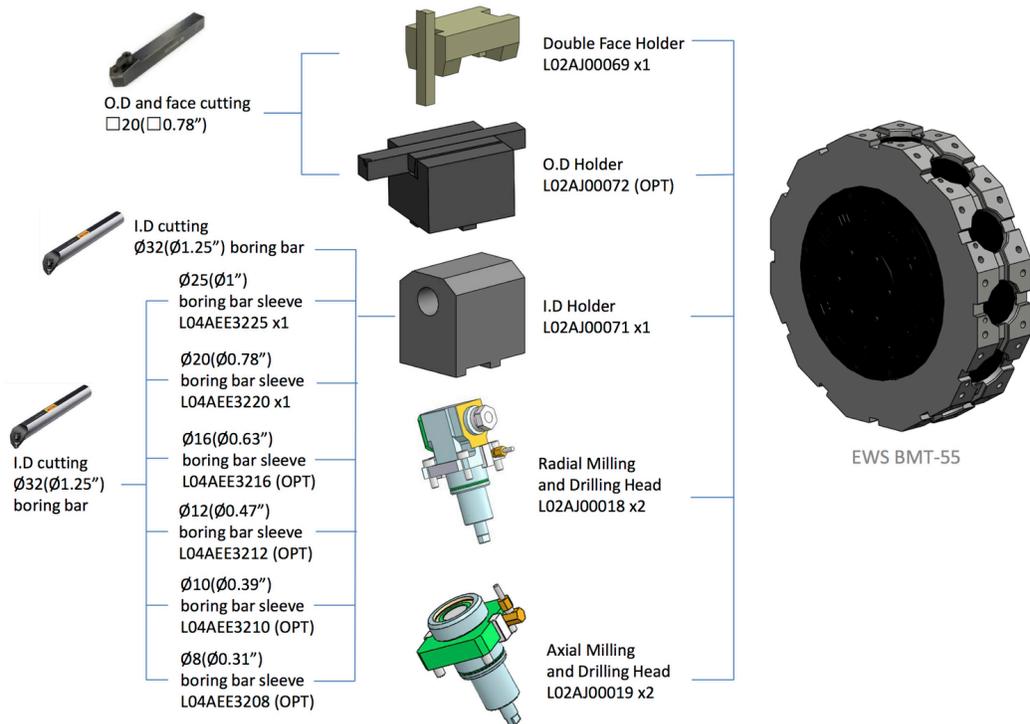
**extra Z-axis clearance:**

The extra Z-axis clearance on the headstock and the sub-spindle side allows for longer tools in the turret and for the turret to pass the sub-spindle centre line.



**rigid tool holder station:**

The 12 station **BMT-55** tool stations offer **high-torque milling with high rigidity + accuracy turning / milling capability**.





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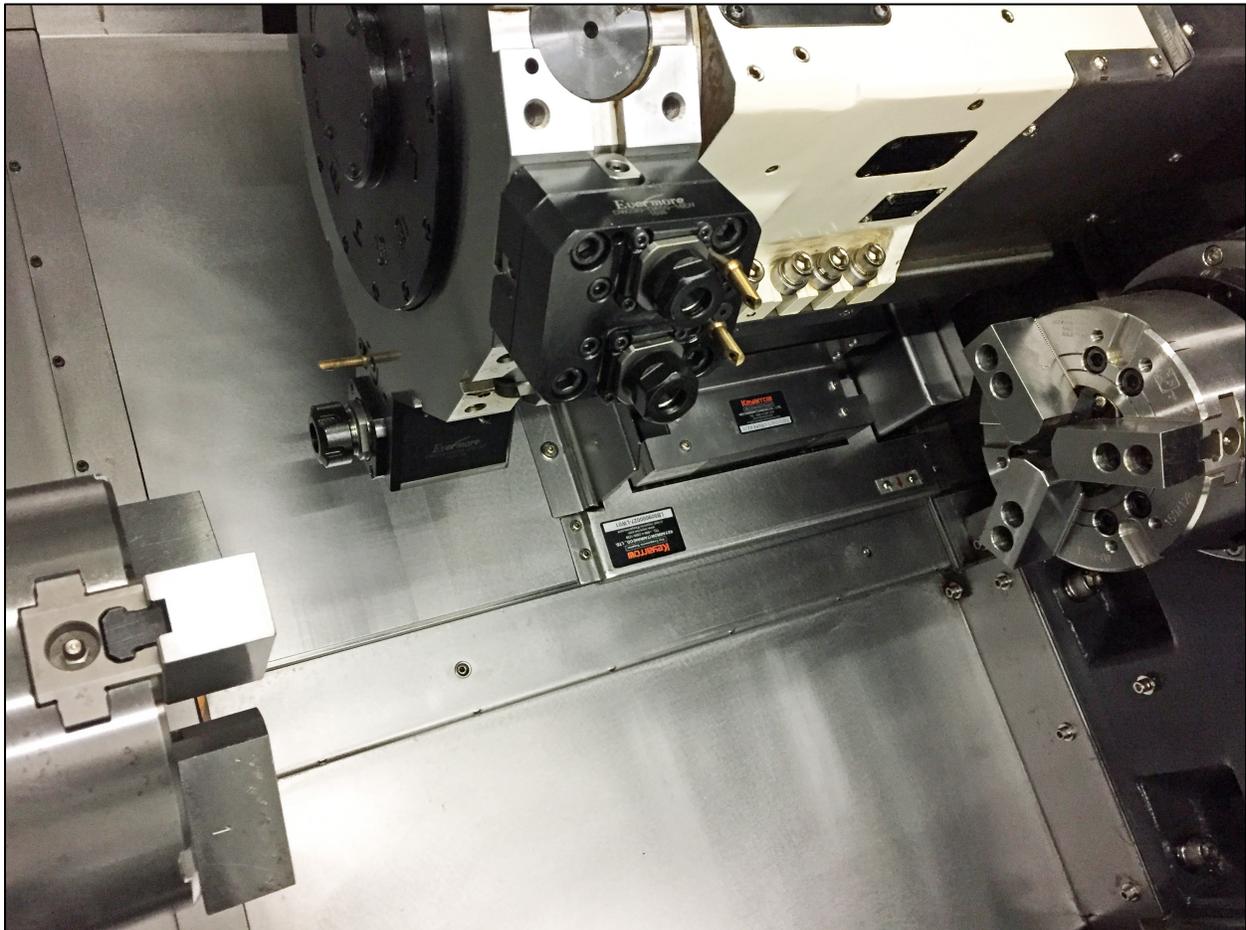
**true single slide orthogonal Y-axis:**

The Y-axis is orthogonally placed on the X-axis (perpendicular to the X-axis) to ensure the **full range of travel** (without dead zones encountered on wedge type Y-axis turning centres) and to **maximize the machining area**.

**Orthogonal Y Axis Explanation**  
Y axis is orthogonal placed on the X axis to ensure the full range of travel and to maximize the machining purposes.

**Orthogonal Y axis**  
No dead area within it's travel

**Virtual Y axis**  
There will be dead area within it's travel, and requires complex programs.

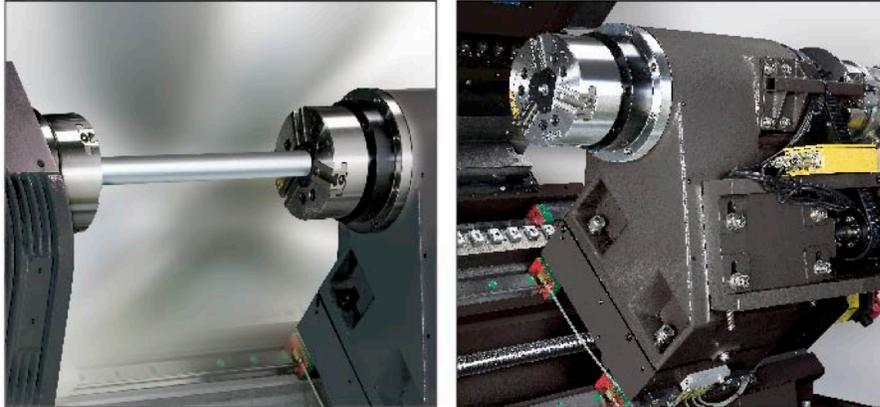




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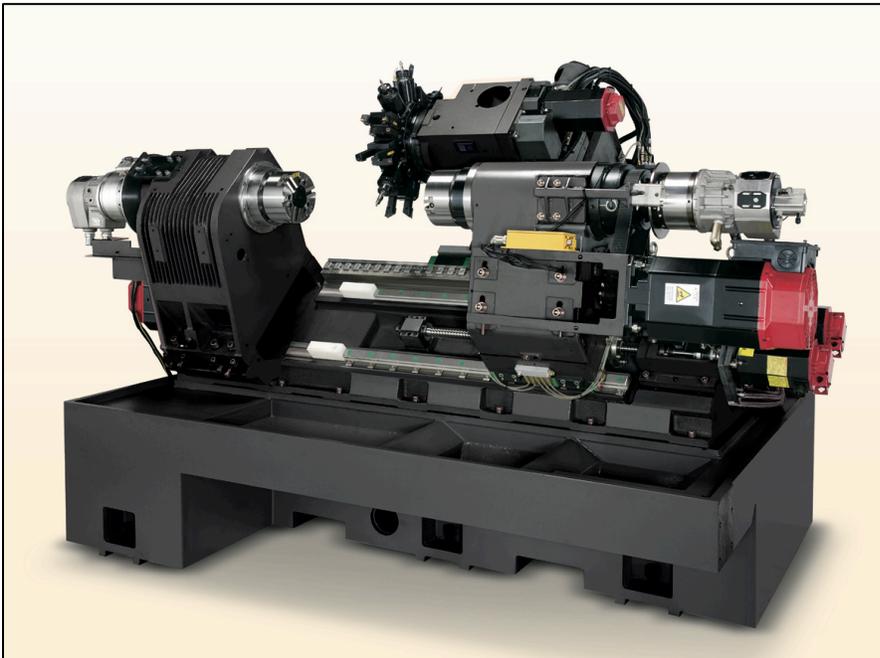
**high power sub-spindle:**

7.5kW motor sub-spindle with A2-5 nose and 6" 3-jaw hydraulic chuck offers **powerful high-torque (79Nm) second side turning capability.**



**heavy-duty machine frame:**

The 4600kg heavy-duty machine frame offers **long term heavy-duty performance.**



## MACHINE SPECIFICATIONS:

### CAPACITY

maximum swing	450mm (17.7")
maximum turning diameter	410mm (16.1")
maximum turning length	458mm (18")

### TRAVEL

X axis	190 + 15mm (7.48" + 0.59")
Y axis	+/- 50mm (+/- 1.96")
Z axis	450mm (17.7")
Z2 axis	500mm (19.68")
C-axis	360 degrees

### MAIN SPINDLE

main spindle nose	A2-6
maximum main spindle speed	4000 rpm
main spindle bar capacity	65mm (2.55")
maximum main spindle power	11/15kW (14.75/20 hp)
hydraulic chuck diameter	8"
C-axis minimum spindle indexing increment	+/- 0.001 degree

### SUB-SPINDLE

sub-spindle nose	A2-5
maximum sub-spindle speed	6,000 rpm
sub-spindle bar capacity	41.275mm (1.625")
maximum sub-spindle power	5.5/7.5kW (7.4/10 hp)
hydraulic chuck diameter	6"
C-axis minimum spindle indexing increment	+/- 0.001 degree

### Y-AXIS ROTARY TOOL TURRET

number of tool stations	12
tool holder type	EWS BMT55
square tool shank size	20mm (0.8")
boring bar holder inside shank diameter	32mm (1.3")
maximum rotary tool speed	4,000 rpm
maximum rotary tool motor power	3kW (4 hp)

### FEED RATE

X axis rapid feed rate	15m per minute (590" per minute)
Y axis rapid feed rate	7.5m per minute (295" per minute)
Z axis rapid feed rate	30m per minute (1181" per minute)

### ACCURACY

X/Z axis positioning accuracy over 1000mm	+/- 0.015mm (+/- 0.0006")
X/Z axis repeatability	0.01mm (0.0004")



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### **BED + SLIDE**

overall bed guide width	332mm (13")
cross slide guide width	231mm (9")
Y axis guide width	231mm (9")
angle of bed	45 degrees

### **FEED MOTORS**

X/Y axis motor power	2.3kW (3 hp)
Z axis motor power	3.5kW (4.7 hp)
X/Y axis motor static torque	11.56Nm (8.5 ft-lbs)
Z axis motor static torque	16.46Nm (12.1 ft-lbs)

### **BALL SCREWS**

X axis diameter x pitch	32mm x P10
Y axis diameter x pitch	32mm x P5
Z axis diameter x pitch	32mm x P10

### **MISCELLANEOUS**

electric power supply	400V / 40kVa
machine length x width x height	3014 x 2060 x 2000mm (118.6" x 81.1" x 78.7")
machine weight	4600kg (10,141 lbs.)

*Note: Specifications are subject to change without notice.*

### **STANDARD + INCLUDED EQUIPMENT**

- Fagor 8060 control\*
- heavy duty box ways on X + Y axis and linear roller ways on Z-axis
- fully enclosed guarding
- work light
- leveling screws + pads
- maintenance tool box
- buzzer
- foot pedal switch
- bullet proof glass window
- high/low pressure control on the main spindle hydraulic chuck
- automatic tool setter on the main spindle
- chip conveyor with cart
- tool holder package:
  - two (2) radial rotary tool holders
  - two (2) axial rotary tool holders
  - four (4) boring bar holders
  - four (4) turning tool holders

**PACKAGE PRICE:**

**US \$159,900**

**SPECIAL PACKAGE PRICE FOR STOCK MACHINE:**

**US \$149,900**



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**\*FAGOR 8060 CONTROL WITH 15" HIGH RESOLUTION COLOUR LCD MONITOR**

- 3D colour graphics
- fully conversational programming + standard EIA format G-code programming, including both formats in a single program
- RS232 / Ethernet / USB interface ports
- collision detection
- retrace function
- 200 user definable M functions
- feedrate in inverted function of time
- linear/helical/circular/cylindrical/polar coordinates
- mirror image, scaling, coordinate rotation
- custom macro programming
- g-code programming with on-screen help feature
- DXF file upload for conversational programming cycle
- tool life monitoring + tool inspection
- simulation with execution time estimate
- back ground programming + editing
- optional stop/block skip function
- 2GB program capacity with 2GB compact flash memory
- high speed machining mode with up to 200 blocks look-ahead, 1 ms block processing time
- g-code generation through conversational programming
- free off-line programming software on the customer's computer
- Fagor remote support program (allowing Fagor to remotely connect to your machine through [TeamViewer](#) to assist in "machine-down" diagnostics, trouble shooting tooling problems and provide programming assistance - all at no charge during the warranty period)



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**FAGOR 8060 REMOTE SUPPORT PROGRAM:**

# FAGOR Remote Support Program

Did you know that a Fagor Automation engineer can remotely connect to your CNC controller and assist in 'machine-down' issue diagnostics, troubleshooting a tooling problem, or even provide programming assistance? This service is free during your system's warranty<sup>1</sup> period, and is now available for a fee (one-time or annual programs are available), for the life of your Fagor CNC Controller.



We're so confident that our engineer can resolve your issues remotely, that we'll give you a 20% discount on any subsequent and required onsite service rates if we can't fix it remotely.<sup>2</sup>

## Post Warranty Remote Support Pricing

### One-Time Only Agreement

There will be a connection fee of \$100 CAD, which includes one hour of service/support. Each additional hour will be billed at \$60 CAD...there is a 2-hour minimum.

### Ongoing/Annual Agreement

There will be a monthly recurring payment of \$80 CAD for a single machine, \$130 CAD for 2 machines, \$180 CAD for 3 machines, or \$220 CAD for 4 machines, at a single site (for more than 4 machines at a single site, please contact Fagor service for Special Pricing). This will include 2 support sessions per month, per machine, with a maximum of 4 hours support, per session. Additional hours of support will be billed at \$60 CAD. All software updates and upgrades (where possible) will be free for any machine(s) under an annual remote service agreement. Sessions are non-transferrable to other machines...support is tied to the registered serial number(s).

**Contact:** Fagor Service Department  
**Phone:** (905) 670 7448  
**Email:** [service@fagorautomation.on.ca](mailto:service@fagorautomation.on.ca)

## Request Fagor Remote Support

Company Name: \_\_\_\_\_

Primary Site Address: \_\_\_\_\_

Fagor CNC Controller: 8060 8065 8070

Machine Type: Mill Lathe VMC Other

Programming: G-Code Conversational

Number of Machines under Agreement: \_\_\_\_\_

Duration of Agreement: One-Time Only

Ongoing/Annual Agreement

Payment Method: Fagor Account Terms

Credit Card: VISA MasterCard

Contact Person: \_\_\_\_\_

Phone: \_\_\_\_\_

Email: \_\_\_\_\_

<sup>1</sup> Warranty period for domestically purchased CNC systems is 2 years from registration date. Warranty for imported machines is 1 year from completion of the install.

<sup>2</sup> Requires current enrollment in an online service agreement. Normal service rate pricing will apply, to obtain 20% discount. No other discounts will apply. Discount applies to labor hours only. Travel hours will be billed accordingly, without discount. Travel expenses, hotel accommodations, rental car, etc. will be billed at actual costs.

Fagor Automation Canada. 3-6380 Tomken Road, Mississauga, ON Tel (905)670 7448 Fax (905) 670 7449

7490 MacDonald Road, Unit 120, Delta, British Columbia V4G 1N2, 800.913.4434  
854 78 Avenue, Edmonton, Alberta T6P 1L7, 780.466.4693  
940 Winston Churchill Boulevard, Oakville, Ontario L6J 7X5, 905.845.4434

## TERMS AND CONDITIONS

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### **The pricing**

Pricing shown is in US funds.

The above pricing is F.O.B. Masteel in Oakville, Ontario.

Applicable taxes are extra.

CSA approval is included in the pricing.

### **The payment terms**

30% with order, 60% before pick-up, 10% 30 days after delivery.

### **Warranty**

Two (2) years on parts & labour.

### **Delivery**

Stock at Masteel in Delta, British Columbia, subject to prior sale.

#### **\*CUSTOMER'S RESPONSIBILITY**

- Pick-up the machine at Masteel in Oakville, Ontario.
- Off load the machine from the truck at the customer's site.
- Move the machine into place for assembly.
- Foundation per requirements.
- Power to the machine.
- Hydraulic + way lube oil plus coolant fluid for the machine.

#### **\*MASTEEL'S RESPONSIBILITY**

- Assemble / level the machine on the customer's shop floor and anchor the machine to the customer supplied foundation if required.
- Complete the machine installation and accuracy test.
- One day of basic machine operator training.

Pre-Start Health and Safety Review (PHSR) is the responsibility of the customer and is not included in the above pricing.

This proposal is valid for thirty (30) days.

We look forward to working with you on this project.

Sincerely,

**MASTEEL AMERICA CORPORATION**

Ron Nater

Manager, Eastern Canada

phone: 647.270.4434

email: [ron@masteels.com](mailto:ron@masteels.com)

website: [www.ronnater.ca](http://www.ronnater.ca)