

# 250 UPL<sup>v3</sup> Compact Diamond Turning Lathe

(Available with 2, 3 or 4 axes)



## *v3 Series* - Major Technology Advancements

- **10,000 RPM Impact Resistant** Porous Graphite Air Bearing Work Spindle with less than 12.5nm motion error throughout entire speed range and **0.01 arc second** C-axis resolution.
- Industry leading **8 picometer** linear feedback resolution.
- **Delta Tau ARM Quad Core Processor** with DAQ data streaming module. Offers 4X increase in computational power compared to single core processor and ability to monitor machine health throughout a cut for process refinement.
- Dedicated Ethernet / LAN connection allows real-time monitoring and control of the machine by the factory (or the customer) to remotely evaluate all control functions for instantaneous diagnosis and troubleshooting of any control or programming problems.
- **NanoSMART<sup>®</sup>** - Industry's First Touch / Swipe Gesture Based Interactive HMI with numerous new value added features including ability to process up to 5GB program file sizes.

# Nanotech 250UPL<sup>v3</sup> Specification Overview

General	Description
System Configuration	Ultra-Precision two, three, or four axis CNC contouring machine with "T" axis orientation
Workpiece Capacity	300mm diameter x 200mm long - (238.2mm diameter swing capability over top of optional rotary oil bearing B-Axis) (Note: additional swing capacity available upon request)
Base Structure	Natural Black Granite with integral slide channels and protective stainless steel apron
Vibration Isolation	Optimally located air isolation system. Optional Shear Damped Air Isolation System with Self Leveling
Computer System Specifications	Intel i5 2.4 GHz processor running Windows 64-bit with 16GB DDR3 1600MHz memory, 10/100/1000 Base-T external customer Ethernet connection, DVD RW Drive, 500GB 7200 RPM removeable Hard Drive. Pendant features dual 22" and 16" wide projected capacitive multi-touch displays. Customer USB ports provided on front of PC and also on operator pendant.
Control System	Delta Tau 1.2GHz Quadcore ARM based PowerPMAC Embedded Real-time 64-bit Linux Motion Controller with Nanotech's NEW Windows based HMI with a Touch / Swipe Gesture Interactive display.
Programming Resolution	0.01 nanometer linear / 0.000001° rotary
<b>Functional Performance</b> (As measured with laser interferometer & white light interferometer on <u>same</u> part)	Material – High Purity Aluminum Alloy Form Accuracy (P-V): ≤ 0.1µm / 75mm Diameter, 250mm Radius convex sphere Surface Finish (Ra): ≤ 2.0 nanometers <i>(Important Notice: Both Form &amp; Surface Finish measured on the same part, same surface!)</i>

Workholding Spindle	Heavy Duty (Standard)
Type	Exclusive impact resistant porous graphite air bearing with center mounted thrust face
Liquid Cooling (optional)	To maintain thermal stability and tool center repeatability, a closed loop chiller provides recirculating temperature controlled water to cooling channels located around the motor and bearing journals of the air bearing spindle. The chiller has an integral PID controller which maintains temperature control to ± 0.1°C.
Speed Range	50 to 10,000 rpm, bi-directional
Swing Capacity	Up to 300mm diameter (without optional risers)
Working Load Capacity (Radial) <sup>1</sup>	85 Kg @ 7bar (185 lbs @ 100psi.) / 102 Kg @ 10bar (225 lbs @ 145psi) @ spindle nose
Working Load Capacity (Axial) <sup>1</sup>	180 Kg @ 7bar (397 lbs @ 100psi.) @ spindle nose
Radial Stiffness (@ spindle nose)	130 N/µm @ 7bar (743,000 lbs/in @ 100psi)
Axial Stiffness	438 N/µm @ 7bar (2,500,000 lbs/in @ 100psi)
Drive System	Frameless, Brushless DC motor
Motion Accuracy	Axial: ≤ 12.5 nanometers (0.5µ")      Radial: ≤ 12.5 nanometers (0.5µ")

Linear Axes	X	Z	Y (Vertical) – Option
Type	Fully constrained oil hydrostatic, box way slide	Fully constrained oil hydrostatic, box way slide	Fully constrained oil hydrostatic box way slide with adaptively controlled air bearing counterbalance to negate gravitational forces & varying loads.
Travel	200mm (8")	200mm (8")	100mm (4")
Drive System	Brushless DC Linear Motor	Brushless DC Linear Motor	Brushless DC Linear Motor
Feedback Type	Laser holographic linear scale	Laser holographic linear scale	Laser holographic linear scale
Feedback Resolution	0.0084 nanometer	0.0084 nanometer	0.0084 nanometer
Feed Rate (maximum)	4500mm/min (upon request)	4500mm/min (upon request)	1500mm/min
Straightness in critical direction	0.2µm (8µ") over full travel	0.2µm (8µ") over full travel	0.2µm (8µ") over full travel
Hydrostatic Oil Supply	Compact, low flow, low pressure system with closed loop servo control and pressure accumulator to minimize pump pulsation.		

Optional Rotational Axes	B	C (Work Spindle Option)
Type	Oil Hydrostatic	Porous Graphite Air Bearing (liquid cooled)
Travel	360° (Bi-directional)	360° (Bi-directional)
Drive System	Brushless DC motor	Brushless DC motor
Axial Stiffness	875 N/µm (5,000,000 lbs./in.)	See <b>Workholding Spindle</b> Specifications Listed Above
Radial Stiffness (at nose)	260 N/µm (1,500,000 lbs./in.)	See <b>Workholding Spindle</b> Specifications Listed Above
Positioning Accuracy	± 1.0 arc seconds (compensated)	± 1.0 arc seconds (compensated)
Feedback Resolution	0.005 arc seconds	0.01 arc seconds
Maximum Speed (Positioning Mode)	50 rpm	3,000 rpm
Motion accuracy	Axial: ≤ 0.1µm (4µ")      Radial: ≤ 0.1µm (4µ")	Axial: ≤ 12.5nm (0.5µ")      Radial: ≤ 12.5nm (0.5µ")

Utility Requirements	Air	Electrical	Machine Footprint (includes utilities cabinet)
For optimal cutting results, facility thermal stability should be held within ±0.5°C (±1.0°F)	7 to 10 bar (100 – 145 psi) 280 liters/min (10 scfm) Dry to 10°C pressure dew point and pre-filtered to 10µm	230 VAC; 1 Phase; 50/60hz (35 amp) (3 phase available by request)	1.50m L x 1.30m D x 1.6m H; Approx. 1,500 Kg (Enclosure & Utilities Cabinet included, but not control pendant. Contact Nanotech for complete overall detailed layouts.)

Warranty	1 year full parts and labor warranty
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Notes: <sup>1</sup> Working Load Capacities shown above are defined at 60% of ultimate load capacities.  
In an effort to continually improve our product performance, specifications are subject to change without notice.  
(Please consult your Sales Representative for our latest specifications).