



The VMC “Spindle Meter”

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Hardinge Inc. expands Vertical Machining Center Product Line

When you hear the name **Hardinge** what do you think of? Many people will say super-precision tool-room, & CNC lathes and collets. Hardinge has broadened their image to include a wide array of products.

One of these products is their line of Vertical Machining Centers. With the series II machines, Hardinge offers a High-Torque series of three machines designed for your heavy metal removal operations. These machines feature a 17.3 hp. Vector spindle drive with 8,000 RPM and 175 ft. lb. torque rating. The 2 speed gear ZF planetary-type gearbox uses an oil recirculating unit and



Hardinge High -Torque VMC 600 II, 800 II & 1000 II

heat exchanger for cooling. Power is transmitted by a herringbone-type belt and pulley arrangement. Helical sun gear design offers lower load per tooth than strait or spur tooth gears. The results are a quieter, smoother, running spindle and a stronger,

longer lasting gear configuration. A 6 row, linear recirculating bearing guideway system are employed for all axis motions on the High Torque models. 1.575” ballscrews are also featured on these machines.

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H & H Machining purchases New Hardinge VMC 1000 II

H&H Machining is a job shop located in Green Bay, Wisconsin. Established in 1989, Paul Heezen started the business in his garage with a used Hardinge HC lathe, which is still in use today.

Gradually he has expanded and taken on

more machinery. Eventually he made the decision to purchase a vertical machining center. After much research, he decided to purchase the Hardinge VMC 1000 II in May of 2000.

“I bought the VMC 1000 II because of it low cost, solid structural design

and Hardinge’s outstanding reliability.”



Kevin and Paul Heezen

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Barnant's VMC Turnkey Increases Output

Barnant Corporation is located in Barrington, Illinois & manufactures pumps, flow meters and laboratory equipment. They have been a good Iverson & Company and Hardinge customer since the days of their DSM-A purchases. Their most recent acquisition was a Hardinge VMC1000II.

Bob Krejci is the machine shop foreman at Barnant who was involved in the decision to buy the Hardinge VMC. Listed are some of Bob's comments on various facets



Bob Krejci, Foreman, Barnant Corporation

of their Hardinge VMC purchase:

TURNKEY "The turnkey we received from Iverson & Company was completed on time. We were very happy with the service we received from the applications personnel at Iverson. We are happy with the fixtures designed by Iverson. It was a lot less costly than we expected."

TRAINING "With the local training that we received, we were able to set up & operate the machine at Iverson using our parts — that way when the machine was delivered we were able to run parts right away!"

MAINTENANCE "We like the use of grease instead of way lube because it eliminates the contamination of the coolant. The flood coolant

removes chips from parts and fixtures."

"We are happy with the fixtures designed by Iverson. It was a lot less costly than we expected.."

REPEATABILITY "The accuracy and repeatability of the Hardinge VMC allows us to hold the tight tolerances of our parts. We have to hold .0005" total on our bores."

MACHINE FEATURES "The rapids of the Hardinge are faster than other machines we have in house."

EASE OF USE "We really like the air blast on the spindle that keeps the tools free of chips. The ability to service the tools from the side door, and the remote handle jog both make it easier for the operator."

H & H Machining cont...

"Upon receiving the machine, I had it outfitted with a Haas Model HRT210 indexer that was wired into a spare M-code on the machine's controller, also available by Hardinge"



VMC 1000 II with Haas HRT 210 indexer attached.

"With the purchase of the VMC, a training program was provided by the

good people at Iverson & Co. We found the class to be very informative and well worth our time."

Paul continued, "Since I've had the machine, I've been most impressed by the control's ease of use, its fine precision and its excellent repeatability."

I could not believe the results and the difference this machine has made. Not only has this purchase

pleased my current customers, it has allowed me to take on new accounts and other various types of work."

"I bought the VMC 1000 II because of its low cost, solid structural design and Hardinge's outstanding reliability."

"My experiences with Hardinge and the machinery they provide have been great."

"I look forward to continuing my business with Hardinge and the people at Iverson & Company."

Iverson has many value added VMC offerings



Iverson & Company is excited to announce Hardinge's recent expansion in their VMC product offering. Starting at IMTS 2000 Hardinge introduced 3 different sizes, with 2 different controls, and 3 different versions of each size. The three sizes that Hardinge now offers are 600, 800 & 1000 mm. There is a standard, high torque and high-speed model of each size. In addition customers can choose to purchase either 2 different Fanuc controls or a Siemens control on these machines. (see photo)

Iverson & Company has offered VMC's in their product offering to customers since 1988. This recent

development allows us to offer one stop shopping for our customers. We also offer full fixture design and manufacture as well as turnkey capabilities.

President Terry Iverson had some comments on the VMC line: "I am very pleased with Hardinge's commitment in the VMC area. They have really studied the market and responded. Iverson & Company has also interfaced programmable rotary products through the standard spare M codes. They have also stock machines, so that when customers need a quick delivery, we are able to give it to them. We have also linked up with Midaco on their automatic pallet changers in order to offer our customers a more automated solution."

Hardinge Inc. expands VMC Product Line cont...

To compliment the commitment to the machining centers, Hardinge has also gone into CAT40 toolholders. People already call Hardinge and order collets for their machines, why not order your milling holders as well? In addition to precision, quality, and competitive pricing Hardinge customers call for quick delivery. This premise is what drove Hardinge to step into the milling toolholder products as well.



The Series II Vertical Machining Center product line also includes high speed product models. These machines feature a 12,000 RPM ceramic bearing spindle as standard equipment. (A 30K RPM version is available) Power is transmitted by three triple-ribbed and two double-ribbed V-belts, providing a cooler running spindle with stable thermal dynamics for high-speed machining.

The mechanical design of the base include x & y linear guideways that produce less heat and thermal growth to provide longer machine life and overall machining consistency compared to box ways. Rapid traverse rates are 1181 IPM for reduced cycle times. Superior Hardinge design



includes 3 guideways and 5 guide trucks on each axis.

All axes also feature direct-drive, double-nut 1.26" fixed and pretensioned ball screws.

OPTIONS THAT ARE OFFERED FOR ALL MODELS INCLUDE:

Renishaw tool & part probes, Twin 20-Tool Automatic Tool Changer, Chip Conveyor, Liner Scales, Advance Mold Packages, Thru-Spindle Coolant, Fanuc or Siemens CNC Control. 4th & 5th Axis Rotary units, Power transformers, & Swing Arm Tool Changers.

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Hardinge

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CE Package Available

Local Company Stocks, Sells and Supports Haas Rotary Products

Iverson & Company of Des Plaines, Illinois, has offered Haas rotary products for sale since 1984. Since that time Iverson has become one of the nation's largest rotary product distributors for Haas.

Some of the items that have allowed Iverson & Company to succeed are:

Stock of Haas indexers and tables

Repair capabilities in house

Rental Units for short term needs



Haas Dual-Spindle Indexer

Financing of Haas rotary units

Jim Flauter has been our Haas service technician since 1988. Jim handles parts orders, application questions, as well as repairs for our customers. This long term commitment assures you that Iverson & Company customers will get correct answers in a timely fashion.

Turnaround on rotary repairs are usually less than 5 days. This is usually less time than it takes to ship the unit out to California.

Some of the other personal touches that we offer when you buy a Haas unit are:

Salesman delivers unit to you in our territory.

Salesman will train you on the unit.



Jim Flauter repairing a Haas unit

Rental unit while your unit is in for a lengthy repair, or loaner during warranty repair.

We have even provided Haas full fourth axis units for Hardinge VMC's. This involves putting a Fanuc motor in the Haas table and making a special motor cabling.

Give us a call when you have rotary requirements for your VMC.