

Model 77 | CNC Machining Centers

5 Axis



THERMWOOD

F i r s t i n C N C R o u t e r s

MADE IN USA 

www.thermwood.com

5 Axis Model 77

Thermwood, the industry leader in 5 Axis applications with more five-axis systems in operation than any other company has developed a heavy duty large contained system for machining large Aerospace and Composite materials.

This robust system offers a variety of options and features to tackle a multitude of different applications. The M77-510 is a heavy duty, high speed five-axis CNC router specifically developed for three dimensional machining. This stationary table high wall machine was designed using advanced 3D software utilizing Finite Element Analysis. All major weldments including the base and gantry are stress relieved to provide long term stability.

Thermwood CNC Machining Centers

- Laser Calibrated to assure the most accurate absolute positioning and repeatability.
- Full five-axis simultaneous motions.
- Execute extremely large CAD generated programs at high speed without pausing.
- Automatic Axis Alignment Verification.

Machine Features Shown

- 12 HP Spindle (3,000-24,000 RPM)
- Impact Resistant Head
- Moving Gantry
- 36" Vertical Z Axis
- QCore SuperControl
- 10 Position Rotary Tool Change System
- Fixed Drill and Tapped Aluminum Table (optional)
- Access doors (optional)
- Siemens Intelligent Servo Drives Throughout
- 3-D Laser Compensated Axis Alignment
- Control Networking
- Machine Training and Installation



Table Sizes Available

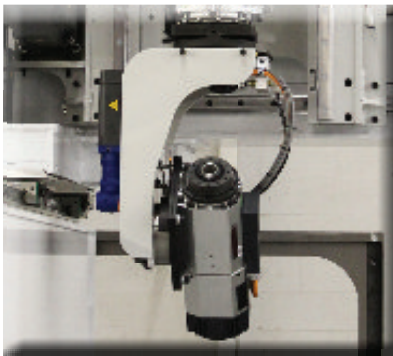
- 5' x 10' Fixed Table
(Larger sizes available)

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Thermwood Advanced Technical Features

- ◆ **Linear Laser Compensation** – This procedure is standard on all machines during the construction phase and compensates for inherent variances in components during machine construction.
- ◆ **Volumetric 3D Laser Compensation** – This procedure is standard on all machines prior to shipment to our customers. This feature compensates for position errors within the three dimensional working envelope of the machine.
- ◆ **Fixture Placement Compensation** - Allows the user to mechanically locate three points on a fixture during initial program set up. These points are used as reference for our controller to automatically align the program to the new fixture location.
- ◆ **Constant Tip Speed Machining** – Automatically varies the machine feed speed to allow the tip of tool to maintain a constant speed. This feature synchronizes the linear and rotary movements ensuring a constant and smooth cutting motion.
- ◆ **Tip Center Rotation** - Allows for maintaining tool tip positioning when commanding a rotary axis to move in coordination with two or more linear axis.
- ◆ **Impact Resistant Head** – A positive locating joint between the axis 5 arm and the rest of the machine. Decreases the amount of force applied to the head in the event of a collision, diminishes the need for realignment, and reduces fixture and spindle damage.
- ◆ **Remote Diagnostics** - provides direct, live, visual contact from the machine control to Thermwood's Service department. Diagnose, troubleshoot and configure the control remotely with a certified Thermwood service technician.
- ◆ **Advanced Communications** – Communication features available between the operator and the Thermwood QCore Supercontrol allows the operator to electronic search the programming and maintenance manuals, view maintenance videos, error reporting, maintenance tracking, and dynamic exploded assembly drawings.
- ◆ **Single Source Service** – Thermwood factory service for both the CNC Control system and the CNC Machine.
- ◆ **Control Upgrades** – On going control upgrades. The evolution and latest features of our control system is available at www.thermwood.com

Machine Standard Options



12 HP Spindle

A direct driven spindle with a speed range up to 24,000 RPM. The High Frequency Spindle is cooled with an electric fan for quieter running and contains ceramic bearings for longer life. The spindle motor is greased for life, for less maintenance. The 12 HP spindle provides the user with a heavy duty, precision spindle which provides high performance and reliability. **Standard**

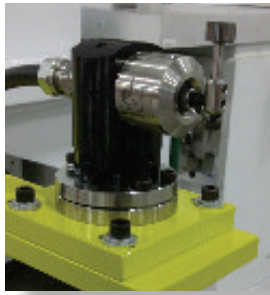
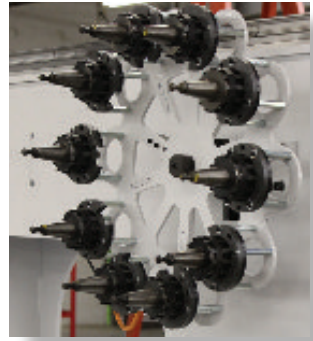
Impact Resistant Head

A positive locating joint between the axis 5 arm and the rest of the machine. Decreases the amount of force applied to the head in the event of a collision, diminishes the need for realignment, and reduces fixture and spindle damage. **Standard**



Automatic Tool Change System

Ten position rotary tool change system which is mounted to the wall of the machine and holds the tapered tool holders. When the program calls for a tool change, the head moves to rotary tool change system and places the tool into an empty space, then the system rotates the appropriate tool, and then continues the program. **Standard**



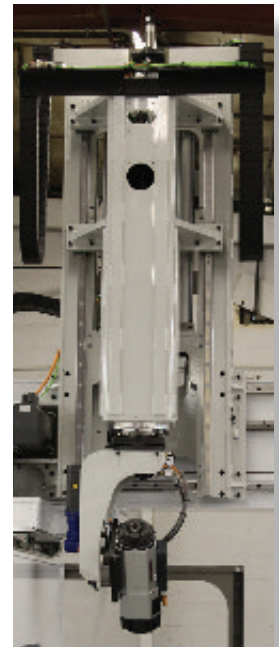
High Tolerance Tool Length Sensor

The TS27R is the standard tool setting probe for machining center applications. A compact, robust design allows simple fitment to the machine bed or bracket mounting where appropriate. **Standard**

Machine Options

21.5 HP Spindle

A direct driven HSK F63 spindle with a speed range up to 24,000 RPM. The High Frequency Spindle is cooled with a IDEA 1600 chiller and contains ceramic bearings for longer life. The spindle motor is greased for life, for less maintenance. The 21.5 HP spindle provides the user with a heavy duty, precision spindle which provides high performance and reliability.



Increased Z Axis Stroke

This option extends the Z Axis movement from the standard 36". Travel for trimming taller parts or parts which require more daylight clearance. 48" and 60" Z Axis Strokes are available.

Continuous C axis

The continuous C axis improves system performance by simplifying operations and eliminates the possibility of damaged wire within movable joints. Maintenance-free metal contacts provide long life with error-free data communication transmission. (not available for use with the 21.5 HP Spindle)



5 Axis Chip Collection Hood

The chip collection hood consists of the piping, ducting, hoods and swivels which attaches directly to the machine. The chip collection hood requires 1300 CFM at 30" WG total static pressure. (collector not included)

Automatic Lubrication System

A pressurized greasing system which continuously applies lubricant with a polyurethane foam pinion using a special grease based on lithium/calcium complex with extreme pressure additives.

Work Table

60 inch wide by 120 inch deep stationary table. Drilled and tapped, aluminum table surface for 3/8-16 threaded inserts on 12" centers starting 6" from edge of table. (Larger sizes available)

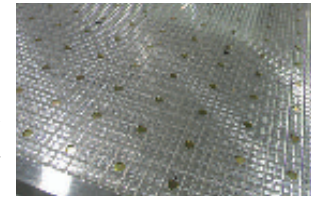


Vacuum Plumbing

The machine table is equipped with conventional vacuum hold-down system. Includes a valve and fixture plumbing connection mounted on the front edge of the table. Two separate 1 inch connection locations for the vacuum pump are located at each end of the table. (Vacuum pump sold separately)

Multi-Function Vacuum Table

A universal table that allows the table to be used with pods, conventional vacuum or universal vacuum. The table consists of a machined aluminum grid top with an aluminum plenum underneath along with a pattern of threaded hold-down holes and o-ring sealed vacuum ports.

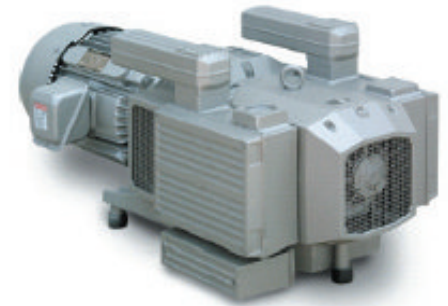


5 HP Vacuum Pump

The 5 HP Vacuum Pump generates 63 CFM and 29 IN Hg. Includes vacuum hose to machine.

15 HP Vacuum Pump

15 HP Combination Vacuum Pump generates 330 CFM and 29 IN Hg. Includes vacuum hose to machine.



18 HP Becker Pump

The 18 HP Becker Pump has a capacity of 280 CFM open flow, and maximum vacuum 22.5" Hg. Includes approximately 15 feet of vacuum hose channeled from pump to the machine base.



Access doors

Heavy duty metal entrance doors that operate on linear rail and bearings. Doors have polycarbonate viewing windows and are located on both ends of the machine.

Position Verification System

This option utilizes the position sensing probe to verify specific X, Y, and Z surface location points created using a CAD/CAM generated NC program. The position sensing probe is manually inserted into the spindle and measures fixture location and automatically modifies the program to compensate for location deviations.



Remote Start/Stop Pedestal

The remote pedestal with start/stop switch is a free standing pedestal located near the machine, includes a 30 foot cable.

QCore SuperControl

Thermwood, the only major CNC router manufacturer that designs and builds its own CNC control, is a leader in implementing advanced control technology. The QCore SuperControl incorporates more advanced control features than any other CNC control in the industry. And, because Thermwood provides all the technology, you have single source responsibility. Thermwood stands behind and supports the entire system and when new technology is available it can easily be upgraded.



Thermwood's QCore SuperControl

- **Full Multi-tasking Control**- Uses Microsoft® Windows® 7 Professional operating system, offering the ability to operate the machine and do other tasks on the control
- **Huge File storage**- 1 TB hard drive for storage and greater file execution with no delays.
- **Direct Link**- accepts raw design files or CNC programs, compatible with virtually all design softwares.
- **Virtual Service**-direct, live, visual contact to Thermwood's Service Department.
- **Tool Management** keeps track of tool usage and automatically replaces it when needed
- **Maintenance Alerts**-alerts you when lubrication or maintenance is needed.
- **Videos and Manuals**- step by step how-to-videos to adjust, maintain and repair your machine. Electronic manual, with error reporting and dynamic 3-D assembly drawings with part numbers.

QCore Options



Hand Held Programmer

A powerful tool for creating, modifying, editing and refining CNC programs at the machine. Programs can be debugged or created right at the machine. The machine moves as it is programmed, so you can see the exact position. Modifications can be made quickly, errors are minimized saving time.

Control Touch Screen

Adds "touch screen" functionality to control system.

Uninterruptable Power Supply

Provides power to the control in the case of a power outage. Power is provided for up to 5 minutes after the main power goes out, allowing time for the operator to save files and power down in a controlled manner. Also, provides a measure of surge protection to the control. ANSI/IEEE C 62.41 A.



Software

Mastercam
*Authorized Dealer

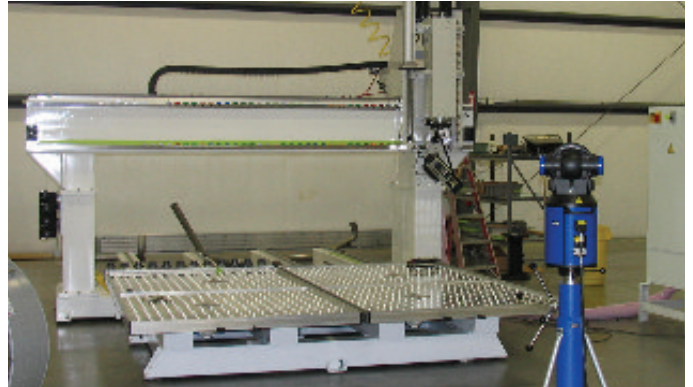
Thermwood has a sales and support group that focuses on software products that work with and enhance the operation of Thermwood CNC routers. Their goal is to offer to Thermwood customers the most effective software products for their specific application, smoothly integrated with the control. You can be certain that software obtained from Thermwood will work properly with your Thermwood CNC router. (Thermwood machines can link with all major CAD/CAM softwares.)

www.thermwood.com

Volumetric Compensation



Volumetric Compensation, standard on all Thermwood CNC routers, dramatically improves the accuracy and quality of the machine. This state-of-the-art advanced technology, developed by Thermwood, is especially essential for large envelope five-axis machines. In this process, the laser measures the exact positions of the cutting head, in three dimensions within the working envelope, and compensates for any remaining error. The com-



pensation then becomes integral within the machine's control providing precise positioning of the cutting head.

Thermwood Technical Service

Thermwood's Technical Service offers a wide range of services for our customers to be comfortable and profitable with their CNC Router System. Each Thermwood CNC router system includes formal, structured training classes including professional support material and hands-on experience.

In addition to Thermwood's professional phone support and on-site service, we offer Virtual Service, which is an audio, video and data link from the machine controller and Thermwood's Service team. When the "Virtual Service" link is established, the customer can see and talk to the Thermwood service technician and the service technician can see, not only the customer, but also all of the critical parameters of the control. Through this link, the control can be diagnosed in real-time while programs are being executed and corrections can be made.

We also offer an On-line Supply Store, extensive Part Inventory, Custom Programming, an Advanced Support Program and a Retrofit and Upgrade Department.

Thermwood's Free Lifetime phone support, training, Virtual Service and continuing control updates offer you support like no one else and assures continuing profits from your Thermwood investment, years into the future.

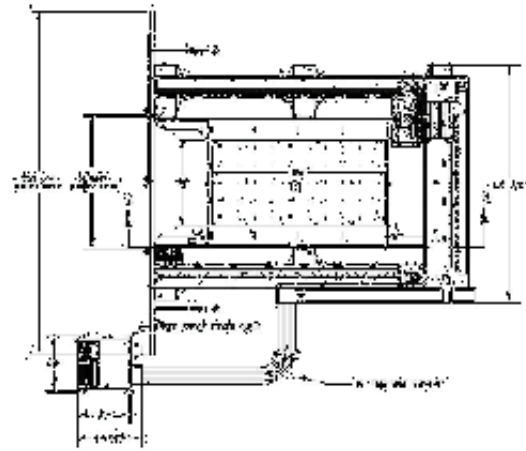
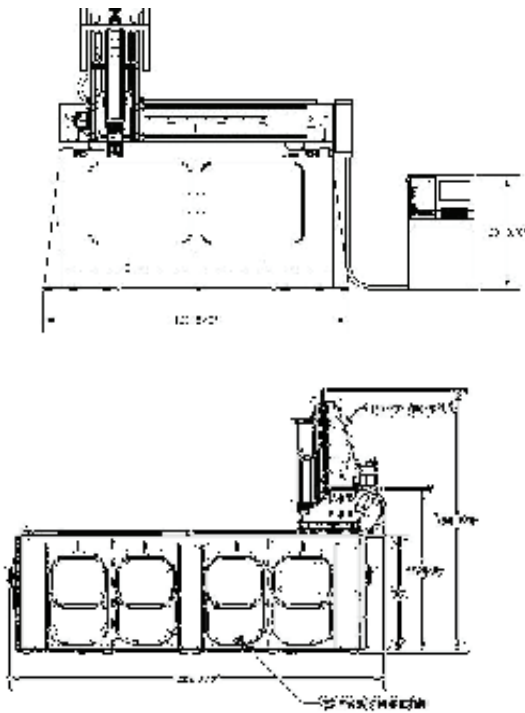
Thermwood's Service

- Free Lifetime Phone Support
- Virtual Service
- On-site Technical Service
- Custom Programming
- Hands on Training Classes
- Professional Set-up
- On-line Supply Store
- Extensive Parts Inventory
- Retrofits and Upgrades
- Advance Support



Dimensions

MADE IN USA 



Model 77 (5' x 10') Overall Dimensions:
Height: 156-7/8" Width: 160-5/8" Length: 225-7/8"
(Dimensions are approximate)

Thermwood...First in CNC Routers

Thermwood is the first company that developed and manufactured CNC router technology in the US. Starting in the late 60's, Thermwood continues to offer products and software technology for the wood, plastics and aerospace industries, involving numerous areas of machining applications.

The main facility consists of 175,000 square feet which includes both an office/showroom and an engineering and

manufacturing plant. Manufacturing utilizes modern fabricating, machining, assembling and testing processes from the machine fabrication to the CNC control production.

Thermwood is an International company that strives in technology, software, support and service to best fit the needs of our customers. Thermwood...the first in CNC routers.



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