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OKUMA



Technical Sheet

Variable Spindle Speed Threading (V SST)

The OKUMA OSP controller makes the difference.

Features

- Advanced Automation
- Variable Spindle Speed Threading
- Maximum automated jobs
- Auto feed optimization: spindle controls perfectly
- V SST Threading in Okuma's Lathes and Turners



The diagram illustrates the V SST process on a lathe. A cutting tool is shown at the end of a workpiece. A dashed line indicates the path of the tool. Labels point to 'Thrust cutting: acceleration of chatter', 'Changing', and 'Chatterless by slow feeding'.

The Variable Spindle Speed Threading function (V SST) is related to automatic threading, generated during feeding to create the spindle speed control. This function also enables high feeding at low spindle speed with a different spindle control setting for rough turning.

In order, changing the spindle speed control is programmed, if changing in the mode of threading operation, the spindle speed change will be interrupted due to backlash clearance. Therefore, the feed rate will be reduced before the change in the spindle speed, resulting in accurate threading.

The V SST function makes it possible to change the spindle speed by using the OKUMA feed control during feeding. This function also enables high feeding at low spindle speed with a different spindle control setting for rough turning.



Chatterless at the bottom of thread
WITHOUT V SST

→



Excellent threads after changing the condition
of feed
WITH V SST

Dimensions: 0.00cm x 0.00cm x 0.00cm

Variable Spindle Speed Threading function (VSST) is intended to eliminate chattering generated during threading by using the spindle speed override.

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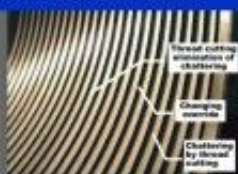
Product Gallery

Variable Spindle Speed Threading (VSST)

The OECUMA OSP controller makes the difference.

Feature

- Integrated Curriculum
- Flexible Course Scheduling
- Multisession semester-long projects
- Active field experiences and experiential learning activities
- STAGE 1 Series Mode at University's Leadership Center campus



The **Variable Speed Feed Threading Function (VSFT)** is intended to eliminate chatter during feeding by using the spindle speed variable. This function also enables both threading at an accurate rate while a different feed rate is selected by roughing.

In general, changing the spindle speed on-site is prohibited. If changes in the mode of threading operation, the spindle speed changes only according to any feature changes. Therefore, the tool axis remains before the change in the spindle speed, resulting in inaccurate thread pitches.

The V&A function makes it possible to change the spindle speeds by changing the feedrate in synchronization with the spindle speed change while it maintains the current thread pitch.



OKUMA Corporation