

MACHINE PARAMETERS

Maximum bar diameter – main spindle	Ø 32 (*Ø 36) mm	Tool rack stroke Z2	260 mm
Maximum length of machining on one stroke	400 mm	Rapid feed Z2	30 m/min
Spindle bore	Ø 37 mm	Maximum diameter of bar – counter spindle	Ø 32 (*Ø 36) mm
Power on main spindle motor (100% / 25%)	5,5 / 7,5 kW	Maximum length of part inside the counter spindle	160 mm
Maximum speed of main spindle	10 000 rpm	Maximum length of part for frontal ejection	200 mm
Spindle indexing orientation	left and right	Counter spindle bore	Ø 37 mm
Main spindle stroke Z1	410 mm	Maximum spindle speed	10 000 rpm
Rapid feed of main spindle	30 m/min	Power of secondary spindle motor (100% / 30 min)	3,7 / 5,5 kW
Number of tool racks	1	Air pressure	6 bar
Tool rack stroke X1	80 mm	Tank capacity	300 l
Rapid feed X1	30 m/min	Flow rate	80 l/min
Tool rack stroke Y1	191 mm	Coolant pump pressure	5,5 bar
Rapid feed Y1	30 m/min	Voltage	3 x 400 V – 50 Hz
Number of tools	(2 x 5) : 10	Power	32 kVA
Size of OD tool	16 x 16 mm		
Tool rack stroke X2	180 mm	MACHINE DIMENSIONS	3 000 x 1 460 x 2 017 mm
Number of tools	(6 + 3) : 9	MACHINE WEIGHT	4 900 kg
Tool rack stroke Y2	447 mm		
Rapid feed Y2	24 m/min		
Number of tools	6		

* optional modification on request

COLLETS AND GUIDE BUSHES

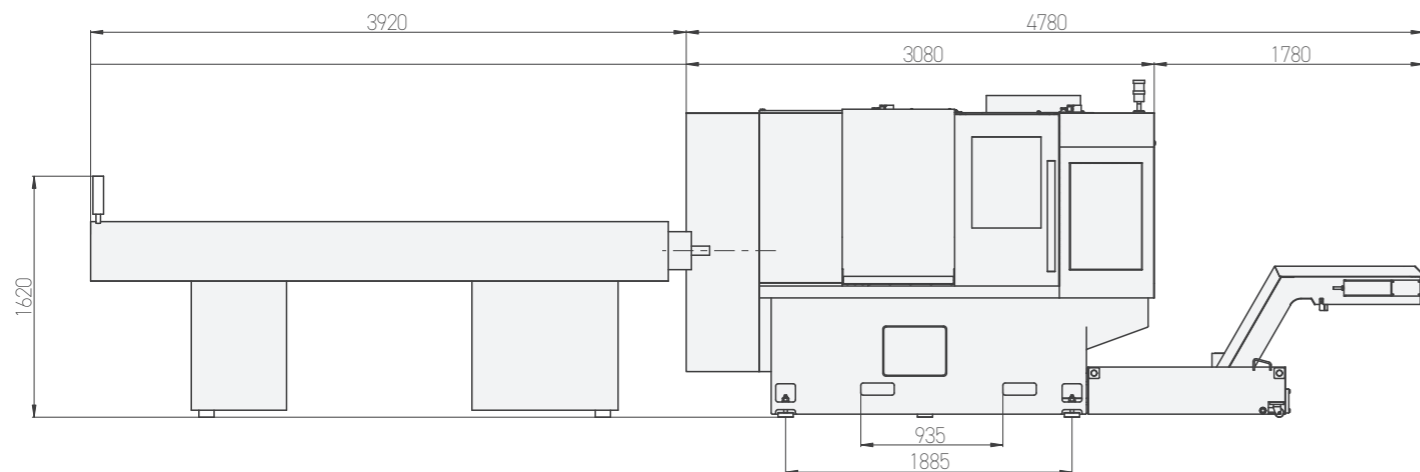


On MANURHIN K'MX 632 we use for both main and counter spindle the collets of type 164E (F38) and we recommend steel ultra-precision collets from well-established collets manufacturers. Usually are used grooved collets or smooth collets or collets with longer nose (LN)



On MANURHIN K'MX 632 we use the guide bushes of type T229 denomination. We recommend the guide bushes with hard metal insert from renowned manufacturers.

MACHINE DIMENSIONS



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Specifications and illustrations may not always correspond with the machine latest version.

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MANURHIN K'MX 632

Innovative technology



MANURHIN K'MX632



Innovative technology

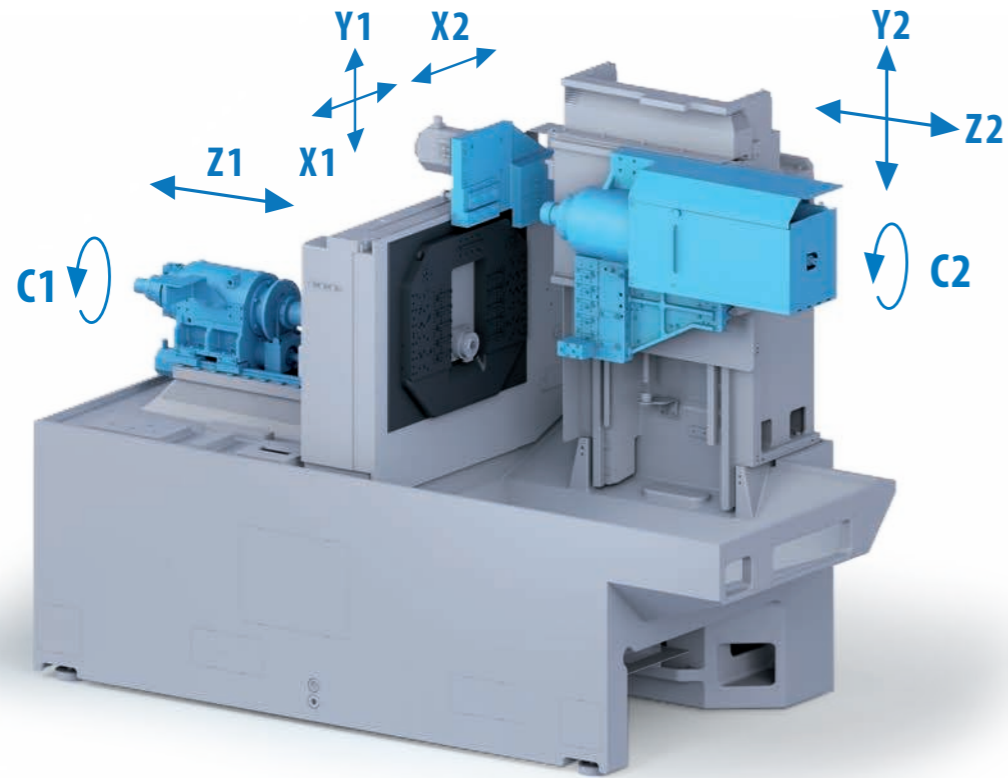
CNC Swiss automatic lathe MANURHIN K'MX 632 is used for productive machining of parts from the bar material of maximum diameter 32 mm. Because of spindle bore diameter 37mm there is no need to modify the end of the bar to smaller diameter for collet of bar feeder pusher.

The machine is in standard equipped by two electrospindles with maximum speed of 10 000 rpm and rotary guide bush, synchronized with main spindle by pulleys and belts. Six linear axes (X1, X2, Y1, Y2, Z1, Z2) and two rotary CNC axes (C1, C2) enable to machine productively simple or complex parts with two tools in

one time. The machine is also used if long drilling operations are required on main spindle. The stroke of the main spindle enables to use the machine for turning of shafts up to 400 mm on one clamping. Longer shafts are possible to be made with multiple clamping.

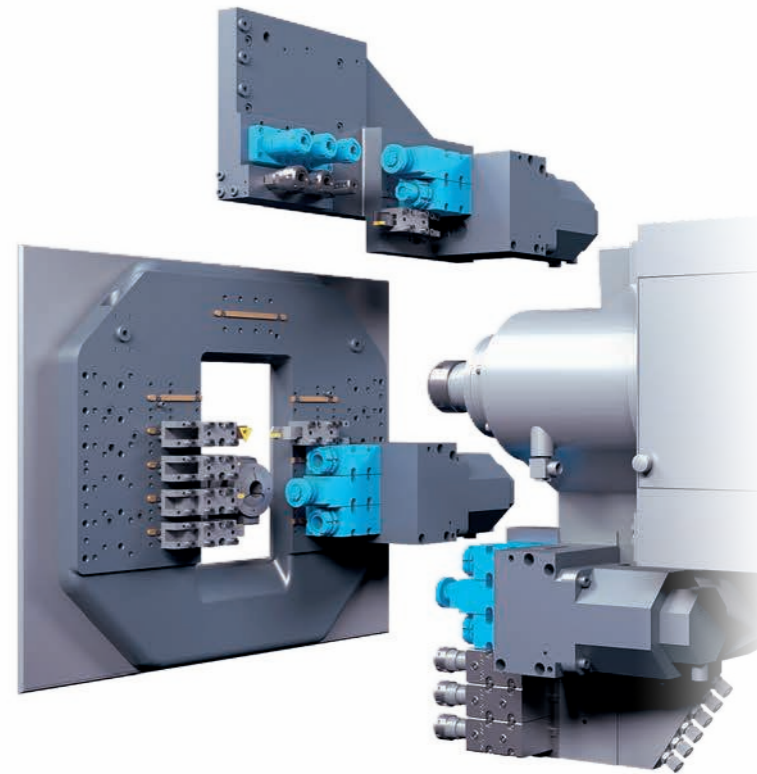
The parts over 160 mm long are possible to be evacuated from the machine only through the counter spindle. The easy setup of tools on tool rack enables the successful use of this machine for the batches starting by hundreds of pieces.

KINEMATICS



Design of machine construction enables deep drilling on main spindle as well as on counter spindle. Optionally it is possible to equip every tool rack by the gear box for live tools. Together with the machine we deliver automatic bar feeder with encoder and magazine for 3 or eventually 4m bars. The length of part is limited with this type of machine only by the length of the bar. Easy installation of tools on tool racks enables to use this machine successfully for the part batches starting from hundreds of pieces.

It is possible to install 9 tools on rear machining tool rack, 6 of them can be driven. Also long drills for very deep holes can be installed there. The designed solution of this machine enables to do all operations on this tool rack on counter spindle simultaneously with machining operations on main spindle.



CONTROL SYSTEM FANUC

The latest CNC control system from Japanese manufacturer FANUC with color 10.4" screen enables to operator easy programming in ISO code. All operations are running in English (or other language if available). The transfer of programs is available comfortably via USB, PCMCIA card, RS 232 interface or Ethernet.

