

MACHINE PARAMETERS

Maximum bar diameter – main spindle	Ø 32 (*Ø 36) mm	Maximum length of part for frontal ejection	170 mm
Maximum length of turning on one stroke	400 mm	counter spindle bore	Ø 37 mm
Main spindle bore	Ø 37 mm	Maximum speed of counter spindle	8 000 ot/min
Power (100% / 25%) of main spindle	15 / 25 kW	Power (100% / 30 min) of counter spindle	3,7 / 5,5 kW
Maximum speed of main spindle	8 000 rpm	Evacuation of parts through the counter spindle	
Spindle direction	Left and right	(for parts max. Ø 26 mm)	volitelné
Main spindle stroke	410 mm	Air pressure required	6 bar
Rapid feed of main spindle	30 m/min	Air connection by "Banjo" coupling	Ø 10 mm
Number of tool racks	2	Coolant tank capacity	300 l
Tool rack – horizontal stroke X1	45 mm	Flowrate	100 l/min
Rapid feed of horizontal stroke	30 m/min	Coolant pump pressure	5,5 bar
Tool rack – vertical stroke Y1	180 mm	Voltage	3 x 400 V – 50 Hz
Rapid feed of vertical stroke	30 m/min	Power input	32 kVA
Tool positions (turning)	(2 x 5) : 10	Cable section	16 mm ²
Tools shank size OD operations	16 x 16 mm	CNC control system	FANUC 31i
Counter spindle stroke	295 mm	MACHINE DIMENSIONS	3 000 x 1 460 x 1 860 mm
Rapid feed of counter spindle	30 m/min	MACHINE WEIGHT	4 500 kg
Maximum bar diameter – counter spindle	Ø 32 (*Ø 36) mm		
Maximum length of part inside the counter spindle for frontal ejection	150 mm		

* optional on request

COLLETS AND GUIDE BUSHES

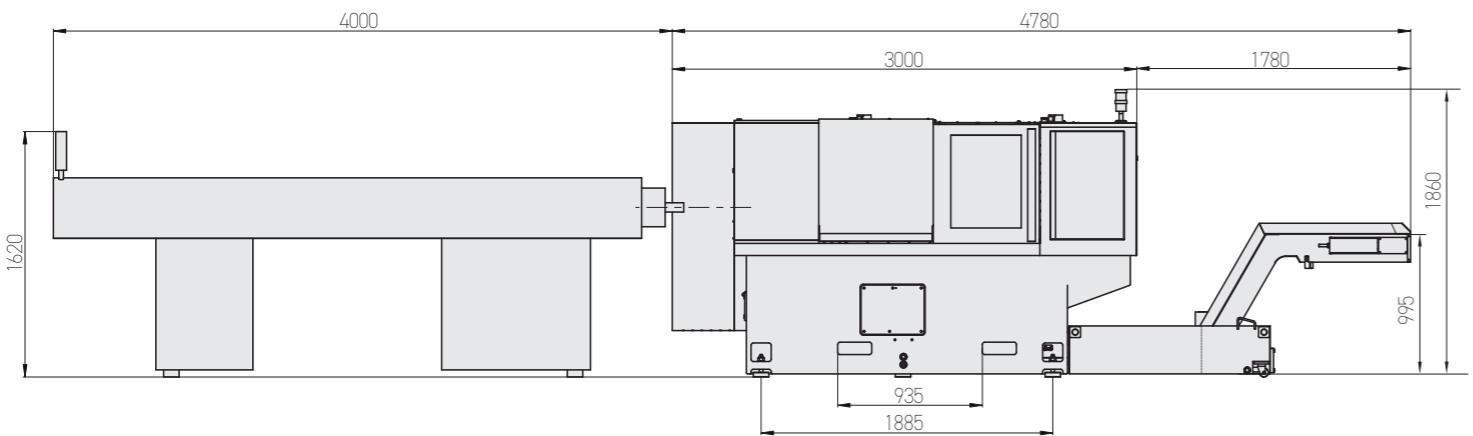


On MANURHIN K'MX 632 DUO we use for both main and counter spindle the collets of type 164E (F38) and we recommend steel ultra-precision collets from well-established collets manufacturers. Usually are used grooved collets or smooth collets or collets with longer nose (LN).



On MANURHIN K'MX 632 DUO 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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10/2021



MANURHIN K'MX 632DUO

Innovative technology

 **TAJMAC-ZPS** 

MANURHIN K'MX®

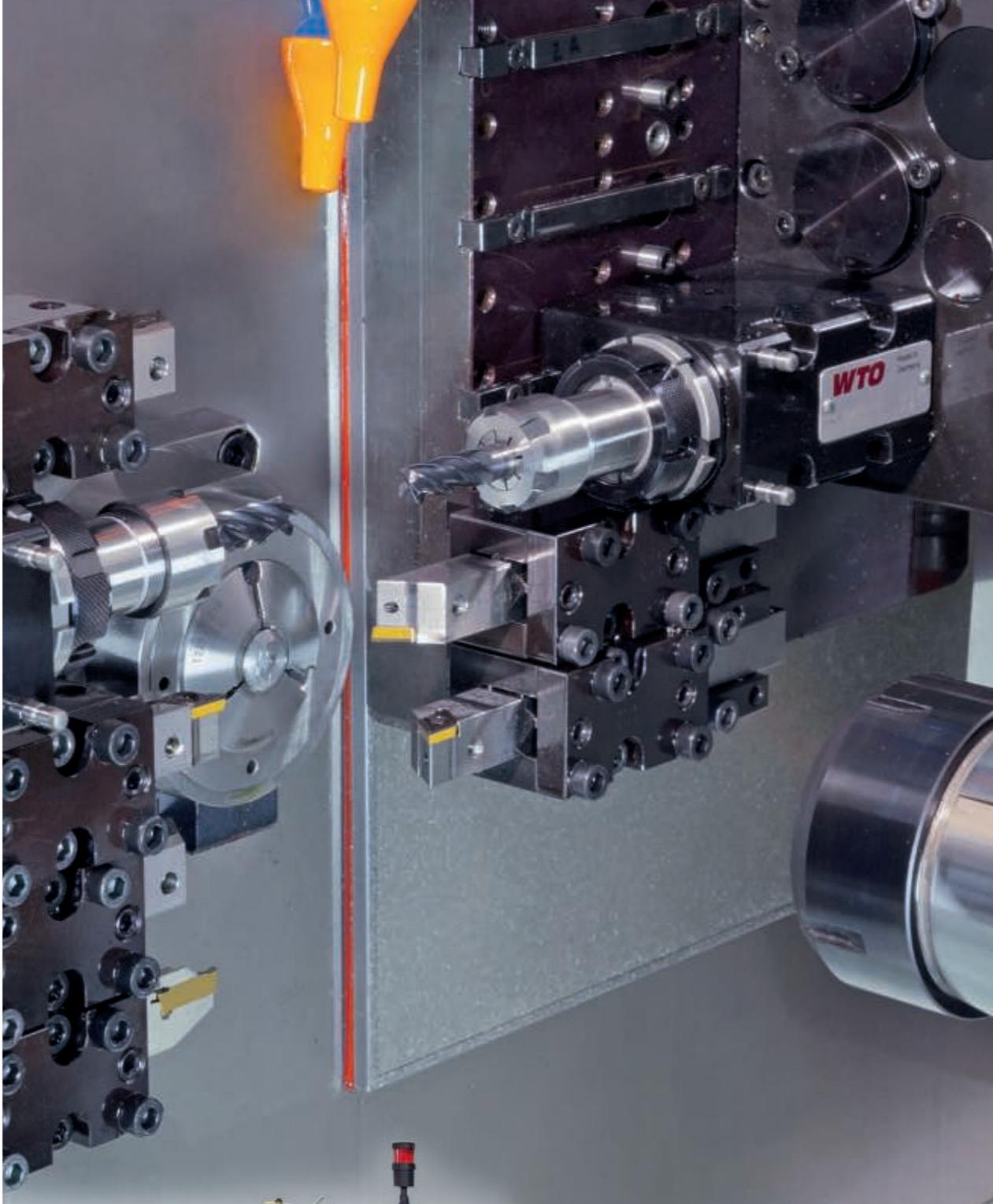
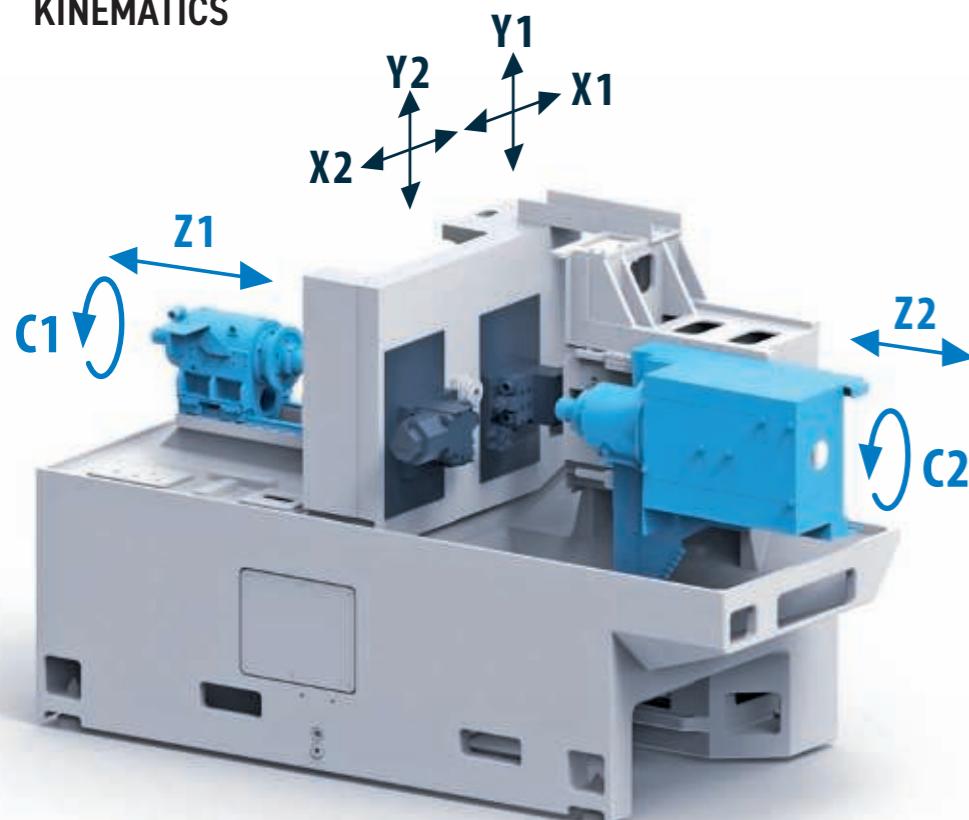
MANURHIN K'MX 632DUO

Innovative technology

Sliding headstock automatic lathe MANURHIN K'MX 632 DUO is designed for productive machining of parts from the bars of maximum diameter 32 mm. As the spindle bore diameter is 37 mm, there is no modification of the end of the bar for bar feeder collet needed.

Machine is equipped in standard with two electro spindles with maximum speed 8 000 rpm each and with rotary guide bush synchronized by pulleys and belts with main spindle. Six linear axes (X1, X2, Y1, Y2, Z1, Z2) and two rotary axes (C1, C2) enable to machine with high productivity the simple as well as complex parts.

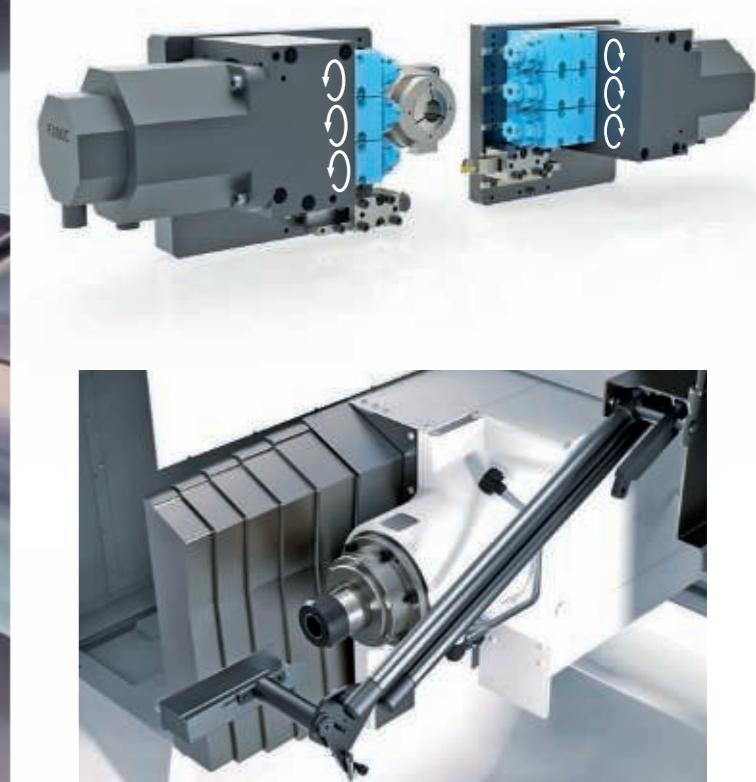
KINEMATICS



MANURHIN K'MX[®]

Big advantage of this model is possibility of parallel turning or milling with two tools at the same time. Optionally the machine can be equipped with motorized tools on both of rear or front tool rack. 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.

MANURHIN K'MX 632 DUO is typically delivered with automatic bar feeder with encoder and magazine for 3m bars. The parts over 170 mm long are possible to be evacuated from the machine only through the counter spindle. The maximum length of the part is limited theoretically only by the length of the bar. The easy setup of tools on tool rack enables the successful use of this machine for the batches starting by hundreds of pieces.



PART COLLECTION AND EVACUATION

Pneumatically controlled arm with bucket is operated by M-function. The arm is easy to set up and enables the parts catching from both main and counter spindle, just as needed by operator. The bucket fits for the parts up to 170 mm. Longer parts are possible to be evacuated through the counter spindle. The bucket can be modified according to shape of part.

The part is evacuated by arm with bucket outside the covers of the machine. This enables immediate manipulation with the part and immediate measuring without the need to stop the machine.

