

G996

High performance milling systems



FIDIA 
Giving shape to design



Technological development

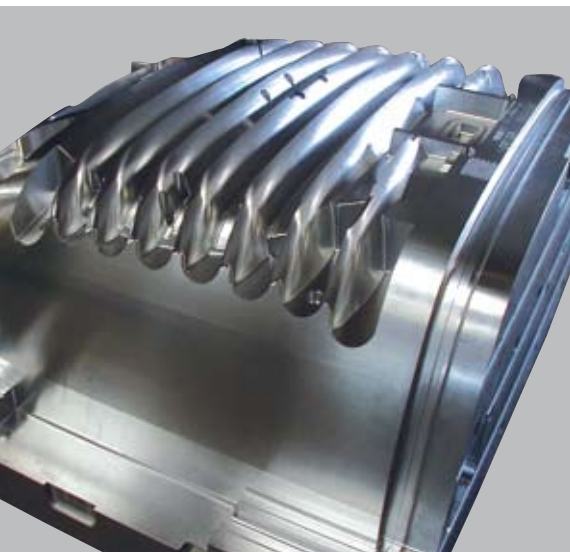
The G996 is the result of Fidia's long experience in the field of high performance milling.

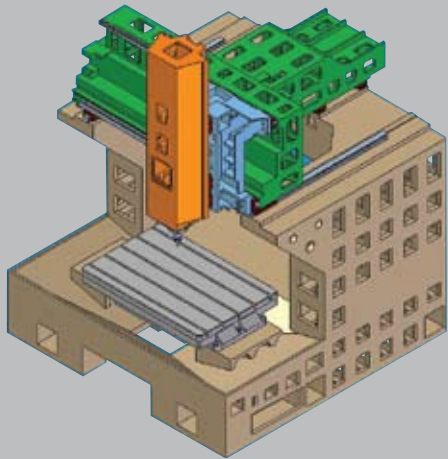
After years spent satisfying the need for improvement in the quality and accuracy of complex machining, since the launching onto the market of machine tools designed for finishing, Fidia has responded to a new challenge in which the rationalization of the production cycle has become an absolute priority.

Combining high dynamics with stability, stock removal with high precision finishing and modular design: the G996 has achieved a new level of performance.

The result is a system offering various milling equipment and different worktable combinations able to satisfy most machining requirements with 3 and 5 continuous or indexed axes.

Sectors in which the G996 can find application include all those where high precision and excellent stock removal are required, from the moulds and dies sector to general machining and the aeronautical industry.





Machine tool structure

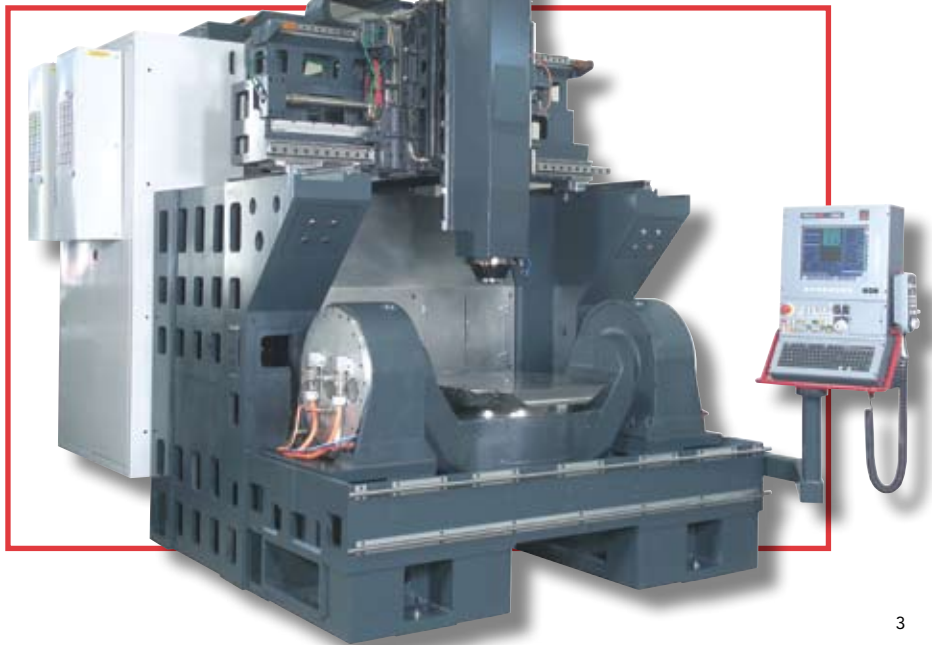
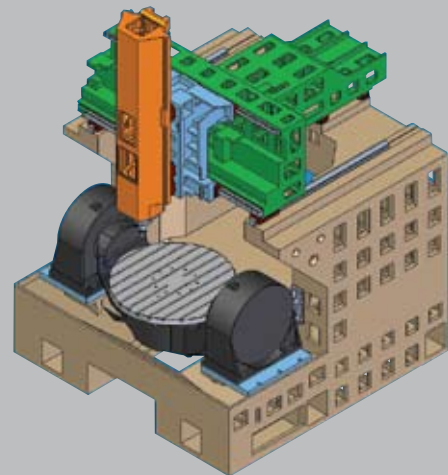
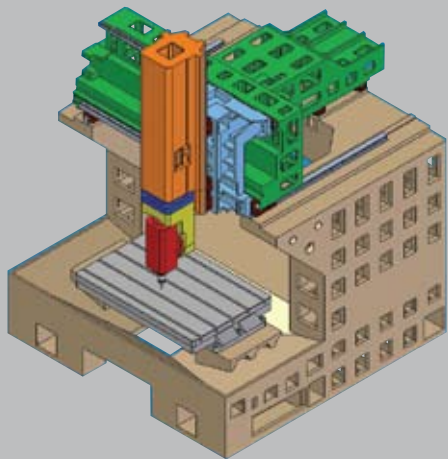
The large cast iron bed provides a stable support for the moving parts, while the open front ensures wide visibility.

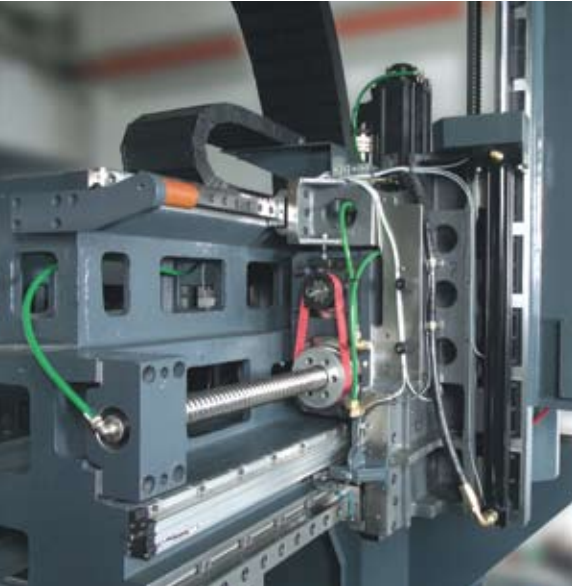
The moving components, also made of cast iron, have been designed for high acceleration with no dynamic deformation. At the same time, they ensure the damping capacity required in order to take full advantage of the high spindle torque.

The use of spheroidal graphite cast iron and a system of guides with 6 support points for each axis has made this difficult compromise possible.

No Foundation

Its self-supporting structure allows installing the machine directly on a standard industrial floor.





Dynamics and thermal stability control

The kinematics chain is based on rotating nut and fixed ball screw technology on all linear axes.

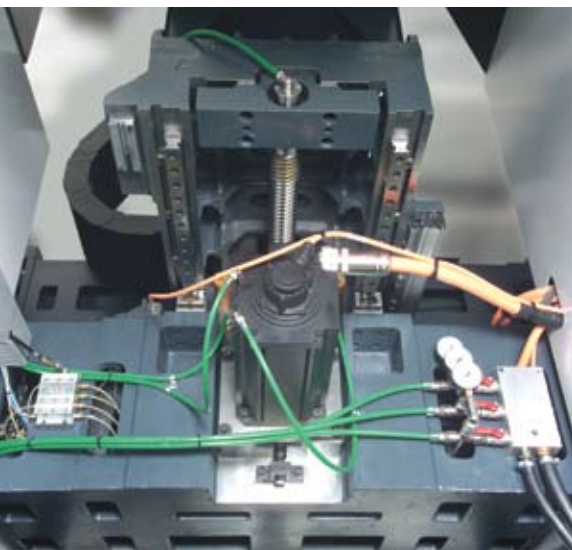
This solution has numerous advantages:

- larger diameter ball screws;
- reduction of moment of inertia;
- extreme rigidity in motion transmission;
- heat control with coolant flow through hollow ball screws.

All the parts generating heat, such as axis motors, nut supports, electrospindles are monitored and cooled by means of a central conditioning system.

Furthermore, dedicated sensors measure the ambient and structural temperatures providing an overall monitoring picture.

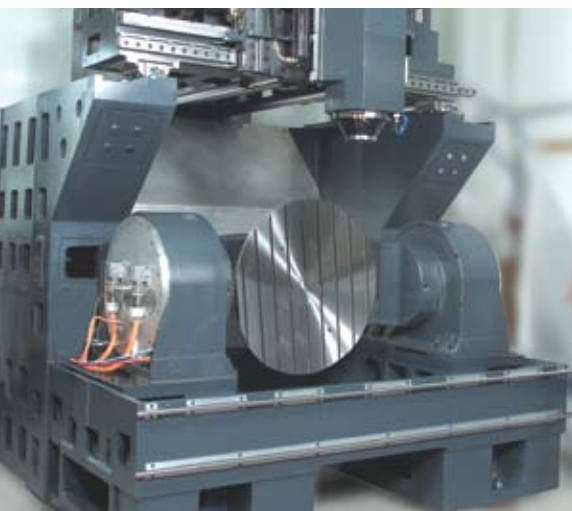
In this way, maximum accuracy is achieved even with lengthy machining cycles requiring numerous re-machining operations and tool changes.



Configurability

The G996 3-axis standard configuration is equipped with a high-speed spindle that is able to deliver High Performance milling, boring, drilling and tapping.

As an option, the vertical axis can be fitted with a robust head with two indexed axes (BSH version) or a continuous head with 5 axes (M5A version).





The fixed worktable can be replaced by different roto-tilting (RT version) tables (trunnion type), each being particularly well dimensioned for the machining of complex geometrical forms, that are equipped with torque motors bringing the technical characteristics of these solutions to the highest levels of performance. The maximum benefits deriving from the increased capabilities of programming systems on 5 continuous axes are also guaranteed.

Interfacing with standardized and modular automatic pallet systems, such as WPM and MP (Multi pallet), reduces down time and allows for full automation of the production cycle.

Tool Changer and Automatic Presetting

24 to 84 position tool magazine is located in the machine bed. The magazine has a large access cover and is suitably protected from dust, fluids and swarf.

The tool measuring probe, which uses a laser device mounted in the machine bed, checks the length, diameter and shape while the tool rotates at working speed in order to reduce machining errors.

Also available, measure and verification of special tools:

- multiple cutting edge;
- angular heads;
- advanced ID Chips management.





FMS

Flexible Manufacturing System

The new FMS system designed by Fidia is equipped with a sophisticated software that optimizes and exalts its operative characteristics. This system is the Fidia answer to the more and more pressing request of increasing the workshop automation level, and integrates a powerful and versatile pallet system shared between more than one G996 machine.

The FMS platform serves independent working islands of minimum 2 machines each, and allows for the complete machining of complex components in 3 or 5 axes, starting from the rough part.

This system is the ideal solution for a highly developed workshop environment, requiring the best standards of automation levels.





The powerful dedicated software automatically manages and optimizes the production flow without intervention of the machine operator. Such a way of functioning pursues the following goals:

- reduction of waiting times;
- simplification of programming;
- optimization of tool wear-out;
- full monitoring of production flow;
- reduction of human error risks;
- never-ending 7/7 & 24/24 production.

Each machine can be also used in a standalone way, nonetheless granting the normal functioning of the FMS system with the other machines.





Coolant and Chip conveyor Systems

Minimum spray mist lubrication for tools is standard, and a swarf collection bin with a large drawer is incorporated in the machine tool bed.

Other systems are available as options:

- external low pressure lubrication / cooling;
- air blow through the tool centre;
- high pressure coolant through the tool centre.

Each of these options is provided of suitable chip conveyor and collection system with tanks and filters of various sizes.

Dust and mist collection units

Machine tool components and the machining environment can be protected by optional dust and mist collection systems that efficiently recover volatile substances such as graphite or resin dust, and oil mist.

The total enclosure of the work area together with optional protection with air sealed guideways and ballscrews enables the machining of highly abrasive materials such as ceramics and carbon fibre.

Vibration monitoring system

The spindle is equipped with an accelerometer to measure vibration, in order to check tool unbalancing or breakage. Two vibration speed thresholds are available: warning threshold and alarm threshold. The vibration value is monitored and displayed on the CNC screen.





HMS

Check and compensate each positioning geometrical error in 5 axis RTCP within the machine working envelope.

It consists of a simple and powerful instrument to grant the highest level of accuracy without complex maintenance interventions.



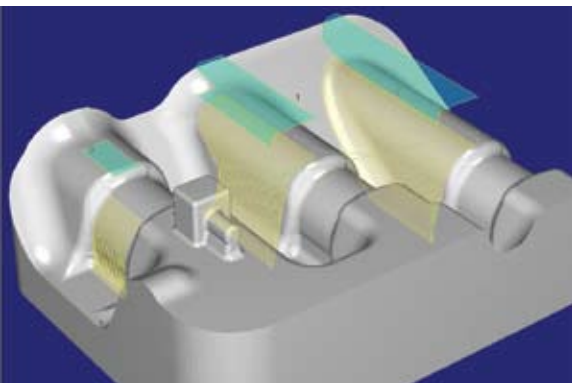
The C20 numerical control

The Fidia C20 numerical control takes full advantage of the potential offered by combining the performance of the Pentium 4 and the RISC Power PC processors. It is conceived to manage the most sophisticated high speed applications running at 5 axes with RTCP. It is equipped with Windows XP Professional operating system in multi-tasking mode.

Simple and reliable machining

The C20 is equipped with a 17" TFT video and thanks to its HI-MILL 3D CAM and ISOGRAPH 2½D CAD/CAM it directly imports CAD mathematical models in IGES, VDA-FS, DXF, DWG formats, enhancing but at the same time simplifying tool path management.

Mechanical machining such as slots, threads and pullers are programmed directly on board of the machine in total safety thanks to its soft keys and to the possibility to simulate in real time any kind of tool path.

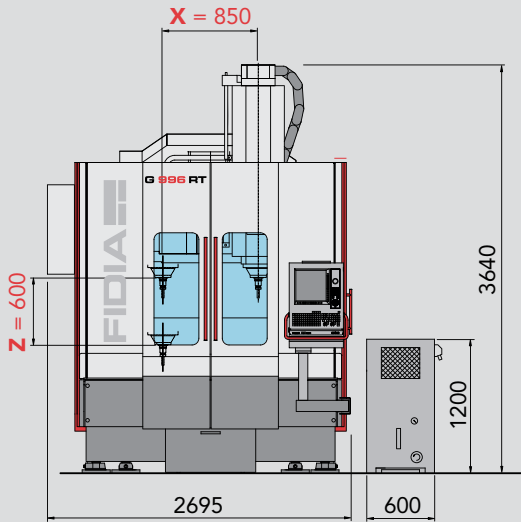


High speed milling

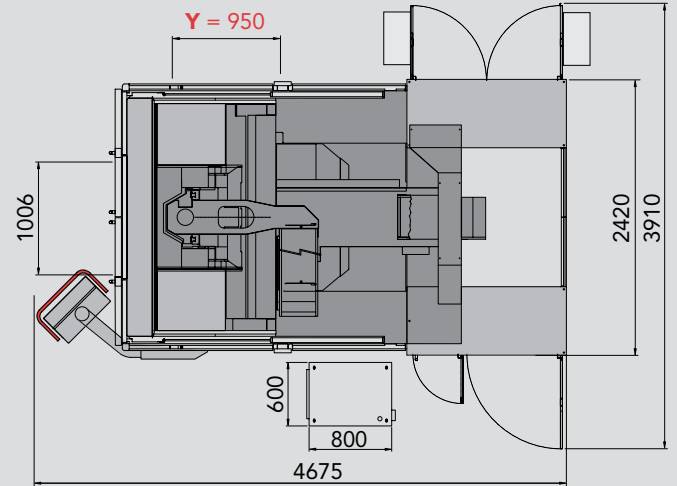
The parameters, adapted to the specific dynamic characteristics of the machine tool, are optimized by the following path control software functions:

- dynamic Look-Ahead with advanced feed control for curves;
- Active Tuning and Active Damping to optimize performance in terms of accuracy, surface quality and execution times;
- set of customized parameters for different machining conditions (roughing, semi-finishing, finishing and rest-machining) recalled by G functions;
- Jerk Control (control of variations in acceleration).

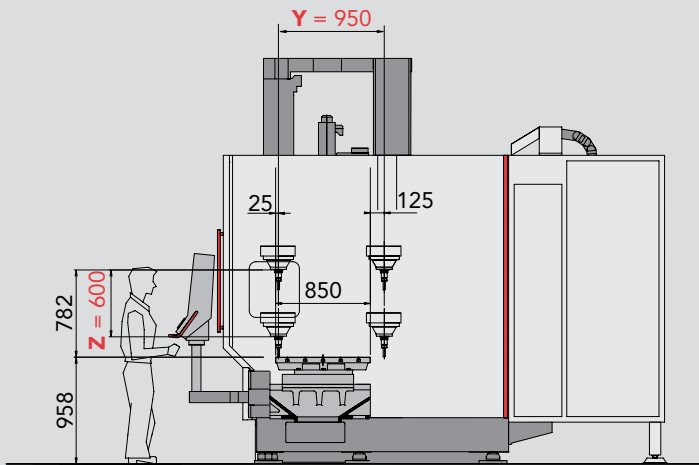




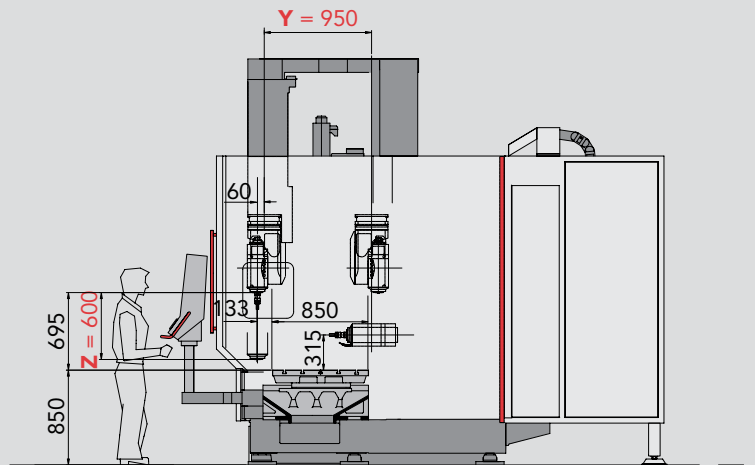
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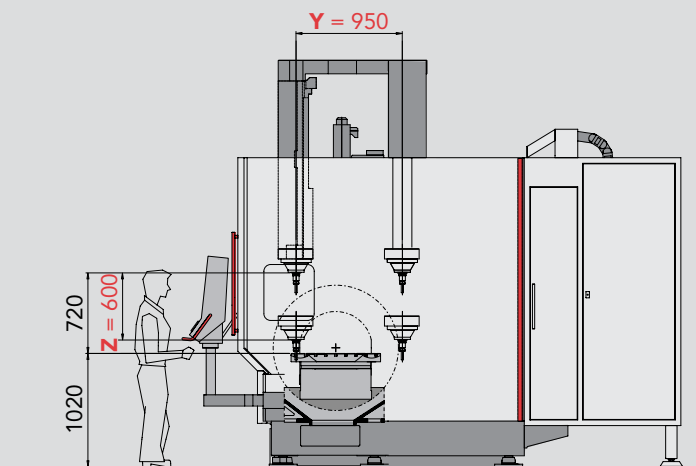
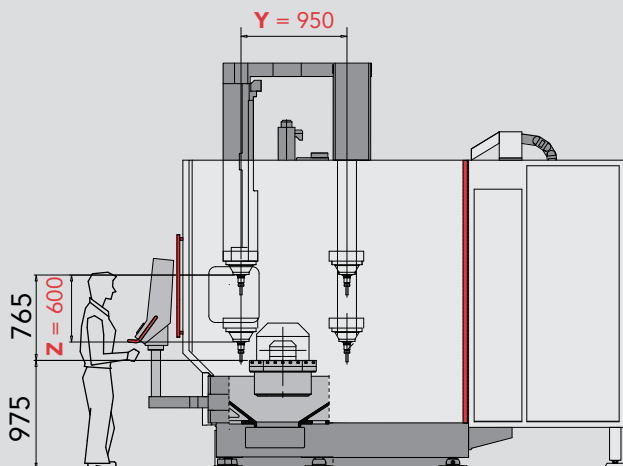
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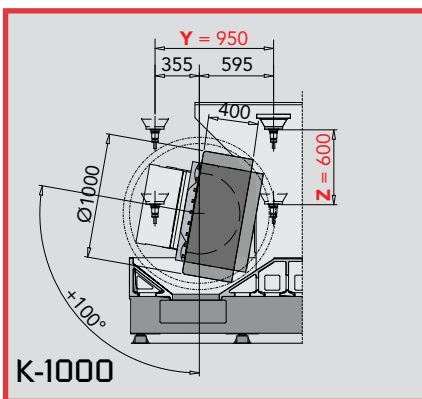
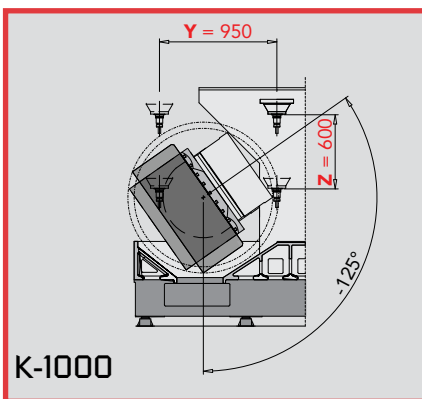
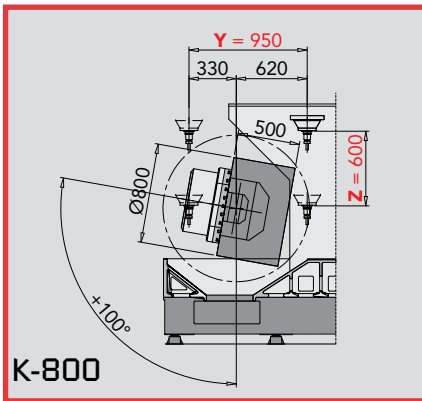
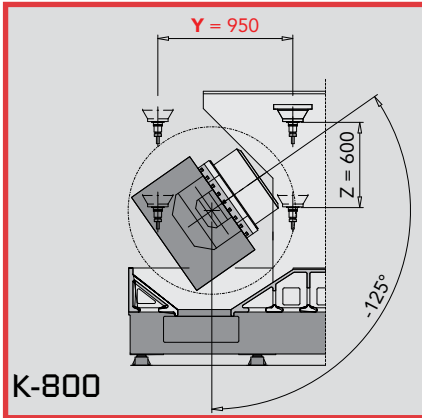


G996RT/K-800



G996RT/K-1000





Technical data

Linear axis travel	
X	850 mm (33")
Y	950 mm (37")
Z	600 mm (24")
Linear axis feed	
X Y Z	45 m/min (1772 ipm)
Positioning precision	
X Y Z	± 0.003 mm (± 0.00012")
Maximum acceleration	
X Y Z	10 m/s ² (394 inches/s ²)
Tool magazine	
positions	24 - 42 - 84
Standard machine tool weight	
	17000 kg (37478 lbs)

Milling heads

Electrospindle 3 axes	V / RT version	
Maximum power (S6)	30 kW	
Maximum torque (S6)	105 Nm	
Max. spindle rotation speed	24000 1/min	
Toolholder	HSK63A	
Bi-rotary heads	indexed BSH	continuous M5A
Work area (X,Y)	970 x 1070 mm (38" x 42")	850 x 950 mm (33" x 37")
B axis travel	-102°/+24°	±110°
C axis travel	-177°/+180°	± 360.1°
B and C axis pitch	3°	continuous
Max. spindle rotation speed	24000 1/min	32000 1/min
Maximum power (S6)	55 kW	7.5 kW
Toolholder	HSK63A	HSK40E

Standard table

Dimensions	1200 x 850 mm (47" x 33")
Load capacity	2000 kg (4409 lbs)
No. and dimensions of T slots	n° 4+1(H7)x18 mm (0.71") pitch 160 mm (6")

RT Table

		K-800	K-1000
Platter dimensions		600 x 600 mm (24" x 24")	Ø 800 mm (Ø 32")
Max. rotating diameter (swing)		800 mm (32")	975 mm (38.38")
A axis	stroke	-125° / +100°	±100°
	speed	50 1/min	50 1/min
	acceleration	2000 °/s ²	2000 °/s ²
C axis	stroke	rollover	
	speed	100 1/min	
	acceleration	2000 °/s ²	
Load capacity		600 kg (1322.7 lbs)	1200 kg (2645.5 lbs)

The TRT/K-800 Option allows for the machining on 5 sides of a cylinder with a diameter of 800 mm (32") and height of 500 mm (20").

The TRT/K-1000 Option allows for the machining on 5 sides of a cylinder with a diameter of 800 mm (32") and height of 500 mm (20"), or diameter of 1000 mm (39") and height of 400 mm (16").

**FIDIA S.p.A.**

Corso Lombardia, 11
10099 San Mauro Torinese - TO - ITALY
Tel. +39 011 2227111
Fax +39 011 2238202
info@fidia.it
www.fidia.com

FIDIA S.p.A.

Via San Crispino 94
35129 Padova - ITALY
Tel. +39 049 8071320
Fax. +39 049 8071320
info-pd@fidia.it

FIDIA GmbH

Robert-Bosch-Strasse 18
63303 Dreieich-Sprendlingen - GERMANY
Tel. +49 6103 4858700
Fax +49 6103 4858777
info@fidia.de

FIDIA Sarl

47 bis, Avenue de l'Europe
B.P. 3 - Emerainville
77313 Marne La Vallée Cedex 2 - FRANCE
Tel. +33 1 64616824
Fax +33 1 64616794
info@fidia.fr

FIDIA Iberica S.A.

Parque Tecnológico de Zamudio
Edificio 208 - 48170 Zamudio - Bilbao - SPAIN
Tel. +34 94 4209820
Fax +34 94 4209825
info@fidia.es

OOO FIDIA

28, Volnaya str.
105187, Moscow - RUSSIA
Tel. +7 095 7867724
Fax +7 095 7867725
info@fidia.ru

FIDIA Sp. z o.o.

ul. Prądzyńskiego 12/14
01-222 Warszawa - Poland
tel./fax: +48 22 256 73 74
mobile: +48 601 486 789
info@fidia.pl

FIDIA Co.

1397 Piedmont, Suite 800
Troy - Michigan 48083 - USA
Tel. +1 248 6800700
Fax +1 248 6800135
info@fidia.com

FIDIA DO BRASIL LTDA

Av. Salim Farah Maluf, 4.236 - 3º andar
Móoca - SÃO PAULO - Cep 03194-010 - BRAZIL
Tel. +55 11 29657600
Fax +55 11 20212718
info@fidia.com.br

FIDIA JVE

Beijing Fidia Machinery & Electronics Co., Ltd
Room 1509, 15/F Tower A, TYG Center Mansion
C2 North Road East Third Ring Road,
Chaoyang District
100027 BEIJING - P.R. CHINA
Tel. +86 10 64605813/4/5
Fax +86 10 64605812
info@fidia.com.cn

FIDIA JVE

Shanghai Office
28/D, No.1076, Jiangning Road
Putuo District
Shanghai 200060 - CHINA
Tel. +86 21 52521635
Fax +86 21 62760873
shanghai@fidia.com.cn

Service centres:**FIDIA SPA - SERVICE UK**

2 Nene Crescent
Corby Northants
NN 172 JQ - UNITED KINGDOM
Tel./Fax: +44 (0)1536504018
ian.houston3@ntlworld.com

FIDIA GmbH - SERVICE CZ

CZ- 74706 Opava
Tel/Fax +420 553 654 402
e-mail: j.vecerek@fidia.de

3H Makina Sanayi ve DIS Tic.Ltd.Sti.

Tavukcuyolu, No:269/5, Y.Dudullu
Umraniye - Istanbul / TURKEY
Tel: +90-216-36.57.155
Fax: +90-216-36.57.154

P.V. ELECTRONIC SERVICES C.C.

P.O. Box 96
Hunters Retreat 6017
Port Elisabeth SOUTH AFRICA
Tel. +27 41 3715143
Fax +27 41 3715143
pvaneek@sancelink.co.za

AXIS SYSTEMS

Flat No.9, Building No.13,
Shraddha Garden, Near Lokamanya Hospital,
Chinchwad
Pune 411033 - INDIA
Tel. +91 20 27656682
Fax +91 20 27656682
pinks@axis-fidia.in

SHIYAN FIDIA SERVICE CENTRE

N.84 Dong Yue Road,
Shiyan, Hubei - CHINA
Tel. +86 719 8225781
Fax +86 719 8228241

CHENGDU FIDIA SERVICE CENTRE

Huang Tian Ba
Chengdu, Sichuan - CHINA
Tel. +86 28 87406091
Fax +86 28 87406091

H&H Machine Tools Australia Pty. Ltd.

45 Fordson Road
Campbellfield (Melbourne), VIC 3061
AUSTRALIA
Tel: +61 3 9357 2368
Fax: +61 3 9359 3887
thegmann@h-h.com.au

IE-MAT s.r.l.

Bv. De Los Alemanes No. 3387
5022 Barrio Los Boulevares
Cordoba - X5022EOF
ARGENTINA
Tel. +54 0351 4750483
Fax +54 0351 4750483
ie-mat@ie-mat.com.ar

Manufacturing plants:**FIDIA S.p.A.**

Via Valpellice, 67/A
10060 San Secondo di Pinerolo
TO - ITALY
Tel. +39 0121 500676
Fax +39 0121 501273

FIDIA S.p.A.

Via Vecchia di Cuneo, 51
12011 Borgo San Dalmazzo (CN) - ITALY

MECCANICA CORTINI S.p.A

Via Gorizia, 162
47100 Forlì
ITALY
Tel. +39 0543 770511
Fax +39 0543 795573
info@meccanicacortini.it

SHENYANG FIDIA NC & MACHINE CO., LTD.

No. 1 17 Jia Kaifa Rd.
Shenyang Economic & Technological Development Zone
110141 Shenyang - P.R. CHINA
Tel. +86 24 25191218/9
Fax +86 24 25191217
info@fidia.com.cn



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