

FX-800

TWIN TURRET TWIN SPINDLE **CNC Turning Center**

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FX-800

Twin turrets turning center for process integration and high productivity.

FX-800 is a multi-purpose, high-productivity, twin spindles, twin turrets turning center. The upper and lower turrets are T16 powered turret, and the upper turret is equipped with Y axis, which can perform complex turning and milling and greatly improve production efficiency.



Both spindle equipped with built-in motor. The bed features highly rigid structure and excellent thermal displacement performance, which can meet the processing requirements of heavy duty and high precision machining.

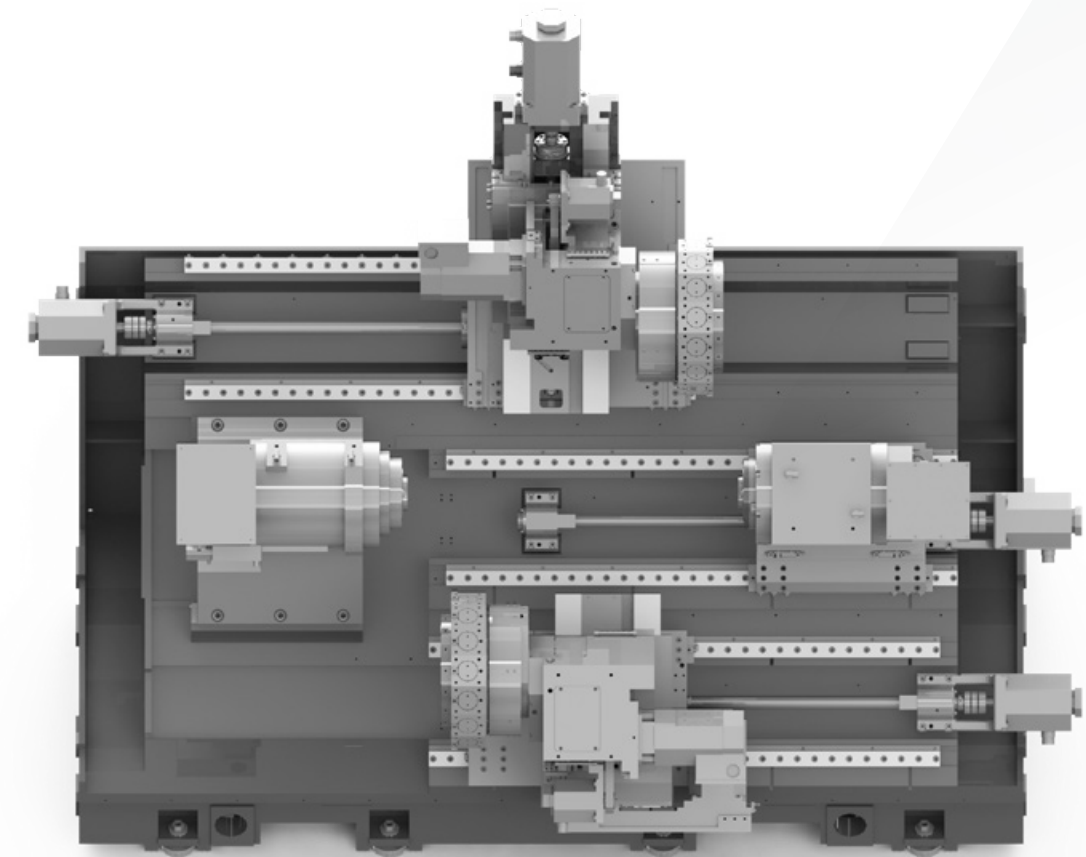
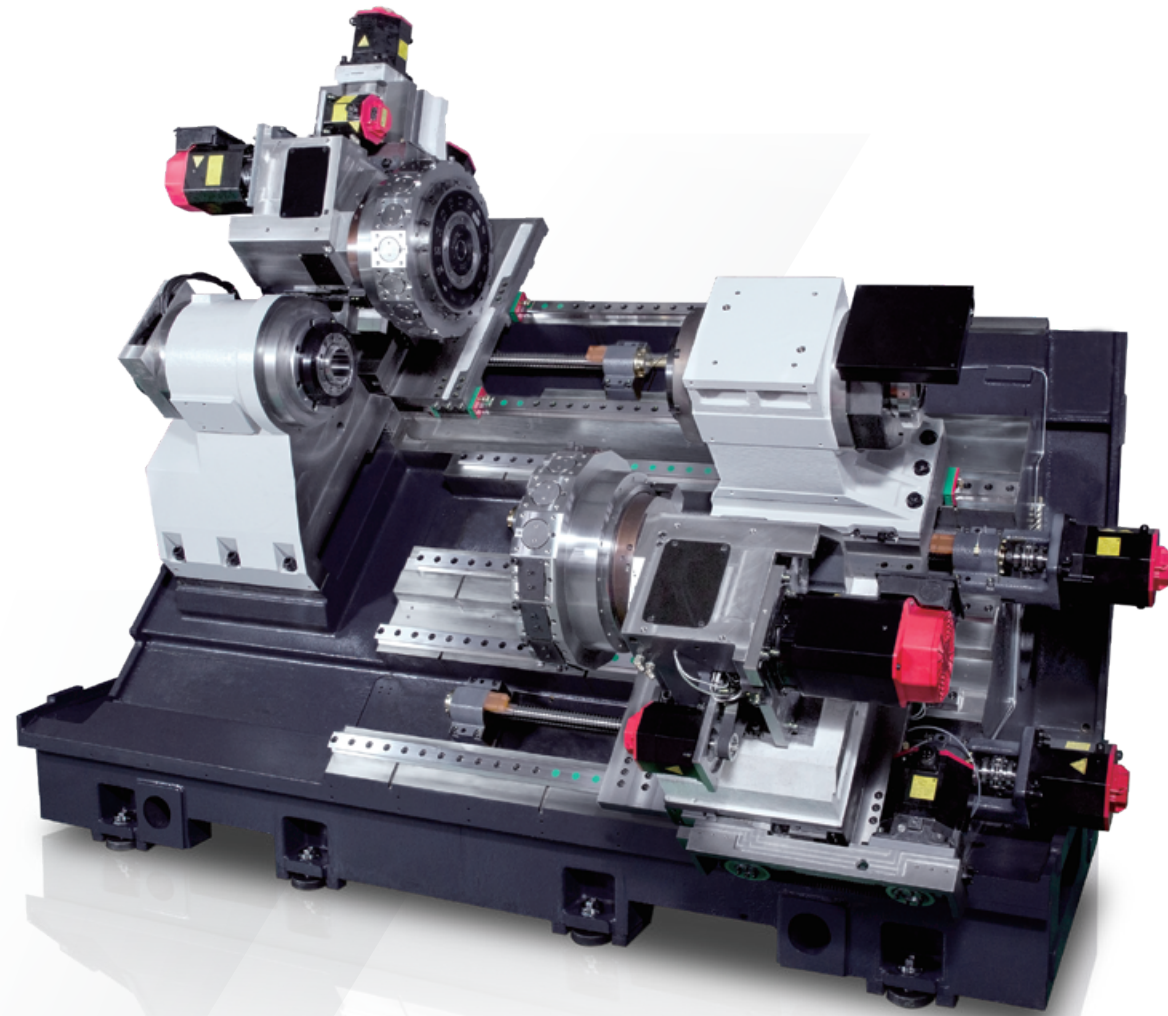
The new generation of FX-800 increases the working range and the speed of feed axes according to the feedback of customers' experience. The evolved interior covers make daily maintenance easier.

01 Workpiece Size

	FX-800	
Max. Turning Diameter	12.20	inch
Max. Turning Length	25.87	inch
Max. Bar Work Capacity Diameter	2.5 / 2.0	inch



Both turret can mill or drill on one spindle at the same time, which means users can flexibly use the tool configuration of the upper and lower turrets, to reduce non-processing time and improve production efficiency.

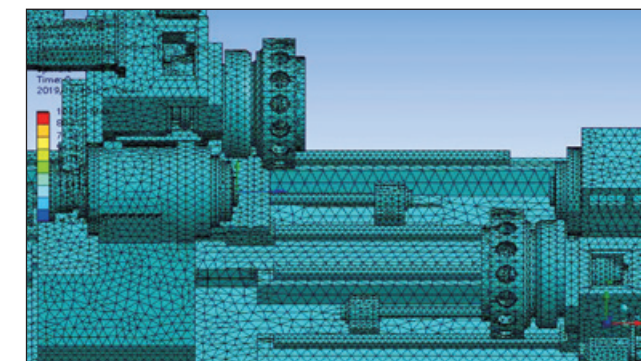


- The upper turret, lower turret and right spindle adopt independent linear slide rails. Since the lower turret and the right spindle are not in the same pair of railway, the rigidity of the right spindle can be improved. In addition, both turret can cut on the left spindle and right spindle, which greatly improves the flexibility and efficiency of use.

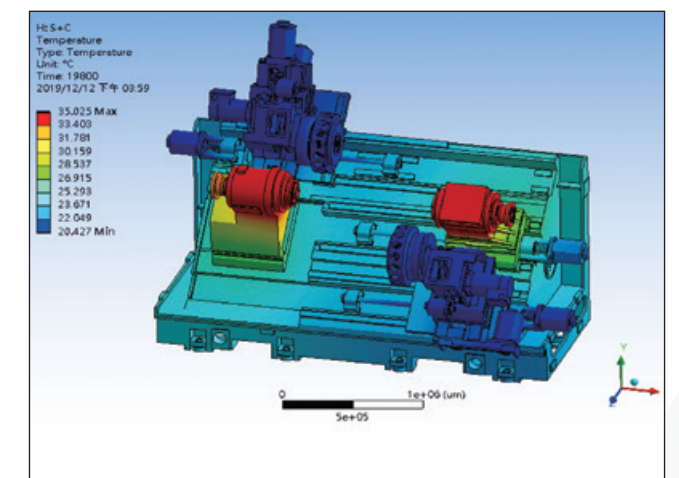
02 Travel & Rapid Traverse

	FX-800	
X1/X2-Axis Travel	8.46 / 8.46	inch
X1/X2-Axis Rapid Traverse	787.4 / 787.4	ipm
Z1/Z2-Axis Travel	29.53 / 29.33	inch
Z1/Z2-Axis Rapid Traverse	787.4 / 787.4	ipm
Y-Axis Travel	± 1.97	inch
Y-Axis Rapid Traverse	393.7	ipm
B-Axis Travel	28.74	inch
B-Axis Rapid Traverse	787.4	ipm

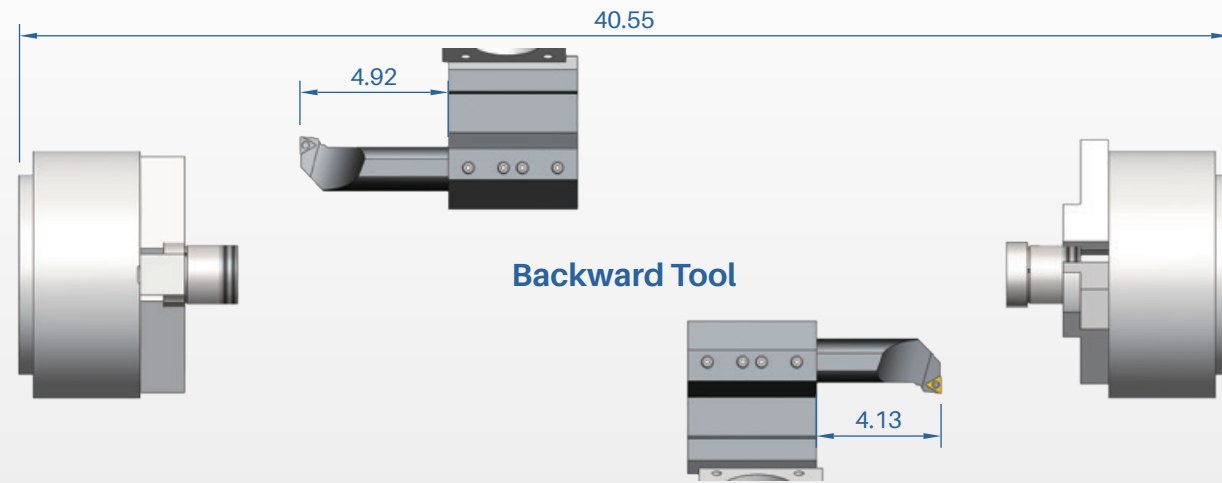
- The guideways introduce the concept of hybrid design. The X-axes and Y-axis with box ways which provide good vibration attenuation and dynamic rigidity. The Z-axes and B-axis with roller linear guides to achieve high precision, high rigidity and high speed.



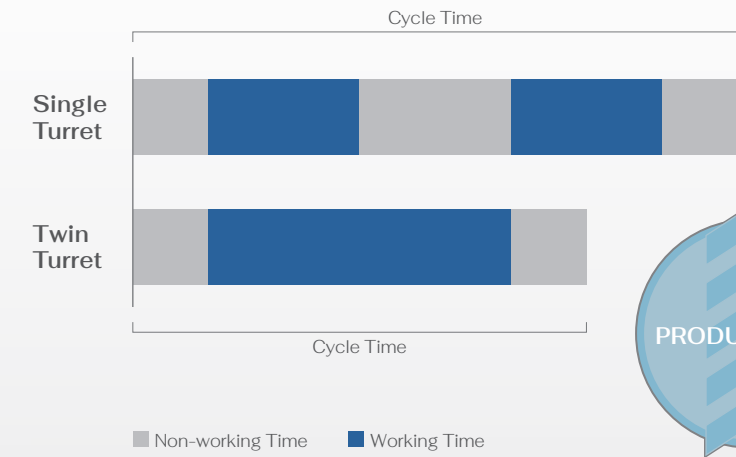
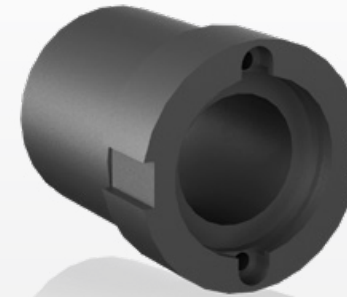
- TAIWAN TAKISAWA is committed to the basic research of machinery, through the finite element method (FEM) analysis to achieve higher machine rigidity and excellent thermal deformation performance.



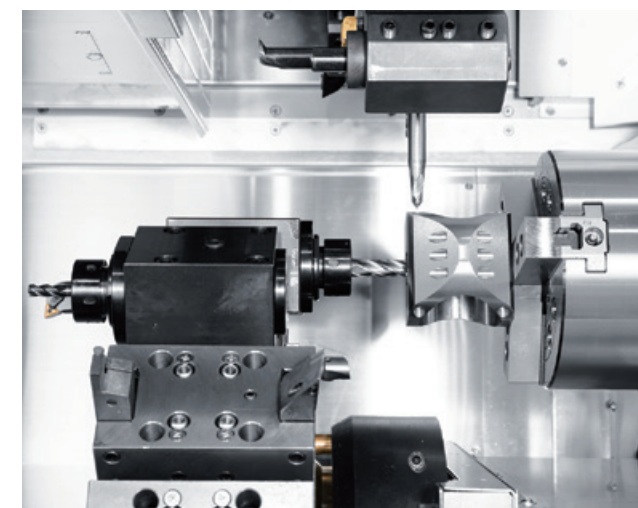
03 Working Area



Sample Workpiece (S45C Ø2.20 x L2.48)



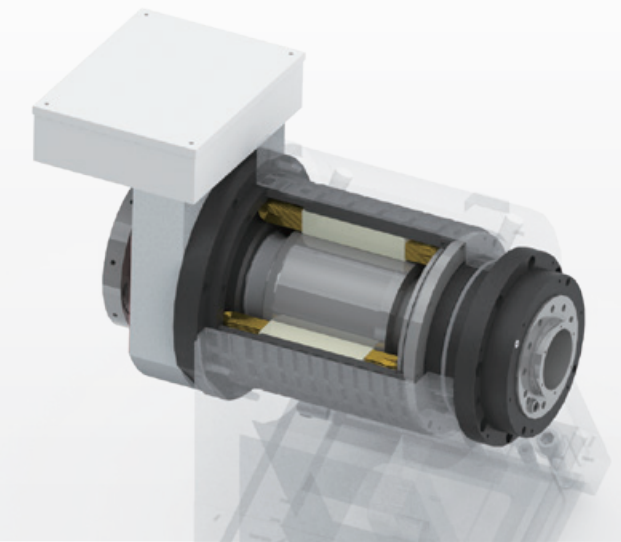
04 Simultaneous Turning and Milling with Upper and Lower Turret



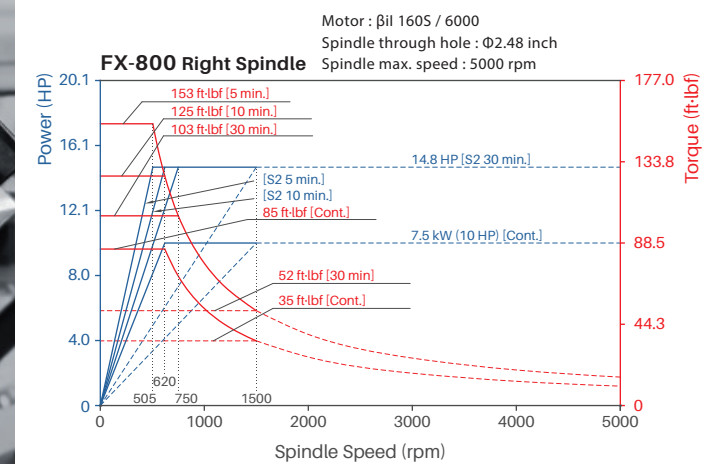
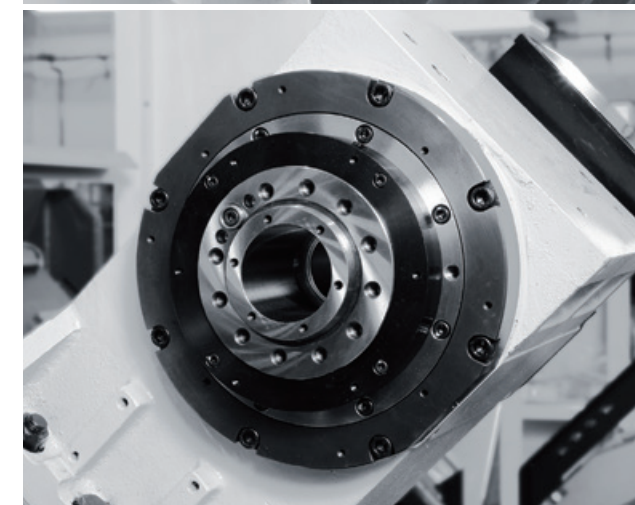
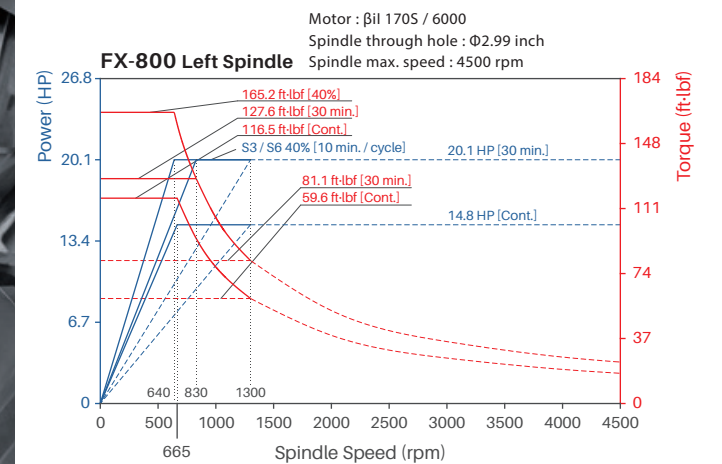
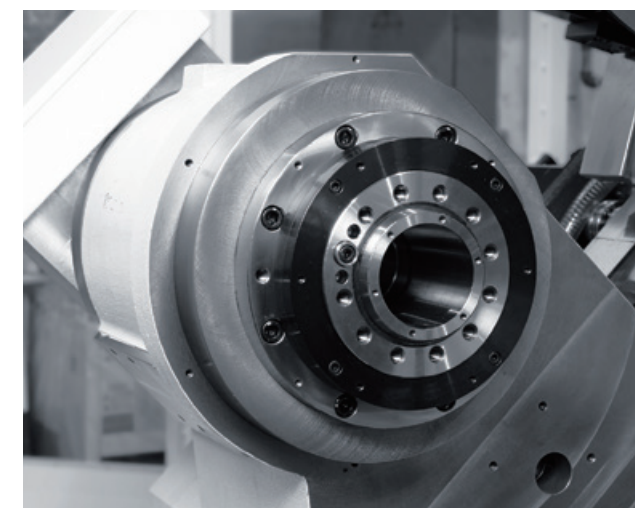
Spindle

The left and right spindles are equipped with built-in motors for high precision, low vibration and low noise, which provide better surface roughness of the workpiece.

	Left Spindle	Right Spindle	
Spindle Nose	A2-6	A2-6	
Spindle Speed	4500	5000	rpm
Through Hole Diameter	3	2.48	inch
Bearing Inside Diameter	4.33	3.94	inch
Motor Output	20.1 / 14.7	14.7 / 10	hp
Max. Torque	165.21	153.41	lb·ft
Standard Chuck Size	8	8	inch

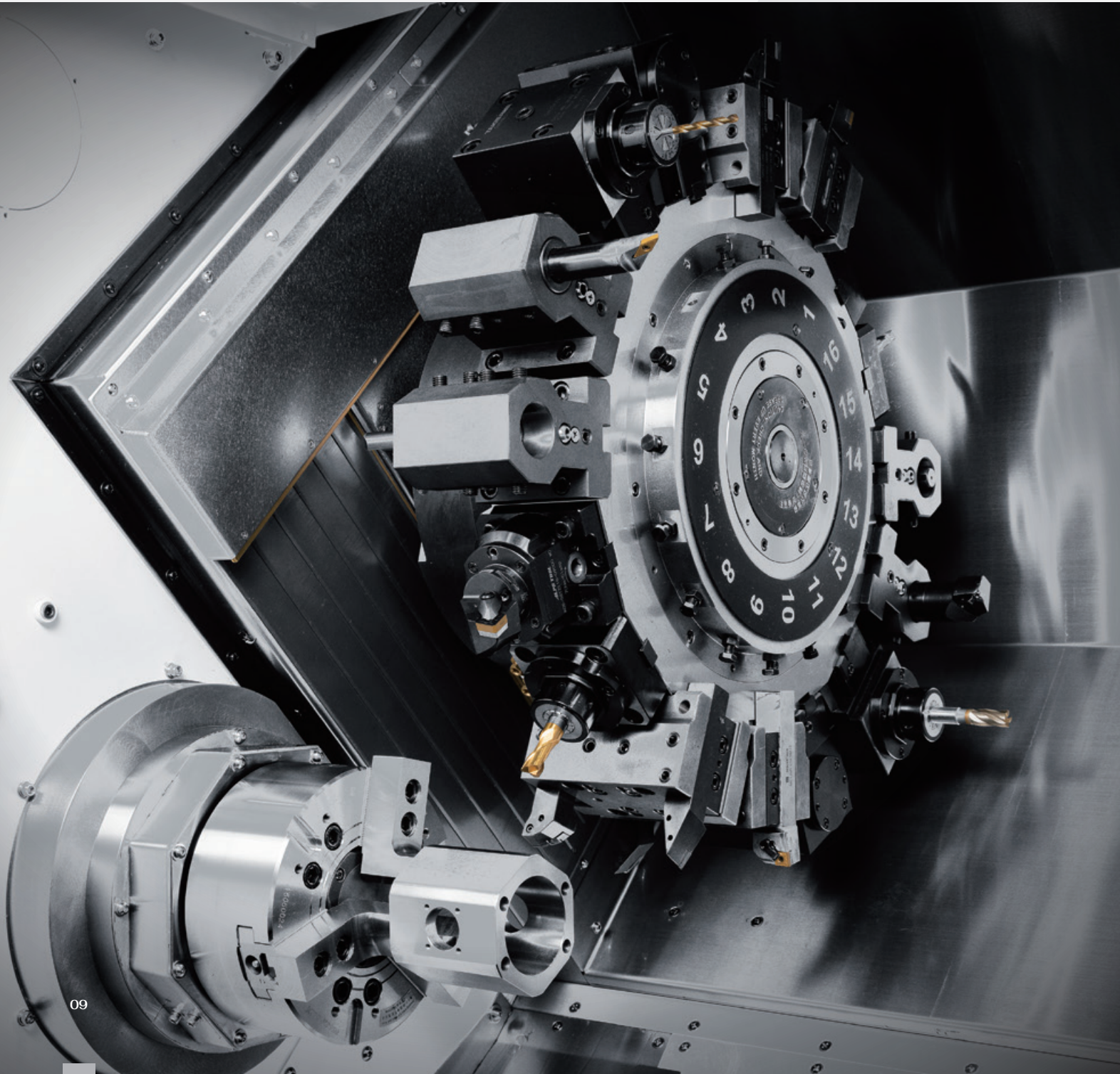


Spindle Output Diagram



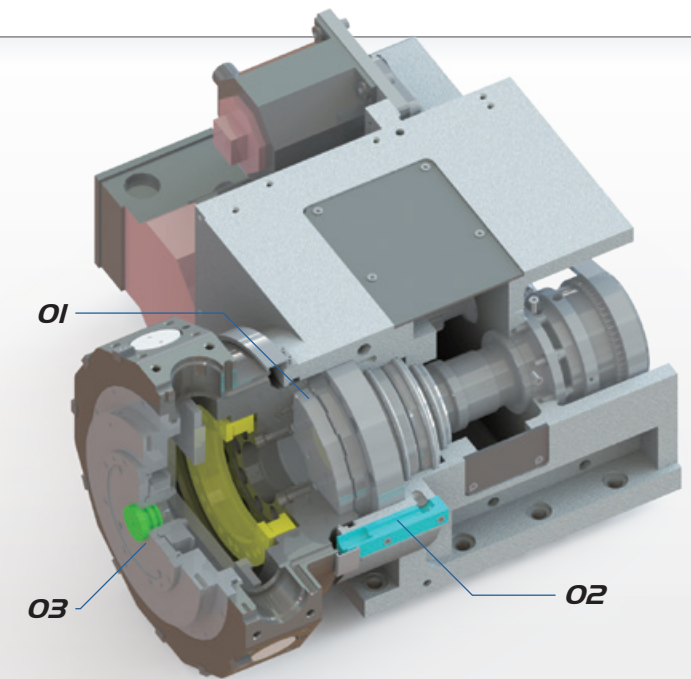
Turret

Equipped with 16 stations power turrets, which can handle combined machining such as milling, drilling and tapping. Inside the turret, the large diameter of coupling gear set with curvic tooth profile provides high rigidity and high accuracy.



Turret Structure

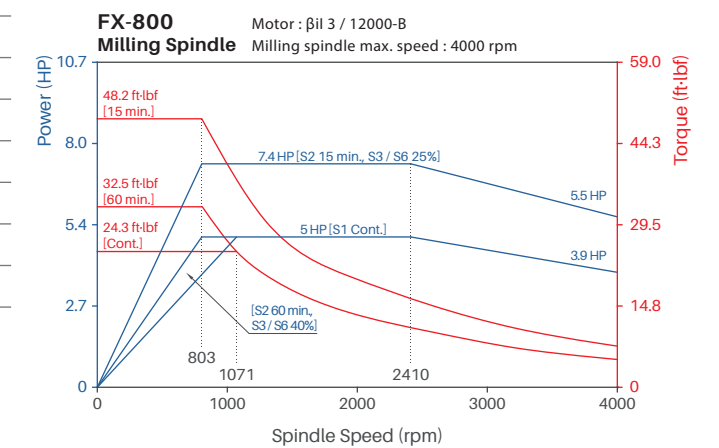
- 01** Curvic Coupling O.D. 11" performs high rigidity and accuracy
- 02** Ready for 1015 psi hi-pressure coolant
- 03** Easy to grease up



T16 Turret

Number of Tools	16
OD Tool Shank Dimension	1 inch
ID Tool Shank Diameter	1.5 inch
Milling Shank Diameter	0.79 inch
Milling Spindle Speed	4000 rpm
Motor Output	7.4 / 5 hp
Max. Torque	48.2 lb·ft

Spindle Output Diagram



Special Tool Holders



01

Gear Hobbing



02

Broaching



03

Power Skiving



04

Adjustable Angle Milling

Machine Specifications

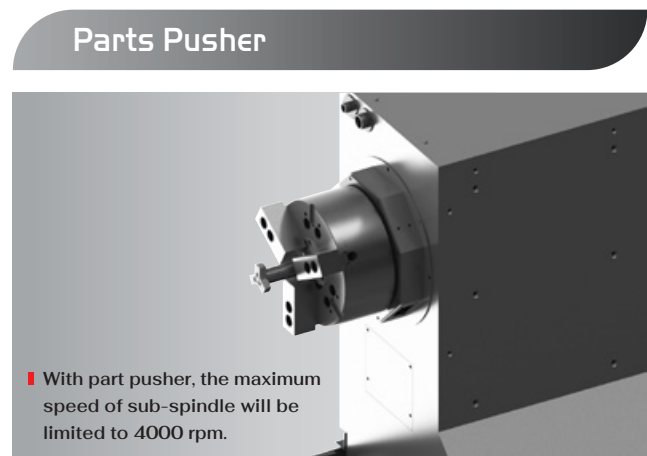
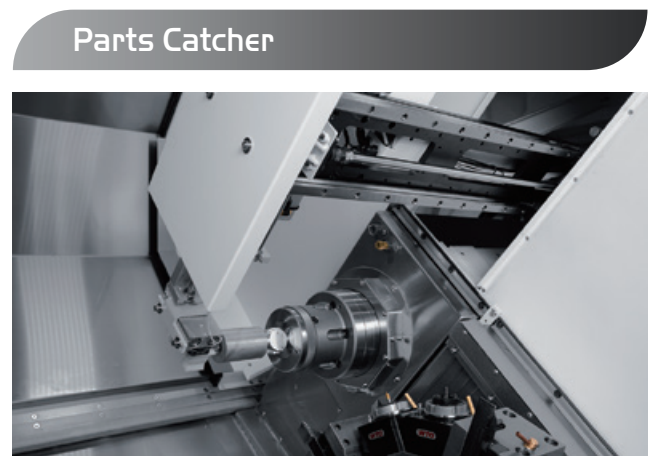
Item		FX-800
Capacity	Max. Swing	inch 12.20
	Standard Turning Diameter	inch 9.02
	Max. Turning Diameter	inch 12.20
	Max. Turning Length	inch 25.87
	Max. Bar Work Capacity	inch 2.56 / 2.05
	Dist. Between Centers	inch 40.55
Travel	X1/X2-Axis Travel	inch 8.46/8.46
	Z1/Z2-Axis Travel	inch 29.53 / 29.33
	Y-Axis Travel	inch ±1.97
	B-Axis Travel	inch 28.74
Left Spindle	Spindle Speed	rpm 4500
	Spindle Nose	A2-6
	Through Hole Diameter	inch 2.99
	Bearing Diameter	inch 4.33
Right Spindle	Spindle Speed	rpm 5000
	Spindle Nose	A2-6
	Through Hole Diameter	inch 2.48
	Bearing Diameter	inch 3.94
Turret	Number of Tools	T16 + T16
	OD Tool Shank Dimension	1
	ID Tool Shank Diameter	inch 1.5
	Milling Shank Diameter	inch 0.79
	Spindle Speed	4000
Feedrate	X1/X2-Axis Rapid Traverse	ipm 787.4 / 787.4
	Z1/Z2-Axis Rapid Traverse	ipm 787.4 / 787.4
	Y-Axis Rapid Traverse	ipm 393.7
	B-Axis Rapid Traverse	ipm 787.4
Motor	Left Spindle Motor	hp 20.1 / 14.7
	Right Spindle Motor	hp 14.7 / 10
	Milling Spindle Motor	hp 7.4 / 5
	Index Motor	hp 1.6
	X1/X2-Axis Servo Motor	hp 4 / 3.4
	Z1/Z2-Axis Servo Motor	hp 3.4 / 3.4
	Y-Axis Servo Motor	hp 3.4
	B-Axis Servo Motor	hp 3.4
Machine Size	Height	inch 92.12
	Width	inch 139.76
	Depth	inch 91.89
	Weight	lb 24250

Standard and Optional Accessories

Accessories	FX-800
Built-In Motor Left Spindle	●
Built-In Motor Right Spindle	●
O.D Tool Holder (2 PCS)	●
Face Tool Holder (2 PCS)	●
U-Drill Tool Holder (2 PCS)	●
Boring Bar Tool Holder (8 PCS)	●
Boring Bar Bush (Ø1/4", Ø5/16", Ø3/8", Ø1/2")	●
Boring Bar Bush (Ø5/8", Ø3/4", Ø1", Ø1-1/4")	●
U-Drill Bush (Ø5/8", Ø3/4", Ø1", Ø1-1/4")	●
Short Boring Bar Bush (Ø1/4", Ø5/16", Ø3/8", Ø1/2")	●
Short Boring Bar Bush (Ø5/8", Ø3/4", Ø1", Ø1-1/4")	●
Drill Bush (MT.1, MT.2, MT.3, MT.4)	◎
Short Drill Bush (MT.1)	◎
X-Axis Milling Holder (2 PCS)	●
Z-Axis Milling Holder (2 PCS)	●
Automatic Tool Setter	◎
Manual Tool Setter	◎
Linear Scales	◎
Coolant Pump (1/2 HP)	●
Coolant Pump (3/4 HP, 1 HP, 1-1/2 HP)	◎
Coolant Chiller	◎
Nut Cooling Ball Screw	◎
Hydraulic System	●
Hydraulic Oil Cooling	◎
Hydraulic Pressure Sensor	●
Lubrication System	●
Hydraulic Chuck	●
Collet Chuck	◎
Foot Switch	●
LED Interior Light	●
LED Signal Tower	●
Chip Cart	●
Right Side Chip Conveyor	●
Parts Catcher	◎
Automatic Bar Feeder and Interface	◎
Auto Door	◎
Safety Door Switch	◎
Safety Light Curtain	◎
Air Blow	◎
Oil Skimmer	◎
Oil Mist Collector	◎
Parts Counter	◎
Automatic Power-Off	◎

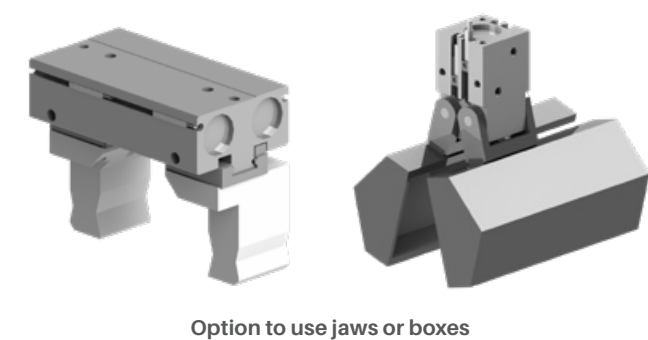
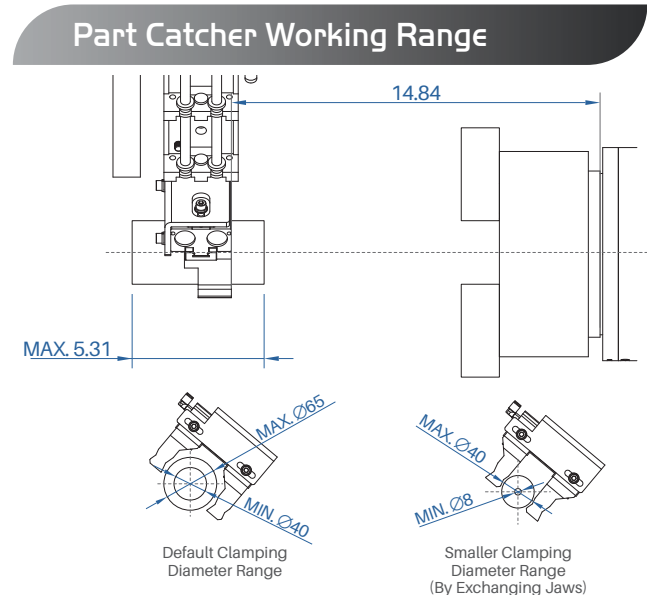
● Standard ◎ Optional - Nope

Special Specification Example



Part Catcher Specifications

Max. Parts Dia.	2.56	inch
Max. Parts Length	5.31	inch
Max. Parts Weight	7.71	lb



Highly Accurate Optional Equipment

There are special requirements for precise machining accuracy and it is necessary to use approved high-precision optional equipment.

Please contact us for advice on these options.

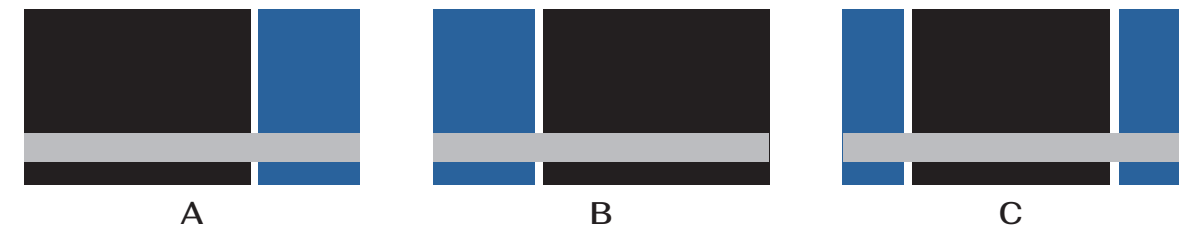
- 01 Linear Scales
- 02 Automatic I Manual Tool Setter
- 03 Nut Cooling Ball Screw
- 04 Cutting Fluid Cooling
- 05 High Pressure Coolant
- 06 Hydraulic Oil Cooling



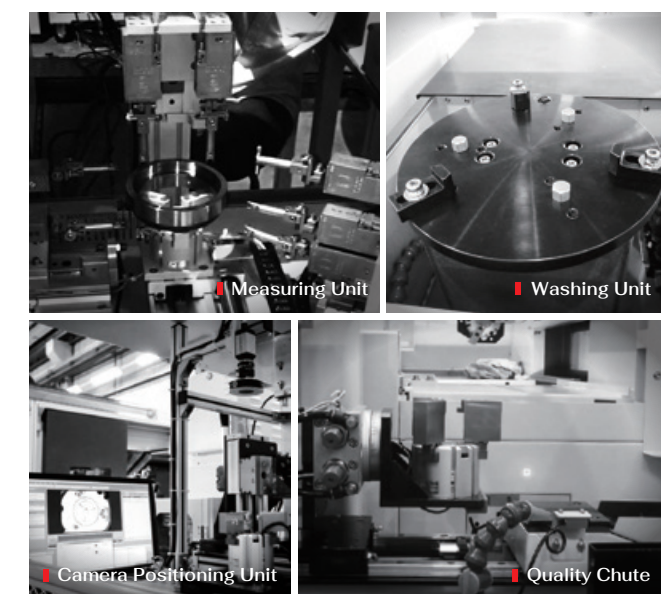
High Speed Gantry Loader System

Layout Variations

- Lathe
- Gantry Loader
- Workpiece Feeder



Peripheral Equipment



Gantry Loader Specifications

Feedrate

X-Axis Rapid Traverse	7086.61	ipm
Z-Axis Rapid Traverse	5905.51	ipm

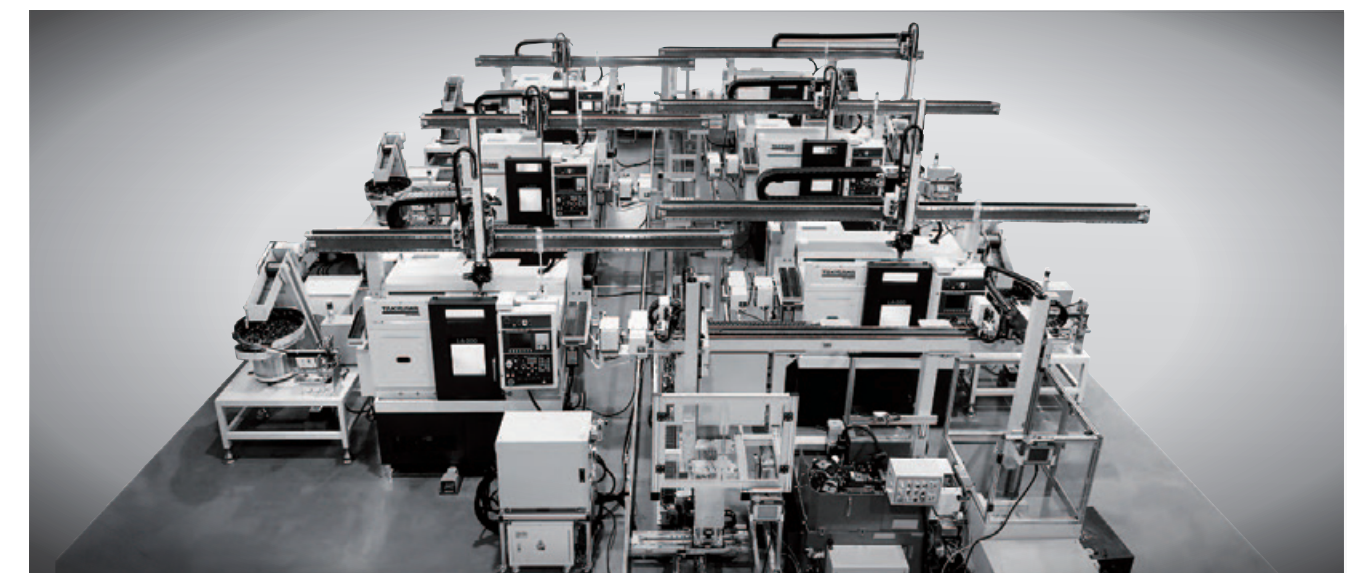
Working Size

O.D	6.3	inch
Length	3.94	inch
Weight	6.6 (x2)	lb

Work Feeder Specifications

Pallet	16	pcs
Loading Weight	88	lb
Max. Height	17.72	inch
Worker Feeder Width	24.02	inch

Turn-Key Solution



NC Unit Specifications

Specifications · Contents	FX-800
Controller	
Oi-TF	●
NC Unit	
8.4" Color LCD	-
10.4" Color LCD	-
15" Color LCD	●
Safety Device	
Front Door Interlock	◎
Front Door Locking Mechanism	◎
Safety Relay	◎
Control Panel Breaker with Tripper	◎
Controlled Axes	
Least Input Increment	●
Maximum Programmable Dimension (± 999999.999)	●
Least Input Increment C	▲
Inch / Metric Selection	●
Interlock	◎
Machine Lock	◎
Emergency Stop	●
Stored Stroke Check 1	●
Stored Stroke Check 2, 3	●
Stroke Limit Check Before Movement	▲
Chuck Tailstock Barrie	▲
Mirror Image (Each Axis)	▲
Chamfering ON / OFF	●
Overload Detection	●
Position Switch	●
Operation	
Auto Run (Memory)	●
MDI Run	●
DNC Run	●
DNC Run with Memory Card	●
Program Number Search	●
Sequence Number Search	●
Sequence Number Collation and Stop	●
Wrong Operation Preventive	▲
Buffer Register	●
Dry Run	●
Single Block	●
Jog Feed	●
Manual Reference Point Return	●
Dogless Reference Point Setting	●
Manual Handle Feed, 1 Unit	●
Interpolating Functions	
Positioning (G00)	●
Exact Stop Mode (G61)	●
Tapping Mode (G63)	●
Cutting Mode (G64)	●
Exact Stop (G09)	●
Linear Interpolation (G01)	●
Circular Interpolation (G02 / 03)	●
Dwell (G04)	●
Polar Coordinate Interpolation	●
Cylindrical Interpolation	●
Thread Cutting	●
Multiple Thread Cutting	●
Thread Cutting Cycle and Retraction	●
Continuous Thread Cutting	●
Variable Lead Thread Cutting	●
Reference Point Return (G28)	●
Reference Point Return Check (G27)	●
2nd Reference Point Return (G30)	●
3rd, 4th Reference Point Return	●

Specifications · Contents	FX-800
Feed Function	
Rapid Traverse Override (F0, 25%, 50%, 100%)	●
Feed Per Minute	●
Feed Per Revolution	●
Constant Tangential Speed Control	●
Cutting Feedrate Clamp	●
Automatic Acceleration / Deceleration	●
Rapid Traverse Bell-Shaped Accel / Decel	●
Linear Accel / Decel After Feedrate Interpolation	●
Feedrate Override (15 Steps)	●
Jog Override (15 Steps)	●
Override Cancel	●
Manual Feed Per Revolution	▲
Program Input	
Tape Code (EIA / ISO Auto Recognition)	●
Label Skip	●
Parity Check	●
Control In / Out	●
Optional Block Skip, 1 Piece	●
Optional Block Skip (2 to 9 Pieces)	⊕
Program Number O4 Digits	●
Program File Name 32 Characters	●
Sequence Number N5 Digits	-
Sequence Number N8 Digits	●
Absolute / Incremental Command	●
Decimal Point Input / Pocket Calculator Type Decimal Point Input	●
Diameter / Radius Programming (X-Axis)	●
Coordinate System Setting (G50)	●
Auto coordinate System Setting	●
Drawing Dimension Direct Input	●
G-Code System A	●
G-Code System B / C	▲
Chamfering / Corner R Programming	●
Programmable Data Input	●
Sub Program Call (10 Levels)	●
Custom Macro	●
Additional Custom Macro Common Variables	●
Single Canned Cycle	●
Combined Canned Cycle	●
Combined Canned Cycle II	●
Drilling Canned Cycle	●
Arc Radius Programming	●
Macro Executor	◎
Coordinate System Shift	●
Coordinate System Shift Direct Input	●
Miscellaneous Function / Spindle Functions	
M Function (M3 Digits)	●
Second Miscellaneous Function (B Function)	-
Spindle Functions (S4 Digits)	●
Constant Surface Speed Control	●
Spindle Orientation	●
Rigid Tap (Spindle Center)	●
Rigid Tap (Rotary Tool)	●
Data I/O	
RS-232C Interface for 1 ch	●
Fast Data Server	⊕
External Message	●
External Workpiece Number Search	◎
Memory Card I/O	●

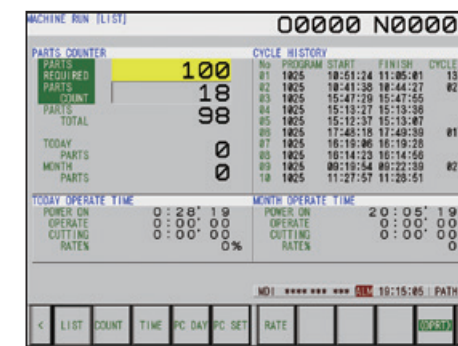
Specifications · Contents	FX-800
Tool Functions / Tool Offset Functions	
T Function (T2 + 2 Digits)	●
Tool Offsets, 32 Pieces	-
Tool Offsets, 64 Pieces	●
Tool Offsets, 99 Pieces	◎
Tool Offsets, 200 Pieces	◎
Tool Offsets, 400 Pieces	-
Tool Geometry Size Data, 100 Pieces	◎
Tool Position Offset	●
Tool Diameter / Nose R Compensation	●
Tool Geometry / Wear Compensation	●
Tool Offset Counter Input	●
Tool Offset Measured Value Direct Input	●
Tool Offset Measured Value Direct Input B	◎
Tool Life Management	▲
Accuracy Offset Functions	
Backlash Compensation	●
Backlash Compensation by Rapid Traverse / Feedrate	●
Editing	
Part Program Memory Capacity 128K byte (320 m)	-
Part Program Memory Capacity 320K byte (800 m)	-
Part Program Memory Capacity 512K byte (1280 m)	-
Part Program Memory Capacity 1M byte	●
Part Program Memory Capacity 2M byte	◎
Registrable Programs, 400 Programs	-
Registrable Programs, 800 Programs	●
Registrable Programs, 1000 Programs	◎
Program Editing	●
Program Protection	●
Extended Program Editing	●
Background Editing	●

Specifications · Contents	FX-800
Setting / Display	
Status Display	●
Clock Function	●
Current Position Display	●
Program Comment Display (31 Characters)	●
Parameter Setting and Display	●
Alarm Display	●
Alarm Log Display	●
Operator Message Log Display	●
Operation Message Log Display	●
Run Hours and Parts Count Display	●
Actual Speed Display	●
Actual Spindle Speed and T Code Display	●
Floppy Cassette Directory Display	●
Grouped Directory Display and Punching	●
Servo Adjustment Screen	●
Maintenance Information Screen	●
Data Protection Key, 1 Kind	●
Help Function	●
Self Diagnostic Function	●
Scheduled Maintenance Screen	●
Hardware & Software System Configuration Display	●
Graphic Display	●
Dynamic Graphic Display	◎
Display Languages	
English	●
Japanese (Kanji)	▲
Other Language	▲
Display Language Dynamic Switching	●

● Standard ◎ Optional ⊕ Special ▲ Parameter setting is required - Nope

Smart Work Manager (Option)

01



It provides simple operation and convenient function.

01 Tool Life Manager

This function can set tool life and wear limit to manage all tools.

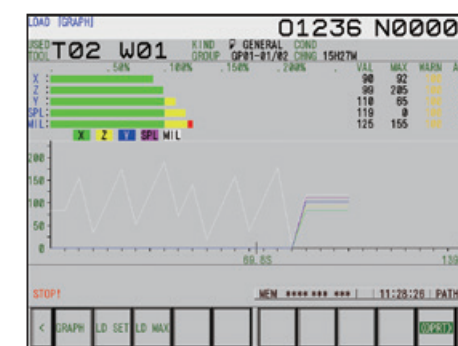
02 Load Monitor

Detecting max load to check tool status.

03 Parts and Machine Manager

It offer parts counter, program history, operate time for today or this month.

02



03

