

# G996

› High performance milling systems ›



**FIDIA** 

## 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

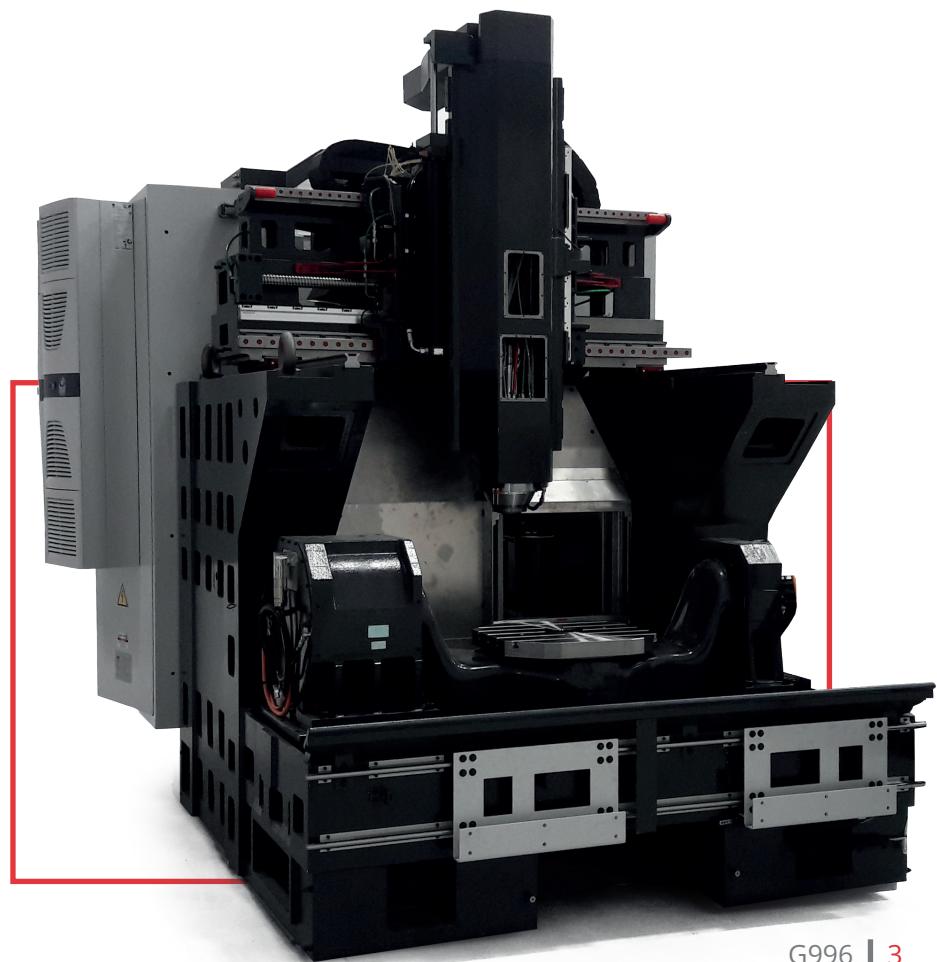
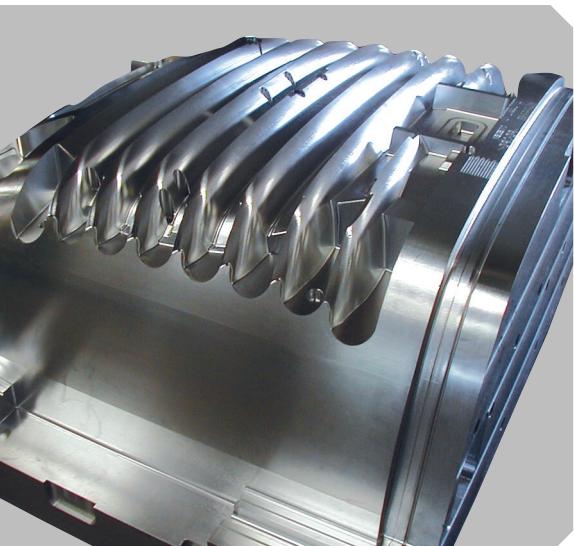
The large cast iron bed provides a stable support for the moving parts, while the open front ensures wide visibility.

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.

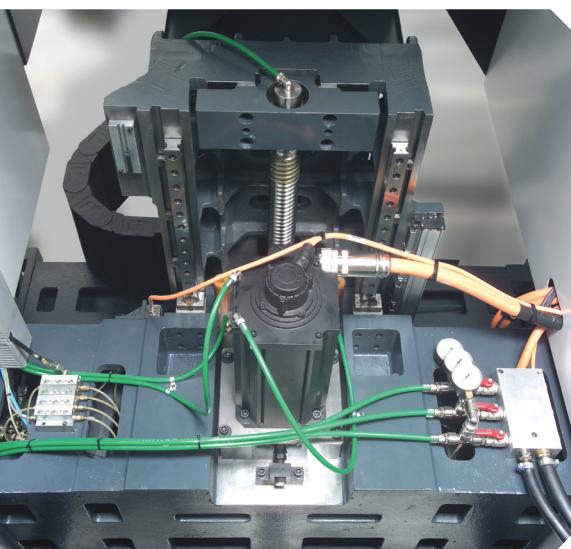
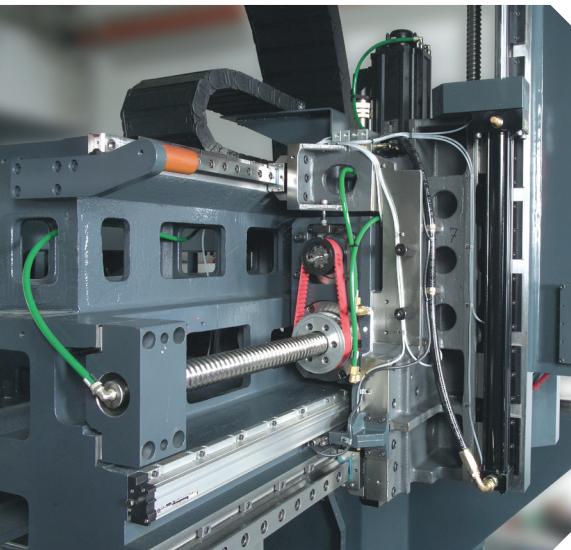
Furthermore, dedicated sensors measure the ambient and structural temperatures providing an overall monitoring picture. In this way, maximum accuracy is achieved even with lengthy machining cycles requiring numerous re-machining operations and tool changes.

## 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.



## 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/C20-Vision Fidia CNCs

The new hardware and software solutions featured in C20/C20-Vision enable achieving maximum performance and the highest precision in the machining of molds and aerospace components. The multiprocessor architecture for operator interface management, axis control, realtime anti-collision software ViMill, in synergy with the new Velocity Six™ function for tool path management, allows for high milling performance in terms of quality and speed.

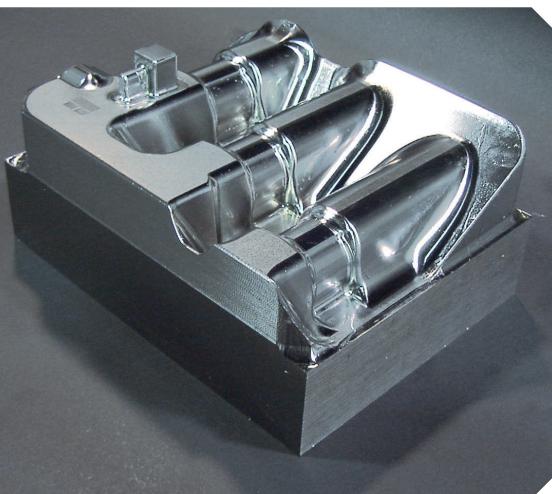
## Simple and reliable machining

The C20 is equipped with a 19" 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).



## 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.

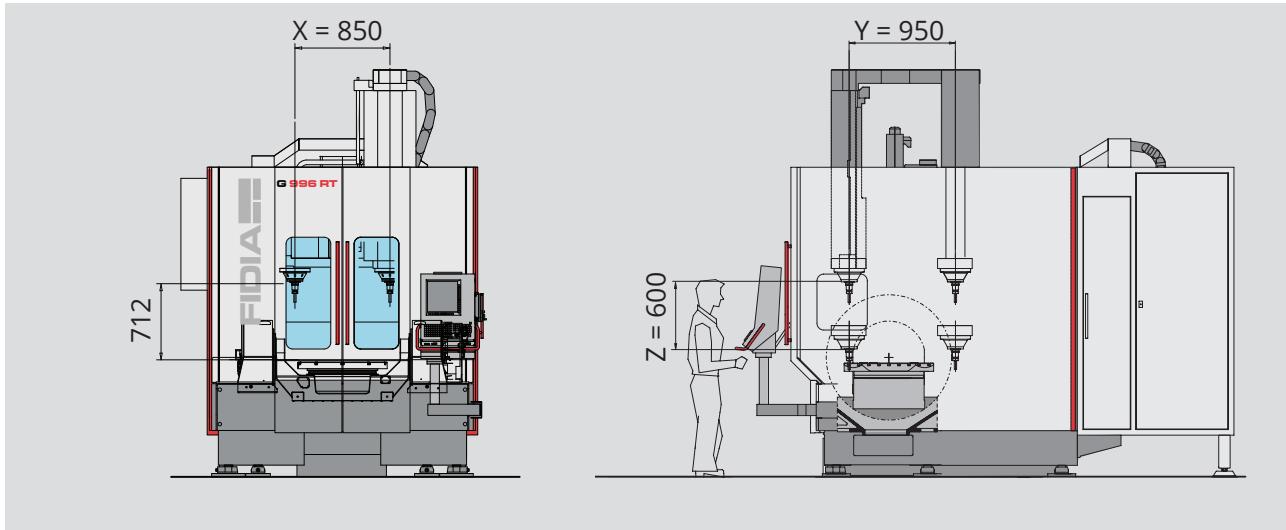
The total enclosure of the work area together with optional protection with air sealed guideways and ballscrews enables the machining of highly abrasive materials such as ceramics and carbon fibre.

## 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.



## G996RT/P-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)
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#### Positioning precision

X, Y, Z	± 0.003 mm (± 0.00012")
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#### Maximum acceleration

X, Y, Z	10 m/s <sup>2</sup> (394 inches/s <sup>2</sup> )
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#### Tool magazine

positions	24 - 42 - 84
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#### Standard machine tool weight

17000 kg (37478 lbs)

### Milling heads

Electrospindle 3 axes	M3A/30-24	M3A/46-16
Maximum power (S6)	30 kW	46 kW
Maximum torque (S6)	105 Nm	183 Nm
Max. spindle rotation speed	24000 1/min	16000 1/min
Toolholder	HSK-A63	HSK-A63

### RT Table

### P-1000

Platter dimensions	Ø 800 mm (Ø 32")
Max. rotating diameter (swing)	1000 mm (3.9")
A axis	± 125°
Stroke	75 1/min
Speed	2000 °/s <sup>2</sup>
Acceleration	
C axis	rollover
Stroke	100 1/min
Speed	2000 °/s <sup>2</sup>
Acceleration	
Load Capacity	1200 kg (2645.5 lbs)

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