

THE FNK 25 milling machine includes several self-contained assembly units.

THE MILLING HEAD

of the machine has a self-contained drive, the units of which are the electric motor, the four-stepped belt drive and the belt countershaft. The milling head is seated in precision antifriction quill bearings. The quill is traversed either manually or mechanically through a fourstepped gearbox, the drive of which is derived from the spindle. The manual traverse of the quill for rough adjustment is effected by means of a lever, while for additional adjustment of fine increments a handwheel is used. When adjusted, the quill is locked in position. When traversing the spindle under power, the switching off of the feed in preselected position can be effected by means of a micrometric stop dog.

Quill travel is 125 mm, mechanical feeds: 0.035 — 0.07 — 0.14 mm/revolution.

Spindle speeds are stepped as follows:

58 — 90 — 112 — 140 — 180 — 224 — 280 — 450 — 560 — 900 — 1120 — 1800 — 2240 — 2800 — 4500 r.p.m. 1400 —

The protection of the quill mechanism against overload is effected by means of an overload coupling.

THE REAR OF THE KNEE

is provided with a long guide for traverse of the knee along the column, the upper part is fitted with flat ways for guiding of the cross slide. To the front face, control units are fitted of both the cross and the vertical table feed. Anchored to the body of the knee is a cross feed traverse screw, the cross feed nut being supported by a stand firmly secured to the foundation plate of the machine.



FNK 25

THE COLUMN

of the machine is designed as a cast iron body of high rigidity, firmly secured to the foundation plate by screws. The inside of the foundation plate forms a coolant reservoir. The back part of the column is protected by a cover in the inside of which there is the electrical equipment. On the front face of the column a flat guide is provided for traversing of the knee. The head of the column carries a rotary pivot support.

THE SLIDING ARM

is carried on a dovetail guide of the pivoted support. To the front part of the arm a body is mounted for supporting the pivoted milling head. To the back part of the arm optional attachments are fitted (e. g. shaper head). The arm can be moved horizontally by means of a manual lever via a rack and a pinion. When a milling operation is to be performed, the arm is locked in position by two screws with a tightening lever.

THE TABLE

The clamping surface of the table is provided with T slots, the other side with dovetail guides for carrying the table on the cross slide. The cross slide is traversed along the guide of the knee. For the travel of the table manual operation is intended, but is it also possible to actuate its longitudinal traverse mechanically. The drive of the mechanical table traverse is derived from a self-contained electric motor via a gearbox situated on the left-hand side of the slide. The operation and breaking of both the feed and rapid traverse is effected by means of a switch-board lever. The switchboard is situated on the right-hand side of the cross slide. The feeds of the table are stepped as following 14 — 20 — 28 — 40 — 56 — 80 — 112 — 160 — 224 — 315 — 450 — 630 mm/min. The engagement of feeds is effected by means of two gearbox levers. The traverse nuts of both the longitudinal and the vertical feed traverse screw are equipped with antibacklash device. The feed mechanism is protected against overload by an overload coupling.

ELECTRICAL EQUIPMENT

All the electrical instruments, e. g. the contactors, fuses, relays, the transformer, the coolant switch, the main switch and the switch of the electric motor, are fitted to the inside of the cover that encloses the rear of the column. After the cover has been unlocked the instruments are easily accessible. On the front face of the milling head there are push-buttons for starting and stopping of the spindle and a red signal light of the main switch. This light signalizes the connection of the machine to the mains. The engagement of the spindle is signalized by a green signal light. On the switchboard there is a switch for actuating of the feed motor, the engagement and disengagement of the feeds and rapid traverse being effected by means of a hand lever.

The standard version of the FNK 25 milling machine is fitted with electrical equipment for current voltage 380 V/50 c/s, the control voltage being transformed to 48 V and lighting to 24 V.

User Manual For Tos Fnk25

O García



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