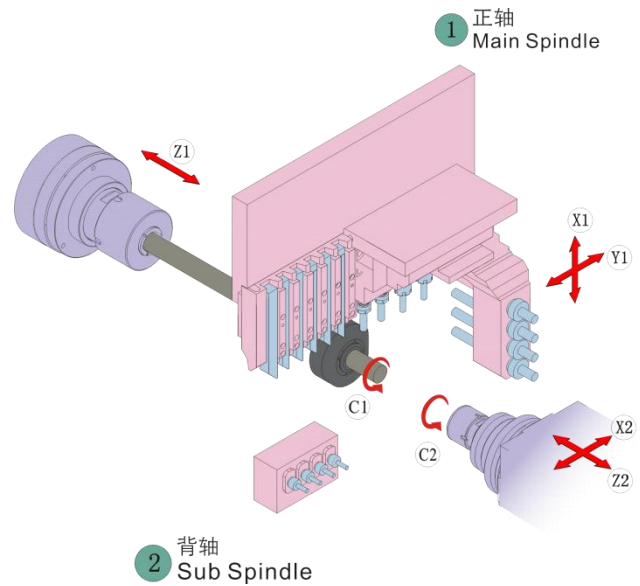


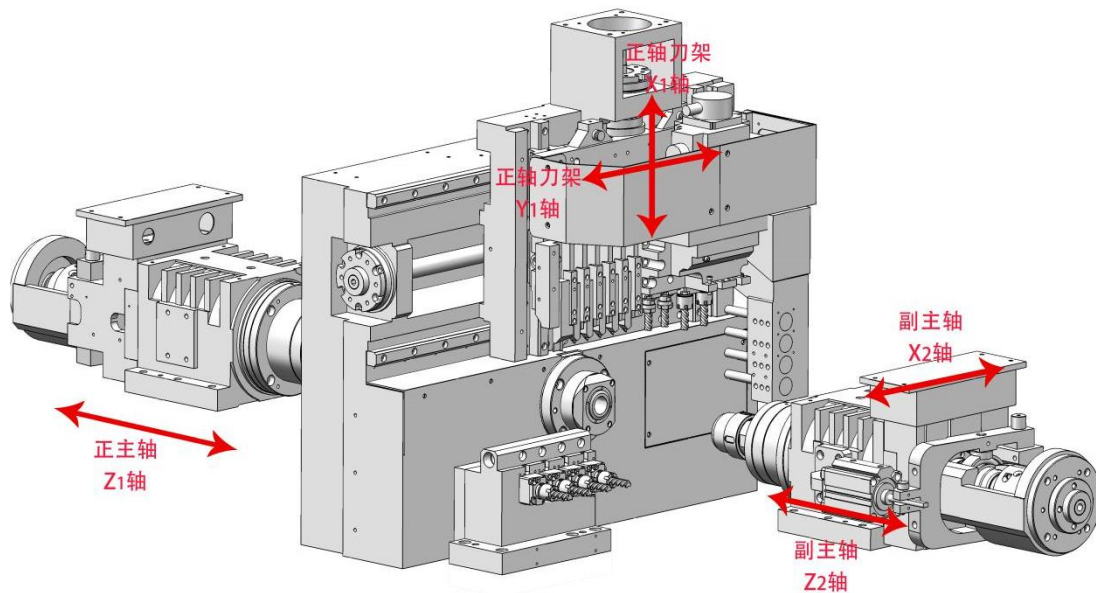


MA25-5 II Description and Technical data

Lathe Appearance/Tool Holder Structure



Structure Diagram





1. Characteristics

1、 Rotary Guide bush/Without guide bush changeable modes

Support Rotary Guide bush/Without guide bush changeable modes. When using rotary guide bush mode, it is suitable for processing slender bar, with a single feeding length of 195~200mm and support for multiple feeding. The tail material length is 180mm; When using without guide bush mode, it is suitable for processing short workpieces with a length to diameter ratio of less than 1:2.5, which can minimize the length of the tail material. The length of the tail is 50mm

2、 Internal oil cooled electric spindle

Adopting Japan oil cooled electric spindle technology, independently designed and developed, we have overcome the core problems of the spindle of the Swiss CNC lathe machine. Compared with other electric spindles of the same power, we have **stronger rigidity and torque force**, and more stable processing accuracy. Using NSK bearings to extend spindle life and radial stability.

3、 Scrap collection tank/large capacity cutting oil tank

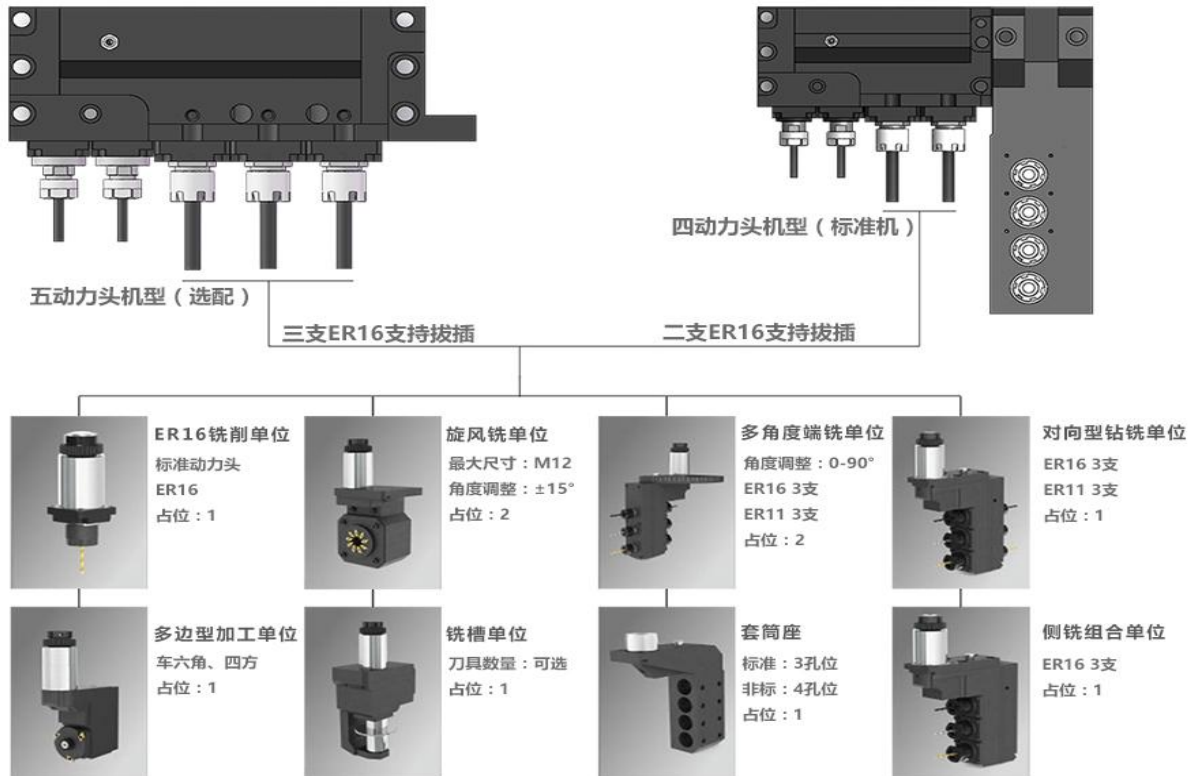
The waste collection box adopts a separation platform for chip collection, allowing the cooling oil to undergo preliminary buffering and cooling on the chip collection platform for preliminary oil chip separation; Then enter the cutting oil tank with a volume of 250L from the oil drain. The cutting oil tank is equipped with multi-channel filter screens and oil return baffles to extend the return path and separate /filter oil chips as far as possible; Make the oil temperature reach full Free cooling and reduce the debris entering the oil pump, so as to extend the service life of the oil pump.

4、 Workpiece eject method: short parts ejected to the front of the conveyor belt/long parts ejected from the rear of sub spindle

Jianke's full series of dual spindle Swiss CNC Lathe come standard with a collection method of front discharge products. When the length of the workpiece is less than 90mm, the front material receiving box can be used for collection and the product can be sent out through a built-in conveyor belt. When the product length is more than 90mm, the rear discharge method can be selected, and the product is ejected through the center of the sub spindle through a slot on the side sheet metal of the equipment.

5、 5、 Highly modular expansion function

The JIANKE MA series lathes comes standard with 2 ER11+2 ER16. The 2 ER16 side rotary power tools supporting modular expansion functions that can be added with additional functions and tool positions according to demand. (The plug-in modules are all for options and if needed for such modules, please list them in the contract/quotation.)



The above is only a demonstration of the plug type expansion functions of some modules. Please confirm with JIANKE if you have more requirements of other modules based on actual processing

2. Technical Data

Double Spindle Swiss CNC Lathe MA25-5 II			
System	Taiwan SYNTEC	Syntec210TB-A	
	Control channels	Dual channel	
	Minimum setting unit	0.001mm	
Machining Ability	Max processing diameter	25 mm	
	Maximum single feeding length	Rotary guide bush	195mm
		Without guide bush	1:2.5D (Dia:Length)
	Main spindle max drilling Dia	axial (main spindle)	$\Phi 10\text{mm}$
	Main spindle tapping Dia	axial	M8
	Rotary tools max drilling Dia	radial	$\Phi 8\text{mm}$
	Rotary tools max tapping Dia	radial	M6
	Sub spindle max drilling Dia	Axial (sub spindle)	$\Phi 8\text{mm}$
Tools	Sub spindle max tapping Dia	axial	M6
	Tool base arrangement	Upper row tool base	



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	Main spindle O.D. tools	6 pieces	1*10X10mm+5*12X12
	Main spindle side rotary live tools	4 pieces	2*ER11+2*ER16
	Main spindle end face fixed tool	4 pieces	ER11/ER16
	Sub spindle end face fixed tool	4 pieces	ER11/ER16
Spindles	Main/Sub spindle type	Internal oil cooling electric spindle	
	Main/Sub spindle speed	10000rpm/min	
	Main/Sub spindle indexing	0.001°	
	Main/Sub spindle through hole Dia	26mm	
	Main/Sub spindle height	1018.5mm	
Motors	Main spindle power (Rated/Max)	2.5kw/3.7kw	
	Sub spindle power (Rated/Max)	2.5kw/3.7kw	
	Side rotary tools motor power	1.0kw	
	Side rotary tools speed	ER11*2 pieces	10000rpm/min
		ER16*2 pieces	6000rpm/min
	Moving axis	5 axis	X ₁ 、Y ₁ 、Z ₁ 、X ₂ 、Z ₂
	Rapid feeding speed	X1	24m/min
		Y1、Z1、X2、Z2	32m/min
	Motor power of moving axis	1.0kw	
Others	Parts collector	Short parts	Belt conveyor to collect parts
		Long parts	rear ejection from sub spindle
	Power capacity	15kw	
	Air pressure	0.4MPa 以上	
	Capacity of machining oil tank	250L	
	Lathe size	2.4m×1.4m×1.7m	
	Lathe weight	3050KG	

3. Standard Accessories

NO	Name	Qty	Note
1	Protective cover	1 set	
2	Nameplate	1 piece	
3	Spindle	2 units	Main and Sub spindle
4	Knife holder for turning tools	1 set	1*10X10mm+5*12X12
5	Side rotary tools base	1 set	2*ER11+2*ER16
6	Main spindle end face drilling tools base	1 set	4 pieces ER11/ER16
7	Sub spindle end face drilling tools base	1 set	4* ER11/ER16 support to upgrade to end face rotary tools
8	Live rotary guide bush	1 set	



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9	Pneumatic system	1 set	
10	Cooling system	1 set	
11	lubricating system	1 set	
12	electrical system	1 set	
13	Parts receiver/collector	1 set	Standard with front ejector/belt conveyor
14	Lathe lighting	1 set	
15	Lathe three color alarm light	1 set	Three color lights+ Beep alarm
16	Tool box	1 set	Including tools such as wrenches, screwdrivers, and oil kettles
17	Transformer	1 unit	
18	Manual book	1 set	Lathe manuals/ System book/ Spare parts list/Quality testing report

4. Options equipments (if needed , please list them in the contract/quotation)

NO	Name	Functions	Note
1	Bar feeder	Realize automatic feeding/refueling function for long bar materials; Assisting the Swiss CNC lathe to achieve automated production;	Recommended essential
2	High pressure pump	Assist in targeting materials that are prone to chip breakage, chip removal, and erosion, reducing the probability of tool chip entanglement; Extend tool life; Improve the accuracy/smoothness of some machining steps;	Select according to demand
3	Oil mist collector	Absorb the atomized oil mist inside the equipment, reduce the overflow of oil mist from the equipment, and maintain the workshop environment. The models are divided into electrostatic type and filter type.	Select according to demand If equipped with a high pressure pump Recommended mandatory oil mist collector
4	Chip conveyor	Chain type conveyor remove chips from lathe collector, standard equipped with a chip trolley. Reduce the frequency and workload of manual chip removal.	Select according to demand
5	Plug type modules	End face rotary tools/Angle rotary tools/Thread whirling/Hobbing	Due to various modules/functions,



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		base/Saw blade base/Boring tool base...	Please confirm with JIANKE according to actual machining requirements.
6	Long parts discharge from backwards	If the parts are longer than the collector opening, need change to eject it from backwards of sub spindle	Select according to demand
...	...		...
Due to the different options/configurations of the Swiss CNC lathe, the above are regular configurations. If you have special needs, please communicate and confirm with JIANKE.			

5. Main accessory brand

Name	Origin and Brand
Operation System	SYNTEC (Made in TAIWAN)
Spindle and Driver	Oil cooling electric spindle/Mitsubishi driver
Bearing	Japan NSK
Guide rail	Japan THK/Taiwan Hiwin/Taiwan PMI
Guide screw	Japan THK/Taiwan Hiwin/Taiwan PMI
Servo Motor	SYNTEC (Made in TAIWAN)
Motor driver	SYNTEC (Made in TAIWAN)
Electrical components	France Schneider
Lubricant system	Japan Herg
Relay	Japan Omron
Stroke switch	Japan Omron
Magnetic valve	Taiwan Airtag

6. Swiss CNC lathe requirements for raw materials in the processing of long bar materials.

- 1、Recommended use of polished/precision drawn materials: As the standard bar feeder supports a maximum length of 3M for bars, it is recommended that the length of a single bar material should be $\leq 3M$;
- 2、Consistency of material diameter tolerance within $\pm 0.02mm$;
- 3、The consistency of material roundness tolerance is within $0.005-0.01mm$;
- 4、The straightness of the material is required to be within $0.35mm/m$;
- 5、All the bar materials need to be chamfered at both ends;
- 6、Some large-diameter materials and irregular (square/hexagonal) materials require turning the tail of them to match the bar feeder collet and easy to be sent through the spindle hole;
- 7、When the material hardness is higher than HRC28 degrees, a prior declaration is required.

**** The above are the regular requirements of raw materials for the Swiss CNC lathe, and the**



material tolerance can be relaxed/tightened according to the actual product accuracy requirements

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7. Quality assurance and technical support

The warranty period for the supplier's equipment is one year from the date of final acceptance by the Buyer before shipment. Under normal use, there is a free service warranty for damage. If the equipment is damaged due to improper use by the buyer, the supplier will only charge material fees within one year, and material and labor fees will be charged after one year. The supplier shall provide paid services /spare parts to the buyer for a long time. Make the following commitments to technical support, pre-sales, in sales, and after-sales service and quality:

1、 Pre sales service: The supplier is responsible for providing free basic training to technical personnel sent by the buyer to the factory for CNC lathe operation, debugging and maintenance learning.

2、 In sales service: At the same time as the equipment arrives at the buyer's factory, the supplier sends personnel to the buyer's factory for free basic training;

3、 After sales service: For equipment malfunction complaints, both the supply and buyer parties shall communicate in detail about the specific malfunction in advance. If it is determined that the malfunction can be eliminated by the buyer party, the supplier shall provide specific guidance through phone, fax, etc. If it is a fault that must be resolved on-site by the supplier, the supplier must respond within 24 hours after determining the fault and provide a solution and expected on-site resolution time. After exceeding the one-year shelf life, a certain amount of material and labor fees can be charged appropriately.

4、 Technical support: When the buyer encounters difficult and miscellaneous parts or high technical requirements during the use of the equipment, the supplier can provide remote technical guidance. If the supplier is required to debug and program on behalf of the supplier, the supplier will only charge the reasonable costs.



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8、Domestic End User Lists of JIANKE



China Aviation Industry Standard Parts
Manufacturing Co., Ltd



Poyang Black Diamond Fishing tackle Co.,
Ltd



JIER Machine-Tool Group



Zhejiang Wangli Door Industry Co., Ltd



SYNTEC Technology (Suzhou) Co., Ltd



惠宝股份
HUIBAO CORP.

Hangzhou Huibao Electromechanical Co.,
Ltd



Zhejiang Anlu Cleaning Machine Co., Ltd



Anhui Dongfeng Electromechanical
Technology Co., Ltd



Xiamen Xiahui Rubber Metal Industry Co., Ltd



Liudao Wanhe (Suzhou) Hot Runner System
Co., Ltd



中国航天

Chongqing Rocket Aerospace Electronic
Technology Co., Ltd



China Hongqi Instrument Co., Ltd



Zhejiang Canaan Technology Co., Ltd



Anhui Tiankang Huayuan Technology Co., Ltd



Jiangsu World Agricultural Machinery Co.,
Ltd



Jiaozuo Xingang Medical Equipment Co., Ltd



Anhui Toposi Automotive Parts Co., Ltd



Zhejiang Diyuan Instrument Co., Ltd



Ningbo Siming Automotive Technology Co.,
Ltd



Guangdong Panasonic Environmental Systems
Co., Ltd



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Weihai Hemingway Fishing tackle Co., Ltd



Ningbo Yinzhou Yada Automotive Pipe
Fitting Co., Ltd

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