

5-axis Machining Centers

FH Series FH630SX-5A

Machine tools & FA systems WEB sight

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Type of Machinery: Machining Center Model Number: FH630SX-5A © JTEKT CORPORATION 2019, 2023 CAT.NO.MA033EN-0TA Printed in Japan '23.03

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CAT.NO.MA033EN-0TA

Supporting manufacturing with rigidity and size

Aerospace industry, energy-related industry, construction machine and transport machine

Top-level performance in machining medium-sized parts of every industry

This series performs simultaneous 5-axis machining - achieving complex shape parts and multi-surface processing all with one set-up. This equates to reduced set-up time and shorter workpiece machining lead time.

The FH630SX-5A 5-axis machining center assures quality, improves production efficiency, and achieves high cost performance.

Highest level of workpiece loading capacity

Cutting ability, the strongest in the class

Maximum workpiece swing, maximum workpiece height and maximum workpiece mass make this machine the largest in its class. From aluminum to titanium - the FH630SX-5A features a highly versatile 5 axis special-purpose spindle not limited to a single material.



"Bigger, More Rigid"

Achieving High-performance Processing of this versatile 5-axis Machine is The Flexible Swivel Spindle and the Highly Rigid, Supportive Platform

We adopted a tilting swivel motion for the spindle of the 5-axis processing machine. This spindle, which carries on the DNA of the JTEKT's unique highly rigid spindle, has enabled exceptionally efficient processing and achieved stable processing of large workpieces, thanks to the 5-axis structure that does not tilt the table.

Furthermore, the Platform, which supports this spindle, minimizes displacement from "external force" that affects processing accuracy. As a result, this is a strong, highly rigid Platform that can endure huge cutting forces in addition to the inertial force of feeding acceleration/deceleration.

An unmatched sturdy platform, utilizing the 5 axis function to the fullest.

Symmetric Y-axis movable body

With the Y-axis ball screw positioned on the center, the series features a symmetrically shaped Y-axis movable body, which reduces heat deformation due to temperature changes, and imbalance due to gravity achieving stable feeding.

Back column system

By moving the X-axis with a saddle and sturdily supporting it with the stationary back column, the product has achieved excellent maneuverability thanks to a reduced weight of the movable body and high rigidity that can endure heavy cutting at the same time.





The bed which supports movable bodies uses FEM analysis technology, securing sufficient rigidity and significantly enhancing the movable level. This has made stable axis feed possible.

Flexible Swivel Type spindle (C-axis unit)

With the adoption of the tilted swiveling spindle, large workpieces can be loaded on the pallet. The product has the swiveling axis (C-axis) on the spindle side, so the weight of workpiece does not affect it. Also, the inclined swiveling spindle, which rotates around the 100-mm tool length point, has the shortest travel distance of the straight axis associated with swiveling of the spindle. This allows for processing larger workpieces in one set-up.

Excellent spindle accessibility

The product has excellent spindle accessibility with optimal axis positioning and sturdy machine rigidity. It can reach the position of 300 mm away from the center of the pallet when the spindle is in the vertical position, which provides a wide processing range





Workpiece maximum dimensions and mass



* The maximum dimensions of workpieces are partially limited. See the tooling document for details.

Highly rigid bed back column of high-class cast iron



Rigid cylindrical roller slide

Compared to the ball guide, the cylindrical roller slide features less elastic deformation against loads and possesses superior vibration damping characteristics. This feature makes it possible to position quickly with smaller orientation changes upon sudden acceleration or stoppages, contributing to a higher level of production efficiency.



Because of JTEKT's assembling technology which allows for strict mounting face accuracies, the rigid cylindrical roller slide offers the best rapid feed rate and acceleration in it's class.





Each and every spindle is backed by its own specific type of outstanding technology.

Optimal for iron and cast metal machining 15,000min⁻¹ spindle [standard] / 8,000min⁻¹ spindle Option

10%(526N·m)

15%(428N•m

25%(358N·m)

Forque (N•m)

Rotation speed: 15,000min

Output (kŴ) Torque (N·m)

1,088 999 811

Rotation speed: 8,000min⁻¹

Output (kW)

10%(1,088N•m)

15%(999N·m

25%(811N·m

30-min. rating(579N·m)

[Spindle speed] 15,000min⁻¹ / 8,000min⁻¹ [Spindle nose shape] BT No. 50 [Spindle motor (short-time/continuous)] 55/37kW / 80/55kW [Max. torque] 526N·m / 1,088N·m [Spindle diameter (front bearing bore)] ϕ 120mm We offer the 15,000min⁻¹ spindle, which is the high speed / high rigidity multi-use type covering a wide

range from iron materials processed at low and medium speeds, to aluminum materials processed at high speeds and a high feed rate. We also provide the high torque 8,000min⁻¹ spindle, which adopts large diameter ceramic ball bearings that can handle heavy cutting of difficult-to-cut materials with a high load capacity.



High-efficiency machining with 15,000min⁻¹ spindle

Test piece

[Workpiece material] S45C

Milling

B/NL

[Tool] ϕ 125 face mill [Spindle speed] 800min⁻¹ [Feed rate] 2,240mm/min [Depth of cut/width] 4.2/100mm [Machining efficiency] 941cm³/min



DD table

The high speed indexing and high precision machining, with the adoption of the high-torque DD (direct drive) motor, features no backlash and highly rigid cross roller bearings. The rotary encoder is included as a standard.



Table cross-section

Reliability starts with chip disposal. The design of the Center trough makes it possible to effectively manage chip disposal directly beneath the cutting point.



1 Center trough

Smoothly processing machining chips with a large chip discharge port in the bed center.





5 X-axis protective cover against chips

The bellow cover with the independent stainless steel plate on both left and right sides excels in maintainability and exchangeability while achieving high sealing performance and durability.



TOYOPUC-Touch

HMI in the IoE* era Simple, safe and connectable



Renewed operability	J-Operate
Realization of simple operation	J-Navigate
Visualization of equipment status	J-Support
Batch management of equipment information	J-Manage
Equipment diagnosis utilizing IoE	J-Care

* JTEKT supports the IoE (Internet of Everything) that connects people, things, information, and services.

Renewed operability

Visible and effective operation thanks to batch data display

Consolidates information onto a single large-size display screen, and displays a keypad window when necessary





Realization of inspirational operation

Screen swiping and pinching in/out mimics the operability of a smart phone, making the TOYOPUC-Touch easy to use and easy to learn



Realization of simple operation

Minimal number of screen calling operations

With the itemized menu lists, a screen can be called up in a maximum of two steps from any screen.



Easy program status check before starting machining

Details, subprogram construction, and tool status can all be checked before starting machining just by selecting a program from the program list screen



J-Operate







Displays keypad window when input is necessary

J-Navigate



Visualization of equipment status

Visualization of inspection

#HE 6010 N00000

Mad

Visualization of fault 00000 N.00000

J-Support

Supports planned maintenance

is almost over

through notifications of when life

 Notifies the user of inspections for parts that are nearing the end of their lives

Minimizes machine stop time through

procedures can be viewed without

Inspection areas and inspection

~Operation monitor~

Supports production control and

operation performance/machining

Performance can be viewed easily on

graphs and tables, and data entry is

 Current performance can be compared with past performance of the selected period

Performance can be viewed easily by shift

improvement via graphs showing past

consulting a manual

performance

also possible

preventive inspection/part preparation

Supports operations performed at customer work sites with functions that visualize equipment status Management function for replacement parts service life~

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Visualization of longevity ~Periodic inspection function~



- messages Inspection areas and inspection procedures can be viewed without consulting a manual
- Registration of completed past inspections/measurement results

~Equipment diagnosis~

-----Supports maintenance by 1. allowing on-screen assessment of equipment status

- ON/OFF status of devices can be viewed
- without having to check devices directly • Device locations can be identified
- easily through image enlargement
- Internal ladder circuits can also be viewed easily

~Fault analysis function~

Displaying error records through graphs for fault analysis

- Displays analysis results in graphs and tables making them easy to understand, and enables data output
- Displays analysis results for a specified period. The number of errors that occurred can be monitored for each of the alarms.
- Helps gain an understanding regarding trends in occurrence for each of the past alarms

Renewed operability

Batch management of tool/pallet information



Tool management function Allows automatic indexing of the selected pot without having to know the tool installation position

- Protects tools by using ATC speed commands suited to each tool
- Enables prior assessment of abnormal or insufficient tooling





J-Manage

J-Care

- values for each pallet Enables omission of unnecessary
- machining

Equipment diagnosis utilizing IoE

Shortens error recovery time thanks to quick support



functions	of TO	OPUC	-Touch

	Classification		Function name	Included
		Running status display		
		Program list display/editing		
		Command list display		
		Macro variables list display	(oditing	
		Workpiece coordinate syste	m offsot display/aditing	
J-Navigate	Basic functions			
		User registration		
		Message board		
				•
		Document browsing		
		Fault list display		•
		Fault history		•
	Basic functions	Operation history		•
		Signal status		•
		System information		•
		Backup		
		Operation monitor	Machining performance	•
J-Support	Production support functions		Operation performance	
e eappert		Cycle time measurement		
	Energy saving functions	Energy monitoring		
		Energy saving settings		
	Sonvicing functions	Periodic inspection function		
	Servicing functions	Management function for replacement parts service life		
	Matalana fastina	Equipment diagnosis		
		Manual ATC recovery (easy-to-recover function)		
	Maintenance functions	Software diagnosis function		
		Fault analysis function		
	Tool management functions	Tool number conversion function		
		Tool offset function		
		Tool longevity management function		
		ATC variable speed function		
		Offset updating function		
		AC function		
		Machining condition setting function		
		Stored tool data save function		
		Tool position display		
		Tool display in magazine		
J-Manage		Abnormal tool list display		
		Share tool list display		
		Tools scheduled to be used		
		Tools scheduled to be used		
		High-performance	Automatic indexing function for tools that require change	
		magazine operation panel	Data updating function at tool mounting/removal	
			Tool ID function	
		APC management		
	Pallet information			
	management functions	Multiple workpiece meretin	a	
		Diognopio dete collection f	5 Instian	
J-Care	Remote support	Diagnosis data collection function		
		Remote diagnosis function (using Team Viewer)		

Details of functions / Workability

TIPROS

An easy to use, comprehensive production system that keeps on evolving.

JTEKT has delivered many systems since the first FMS sold in 1972 and has come to be seen by both domestic and overseas customers as an innovative company offering high reliability while exceeding industry expectations, and as such, indispensable in the FA era. At JTEKT, we manufacture the best FMC/FMS by combining our original thorough mechatronics technologies with cutting-edge software modules - delivering numerous records.



Flexible machine tool supports high speed, high efficiency and high precision Intelligent peripheral units

FPA: Flexible Pallet Automation (pallet transfer method) Expandability and unmanned operation

RGV (rail-guided vehicle) + stacker crane



FDT: Flexible Directly Transfer (workpiece transfer method) Low-cost unmanned operation of low-variety, high-volume production



The 5-axis machine shares the same system setup as that for the 4-axis machine

The pallets, pallet height, and workpiece restrictions (swing x height x mass) are common to the existing 🗌 630 (FH630SX-i). This allows for easy connection to the existing FMS. Flexible in compatibility for various production patterns.



Software

FMS software for TIPROS FPA(CL30, MG30, TL30)

Superior control functions

Data setting is possible with a simple click. Workpiece tshat are behind schedule are displayed in red. The machine automatically decides which fixtures in the line need replacing with the schedule.





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Flexible control functions Enriched unmanned operation support functions

acker crane method, carrier method					
1		FMS Level2	FMS Level3		
		•	•		
		•	•		
			•		

Option: Scheduling, preventive maintenance, multiple-parts loading, etc.



Scheduling by work

Easy fixture management



Automatically deciding fixture replacement



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Machine specifications

Item			FH630SX-5A		
			Unit	Standard specifications	Special specifications
	Table dimensions (pallet dimensions)		mm	630 × 630	
	Rotary table indexing angle		•	0.0001	
Table (B-axis)	Pallet height (from floor)		mm	1,250	
& Pallet	Loading mass on the pallet		kg	1,500	
T dilot	Table indexing time (90° ind	dexing)	sec	1.0	
	Pallet change time		sec	20	
Spindle swiveling	C-axis indexing angle		0	0.0001	
(C-axis)	C-axis swiveling center tilte	d angle	0	45	
	X-axis		mm	800 (+300_ATC stroke)	
	Y-axis		mm	850	
	Z-axis		mm	1,050	
	C-axis		0	-210~+20	
Stroke	Distance from spindle center to pall	let upper face (When the spindle is horizontal)	mm	50~900	
	Distance from spindle endface to pa	allet upper face (When the spindle is vertical)	mm	150~1,000	
	Distance from spindle endface to ta	able center (When the spindle is horizontal)	mm	-200~+850	
	Distance from spindle center to tabl	le center (When the spindle is vertical)	mm	-300~+750	
	Max. workpiece swing × Ma	ax. workpiece height	mm	φ1,170 × 1,600 *1	
		X-, Y-, Z-axes	m/min	60	
	Rapid feed rate	B-axis	°/min	14,400	
		C-axis	°/min	10,800	
Feeds		X-, Y-, Z-axes	m/min	0.001~30	
	Cutting feed rate	B-axis	°/min	1~14,400	
		C-axis	°/min	1~10,800	
	Ball screw diameter		mm	φ45 (X, Z), φ50 (Y)	
	Spindle speed		min ⁻¹	50~15,000	50~8,000
Qualitatilla	Spindle diameter (front side bearing inner diameter)		mm	φ120	φ120
Spindle	Spindle nose shape			BT No.50 Big+	HSK-A100
	Spindle motor short time / continuous		kw	55/37	80/55
	Tool holding capacity		tool	60	121
	Tool selection			Absolute address	
	Tool (dia. \times length)		mm	φ120 × 600 *2	
ATC	Tool mass		kg	27	
AIC	Tool change time (Tool to Tool)		sec	3.1 (~15kg), 3.5 (15~27kg)	
	Tool change time (Chip to Chip)		sec	5.8 (~15kg), 6.2 (15~27kg) *3	
	Tools	Holder		MAS BT50 Big+	CAT#50 Big+ / HSK-A100
	10013	Pull stud		MAS P50T-1	
Dimensions	Floor space (width × depth	h)	mm	6,670 × 4,320 *4	
&	Machine height		mm	4,135	
Weight	Machine weight (Main unit	only)	kg	22,000	
	Working oil		L	18	
	Slide lubricant		L	5	
	Spindle oil air		L	5	
	ATC lubricant		L	7.5	
Various	C-axis lubricant		L	13	
Capacities	Spindle / table coolant		L	70	
	Power supply capacity		kVA	75	88
	Power voltage		V	400	200
	Control voltage		V	DC24	
	Air source capacity		NL/min	900	
	Air source pressure		MPa	0.4~0.5	
	Positioning accuracy *5	X-, Y-, Z-axes	mm	±0.002	
Capability & Performance		B-axis	sec	±3.5	
		C-axis	Sec	±3.5	
	Repeatability *5	X-, Y-, Z-axes	mm	±0.001	
		B-axis	Sec	±2	
		C-axis	Sec	±2	

*1 Partial limitations exist for Workpiece swing × Height. For detail shape, refer to the tooling data. *2 Partial limitations exist for Tool (diameter × length). For detail shape, refer to the tooling data. *3 For the M06 Q1. command. See the operation manual for details. *4 For details, refer to the layout plan. *5 According to our inspection method

Accessories Standard accessories

Item	Equipment name		Category
Table and nallet		DD table (with encoder)	
	Pallet	Standard nallet screw hole	
	i angt		
	Addition of pallet	Single niece screw hole	
	Addition of pariet		
	Pallet changer (APC)	The nallet manual swiveling function is available	
Spindla relations	Spood	15 000min: RT50 Rigt/CAT#50 Rigt	
Spiriule relations	Speeu	15,000min:1 HSK A100	
		2 000min: DTEO Dig+/CAT#EO Dig+	
		0,000min1 B150 Big+/CA1#50 Big+	
	Collet		
	Collet	MAS I	
	Spindle swiveling equipment	Spindle swiveling equipment (with encoder)	
roor magazine	NO OF TOOIS		
		121 tools	
a	Equipment for detecting broken tools in a magazine	Touch switch type	
Coolant	Coolant supply unit	Coolant supply unit (water soluble/with take-up chip conveyor/scraper type/without spindle-thorugh coolant spec)	•
		Coolant supply unit (water soluble/with take-up chip conveyor/scraper type/spindle-thorugh coolant spec/1MPa through pump)	
		Coolant supply unit (water soluble/with take-up chip conveyor/scraper type/spindle-thorugh coolant spec/3MPa through pump)	
		Coolant supply unit (water soluble/with take-up chip conveyor/scraper type/spindle-thorugh coolant spec/7MPa through pump)	
		Coolant supply unit (water soluble/with take-up chip conveyor/2-tank type/spindle-through coolant spec/1MPa through pump)	
		Coolant supply unit (water soluble/with take-up chip conveyor/2-tank type/spindle-through coolant spec/3MPa through pump)	
		Coolant supply unit (water soluble/with take-up chip conveyor/2-tank type/spindle-through coolant spec/7MPa through pump)	
	External nozzle coolant	en e	•
	Overhead shower coolant	External nozzle coolant and simultaneous discharge	•
		Individual discharge	
	Internal chip flushing coolant		
	Chip flow coolant in pallet changer		
	Internal screw conveyor		
	Coolant cooling		
	Oil skimmer	Belt type	
	Chin box	Don type	
	Splash gun (at APC)		
	Mist collector		
		Tapar / contar through air blow (spindle ratation not possible)	
		Conter through air blow (spinule rotation norsable)	
Splach guard			
Spiasri guaru			
	Deer interleek at executing position	Fleetremennetie leek ture	
	Door Interlock at operating position		
		Electromagnetic lock type	
		Electromagnetic lock type	•
	Internal lighting		•
Electric control	Power voltage	400 V specification	
	Ocales for control achieve incide	200 V specification (with 200 \Rightarrow 400 V step-up transformer)	
0			
Support for high accuracy	Spinale / DD table chiller		•
	scale teedback	X-, Y-, Z-, B-, and C-axes	•
Foundation	Anchor type	Chemical anchor * Please drill holes and purchase/place chemical anchors at the customer's premises.	-
		UTIII anchor * Please drill holes and place drill anchors at the customer's premises. (We provide drill anchors.)	

Specifications Accessories







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Max. spec
600mm
With 40 or 60 tools magazine: ϕ 120mm(with no limitations caused by adjacent tools) With 121 tools magazine: ϕ 130mm(with no limitations caused by adjacent tools)
27kg: The moment at the spindle nose must be within 29N·m.
30×10^{5} N·m or less (tools not exceeding 6,000min ⁻¹) 10×10^{5} N·m or less (tools between 6,000min ⁻¹ and 8,000min ⁻¹) 3×10^{5} N·m or less (tools exceeding 8,000min ⁻¹)

Tools with diameters exceeding those described above are subject to limitations in the diameter of adjacent tools in the magazine, key grood position of the tool holder and so on.

CNC unit FANUC 31i. • Standard / Optional

Division	Name	FH630SX-5A
Axis control	Min. input increment (0.001mm)	
	Machine lock	•
	Absolute position detection	
	Inch/metric switch	•
Operation	Dry run	
	Single block	•
	Manual handle feed 1 unit	
	Program restart	•
	Manual handle interrupt	
Internelation	Nano interpolation	
function	Positioning (G00)	
	Exact stop mode (G61)	
	Tapping mode (G63)	
	Cutting mode (G64)	
	Exact ston (GO9)	
	Linear interpolation (CO1)	
	Are interpolation (CO2, CO2)	
	Alc Interpolation (doz, dos)	
	Period Interpolation	
	Reference point return (G28, G29)	
	Second reference point return (G30)	•
	Third and fourth reference point return (G30)	
Feed function	F1-digit feed	
	Al contour control II (pre-read 200 blocks)	•
Program entry	Local coordinate system (G52)	•
	Machine coordinate system (G53)	•
	Workpiece coordinate system (G54 to G59)	
	Additional workpiece coordinate systems (48 sets)	•
	Additional workpiece coordinate systems (300 sets)	
	Custom macro	•
	Additional custom macro common variables (#100 to #199, #500 to #999)	•
	Fixed drilling cycle (G73, G74, G76, G80 to G89, G98 and G99)	
	Additional optional block skip (9 pieces)	
	Automatic corner override	
Spindle function	Rigid tap	
Tool function	Tool corrections (99)	•
Tool correction	Tool corrections (200)	
function	Tool corrections (400)	
	Tool corrections (499)	
	Tool corrections (999)	
	Tool position offset	
	Tool diameter and cutter radius compensation	•
	Tool length compensation (G43, G44 and G49)	
Editing	Program storage capacity (128K bytes)	•
operation	Program storage capacity (256K bytes)	
	Program storage capacity (512K bytes)	
	Program storage capacity (1M byte)	
	Program storage capacity (2M bytes)	
	Program storage capacity (2M bytes)	
	Program storage capacity (SM bytes)	
	Number of registered programs (250)	
	Number of registered programs (500) & Storage capacity 256K bytes compulsery	
	Number of registered programs (1000) *Storage capacity 512K bytes compulsory	
	Number of registered programs (2000) & Storage capacity 312K bytes compulsory	
	Number of registered programs (2000) * Storage capacity TM bytes compulsory	
	Number of registered programs (4000) * Storage capacity 2N bytes compulsory	
Data anti (21 - 1	Simultaneous multi-program editing (Incl. background editing)	
Data entry/display	I ouch panel control	
Communication function	Built-in Ethernet	
Uthers		
	TUYUPUC-TUUCH 19 color LCD	

FANUC is a registered trademark of FANUC LTD.

Program support

Mastercam





Creates a program by post processor development compatible with swivel spindle 5-axis machines.

Mastercam is the registered trademark of CNC Software, inc. in the U.S.

VERICUT



Checks the program / interference in advance by means of simulation corresponding to spindle swiveling 5-axis machines.

VERICUT is the registered trademark of CGTech.

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