

# FCL-T2 series

PRECISION CNC SLANT BED LATHE



FORCE ONE MACHINERY CO.,LTD.

No.5, Ln. 272, Dalin Rd., Daya Dist. Taichung City 428, Taiwan

Tel: +886-4-2560 2500 Fax: +886-4-2560 2400

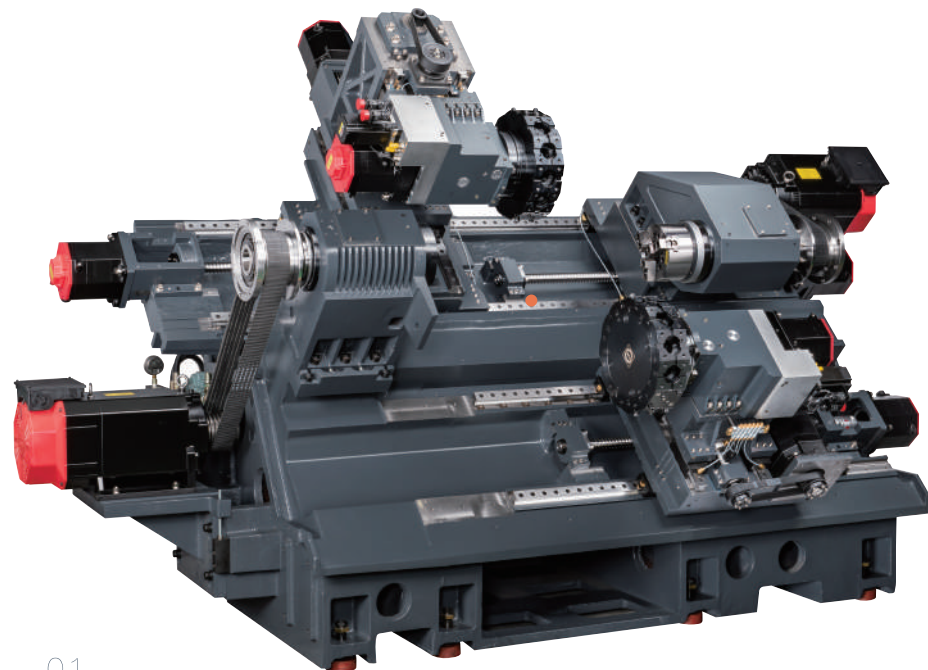
E-mail: [sales@forceonecnc.com](mailto:sales@forceonecnc.com) <http://www.forceonecnc.com>

First edition third print 07 . Aug . 2024

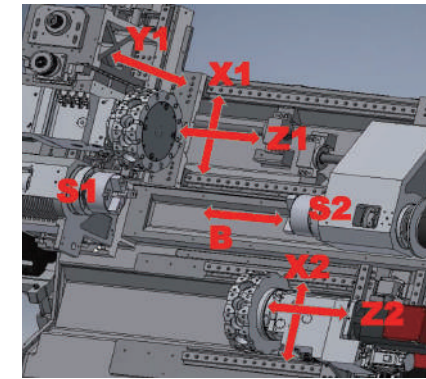
# FCL-T2 series

MULTI-AXIS TURNING CENTER DESIGNED TO DRASTICALLY BOOST MACHINING EFFICIENCY AND THROUGHPUT

- Swing over bed 235 mm
- Distance between spindle noses 950 mm
- 12 Position upper and lower turrets
- 5000 rpm spindle speed as standard, 4500 rpm optional
- With Y axis for upper turret, multi-axis milling operations can be performed (FCL-20T2Y only)
- 45 degree slant bed structure with outstanding rigidity and stability
- Heavy duty roller type linear guideways on all axes
- Fully enclosed splash guard



Twin spindles twin turrets creating double productivity. The Force One FCL-T2 series multi axis turning centers integrate two spindles and two turrets in one machine. With high spindle speed of up to 5000 rpm in combination with two BMT-55 type turrets, many complex shaped parts can be machined in just a single step.

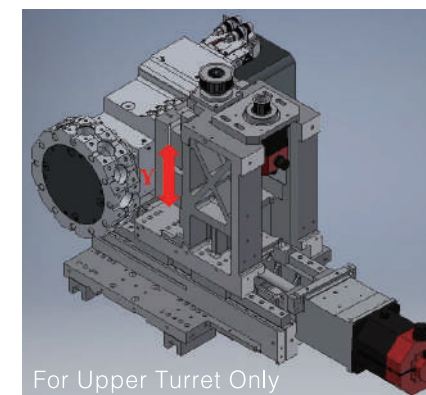


## ROLLER TYPE LINEAR GUIDEWAYS

All machine axis are mounted with roller type linear guideways, featuring heavy duty construction, high rigidity, and low friction coefficient, allowing for extremely high rapid traverse rates.

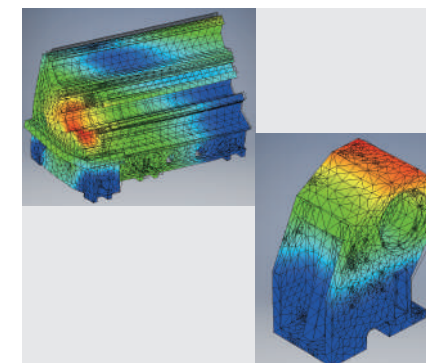
## RAPID TRAVERSE RATE ON EACH AXIS:

- X1, X2 axis: 30 m/min
- Y1 axis: 10 m/min
- Z1, Z2 axis: 40 m/min
- B axis: 40 m/min



## Y AXIS

- With the use of Y axis for the upper turret, a wide variety of multi axis milling operations can be performed.
- Y axis stroke: 100 (+50) mm
- Extremely rigid structure offers high precision machining equal to or better than a machine center.



## FINITE ELEMENT ANALYSIS

The bed design is subject to Finite Element Analysis to simulate various stress / strain conditions, which in turn ensures optimal structural rigidity, machining stability, and deformation free performance even after years of operation.



## LONG WORKPIECE MACHINING DOUBLE PRODUCTIVITY

The Force One FCL-T2 series turning centers can hold long workpieces with synchronized control of the right and left spindles and simultaneous cutting by the upper and lower turrets, which dramatically upgrades machining efficiency and results in doubled productivity.

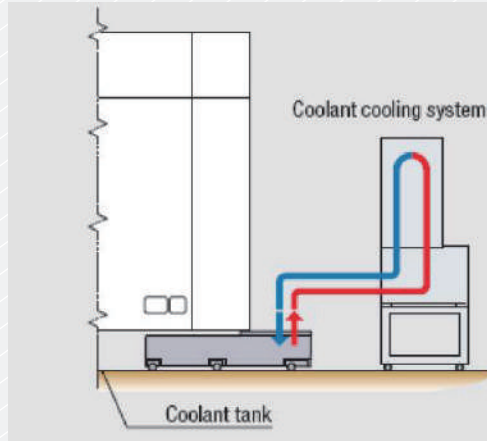


# MACHINE FEATURES



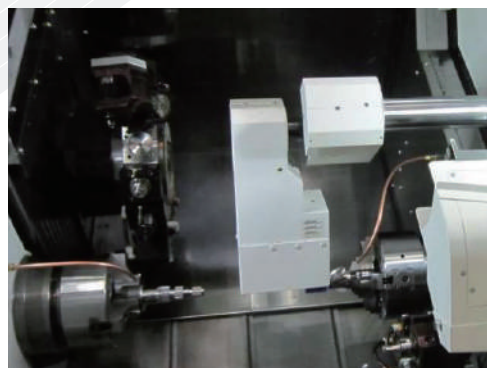
## 20 BAR HIGH PRESSURE COOLANT SYSTEM (OPT.)

The 20 bar high pressure coolant system is recommended for high production machining.



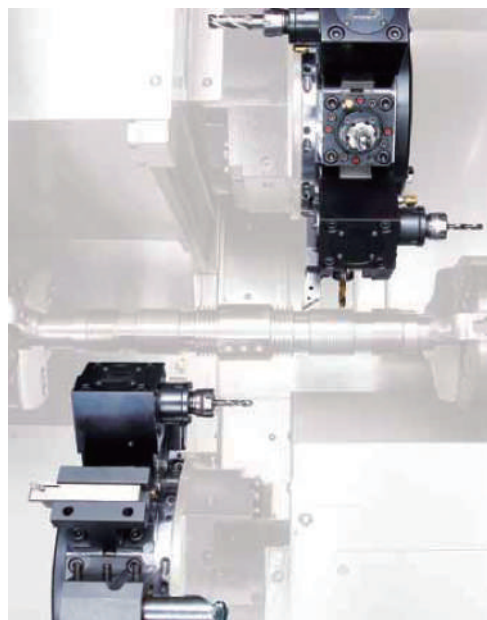
## COOLANT CHILLER (OPT.)

The coolant chiller is used to control the temperature of coolant, helping to ensure consistent machining accuracy. The chiller is essential equipment when high pressure coolant is used.



## PARTS UNLOADER AND CONVEYOR FOR SUB-SPINDLE (OPT.)

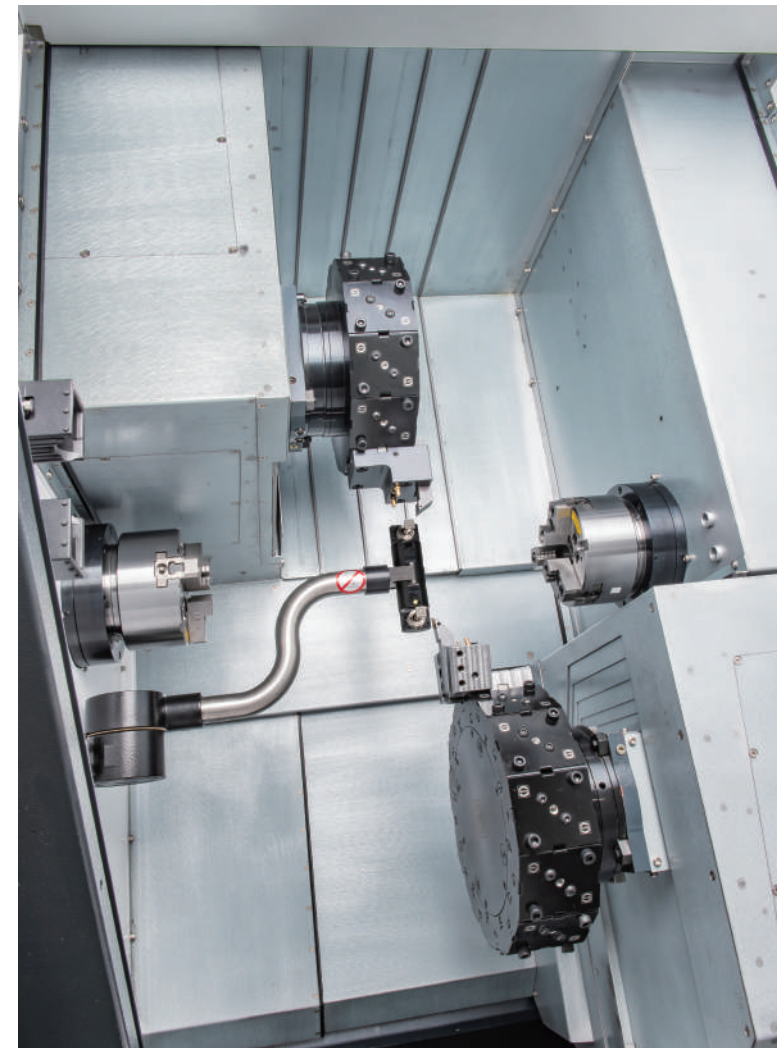
Once the workpiece is machined by the right spindle, it will be delivered to the parts unloader by the part ejector. Then the workpiece is discharged to the parts conveyor.



## TURRET

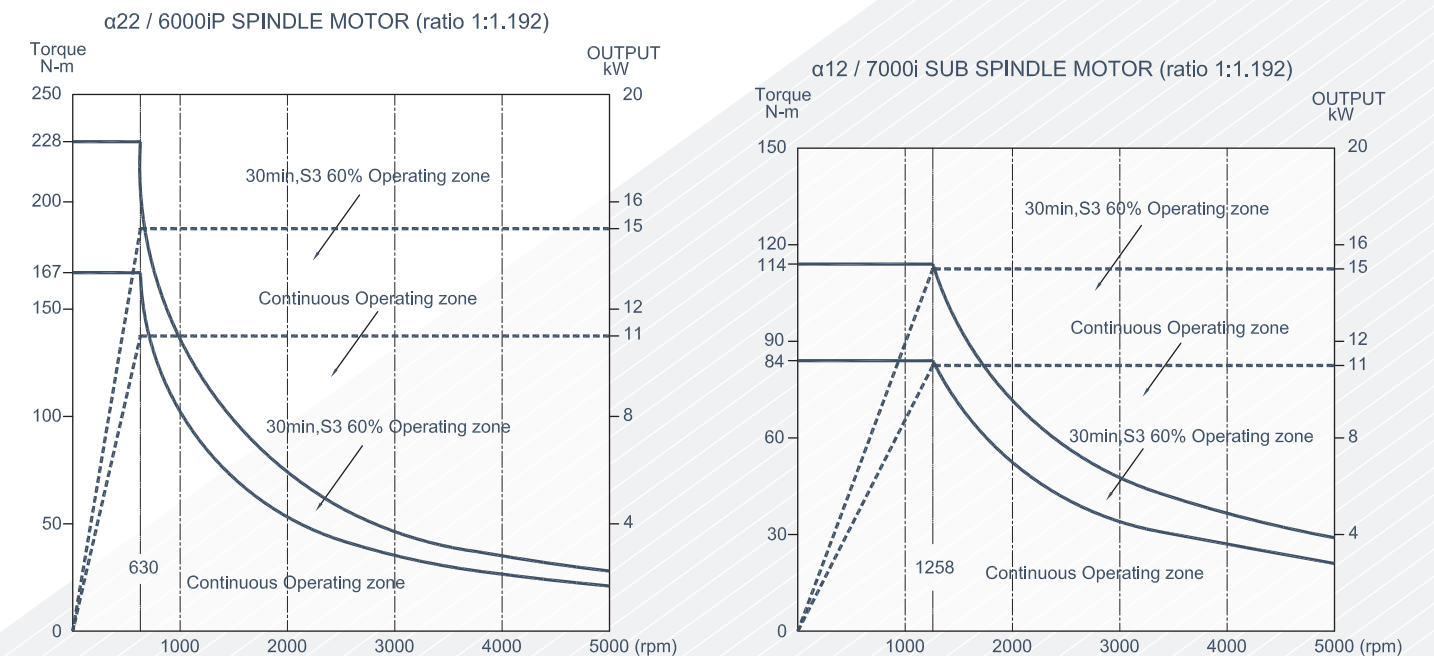
The upper and lower turrets double machine productivity by allowing Independent, simultaneous operation.

- Turret indexing time (1 Face)  
0.15s
- No. of tool station  
(The same for the upper and lower turrets)  
12 station
- No. of index positions  
(The same for the upper and lower turrets)  
24 index position



## AUTO TYPE TOOL PRESETTER (OPT.)

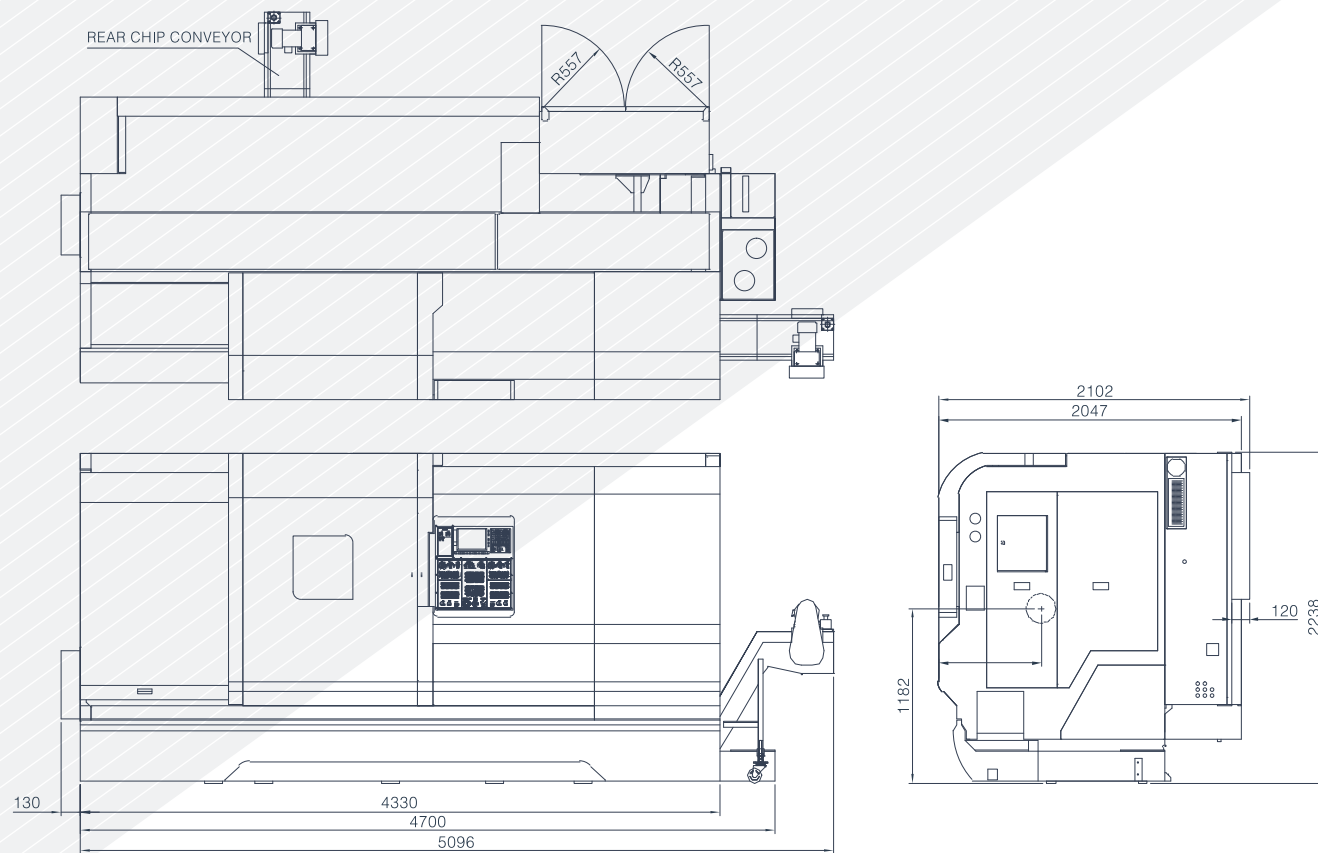
# SPINDLE POWER - TORQUE DIAGRAM



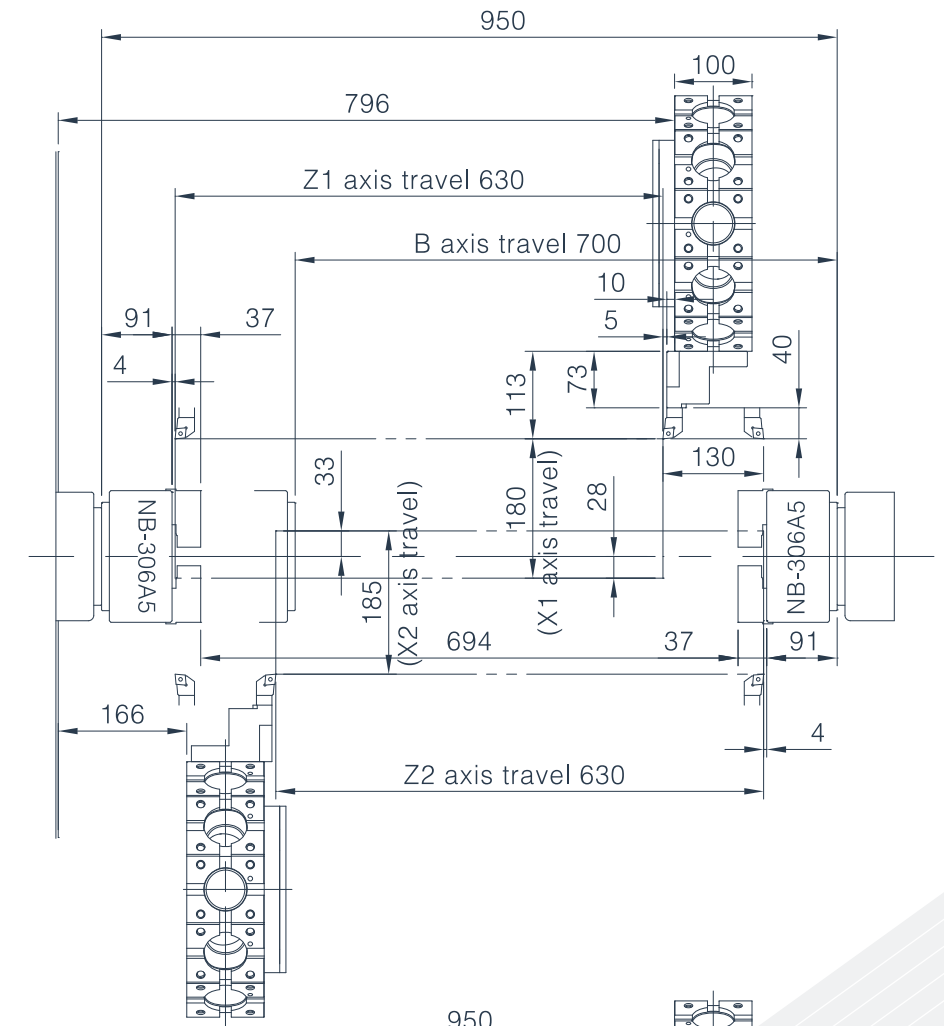
- All specification, design and characteristics shown on this catalogue are subject to change without prior notice.

# DIMENSIONAL DRAWINGS

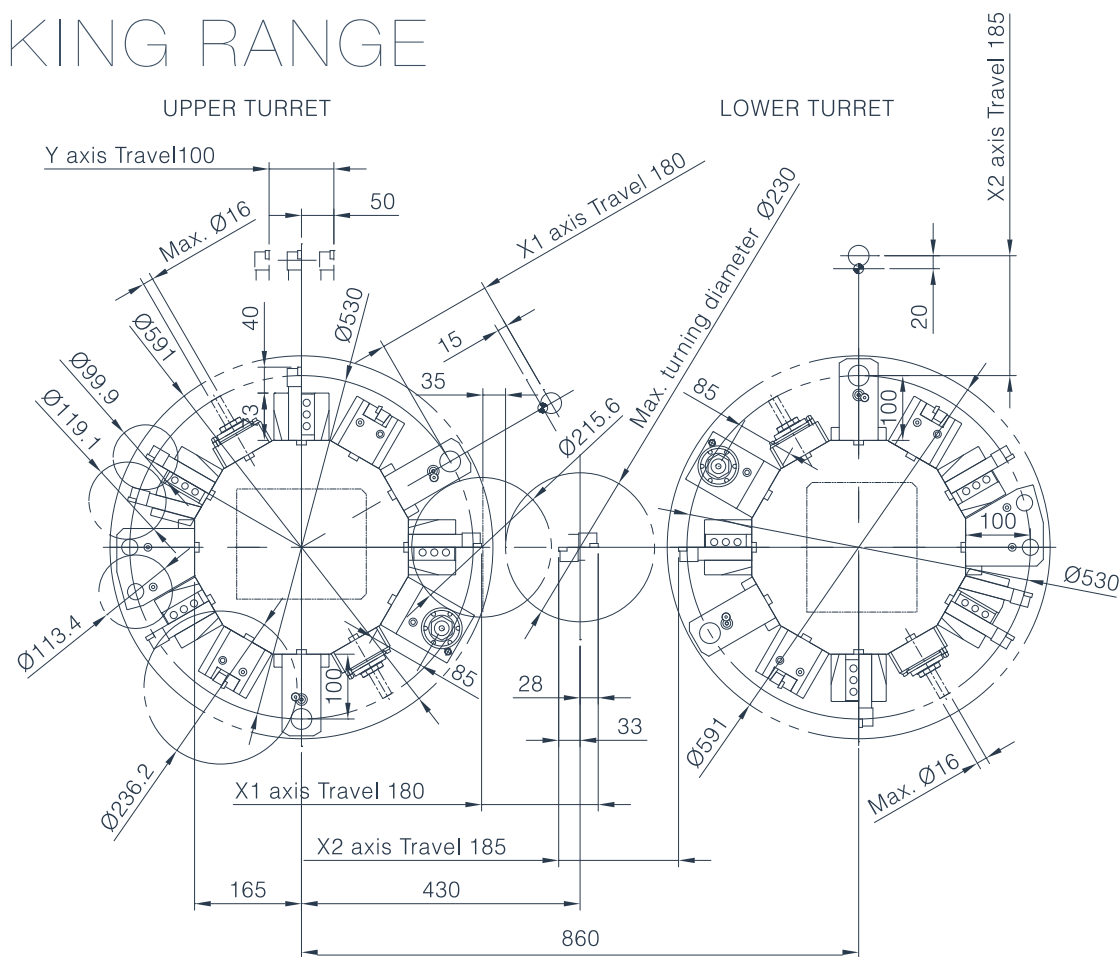
# WORKING RANGE



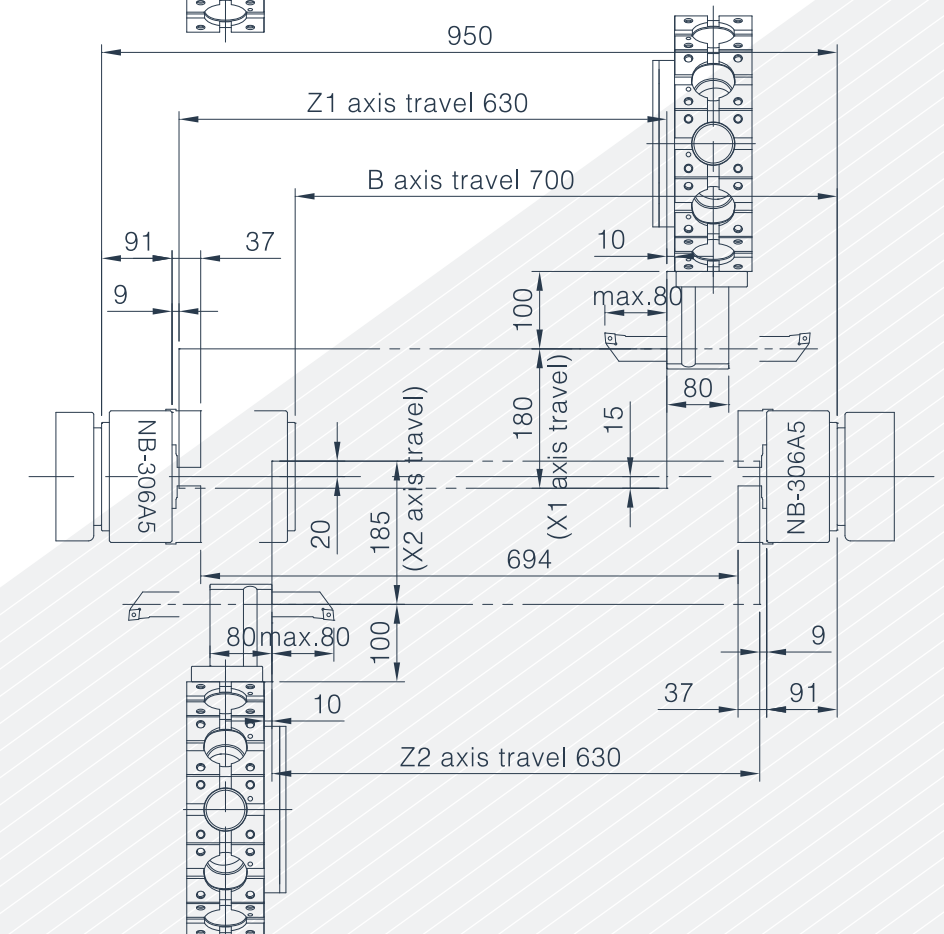
Single OD Tool Holder



# WORKING RANGE

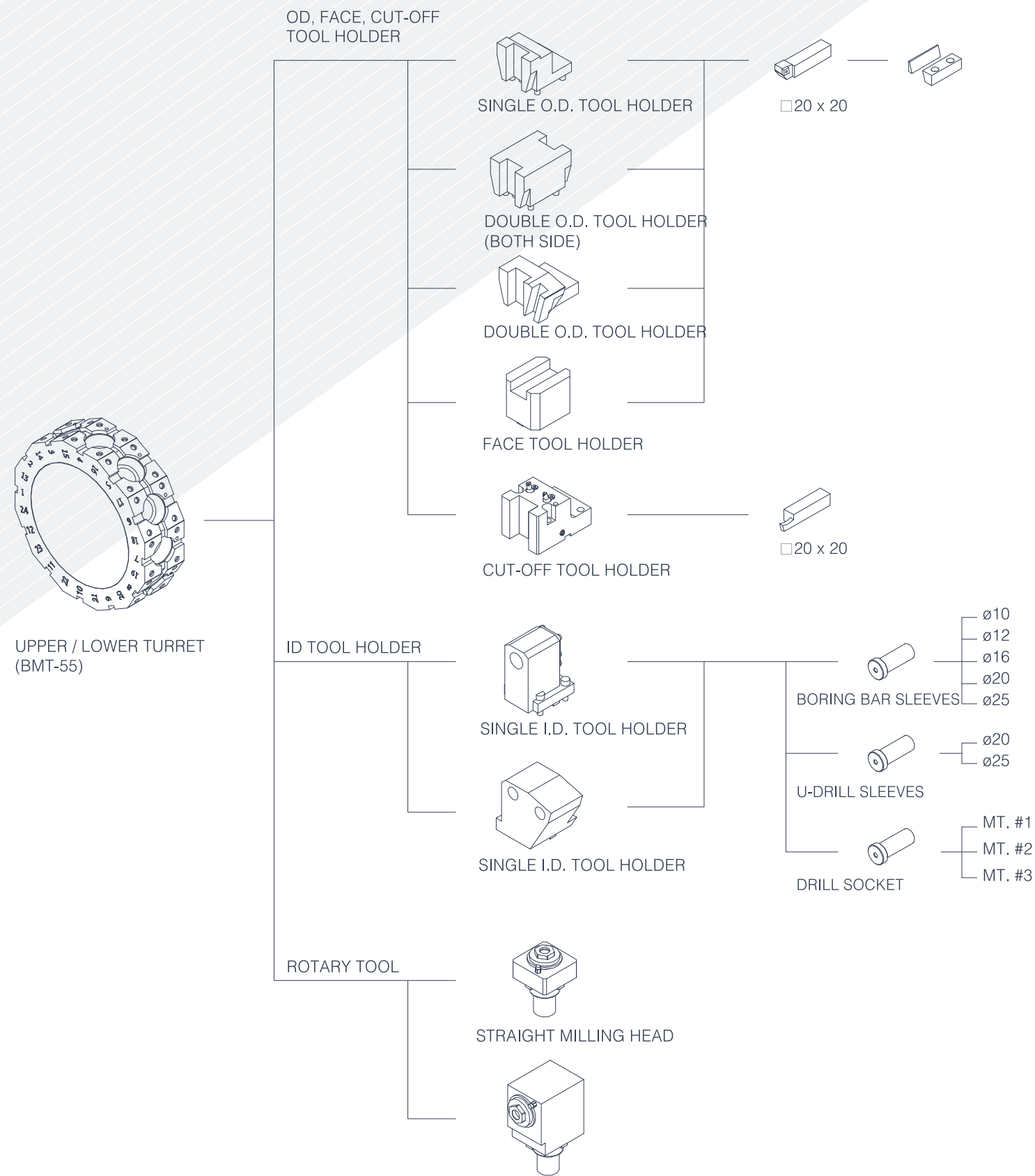


ID Tool Holder





# TOOLING SYSTEM



- All specification, design and characteristics shown on this catalogue are subject to change without prior notice.



# SPECIFICATIONS

MODEL	ITEM	UNIT	FCL-20T2	FCL-20T2Y
Capacity	Swing over bed	mm	235	
	Swing over cross slide	mm	235	
	Max. distance between spindle noses	mm	950	
	Max. turning diameter	mm	230	
	Max. turning length	mm	690	
Travel	Bar work capacity	mm	52 / 65 (OPT.)	
	X axis travel	mm	X1: 180, X2: 185	
	Y axis travel	mm	-	Y: 100 (±50)
	Z axis travel	mm	Z1, Z2: 630	
Spindle 1/2	E axis travel (Spindle 2)	mm	700	
	Max. spindle speed	mm-1	5000 / 4000 (OPT.)	
	Spindle nose		JIS A2-5 / A2-6 (OPT.)	
	Chuck size	inch	6 / 8 (OPT.)	
	Through spindle hole diameter	min	61 / 77 (OPT.)	
	Spindle bearing inner diameter	mm	100 / 120 (OPT.)	
Turret	Min. spindle indexing increment		0.001°	
	Turret type		BMT-55	
	Number of tool stations	Tool	24 x 2 = 48	
	Shank height for square tool	mm	20	
	Height of boring bar shank part	mm	32	
	Turret indexing time (1 station)	sec.	0.2	
Feedrate	Max. rotary tool spindle speed	min-1	4000	
	Rapid traverse rate	m/min	X1, X2: 3.0 Z1, Z2: 40, E: 40	X1, X2: 3.0 Y: 10 Z1, Z2: 40, E: 40
Motors	Spindle 1 drive motor (30 min/cont)	kW	15.0 / 11.0	
	Spindle 2 drive motor (30 min/cont)	kW	15.0 / 11.0	
	Rotary tool spindle drive motor (30 min/cont)	kW	3	
Machine size	Feed motor	kW	X1, X2: 3.0 Z1, Z2, E: 3.0	X1, X2: 3.0 Y: 1.6 Z1, Z2, E: 3.0
	Machine height (From Floor)	mm	2238	
	Floor space (Width x Depth)	mm	3260 x 2047	
	Mass of machine	kg	8000	8500

- All specification, design and characteristics shown on this catalogue are subject to change without prior notice.

## STANDARD ACCESSORIES

- High pressure coolant pump
- Automatic lubrication system
- Tool and tool box
- Work light
- Three color alarm light
- Right side chip conveyor and bucket
- Hydraulic unit (3 HP / 2.2 KW)
- Heat exchanger for electric cabinet

## OPTIONAL ACCESSORIES

- High pressure coolant pump
- Oil skimmer
- Coolant chiller
- Chuck coolant (L/R)
- Coolant gun
- Rear side chip conveyor and bucket
- Air blower (L/R)
- Mist collector
- Tool setter (Manual/Auto)
- Parts unloader and conveyor for subspindle
- Part ejector
- Auto door
- Robot interface
- Bar feeder interface
- Linear scale (X1, X2, Z1, Z2)
- Air gun
- Air conditioner for electric cabinet
- Auto power off
- Parts catcher for main spindle