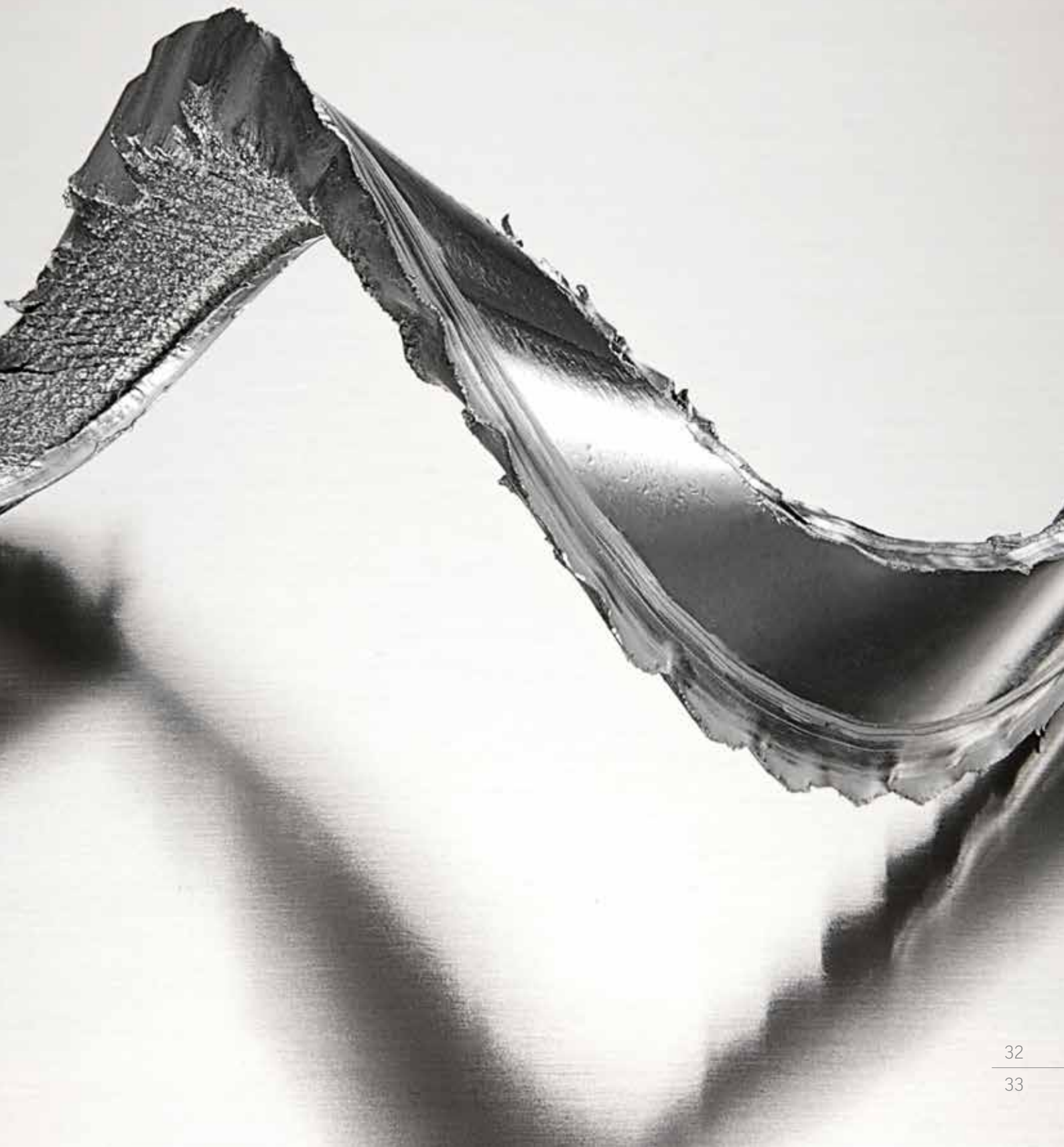


03

Technical data . C 32





03.1

Technical data . C 32

Working area	Traverse	X axis	650 mm
	Traverse	Y axis	650 mm
	Traverse	Z axis	500 mm
	Rapid linear traverse (dynamic)	X-Y-Z	45 - 45 - 40 m/min (60 - 60 - 60 m/min)
	Linear acceleration (dynamic)	X-Y-Z	6 (10) m/s ²
	Linear feed force	X-Y-Z	8500 N
	Max. vertical table clearance		600/635 mm
	Max. workpiece diameter		Ø 650 mm
	Max. workpiece height		420 mm
	Collision circle (A axis) in 0° position		Ø 840 mm
Main spindle drive	Speed	15000 rpm	SK 40 ○
	Main power/Torque	20% c.d.f.	42 kW / 148 Nm
	Speed	15000 rpm	HSK A 63 ○
	Main power/Torque	20% c.d.f.	31 kW / 194 Nm
	Speed	16000 rpm	HSK A 63 ●
	Main power/Torque	20% c.d.f.	42 kW / 148 Nm
	Speed	20000 rpm	HSK A 63 ○
	Main power/Torque	20% c.d.f.	42 kW / 148 Nm
	Speed	25000 rpm	HSK A 63 ○
	Main power/Torque	20% c.d.f.	31 kW / 98 Nm
	Speed	42000 rpm	HSK E 40 ○
	Main power/Torque	20% c.d.f.	35 kW / 17,5 Nm
Control unit	Heidenhain		TNC 640 / TNC7 ●
	Siemens		Sinumerik 840 D sl ○
Tool changer (pick-up)	Interface	SK 40 / HSK A 63 ●	HSK E 40 ○
	Magazine pockets	36 items	36 items
	Chip-to-chip time	approx. 4.5 s	approx. 4.5 s
	Max. tool length	300 mm	300 mm
	Max. tool diameter for free adjacent pockets	Ø 80 mm Ø 125 mm	Ø 80 mm Ø 125 mm
	Max. tool weight	8 kg	2.5 kg
	Max. magazine load	144 kg	90 kg

● Included in standard delivery

○ Available upon request

Extension of tool storage capacity	Additional magazine ZM 50 (SK 40 / HSK A 63 / HSK E 40)		Additional 50 pockets	○
	Additional magazine ZM 88 k (SK 40 / HSK A 63 / HSK E 40)		Additional 88 pockets	○
	Additional magazine single ZM 216 (HSK A 63)		Additional up to 216 pockets	○
	Additional magazine double ZM 528 (HSK A 63)		Additional up to 528 pockets	○
	Interface		SK 40 / HSK A 63	HSK E 40
	Maximum tool diameter with corresponding adjacent pocket allocation		Ø 80 mm Ø 125 mm	Ø 80 mm Ø 125 mm
	Max. tool weight		8 kg	2.5 kg
	Table variants*	Swivelling rotary table		Ø 320
Clamping surface		Ø 320 mm	Ø 320 mm	
Swivelling range		+/- 130°	+/- 130°	
C axis drive mode		Worm	Torque	
Swivelling axis A speed				
One-sided drive		25 rpm	25 rpm	
Tandem drive		-	55 rpm	
Rotary axis C speed		40 rpm	80 rpm	
Max. table load				
One-sided drive		300 kg	200 kg	
Tandem drive		-	200 kg	
Star-shaped T grooves		4 / 14 H7	4 / 14 H7	
Clamping surface		Ø 450 x 360 mm	-	
Secondary clamping plates		760 x 370 mm	760 x 370 mm	
T grooves parallel		5 / 14 H7	5 / 14 H7	
Swivelling rotary table		Ø 650	Ø 650	
			Rigid ● clamping table	
Clamping surface		Ø 650 x 540 mm	Ø 650 x 540 mm	
Swivelling range		+/- 130°	+/- 130°	
C axis drive mode		Worm	Torque	
Swivelling axis A speed with one-sided drive		25 rpm	25 rpm	
Tandem drive		-	25 rpm	
Rotary axis C speed		30 rpm	65 rpm	
Max. table load			1500 kg	
One-sided drive		600 kg	-	
Tandem drive		-	1000 kg	
T grooves parallel		7 / 14 H7	7 / 14 H7	
			10 / 14 H7	

*All machining tables available on demand

Positioning uncertainty	A in X-Y-Z axes according to VDI/DGQ 3441 (calculated at a constant ambient temperature of 20 °C +/-1 °C. Our products are subject to the German Export Law and require authorization since the attainable precision may be less/greater than 6 µm.)	≤ 0.006 mm ●
Chip drawer	Removable chip drawer	●
Chip conveyor	Scraper belt conveyor	○
	Hinged belt conveyor	Advanced / Advanced 250 ○
	Ejection height	mind. 940 mm
	Chip cart	450 l ○
External cooling lubricant supply	With chip drawer and cooling lubricant tank Cooling lubricant tank capacity	360 l ●
Internal cooling lubricant supply with paper band filter	Capacity of standard tank	80 l ○
	Capacity of cooling lubricant tank	1100 l at 80 bar / 570 l at 40 bar
	Pressure (adjustable up to)	max. 40 bar / 27 l/min max. 80 bar / 22 l/min
	Mains connection (ICS)	400 V / 50/60 Hz
	Power consumption (ICS)	without temperature controller up to 16.5 kVA with temperature controller up to 22.5 kVA
Hydraulics	Operating pressure	120 bar ●
Central lubrication	Minimum grease lubrication quantity	●
Connected loads (machine)	Mains connection	400 V / 50 Hz
	Power consumption	up to 53 kVA
	Compressed air	6 bar
Weight	(Standard version without optional extras, attachments, workpieces and cooling lubricant)	about 11.0 t

- Included in standard delivery
- Available upon request

