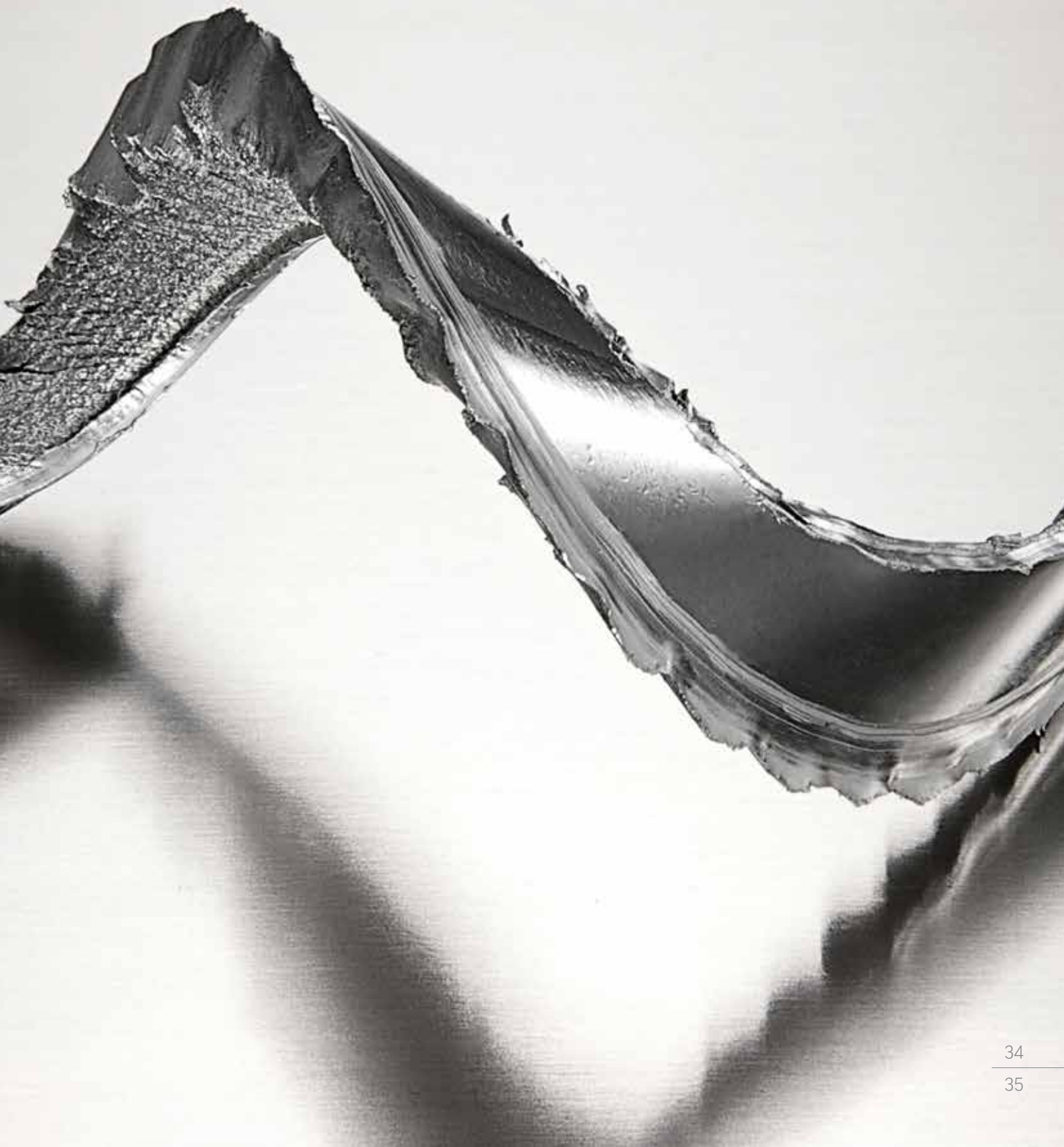


03

Technical data . C 42





03.1

Technical data . C 42

Working area	Traverse	X axis	800 mm
	Traverse	Y axis	800 mm
	Traverse	Z axis	550 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		700 mm
	Max. workpiece diameter		Ø 800 mm
	Max. workpiece height		560 mm
	Collision circle (A axis) in 0° position		Ø 990 mm
Main spindle drive	Speed	15000 rpm	HSK A 63 ○
	Main power/Torque	20% c.d.f.	31 kW / 194 Nm
	Speed (MT variants)	15000 rpm	HSK T 63 ○
	Main power/Torque	20% c.d.f.	31 kW / 194 Nm
	Speed	15000 rpm	SK 40 ○
	Main power/Torque	20% c.d.f.	42 kW / 148 Nm
	Speed	18000 rpm	HSK A 63 / HSK T 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	
Speed (MT variants)	18000 rpm	HSK A 63 / HSK T 63 ●	
Main power/Torque	20% c.d.f.	42 kW / 148 Nm	
Control unit	Heidenhain		TNC 640 ●
	Siemens		Sinumerik 840 D sl ○
Tool changer (pick-up)	Interface	SK 40 / HSK A/T 63 ●	HSK E 40 ○
	Magazine pockets	42 items	42 items
	Chip-to-chip time	approx. 4.5 s	approx. 4.5 s
	Max. tool length	300 mm	300 mm
	Max. tool diameter	Ø 80 mm	Ø 80 mm
	with corresponding adjacent pocket allocation	Ø 125 mm	Ø 125 mm
	Max. magazine load	168 kg	105 kg
	Extension of tool storage capacity	Additional tool magazine ZM 50	
Additional tool magazine ZM 88 k			Additional 88 pockets ○
Additional tool magazine single ZM 192			Additional 192 pockets ○
Additional tool magazine double ZM 462			Additional 462 pockets ○
Interface		SK 40 / HSK A 63 / HSK T 63	HSK E 40
Max. tool diameter in the additional tool magazine		Ø 80 mm	Ø 80 mm
with corresponding adjacent pocket allocation		Ø 125 mm	Ø 125 mm
Max. tool weight			8 kg 2.5 kg

Table variants *

Swivelling rotary table	Ø 800	Ø 800	Ø 440
Clamping surface	Ø 800 x 630 mm	Ø 800 x 630 mm	Ø 440 mm
Swivelling range	+/- 130°	+/- 130°	+/- 130°
C-axis drive mode	Worm	Torque	Torque
Swivelling axis A speed			
One-sided drive	15 rpm	-	-
Tandem drive	-	25 rpm	55 rpm
Rotary axis C speed	25 rpm	65 rpm	65 rpm
Max. table load			
One-sided drive	850 kg	-	-
Tandem drive	-	1400 kg	450 kg
Parallel T grooves	9 / 14 H7	9 / 14 H7	5 / 14 H7
Secondary clamping plates	-	-	920 x 490 mm
Parallel T grooves	-	-	7 / 14 H7
Swivelling rotary table	Ø 440	MT variants	Rigid Clamping table
Clamping surface	Ø 440 mm	Ø 750 mm	1050 x 805 mm
Swivelling range	+/- 130°	+/- 130°	-
C-axis drive mode	Worm	Torque	-
Swivelling axis A speed			
with one-sided drive	25 rpm	-	-
Tandem drive	-	25 rpm	-
Rotary axis C speed	30 rpm	800 rpm	-
Max. table load			2000 kg
One-sided drive	450 kg	-	-
Tandem drive milling	-	1400 kg	-
Tandem drive turning	-	700 kg	-
Parallel T grooves	5 / 14 H7	-	12 / 14 H7
Star-shaped T grooves		16 / 14 H7	
Secondary clamping plates	930 x 490 mm	-	-
Parallel T grooves	7 / 14 H7	-	-

*All machining tables available on demand

- Included in standard delivery
- Available upon request

Positional uncertainty	P 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.)	0.008 mm	●
Chip drawer	Removable chip drawer		●
Chip conveyor	Scraper belt or hinge conveyor ejection height ejection height chip cart	at least 940 mm 450 l	○ ○
External cooling lubricant supply	With chip drawer and cooling lubricant tank Cooling lubricant tank capacity	390 l	●
Internal cooling lubricant supply with paper band filter	Capacity of standard tank	100 l	100 l ○
	Capacity of cooling lubricant tank	570 l	1100 l
	Pressure (manually adjustable up to)	max. 40 bar / 27 l/min	max. 80 bar / 30 l/min
	Mains connection (ICS)	-	400 V / 50 Hz
	Power consumption (ICS)	-	16.5 kVA
	Power consumption (ICS with recooling unit)	-	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 C 42	53 kVA	
	Power consumption C 42 MT	57 kVA	
	Compressed air	6 bar	
Weight	(standard version without optional extras, attachments, workpieces and cooling lubricant)	Approx. 13.5 t	

- Included in standard delivery
- Available upon request