

03

Technical data . C 250



# 03.1

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<b>Working area</b>	Traverse	X axis	600 mm
	Traverse	Y axis	550 mm
	Traverse	Z axis	450 mm
	Rapid linear traverses	X-Y-Z	35 - 35 - 35 m/min
	Linear acceleration	X-Y-Z	6 m/s <sup>2</sup>
	Linear feed force	X-Y-Z	5000 N
	Max. vertical table clearance		550 mm
	Max. workpiece diameter		Ø 450 mm
	Max. workpiece height		355 mm
	Collision circle (A axis) in 0° position		Ø 770 mm
<b>Main spindle drive</b>	Speed	15000 rpm	SK 40 / HSK A 63
	Main power/torque	20% c.d.f.	20 kW / 180 Nm ●
	Speed	18000 rpm	HSK A 63
	Main power/torque	20% c.d.f.	20 kW / 180 Nm ○
<b>Control unit</b>	Heidenhain		TNC 640 ●
<b>Tool changer (pick-up)</b>	Magazine pockets		30 items ●
	Chip-to-chip time*		approx. 6 s
	*(chip-to-chip times for 3-axis unit calculated in keeping with German standard VDI 2852, page 1)		
	Maximum tool length		300 mm
	Max. tool diameter with corresponding adjacent pocket allocation		Ø 80 mm Ø 125 mm
	Max. magazine load		120 kg
	<b>Extension of tool storage capacity</b>	Additional tool magazine ZM 50	
Additional tool magazine ZM 88 k			additional 88 pockets ○
Max. tool diameter in the additional tool magazine with corresponding adjacent pocket allocation in additional tool magazine			Ø 80 mm Ø 125 mm
Max. tool weight			8 kg
<b>Chip drawer</b>		Removable chip drawer	
<b>Chip conveyor</b>	Scraper belt		○
	Ejection height		1100 mm
	Chip cart		450 l ○
<b>Internal cooling lubricant supply with paper band filter</b>	Capacity of standard tank		305 l ●
	Capacity of cooling lubricant tank		570 l
	Pressure (manually adjustable up to)		max. 40 bar / 26 l/min ○

<b>Table variants</b>	Swivelling rotary table	Ø 320	Ø 450 x 360	Rigid clamping table
	Clamping surface	Ø 320 mm	Ø 450 x 360 mm	800 x 616 mm
	Swivelling range	+/- 115°	+/- 115°	-
	C axis drive mode	Worm	Worm	-
	Swivelling axis A speed:			
	One-sided drive	25 rpm	25 rpm	-
	Speed rotary axis C:	40 rpm	40 rpm	-
	Max. table load	-	-	1100 kg
	One-sided drive	300 kg	300 kg	-
	T grooves parallel	4 / 14 H7 star-shaped	5 / 14 H7 parallel	9 / 14 H7 parallel
	Secondary clamping plates	710 x 370 mm	-	-
	T grooves parallel	5 / 14 H7	-	-
	System table (can be extended with table plate)	Ø 320 mm	Ø 450 x 360 mm	-
<b>Positional uncertainty</b>	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 ●
<b>Hydraulics</b>	Operating pressure			120 bar ●
<b>Central lubrication</b>	Minimum grease lubrication quantity			●
<b>Connected loads (machine)</b>	Mains connection			400 V / 50 Hz
	Power consumption			28 kVA
	Compressed air			6 bar
<b>Weight</b>	(standard version without optional extras, attachments, work-pieces and cooling lubricant)			approx. 7.6 t

- Included in standard delivery
- Available upon request