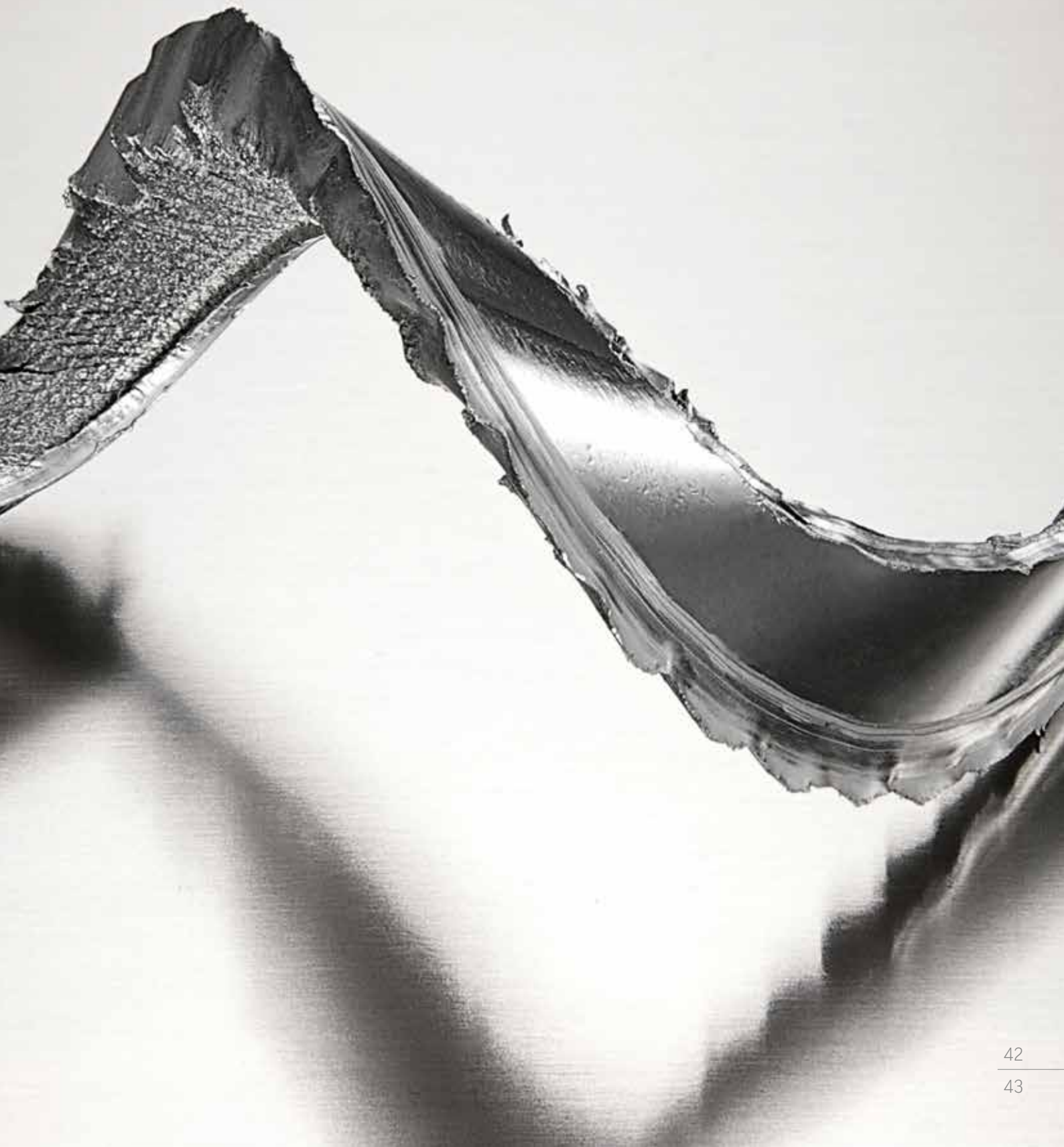


03

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
Main spindle drive	Speed	10000 rpm	SK 40 / HSK A 63 ●
	Main power/Torque	20% c.d.f.	29 kW / 200 Nm
	Speed	15000 rpm	SK 40 ○
	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
Control unit	Speed	25000 rpm	HSK A 63 ○
	Main power/Torque	20% c.d.f.	31 kW / 100 Nm
	Speed	42000 rpm	HSK E 40 ○
	Main power/Torque	20% c.d.f.	35 kW / 17,5 Nm
	Heidenhain		iTNC 530 / TNC 640 ●
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
	*(Chip-to-chip times for 3-axis unit calculated in keeping with German standard VDI 2852, page 1)		
	Max. tool length	300 mm	300 mm
	Max. tool diameter with empty adjacent pockets	Ø 80 mm Ø 125 mm	Ø 80 mm Ø 125 mm
	Max. magazine load	144 kg	90 kg

Extension of tool storage capacity	Additional magazine ZM 43	Additional 43 pockets ○	
	Additional magazine ZM 87	Additional 87 pockets ○	
	Additional magazine single ZM 192	Additional 192 pockets ○	
	Additional magazine double ZM 462	Additional 462 pockets ○	
	Interface	SK 40 / HSK A 63	HSK E 40
	Max. tool diameter in the additional magazine	Ø 80 mm	Ø 80 mm
	Maximum tool diameter with corresponding adjacent pocket allocation in additional magazine	Ø 125 mm	Ø 125 mm
	Max. tool weight	8 kg	2.5 kg

Table variants*	NC swivelling rotary table	Ø 650	Ø 650		
	Clamping surface	Ø 650 x 540 mm	Ø 650 x 540 mm		
	Collision circle of table plate	Ø 650 mm	Ø 650 mm		
	Swivelling range	+/- 130°	+/- 130°		
	C axis drive mode	Worm	Torque		
	Swivelling axis A speed				
	One-sided drive	25 rpm	25 rpm		
	Tandem drive	-	25 rpm		
	Rotary axis C speed	30 rpm	65 rpm		
	Max. table load				
	One-sided drive	600 kg	600 kg		
	Tandem drive	-	1000 kg		
	T grooves parallel	7 / 14 H7	7 / 14 H7		
	NC swivelling rotary table	Ø 320	Ø 320	Rigid clamping table	
	Clamping surface	Ø 320 mm	Ø 320 mm	900 x 665 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	-	55 rpm	-	
Rotary axis C speed	40 rpm	80 rpm	-		
Max. table load			1500 kg		
One-sided drive	300 kg	200 kg	-		
Tandem drive	-	200 kg	-		
T grooves parallel	4 / 14 H7	4 / 14 H7	10 / 14 H7		
T grooves star-shaped	-				
Clamping surface	Ø 450 x 360 mm	-	-		
Secondary clamping plates	760 x 370 mm	760 x 370 mm	-		
T grooves parallel	8 / 14 H7	8 / 14 H7	-		

*All tables available on demand

- Included in standard delivery
- Available upon request

Position measuring system, direct	Resolution	0.0001 mm	●
Positional tolerance	<p>Tp in X-Y-Z axes according to VDI/DGQ 3441</p> <p>(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.)</p>	0.008 mm	●
Chip drawer	Removable chip drawer		●
Chip conveyor	<p>Scraper belt or hinge conveyor ejection height</p> <p>ejection height</p> <p>chip cart</p>	<p>1100 mm</p> <p>450 l</p>	<p>○</p> <p>○</p>
External cooling lubricant supply	<p>With chip drawer and cooling lubricant tank</p> <p>Cooling lubricant tank capacity</p> <p>Cooling lubricant system without high-pressure pump with sieve basket</p> <p>Capacity of standard tank</p> <p>Capacity of cooling lubricant tank</p> <p>Cooling lubricant system without high-pressure pump with paper band filter</p> <p>Capacity of standard tank</p> <p>Capacity of cooling lubricant tank</p>	<p>375 l</p> <p>100 l</p> <p>500 l</p> <p>100 l</p> <p>570 l</p>	<p>●</p> <p>○</p> <p>○</p> <p>○</p>
Internal cooling lubricant supply with paper band filter	<p>Capacity of standard tank</p> <p>Capacity of cooling lubricant tank</p> <p>Pressure (manually adjustable up to)</p> <p>Mains connection (ICS)</p> <p>Power consumption (ICS)</p>	<p>100 l</p> <p>570 l</p> <p>max. 40 bar / 26 l/min</p> <p>-</p> <p>-</p>	<p>100 l</p> <p>1000 l</p> <p>max. 80 bar / 29 l/min</p> <p>400 V / 50 Hz</p> <p>17 kVA</p>
Hydraulics	Operating pressure	120 bar	●
Central lubrication	Minimum grease lubrication quantity		●
Connected loads (machine)	<p>Mains connection</p> <p>Power consumption</p> <p>Compressed air</p>	<p>400 V / 50 Hz</p> <p>45 kVA</p> <p>6 bar</p>	
Weight	(Standard version without optional extras, attachments, workpieces and cooling lubricant)	about 11.0 t	

- Included in standard delivery
- Available upon request

