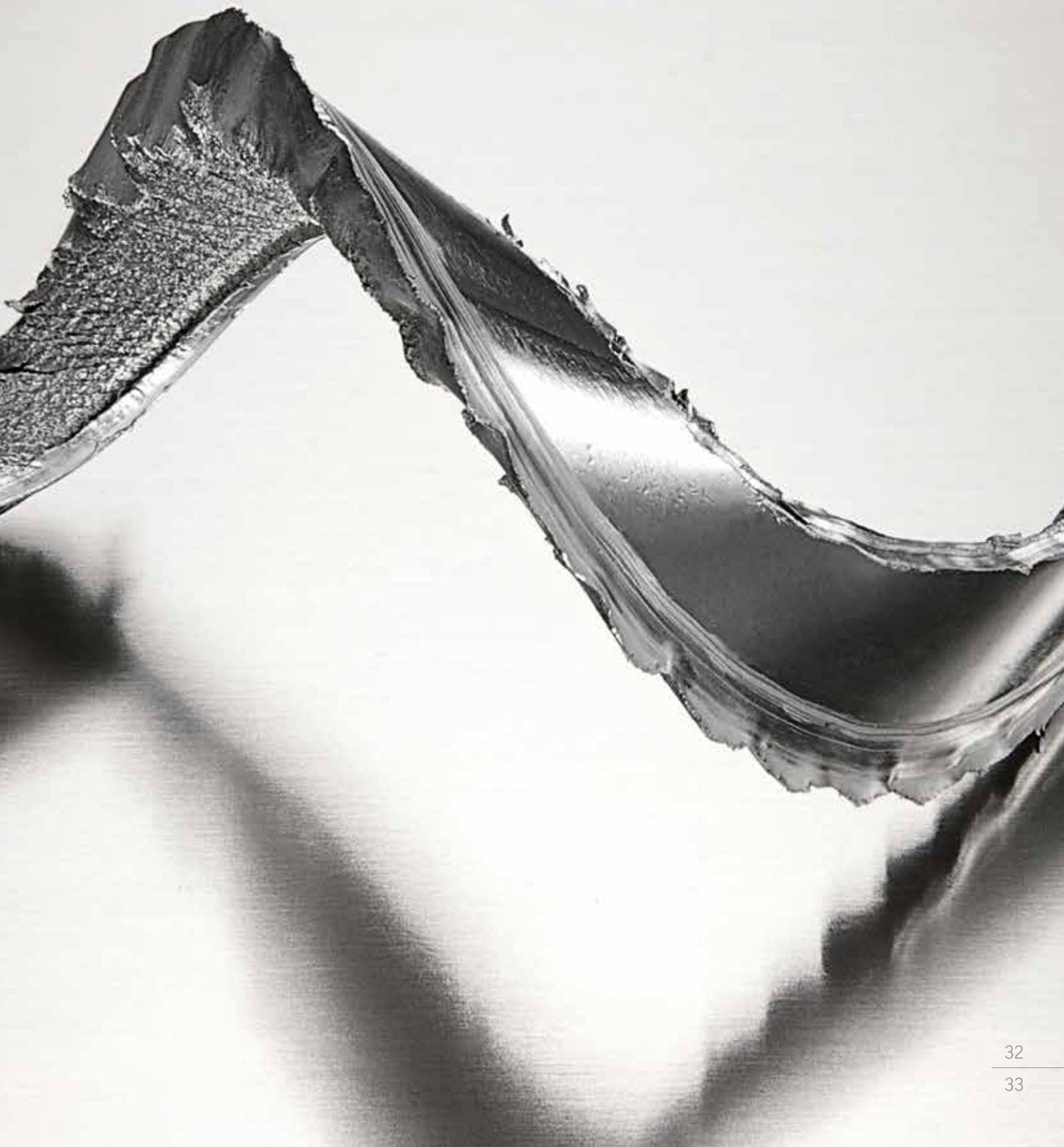


03

Technical data . C 32





# 03.1

## Technical data . C 32

<b>Working area</b>	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 <sup>2</sup>
	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
<b>Main spindle drive</b>	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	18000 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
<b>Control unit</b>	Heidenhain		TNC 640 ●
	Siemens		Sinumerik 840 D sl ○
<b>Tool changer (pick-up)</b>	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. magazine load	144 kg	90 kg
	<b>Extension of tool storage capacity</b>	Additional magazine ZM 50	
Additional magazine ZM 88 k			Additional 88 pockets ○
Additional magazine single ZM 192			Additional up to 192 pockets ○
Additional magazine double ZM 462			Additional up to 462 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 650		Ø 650
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			
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
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	-	-	10 / 14 H7
T grooves star-shaped	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	-

\*All machining tables available on demand

- Included in standard delivery
- Available upon request

<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>Chip drawer</b>	Removable chip drawer		●
<b>Chip conveyor</b>	Scraper belt conveyor		○
	Slat conveyor		○
	Ejection height	mind. 940 mm	
	Chip cart	450 l	○
<b>External cooling lubricant supply</b>	With chip drawer and cooling lubricant tank Cooling lubricant tank capacity	375 l	●
<b>Internal cooling lubricant supply with paper band filter</b>	Capacity of standard tank	100 l	○
	Capacity of cooling lubricant tank	1100 l bei 80 bar / 570 l bei 40 bar	
	Pressure (manually adjustable up to) (over Variovalve)	max. 40 bar / 27 l/min max. 80 bar / 22 l/min	
	Mains connection (ICS)	- 400 V / 50 Hz	
	Power consumption (ICS)	without temperature controller with temperature controller	- 16,5 kVA 22,5 kVA
<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	up to 53 kVA	
	Compressed air	6 bar	
<b>Weight</b>	(Standard version without optional extras, attachments, workpieces and cooling lubricant)	about 11.0 t	

- Included in standard delivery
- Available upon request



