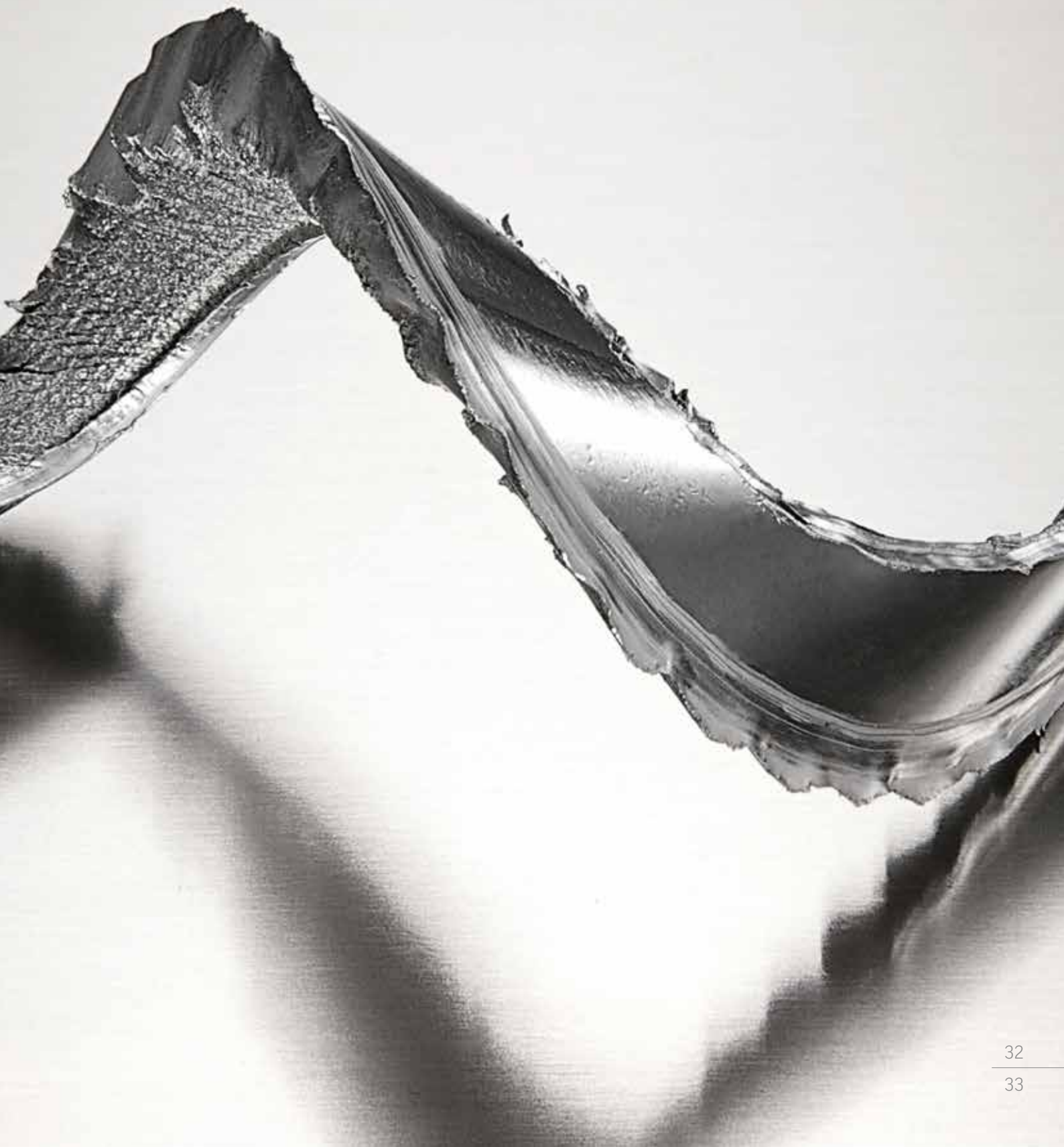


03

Technical data . C 52





# 03.1

## Technical data . C 52

<b>Working area</b>	Traverse	X axis	1000 mm	
	Traverse	Y axis	1100 mm	
	Traverse	Z axis	750 mm	
	Rapid linear traverses	X-Y-Z	60-60-55 m/min	
	Linear acceleration	X-Y-Z	6 m/s <sup>2</sup>	
	Linear feed force	X-Y-Z	16000 N	
	Max. vertical table clearance		950 mm	
	Max. workpiece diameter		Ø 1000 mm	
	Max. workpiece height		810 mm	
	Collision circle (A-axis) 0° position		Ø 1290 mm	
<b>Main spindle drive</b>	Speed	9000 rpm	SK 50	○
	Main power/Torque	20% c.d.f.	56 kW / 356 Nm	
	Speed	9000 rpm	HSK T 100	○
	Main power/Torque	20% c.d.f.	70 kW / 560 Nm	
	Speed	14000 rpm	HSK A 100	○
	Main power/Torque	20% c.d.f.	56 kW / 356 Nm	
	Speed	18000 rpm	HSK A 63	●
	Main power/Torque	20% c.d.f.	35 kW / 215 Nm	
	Speed	9000 rpm	HSK T 100	○
	Main power/Torque	20% c.d.f.	70 kW / 560 Nm	
Speed	14000 rpm	HSK T 100	○	
Main power/Torque	20% c.d.f.	56 kW / 356 Nm		
Speed (MT variants)	18000 rpm	HSK T 63	●	
Main power/Torque	20% c.d.f.	35 kW / 215 Nm		
<b>Control unit</b>	Heidenhain		TNC 640	●
	Siemens		S 840 D sl	○

<b>Tool changer (pick-up)</b>	Interface	HSK A 63 / HSK T 63	SK 50 / HSK A 100 / HSK T 100	○
	Magazine pockets		60	
Chip-to-chip time*		approx. 7.0 s		approx. 7.0 s
*(chip-to-chip times for 3-axis units in milling mode calculated in keeping with German standard VDI 2852, page 1)				
Max. tool length		500 mm		500 mm
Max. tool diameter		Ø 160 mm		Ø 250 mm
Max. magazine load		480 kg		462 kg
Max. tool weight		15 kg		30 kg

<b>Extension of tool storage capacity*</b>	Interface / Interface MT	additional magazine		magazine load	
		single	double	single	double
SK 40		ZM 90 / 115	ZM 220 / 270	90 / 115	220 / 270
SK 50		ZM 72 / 92	ZM 176 / 216	72 / 92	176 / 216
HSK A 63 / HSK T 63		ZM 110 / 135	ZM 265 / 325	110 / 135	265 / 325
HSK A 100 / HSK T 100		ZM 88 / 108 / 128	ZM 212 / 260 / 300	88 / 108 / 128	212 / 260 / 300

\*The tool length depends on the use of the magazine and is at max. 500 mm. More details on request.

<b>Table variants*</b>	Swivelling rotary table	Ø 700	Ø 1150	Ø 1000 (MT variant)
	Clamping surface		Ø 700 mm	Ø 1150 mm
Clamping surface flattened on 2 sides		-	900 mm	-
Swivelling range		+100° / -130°	+100° / -130°	+100° / -130°
C-axis drive mode		torque	torque	torque
Speed - swivelling axis A (tandem)		20 rpm	20 rpm	20 rpm
Speed - rotary axis C		30 rpm	30 rpm	500 rpm
Max. milling table load		2000 kg	2000 kg	2000 kg
Max. turning table load		-	-	1000 kg
T grooves parallel		9 units / 14 H7	9 units / 18 H7	-
T grooves star-shaped		-	-	16 units / 18 H7

\*All tables available on demand

- Included in standard delivery
- Available upon request

<b>Positional tolerance</b>	<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 ●
<b>Chip conveyor</b>	Scraper belt conveyor	●
	Hinged belt conveyor	
	Chip conveyor ejection height	at least 940 mm
	Chip cart	450 l ○
<b>Cooling lubricant unit</b>	Amount of cooling lubricant	500 l ●
	Pump capacity	5 bar / 140 l/min
<b>Internal cooling lubricant supply with paper band filter</b>	Amount of cooling lubricant	1650 l
	Pressure (adjustable up to)	max. 80 bar / 39 l/min
	Mains connection (ICS)	400 V / 50/60 Hz
	Power consumption (ICS)	18.5 kVA
<b>Hydraulics</b>	Operating pressure	120 bar ●
<b>Central lubrication</b>	Minimum grease lubrication quantity	●
<b>Weight</b>	Weight C 52 U	Approx. 21.5 t
	Weight C 52 U MT	Approx. 21.9 t
(standard version without optional extras, attachments, workpieces and cooling lubricant)		
<b>Connected loads</b>	Mains connection	400 V / 50/60 Hz
	Power consumption C 52 U	to 94 kVA
	Power consumption C 52 U MT	to 94 kVA
	Compressed air	6 bar

- Included in standard delivery
- Available upon request