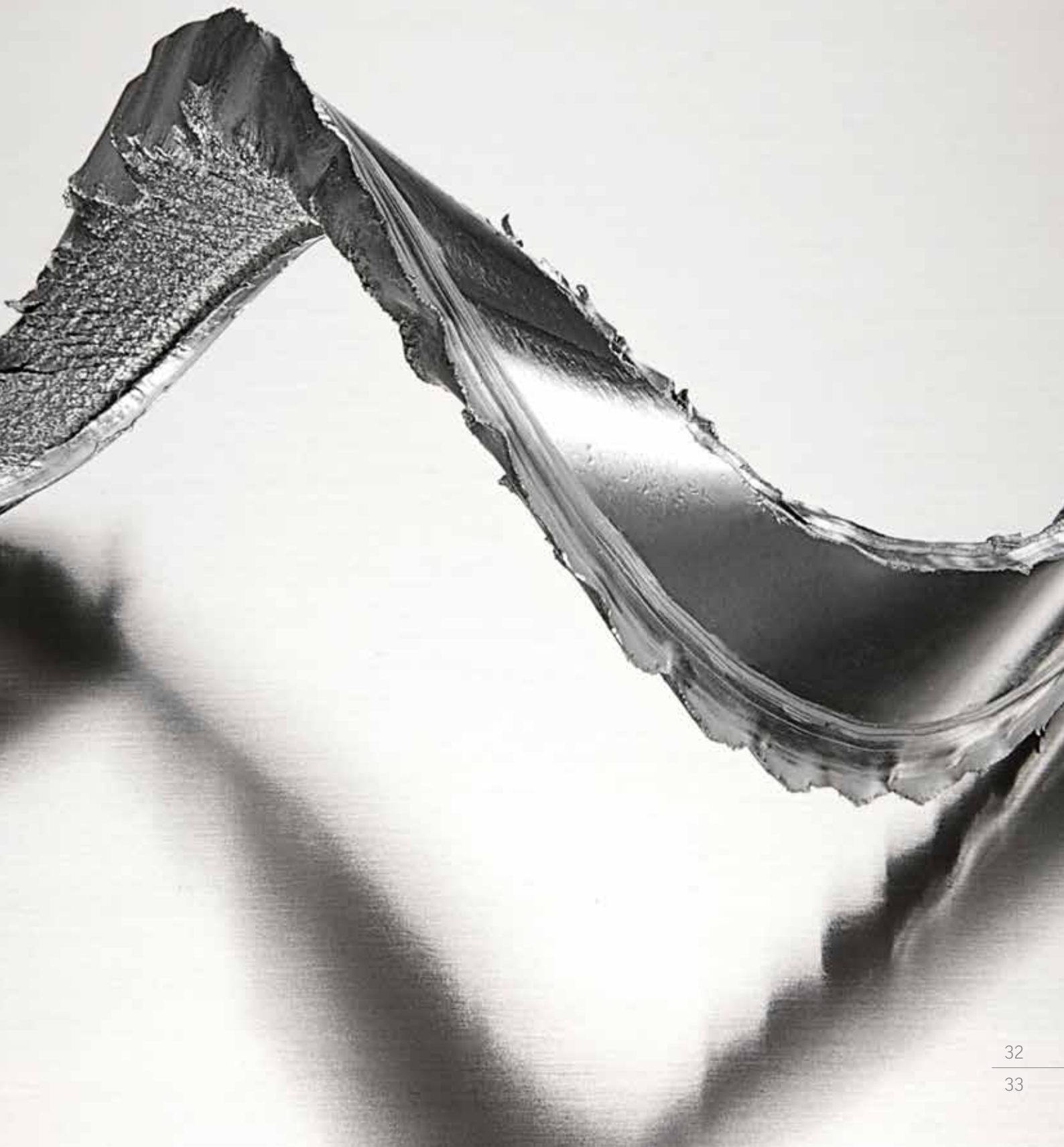


03

Technical data . C 22





03.1

Technical data . C 22

Working area	Traverse	X-axis	450 mm	
	Traverse	Y-axis	600 mm	
	Traverse	Z-axis	330 mm	
	Rapid linear traverse (dynamic)	X-Y-Z	30 (50) m/min.	
	Linear acceleration (dynamic)	X-Y-Z	8 (15) m/s ²	
	Linear feed force	X-Y-Z	4500 N	
	Max. vertical table clearance		470 mm	
	Max. workpiece diameter		Ø 450 mm	
	Max. workpiece height		370 mm	
	Collision circle (A-axis) in 0° position		Ø 610 mm	
Main spindle drive	Speed	15000 rpm	SK 40 ○	
	Main power/Torque	20% c.d.f.	31 kW / 98 Nm	
	Speed	18000 rpm	HSK A 63 ●	
	Main power/Torque	20% c.d.f.	31 kW / 98 Nm	
	Speed	25000 rpm	HSK A 63 ○	
	Main power/Torque	20% c.d.f.	37 kW / 35 Nm	
	Speed	30000 rpm	HSK A 50 ○	
	Main power/Torque	20% c.d.f.	37 kW / 35 Nm	
	Speed	42000 rpm	HSK E 40 ○	
	Main power/Torque	20% c.d.f.	35 kW / 17.5 Nm	
Control unit	Heidenhain		TNC 640 / TNC7 ●	
	Siemens		Sinumerik 840 D sl ○	
Tool changer (pick-up)	Interface	SK 40 / ○ HSK A 63 ●	HSK A 50 ○	HSK E 40 ○
	Magazine pockets	55	65	65
	Chip-to-chip time*	approx. 4.5 s	approx. 4.5 s	approx. 4.5 s
	Max. tool length	250 mm	250 mm	250 mm
	Max. tool diameter with corresponding adjacent pocket allocation	Ø 80 mm Ø 125 mm	Ø 70 mm Ø 125 mm	Ø 70 mm Ø 125 mm
	Max. tool weight	8 kg	6 kg	2.5 kg
	Max. magazine load	220 kg	195 kg	163 kg

Extension of tool storage capacity				
Additional tool magazine ZM 50 (SK 40 / HSK A 63 / HSK A 50 / HSK E 40)		Additional 50 pockets ○		
Additional tool magazine ZM 88 k (SK 40 / HSK A 63 / HSK A 50 / HSK E 40)		Additional 88 pockets ○		
Additional tool magazine single ZM 216 (HSK A 63)		Additional 216 pockets ○		
Additional tool magazine double ZM 528 (HSK A 63)		Additional 528 pockets ○		
Interface	SK 40 / HSK A 63	HSK A 50	HSK E 40	
Max. tool length	250 mm	250 mm	250 mm	
Max. tool diameter with corresponding adjacent pocket allocation	Ø 80 mm Ø 125 mm	Ø 70 mm Ø 125 mm	Ø 70 mm Ø 125 mm	
Max. tool weight	8 kg	6 kg	2.5 kg	
Table variants*				
Swivelling rotary table	Ø 320	○	Ø 320 ○	
Clamping surface	Ø 320 mm		Ø 320 mm	
Swivelling range	+/- 135°		+/- 135°	
C-axis drive mode	torque		worm	
Swivelling axis A speed				
One-sided drive	25 rpm		25 rpm	
Tandem drive	55 rpm		-	
Rotary axis C speed	80 rpm		40 rpm	
Max. table load	150 kg		300 kg	
T grooves star-shaped	4 units / 14 H7		4 units / 14 H7	
Clamping surface	-		Ø 450 x 360 mm	
System table (can be extended with table plate)	Ø 320 mm		Ø 320 mm / Ø 450 x 360 mm	
Zero-point system / pallet clamping system				
Installation clamping device	-		SK 50	
Installation clamping device	-		HSK 100	
Rigid clamping table			●	
Clamping surface			600 x 630 mm	
Max. table load			750 kg	
T grooves parallel			10 units / 14 H7	

● Included in standard delivery
○ Available upon request

*All machining tables available on demand

Positioning uncertainty	A 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.)	≤ 0.006 mm	●
Chip slide	Space-saving mounting on the left or right Capacity		●
Chip conveyor	Scraper belt conveyor		○
	Hinged belt conveyor	Advanced / Advanced 250	○
	Chip conveyor ejection height	at least 940 mm	
	Chip cart	450 l	
Internal cooling lubricant supply with Paper band filter	Capacity of standard tank	130 l	130 l ○
	Capacity of cooling lubricant tank	570 l	750 l
	Pressure (manually adjustable up to)	max. 40 bar / 27 l/min	max. 80 bar / 11 l/min
	Mains connection (ICS)	-	400 V / 50/60 Hz
	Power consumption (ICS)		14 kVA
	Power consumption (ICS with temperature controller)	-	up to 20 kVA
Hydraulics	Operating pressure	120 bar	●
Central lubrication	Minimum grease lubrication quantity		●
Connected loads (machine)	Mains connection	400 V / 50/60 Hz	
	Power consumption	up to 55 kVA	
	Compressed air	6 bar	
Weight	(standard version without optional extras, workpieces and cooling lubricant)	Approx. 8.7 t	

● Included in standard delivery

○ Available upon request

