

**DESCRIPTION
TECHNICAL PARAMETERS
WALDRICH COBURG
30 10s3640**

Machine for grinding guides/planes.

The machine was upgraded with a SIEMENS CPU1511-1PN controller. Filtration system (new, 2019).

Hydraulic table drive; load capacity - 18,000 kg.

Total installed electrical capacity: 74 kW. Modernization (major repairs) in 2019 cost €1.1 million.

A large set of flanges and grinding wheels.

A large set of spare parts: measuring equipment, protective covers.

MODERNIZATION PASSPORT (Electrical part)

The electrical equipment of the machine is made using Siemens components.

The controller is used as a control unit.

The CPU1511-1PN, together with the KTP1200 touchscreen operator panel, creates a set of grinding parameters for the operator and monitors their progress (similar to a CNC).

Installed capacity of electrical equipment (total) 74 kW:

- **Oil leak pump 0.33 kW**
- **Hydraulic pump 4 kW**
- **Guide pump on a frame 1.5 kW**
- **Main table drive motor, 30 kW hydraulic station**
- **Crossbar clamp and lubrication pump motor 0.75 kW**
- **Crossbar movement motor 7.5 kW**
- **Cross member alignment motor 0.12 kW**
- **Coolant pump 0.85 kW**
- **Peripheral spindle lubrication and cooling pump 0.55 kW**
- **Coolant cleaning pump 0.12 kW**
- **Peripheral spindle motor 15 kW**
- **Electric drive for moving peripheral support slides (vertical movement) 1FK2105-6AF10-1SA0 Electric motor P=2.1 kW, Nn=3000 rpm, Mo=8.0 Nm, TTL2500 imp/rev., key, parking brake converter 6SL3210-5HE12-0UF0SINFMICS S210 Single axis, Compact.**
- **Electric drive for moving the peripheral support carriage (horizontal movement) 1FK2208-4AC10-1SA0-Electric motor**

P=3.55 kW, Nn=2000 rpm, Mo=22.0 Nm, TTL2500 imp/rev., key, parking brake converter 6SL3210-5HE15-0UF0 SINAMICS S210 Single axis, Compact.

- **Electric drive for moving the carriage of the universal support (horizontal movement) 1FK2208-4AC10-1SA0 Electric motor P = 3.55 kW, Nn = 2000 rpm, Mo = 22.0 Nm, TTL 2500 imp/rev., key, parking brake converter 6SL3210-5HE15-0UF0 SINAMICS S210 Single axis, Compact.**
- **Electric drive for moving the universal support slide (vertical movement) 1FK2105-6AF10-1SA0 Electric motor P=2.1 kW, Nn=3000 rpm, Mo=8.0 Nm, TTL2500 imp/rev., key, parking brake converter 6SL3210-5HE12-0UF0 SINFMICS S210 Single axis, Compact.**
- **The 6 kW DC universal spindle motor is controlled by a 6RA8025-6DS22-0AA0-ZG00+G20+L11 converter.**
- **Device for straightening and turning a universal support, hydraulic pump 1.1 kW**