

Machine - Datasheet

Machinetype:	Bed, milling and drilling centre
Make:	SORALUCE
Type:	F-MT 4000
Year of manufacture:	2015
Control:	Heidenhain TNC 640 HSCI
Term of delivery:	On request
Quotation:	Ex works



Technical details	Dimension
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Travel paths:

Longitudinal (X):	4000 mm
Vertical (Z):	1600 mm
Cross (Y):	1300 mm

Carousel rotary table:

Diameter:	1600 mm
Max. speed:	250 min ⁻¹
Drive power (100% duty cycle):	53 kW
Max. transport load (positioning):	8000 kg
Max. transport load (turning):	3000- 8000 kg

Clamping table:

Length:	4000 mm
Width:	1240 mm
Clamping table height:	760 mm

Automatically indexing milling head:

Tool holder: ISO 50, DIN 69871 AD
 Automatic tool clamping: clamping force 20000 N

Spindle speed range:

Spindle speed:	20-5000 min ⁻¹
Full power from	340 min ⁻¹
Torque at	32 kW/S1 : 900 Nm

Main drive:

Drive power:	43 kW
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Max. rapid traverse speed:

X-axis	45000 mm/min
Y- and Z-axis	35000 mm/min

Max. feed force:

X-, Y- and Z-axis	16000 N
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Automatic tool changer**Magazine stations in M version:**

Max. tool stations: SK	50 40 stations
Max. tool stations: Capto	C8 20 stations

Machine weight:	approx. 32.100 kg
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Equipment:

- Clamping table 4000 x 1240 x 760 mm with integrated carousel rotary table dia. 1600 mm
- Rotating operator pendant with telescopic arm and control
HEIDENHAIN TNC 640 HSCI (6 axes + spindle), including 19" flat screen, metallic keyboard with integrated mouse and USB interface on the operator panel.
Processor speed 0.5 ms including HEIDENHAIN smarT.NC.
- Interpolation turning with HEIDENHAIN TNC 640 HSCI consisting of CAM system, HEIDENHAIN postprocessor, C-axis (spindle) software adaptation.
- Portable electronic handwheel unit HEIDENHAIN HR 520 with 5 m cable.
- Automatically indexing milling head / 2 planes with 2.5° x 2.5° indexing and a tool clamping force of 20,000 N (H200), 32 kW / 900 Nm, tool holder ISO 50 - DIN 69871 AD. Mounting flange with Hirth serration for adapting turning tool holders, grinding spindles or additional milling heads and a protective ring to cover the Hirth serration; omitted when selecting H205.
- Spindle drive 43 kW at 100% duty cycle via water-cooled HEIDENHAIN inline motor with direct power transmission. The motor is integrated in the milling ram.
- Turning tool holder with Capto C8 holder (manual tool clamping) for turning operations incl. Hirth serration and SK 50 holder according to DIN 69871 AD for adaptation to SORALUCE milling heads. (Semi-automatic changing with additional manual fastening by 8 x M8 screws); omitted with fully automatic insertion of the turning tool holder.
- Pneumatically 500 mm movable pick-up station in the tool changer area for the turning tool holder and protective ring for semi-automatic insertion.
- Clamping table with integrated NC carousel rotary table dia. 1,600 mm, for turning and positioning operation with hydraulic clamping
- Rack-and-pinion drive in the X-axis via two servo motors controlled in master-slave mode.