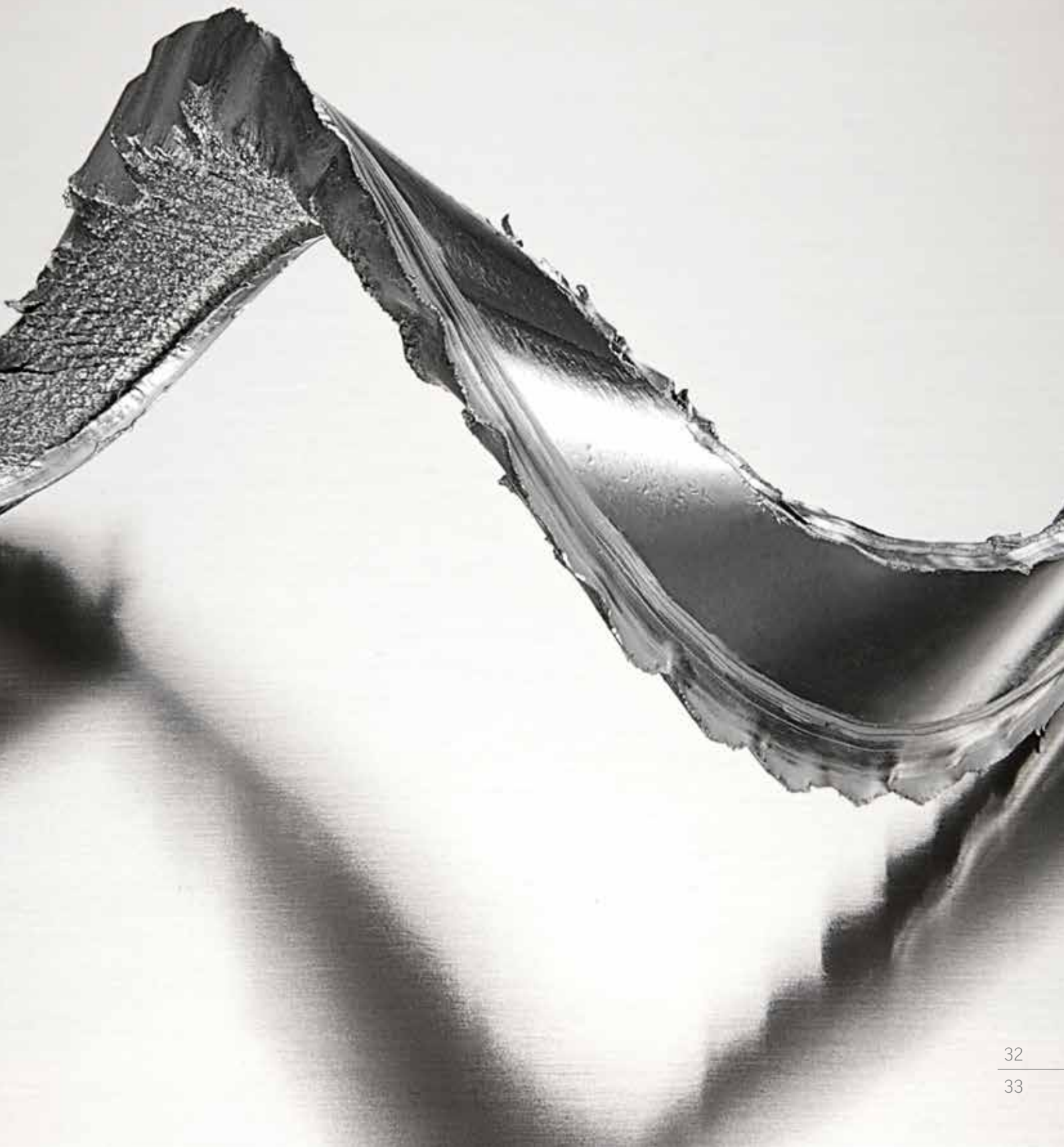


03

Technical data . C 12





# 03.1

## Technical data . C 12

<b>Working area</b>	Traverse	X-axis	350 mm
	Traverse	Y-axis	440 mm
	Traverse	Z-axis	330 mm
	Rapid linear traverse (dynamic)	X-Y-Z	30 m/min (50 m/min)
	Linear acceleration (dynamic)	X-Y-Z	4 (8) m/s <sup>2</sup>
	Linear feed force	X-Y-Z	3000 N
	Max. vertical table clearance		430 mm
	Max. workpiece diameter		Ø 320 mm
	Max. workpiece height		265 mm
<b>Main spindle drive</b>	Speed	12000 rpm	SK 40 / HSK A 63 ●
	Main power/Torque	20% c.d.f.	31 kW / 98 Nm
	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	30000 rpm	HSK A 50 ○
	Main power/Torque	20% c.d.f.	37 kW / 32 Nm
	Speed	42000 rpm	HSK E 40 ○
	Main power/Torque	20% c.d.f.	35 kW / 17.5 Nm
<b>Control</b>	Heidenhain		TNC 640 ●
<b>Tool changer (pick-up)</b>	Magazine pockets		36 items ●
	Additional magazine ZM 35		35 items ○
	Chip-to-chip time*		approx. 4.5 s
	*(Chip-to-chip times with German standard VDI 2852, page 1)		
	Max. tool length		200 mm
	Max. tool diameter with		Ø 80 mm
	Max. magazine load		144 kg
<b>NC swivelling rotary table</b>	NC swivelling rotary table		Ø 320 ●
	Clamping surface		Ø 320 mm
	Collision circle		Ø 610 mm
	Swivelling range		+/- 115°
	C-axis drive mode		Torque
	Swivelling axis A speed standard (dynamic)		25 (55) rpm
	Rotary axis C speed standard (dynamic)		40 (80) rpm
	Max. table load		100 kg
	T grooves star-shaped		4 / 14 H7

<b>Position measuring</b>	Resolution	0.0001 mm	●
<b>Positional tolerance</b>	<p>Tp 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 than 6 µm.)</p>	0.008 mm	●
<b>Chip slide</b>	Removable chip slide		●
<b>Chip conveyor</b>	<p>Scraper belt or hinge conveyor ejection height</p> <p>ejection height</p> <p>chip cart</p>	<p>1100 mm</p> <p>450 l</p>	<p>○</p> <p>○</p>
<b>External cooling lubricant supply</b>	<p>With chip slide and cooling lubricant tank</p> <p>Base container capacity chip slide</p> <p>Base container capacity chip conveyor</p> <p>Cooling lubricant unit without high-pressure pump with sieve basket</p> <p>Capacity of base container</p> <p>Capacity of cooling lubricant tank</p> <p>Cooling lubricant unit without high-pressure pump with paper band filter</p> <p>Capacity of base container</p> <p>Capacity of cooling lubricant tank</p>	<p>236 l</p> <p>325 l</p> <p>100 l</p> <p>570 l</p> <p>100 l</p> <p>570 l</p>	<p>●</p> <p>○</p> <p>○</p>
<b>Internal cooling lubricant supply with paper band filter</b>	<p>Capacity of base container</p> <p>Capacity of cooling lubricant tank</p> <p>Pressure (manually adjustable up to)</p> <p>Mains connection (ICS)</p> <p>Power consumption (ICS)</p>	<p>100 l</p> <p>570 l</p> <p>max. 40 bar / 27 l/min</p> <p>-</p> <p>-</p>	<p>100 l</p> <p>750 l</p> <p>max. 80 bar / 18 l/min</p> <p>400 V / 50 Hz</p> <p>17 kVA</p>
<b>Hydraulics</b>	Operating pressure	120 bar	●
<b>Central lubrication</b>	Minimum grease lubrication quantity		●
<b>Connected loads (machine)</b>	<p>Mains connection</p> <p>Power consumption</p> <p>Compressed air</p>	<p>400 V / 50 Hz</p> <p>46 kVA</p> <p>6 bar</p>	
<b>Weight</b>	(Standard version without optional extras, attachments, workpieces and cooling lubricant)	about 7.2 t	

- Included in standard delivery
- Available upon request