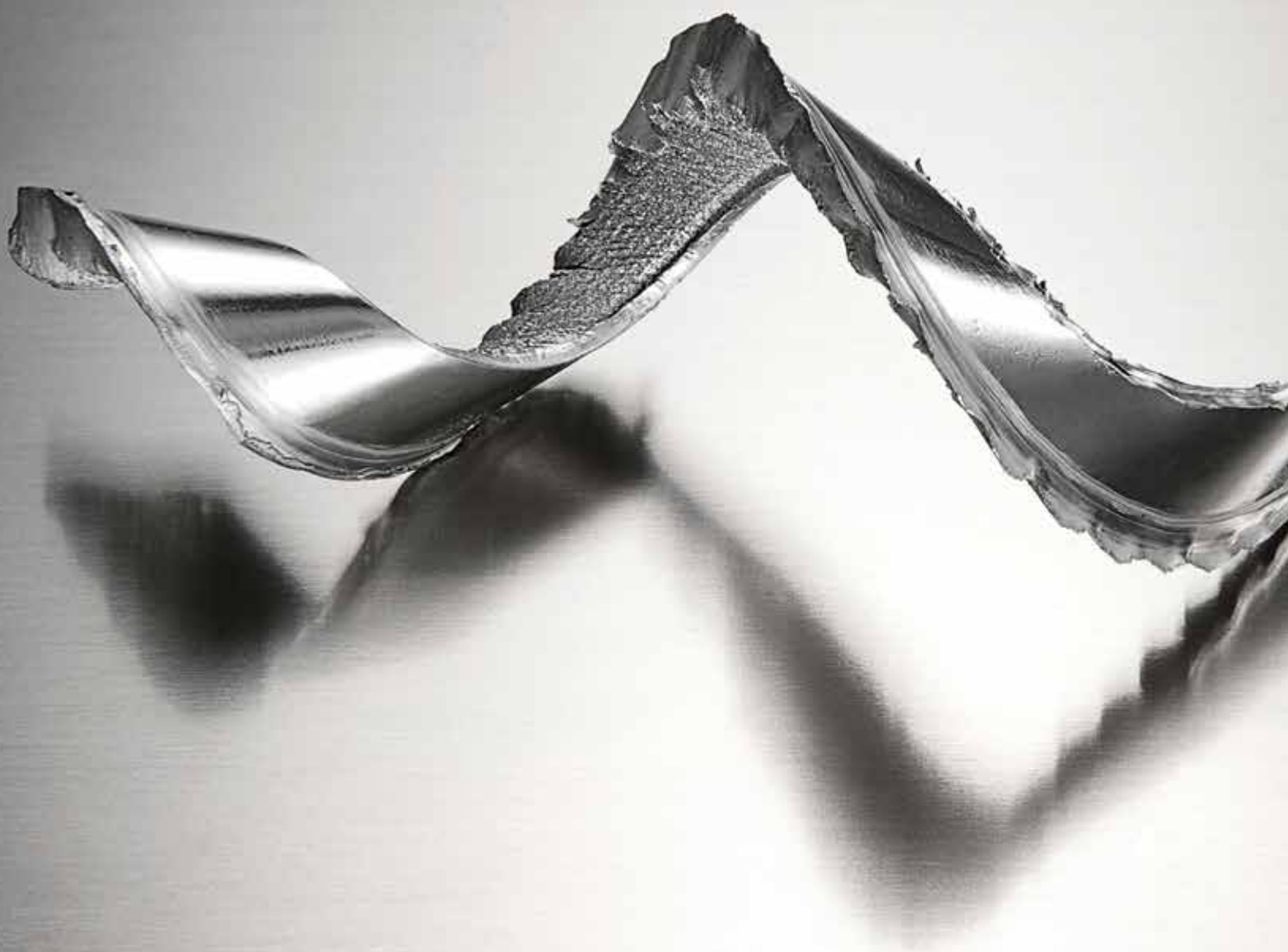


03

Technical data . C 250



03.1

Technical data . C 250

Working area	Traverse	X axis	600 mm
	Traverse	Y axis	550 mm
	Traverse	Z axis	450 mm
	Rapid linear traverses	X-Y-Z	35 - 35 - 35 m/min
	Linear acceleration	X-Y-Z	6 m/s ²
	Linear feed force	X-Y-Z	5000 N
	Max. vertical table clearance		550 mm
	Max. workpiece diameter		Ø 450 mm
	Max. workpiece height		355 mm
	Collision circle (A axis) in 0° position		Ø 770 mm
Main spindle drive	Speed	15000 rpm	SK 40 / HSK A 63
	Output/torque	20% c.d.f.	20 kW / 180 Nm ●
	Speed	18000 rpm	HSK A 63
	Main power/torque	20% c.d.f.	20 kW / 180 Nm ○
Control unit	Heidenhain		TNC 640 ●
Tool changer (pick-up)	Magazine pockets		30 items ●
	Chip-to-chip time*		approx. 6 s
	*(chip-to-chip times for 3-axis unit calculated in keeping with German standard VDI 2852, page 1)		
	Maximum tool length		300 mm
	Max. tool diameter		Ø 80 mm
	with corresponding adjacent pocket allocation		Ø 125 mm
	Max. magazine load		120 kg
Extension of tool storage capacity	Additional magazine ZM 50		additional 50 pockets ○
	Additional magazine ZM 88 k		additional 88 pockets ○
	Max. tool diameter in the additional magazine		Ø 80 mm
	Maximum tool diameter with corresponding adjacent pocket allocation in additional magazine		Ø 125 mm
	Max. tool weight		8 kg
Chip drawer	Removable chip drawer		●
Chip conveyor	Scraper belt or hinged belt conveyor		
	Ejection height		1100 mm ○
	Chip cart		450 l ○
Internal cooling lubricant supply with paper band filter	Capacity of standard tank		305 l ●
	Capacity of cooling lubricant tank		570 l
	Pressure (manually adjustable up to)		max. 40 bar / 27 l/min ○

Table variants	NC swivelling rotary table	Ø 320	Ø 450 x 360	Rigid clamping table
Clamping surface	Ø 320 mm	Ø 450 x 360 mm	800 x 616 mm	
Swivelling range	+/- 115°	+/- 115°	-	
C axis drive mode	Worm	Worm	-	
Swivelling axis A speed:				
One-sided drive	25 rpm	25 rpm	-	
Speed rotary axis C:	40 rpm	40 rpm	-	
Max. table load	-	-	1100 kg	
One-sided drive	300 kg	300 kg	-	
T grooves parallel	4 / 14 H7	5 / 14 H7	9 / 14 H7	
Secondary clamping plates	710 x 370 mm	-	-	
T grooves parallel	5 / 14 H7	-	-	
System table (can be extended with table plate)	Ø 320 mm	Ø 450 x 360 mm	-	
Positional tolerance	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/greater than 6 µm.)			0.008 mm ●
Hydraulics	Operating pressure			120 bar ●
Central lubrication	Minimum grease lubrication quantity			●
Connected loads (machine)	Mains connection			400 V / 50 Hz
	Power consumption			28 kVA
	Compressed air			6 bar
Weight	(standard version without optional extras, attachments, work-pieces and cooling lubricant)			approx. 7.6 t

- Included in standard delivery
- Available upon request