



- High accuracy during bulk and serial production
- High temperature stability
- Rigidity comparable to cam-machines
- 8 independent AC spindle drive units
- 32 controlled CNC axes in total
- 24 auxiliary CNC axes for special equipment control
- 2 control CNC systems SINUMERIK 840D solution line
- Own technological software TMis
- Great selection and flexibility of fast exchangeable tool holders
- Auxiliary functions controlled by hydraulic or pneumatic means
- Compliance with EU Council Directive 89/392 EEC

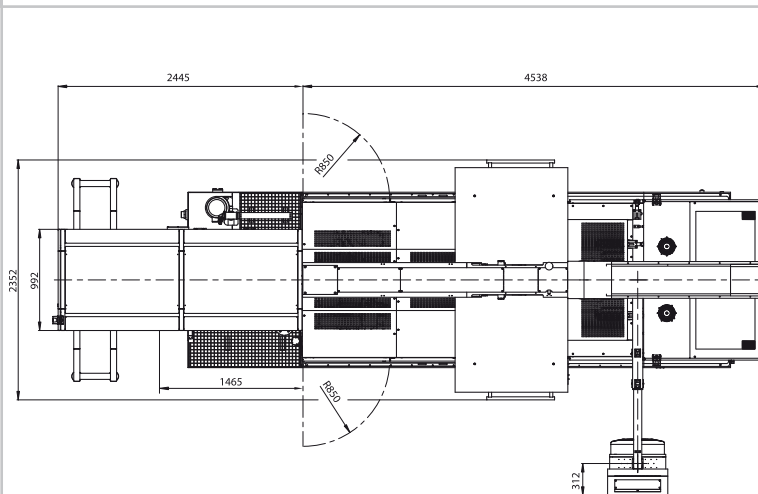
TECHNICAL DATA

STANDARD MODEL

- Reinforcement of the spindles drum with three rims with frontal toothing
- 8 spindle motors
- 8 longitudinal slides
- 7 cross slides (power slides in working pos. 1 & 2, axes X1 & X2)
- 1 cut-off slide
- 1 spindles drum indexing axis, fastening and feed of material
- 2 control CNC systems SINUMERIK 840D solution line
- 32 control and 24 auxiliary CNC axes for special equipment control
- Motors and drive units with stepless speed control SINAMICS by SIEMENS
- Material clamping and stop in working pos. 1

OPTIONAL EQUIPMENT

- Pick-up spindle with CNC controlled speed and collet fixing with hydraulic control
- Other auxiliary equipment for longitudinal machining
- Auxiliary equipment for profile openings
- Slide for machining from cut-off side (1st tool holder)
- Y-axis for cross slides in working pos. 3, 4, 5, 6, 7
- Tool for radial and axial drilling and milling operations from the cut-off side
- Driven tools with CNC controlled speed
- Material feed at 1st operating position
- Material clamping and stop at 5th operating position
- Material feed at 5th operating position
- Pneumatic parts-catching attachment
- Great selection of chip conveyor systems
- Great selection of high-pressure tool cooling systems
- Great selection of equipment for drilling, reaming, milling, extrusion, thread cutting and machining of polygons
- Complete machinery adjustment and acceptance of the machine at TAJMAC-ZPS premises



CNC OPTIONS

Slide for machining from cut-off side with 1 tool holder (X8 axis)

		max.
Fast traverse	m/min	15
Radial elevation	mm	90
Force	N	3 000
Ball screw thread pitch	mm	5

Slide for machining from cut-off side with 3-tool holder (X8, Y8 axis)

		max.
Fast traverse	m/min	15
Radial elevation (X)	mm	95
Force	N	2 900
Radial elevation (Y)	mm	110
Quantity of toolholders (solid or rotating)		3

Drives for longitudinal rotary equipment (axes S01 to S08)

		max.
Speed	rpm	6 000
Torque	Nm	20

Drive units for driven tools (axes ST01 to ST08)

		max.
Quantity available		8
Speed	rpm	12 000
Standard torque	Nm	22

Drives for machining of inner profiles (axes U1 to U7)

Working positions		1 to 7
Fast traverse	m/min	30
Force	N	2 500
Radial elevation	mm	340

Machining of polygons and thread cutting

Speed	rpm	4 500
Torque	Nm	11

Systems of fast tool-changing

CAPTO	C3, C4
KENNAMETAL	K32, K40

SK52 BZI collet bar diameter

		min.	max.
With automatic feeder and bar end finishing	mm		Ø 52
With automatic feeder without bar end finishing	mm		Ø 48
With magazine	mm	Ø 11	Ø 42
Material feed length (with magazine)	mm		180

DIN 9112 E collet bar diameter

		min.	max.
With automatic feeder and bar end finishing	mm		Ø 49
With automatic feeder without bar end finishing	mm		Ø 45
With magazine	mm	Ø 10	Ø 42
Material feed length (with magazine)	mm		180

Bar dimensions

		min.	max.
Bar diameter	mm		42 (52)
Bar length	m		3 (4)

Spindles (axes S1 to S8)

		nominal	max.
Spindle pitch diameter	mm		480
Speed	rpm		4 500
Spindle motor performance	kW	7	11
Total spindle motor performance	kW	56	88
Spindle torque (at 1,000 rpm)	Nm		66

Drum indexing (CMI axis)

Time to index by 1 position (45°)	s		1
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Longitudinal slides (axes W1 to W7 and Z8)

			max.
Quantity			8
Fast traverse	m/min		30
Force	N		3 400
Thrust	mm		425
Ball screw thread pitch	mm		10

Cross slides (axes X1 to X7 and Z1 to Z7)

			max.
Quantity			7
Fast traverse (radial X, axial Z)	m/min		15, 30
Axial thrust (axes Z1 to Z7)	mm		200
Axial force (axes Z1 to Z7)	N		3 600
Radial thrust (axes X1 to X7)	mm		80
Radial force (axes X1 to X7)	N		3 200
Thread pitch	mm		5, 10

Cut-off slide (U8 axis)

			max.
Fast traverse	m/min		15
Force	N		3 000
Thrust	mm		70
Ball screw thread pitch	mm		5

Machine dimensions

Length × width × height	mm	4 538 × 2 352 × 3 238
Machine weight	kg	16 600
Electric cabinet weight	kg	2 400
Electric cabinet dimensions	mm	5 000 × 600 × 2 268
Coolant volume	litres	1 400

Description, illustrations and numerical data may not always correspond with the machine latest version.

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