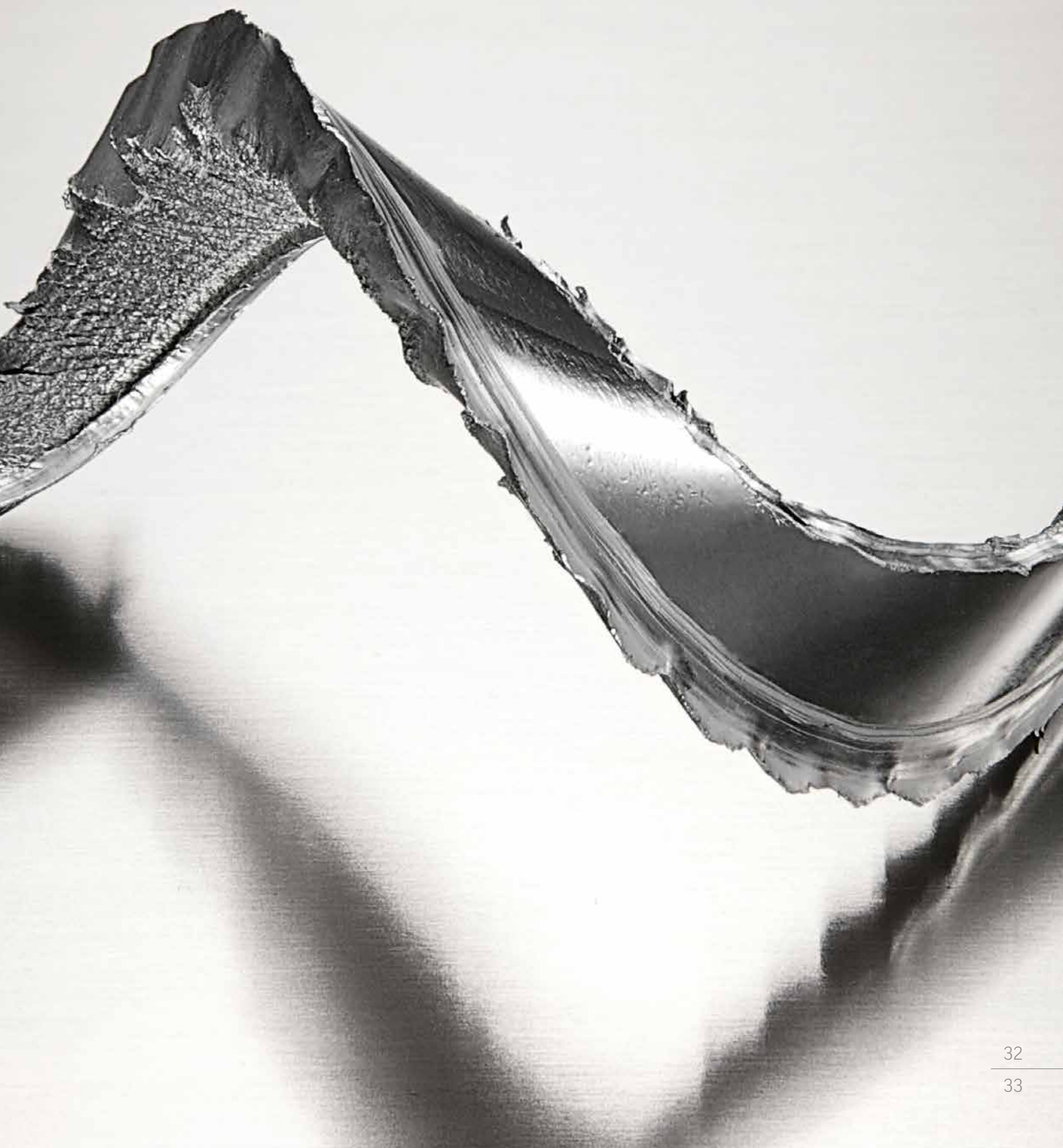


03

Technical data C 32 GEN2





03.1

Technical data C 32 GEN2

Working area	Traverse	X-axis	650 mm
	Traverse	Y-axis	650 mm
	Traverse	Z-axis	500 mm
	Rapid linear traverse (dynamic)	X-Y-Z	45 – 45 – 40 m/min (60 – 60 – 60 m/min)
	Linear acceleration (dynamic)	X-Y-Z	6 (10) m/s ²
	Linear feed force	X-Y-Z	8500 N
	Max. vertical table clearance		600/635 mm
	Max. workpiece diameter		Ø 650 mm
	Max. workpiece height		420 mm
	Collision circle (A-axis) in 0° position		Ø 840 mm
Main spindle drive	Speed	15000 rpm	HSK A 63 ○
	Main power/Torque	20 % c.d.f	31 kW / 194 Nm
	Speed	16000 rpm	HSK A 63 ●
	Main power/Torque	20% c.d.f	20 kW / 173 Nm
	Speed	20000 rpm	HSK A 63 ○
	Main power/Torque	20% c.d.f	42 kW / 148 Nm
	Speed	25000 rpm	HSK A 63 ○
	Main power/Torque	20% c.d.f	31 kW / 98 Nm
	Speed	42000 rpm	HSK E 40 ○
	Main power/Torque	20% c.d.f	35 kW / 17,5 Nm
Control unit	Heidenhain		TNC7 ●
	Siemens		SINUMERIK ONE ○
Tool changer (pick-up)	Interface	HSK A 63 ●	HSK E 40 ○
	Magazine pockets	36 items	36 items
	Chip-to-chip time	approx. 4.5 s	approx. 4.5 s
	Max. tool length	350 mm	350 mm
	Max. tool diameter for free adjacent pockets	Ø 80 mm Ø 125 mm	Ø 80 mm Ø 125 mm
	Max. tool weight	8 kg	2.5 kg
	Max. magazine load	144 kg	90 kg

- Included in standard delivery
- Available upon request

Extension of tool storage capacity	Additional magazine ZM 30 (HSK A 63 / HSK E 40)	Additional 30 pockets ○	
	Additional magazine ZM 50 (HSK A 63 / HSK E 40)	Additional 50 pockets ○	
	Additional magazine ZM 88 k (HSK A 63 / HSK E 40)	Additional 88 pockets ○	
	Additional magazine single ZM 216 (HSK A 63)	Additional up to 216 pockets ○	
	Additional magazine double ZM 528 (HSK A 63)	Additional up to 528 pockets	
	Interface	HSK A 63	HSK E 40
	Maximum tool diameter with corresponding adjacent pocket allocation	Ø 80 mm Ø 125 mm	Ø 80 mm Ø 125 mm
	Max. tool weight	8 kg	2.5 kg

Table variants*	Swivelling rotary table	Ø 320	Ø 320
	Clamping surface	Ø 320 mm	Ø 320 mm
	Swivelling range	+/- 130°	+/- 130°
	C-axis drive mode	Worm	Torque
	Swivelling axis A speed		
	One-sided drive	25 rpm	25 rpm
	Tandem drive	-	55 rpm
	Rotary axis C speed	40 rpm	80 rpm
	Max. table load		
	One-sided drive	300 kg	200 kg
	Tandem drive	-	200 kg
	Star-shaped T grooves	4 / 14 H7	4 / 14 H7
	Clamping surface	Ø 450 x 360 mm	-
	Secondary clamping plates	760 x 370 mm	760 x 370 mm
	T grooves parallel	5 / 14 H7	5 / 14 H7
	Swivelling rotary table	Ø 650	Ø 650 Rigid ● clamping table
	Clamping surface	Ø 650 x 540 mm	Ø 650 x 540 mm 900 x 665 mm
	Swivelling range	+/- 130°	+/- 130° -
	C-axis drive mode	Worm	Torque -
	Swivelling axis A speed		
	with one-sided drive	25 rpm	25 rpm -
	Tandem drive	-	25 rpm -
	Rotary axis C speed	30 rpm	65 rpm -
	Max. table load	-	- 1500 kg
	One-sided drive	600 kg	600 kg -
	Tandem drive	-	1000 kg -
	T grooves parallel	7 / 14 H7	7 / 14 H7 10 / 14 H7

*All machining tables available on demand

Positioning uncertainty	A in X-Y-Z axes according to ISO 230-2 (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.)	≤ 0.006 mm ●
Chip drawer	Removable chip drawer	●
Chip conveyor	Scraper belt conveyor	○
	Hinged belt conveyor	Advanced / Advanced 250 ○
	Ejection height	mind. 940 mm
	Chip cart	450 l ○
External cooling lubricant supply	With chip drawer and cooling lubricant tank Cooling lubricant tank capacity	360 l ●
Internal cooling lubricant supply with paper band filter	Capacity of standard tank	80 l ○
	Capacity of cooling lubricant tank	860 l at 40 bar / 860 l at 80 bar
	Pressure (adjustable up to)	max. 40 bar / 27 l/min max. 80 bar / 22 l/min
	Mains connection (ICS)	400 V / 50 Hz 460 V / 60 Hz
	Power consumption (ICS)	up to 12.5 kVA
	Power consumption (temperature controller)	up to 6,0 kVA
Hydraulics	Operating pressure	120 bar ●
Central lubrication	Minimum grease lubrication quantity	●
Connected loads (machine)	Mains connection	400 V / 50 Hz 460 V / 60 Hz
	Power consumption	up to 54 kVA
	Compressed air	6 bar
Weight	(Standard version without optional extras, attachments, workpieces and cooling lubricant)	about 11.0 t

● Included in standard delivery

○ Available upon request

