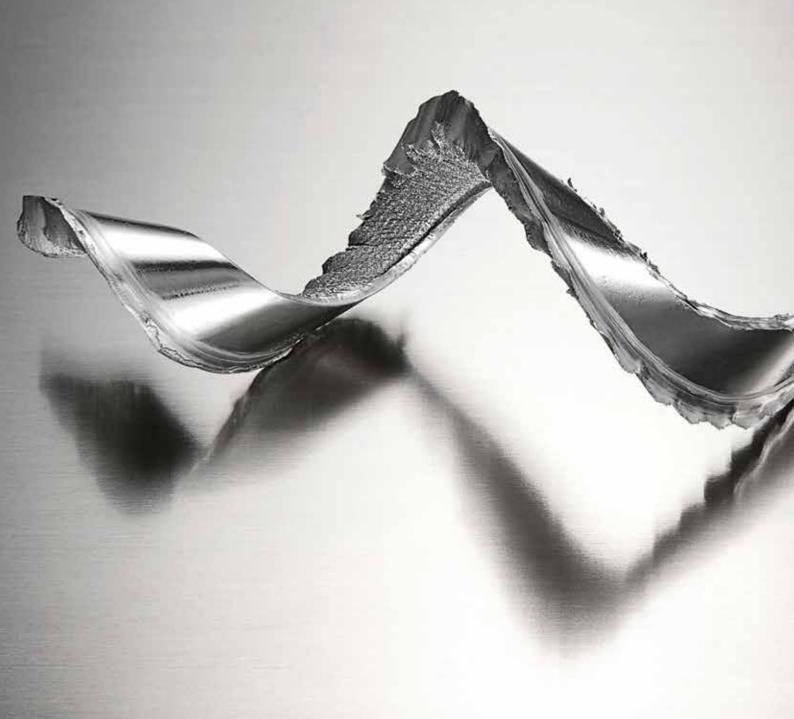
03 Technical data . C 250



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/s²	
	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 Main power/torque	15000 rpm 20% c.d.f.	SK 40 / HSK A 63 20 kW / 173 Nm	
	Speed Main power/torque	18000 rpm 20% c.d.f.	HSK A 63 20 kW / 173 Nm	
Control unit	Heidenhain		TNC 640	•
Tool changer (pick-up)	Magazine pockets		30 items	•
	Chip-to-chip time		approx. 6 s	
	Maximum tool length		300 mm	
	Max. tool diameter with corresponding adjacent pocket allocation	n	Ø 80 mm Ø 125 mm	
	Max. magazine load		120 kg	
Extension of tool storage capacity	Additional tool magazine ZM 50		additional 50 pockets	
	Additional tool magazine ZM 88 k		additional 88 pockets	0
	Max. tool diameter in the additional tool mag with corresponding adjacent pocket allocation is		Ø 80 mm ne Ø 125 mm	
	Max. tool weight		8 kg	
Chip drawer	Removable chip drawer			•
Chip conveyor	Scraper belt			0
	Ejection height		at least 940 mm	
	Chip cart		450	0
Internal cooling lubricant supply with paper band filter	Capacity of standard tank		305 I	•
	Capacity of cooling lubricant tank	750 I with 80 b	ar / 570 I with 40 bar	
	Pressure (manually adjustable up to)		max. 80 / 40 bar / 17 / 27 l/min	0

Table variants	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 One-sided drive	- 300 kg	- 300 kg	1100 kg
	T grooves parallel	4 / 14 H7 star-shaped	5 / 14 H7 parallel	9 / 14 H7 parallel
	Secondary clamping plates T grooves parallel	710 x 370 mm 5 / 14 H7	-	-
	System table (can be extended with table plate)	Ø 320 mm	Ø 450 x 360 mm	-
Positional uncertainty	P in X-Y-Z axes according to V	DI/DGQ 3441		0.008 mm
	(calculated at a constant ambi- Our products are subject to th authorization since the attaina than 6 µm.)			
Hydraulics	Operating pressure			120 bar •
Central lubrication	Minimum grease lubrication qu	uantity		•
Connected loads (machine)	Mains connection			400 V / 50 Hz
	Power consumption			28 kVA
	Compressed air			6 bar
Weight	(standard version without opti pieces and cooling lubricant)	ional extras, attachme	ents, work-	approx. 8.2 t
	Included in standard deliveAvailable upon request	ery		