

SW BA622 double-spindle machining center BA2353, used

**manufacturer :** SW**Product number:**

BA2353

Description

Machining center	Horizontal
Manufacturer	SW
Model	BA 622
Year of manufacture	2018
working hours	38153h

Technical data

- Control system: Siemens 840 D SL
- Version with 2 independent Z-axes

Spindle HSK 100 with 375 Nm (2x)

- Motor spindle! In AC asynchronous technology
- with star-delta connection
- Speed range 1 • 10,000 rpm
- Power (25% duty cycle) 30 kW/730 rpm
- Torque (25% duty cycle) 375 Nm
- Rated power 20 kW/730 rpm
- Rated torque 266 Nm
- Start-up time, 1.70 s (n = 0-10,000 rpm)
- Range switchover star - 3000 rpm - delta
- Spindle bearing diameter 100 mm
- Front bearing arrangement 4-fold T-0-T
- Spindle lubrication 01-minimal lubrication
- Tool interface hollow shaft DIN69893-HSK-A100
- Tool clamp mechanically operated
- Clamping force > 46 kN
- Media transfer, radial, cleaning air, pan system control
- Media transfer, central, cooling lubricant: emulsion, oil < 80 bar
- Media transfer, central, MMKS: aerosol 5 bar

Torsion compensation

Hydraulic compensation module for the 4th axis. Used for torsion-sensitive devices and off-centre loads.
Compensation torque (adjustable) 450 Nm Torque constant 1.8 Nm/bar.

5th axis, 2-fold direct drive

Consisting of:

- 2 direct-drive NC tables

2x 0 340 mm (C1/C2 or W1/W2 axis) installed in a common crossbeam

- Direct, absolute angle measurement
- Max. fixture dimensions 2x 0 600 x 225 mm (400 mm)
- Max. fixture weight 2x 120 kg
- Peak torque 490 Nm
- Nominal torque 350 Nm
- Max. speed 50 rpm
- Position tolerance without load Tp" 1 r:r
- Tangential torque 2000 Nm Mechanically clamped, hydraulically released

- Weight moment 150 Nm

Rotary distributor

- For working areas 1 and 2 (A, IJ axis)
- Uncontrolled - Leak oil sealed
- Nominal size NG 5
- Distributor track 10
- Max. operating pressure hydraulics 250 bar
- Max. operating pressure pneumatics 8 bar (Connection assignment according to standard assignment plan)

Scraper conveyor (two-part)

(short, broken chips, needle chips, casting chips, casting abrasion, no lumps, no mats)

- Suitable for chips 100 mm
- Conveyor width 1000 mm
- Discharge height 1100 mm
- Dirty water filter, slotted screen w= 0.35 mm
- Dirty water pump 400 l/min/ 1.5 bar
- Coal dust content approx. 0.3 m

Cooling agent filtration via compact belt filter

Full flow cleaning Top compact paper belt filter for cooling agent emulsion

- Nominal flow rate 400 Vmln
- Nominal filter accuracy 25µm
- tank volume 1.2 m
- Low-pressure pump 200 Vmin at 3 bar
- High-pressure pump, max. 75% EO 40 Vmln at 40 bar
- Heat exchanger for cooling the coal dust via the machine's central cooling system

Pneumatic control, basic module

- Pneumatic control system for advertising stock holders or clamping elements

- Flow measurement - Integrated blow-off function
- 2 probes each for table 1 and 2
- Simultaneous measurement on the loading side of 2 profile controls for table 1 or 2, corresponding to selection - Detectable gap $>/=$ 0.05 mm, corresponding to device design
- Convenient diagnosis and adjustment via SW-HMI
- The determined values are automatically activated by the device selection

Tool breakage detection, inductive**Additional control panel, 19 inches****Tool coding Balluff with chip coding In the tool holder.****PROFIBUS for automation**

Delivery time	immediately
Price	on request



