

SW BA W06-22 5-axis double-spindle machining centre BA2408, used



manufacturer : SW

Product number:
BA2408

Description

Machining center	Horizontal
Manufacturer	SW
Model	BA W06-22
Year of manufacture	2020
Working hours	approx. h
Spindle runtime	approx. h

Technical data

- Control system: Siemens 840 D SL
- Version with 2 independent Z-axes
- Spindle HSK A63 with 80 Nm (2x)
- Speed range 1 • 17,500 rpm
- Power 35 kW
- Torque 80 Nm
- Rated power 26 kW
- Rated torque 60 Nm

Feed drives

- Siemens linear motors, type 1FN3

Technical data:

Axis Rapid traverse Acceleration

- X 100 m/min 12 m/s²
- Y 100 m/min 10 m/s²
- Z 100 m/min 22 m/s²

Tool magazine

- Slide-guided magazine chain
- Pick-up system
- Capacity: 2 × 42 tool positions
- HSK 63
- Fixed-position coded tool management
- Max. tool length 400 mm
- Max. tool weight 10 kg

2xset oil distributors for NC rotary table

- for work areas 1 and 2 (A- and U-axes)
- NW6 - uncontrolled
- sealed to prevent oil leakage
- 10 distributor tracks
- max. hydraulic operating pressure 250 bar
- max. pneumatic operating pressure 8 bar

2 sets of clamping bridge supports

- for mounting a clamping bridge, jigs or a 5-axis system,
- with a 10-way quick-connect coupling for hydraulics/pneumatics up to a maximum of 250 bar

2 sets of preparation for torsional compensation

- Preparation for the hydraulic compensation module for the 4th axis when using torsion-sensitive fixtures, as well as off-centre loads

Hydraulic Clamping Base Module

- Workpiece clamping via hydraulic valves, NG 6, double-acting clamping cylinders
- Pressure regulating valve, max. p=250 bar
- Throttle check valves in A and B
- Clamping pressure monitoring via electronic pressure sensor

- Clamping pressure is maintained in the event of a system failure via unlockable check valves
- To replace the clamping device, the unlockable check valves can be deactivated in groups via the PLC controller.
- 1 clamping circuit in working area 1
- 1 clamping circuit in working area 2
- Inputs and outputs in the PLC controller

2 x 3 Spannkreise additional members per working group

4 x 2-stage pressure changeover, hydraulic

Pneumatic pressure booster

Central coolant equipment

Scraper belt conveyor

(short, broken chips, needle-like chips, castings, casting swarf; no clumps, no mats)

- suitable for chip lengths < 100 mm
- Conveyor width 1000 mm
- Discharge height with hopper 1100 mm
- Waste water filter, slotted screen w = 0.35 mm
- Waste water pump 400 l/min
- Coolant capacity approx. 0.5 m³

1x emulsion mist separator

- Two-stage centrifuge
- Air flow rate 1200 m³/h

Automatic loading door

- open / close, door safety mechanism via contact strip

Tool and Planar System Inspection

Pneumatic tool and planar system inspection. The tool change and cleaning process is repeated three times if the tolerance limit is exceeded. The activation and selection of tolerance levels are tool-specific and carried out via the software HMI.

Position control, basic module

- Pneumatic control system for workpiece support or clamping elements
- Flow measurement
- With integrated free-blow function
- 2 pressure lines each for the A-side and U-side

