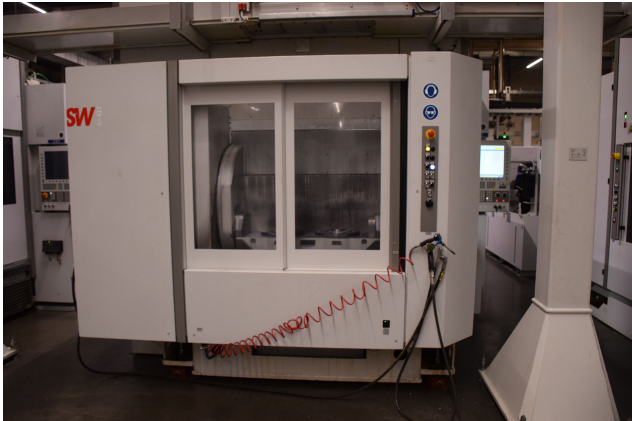


SW BA 422 5-axis twin-spindle machining centre BA2413, used



manufacturer : SW

Product number:
BA2413

Description

Machining center	Horizontal
Manufacturer	SW
Model	BA 422
Year of manufacture	2020
Working hours	approx. 52635 h
Spindle hours	approx. 29331 h

Technical data

- Control system: Siemens 840 D SL
- Version with 2 independent Z-axes
- Increase in 2x working spindle speed to 1-17,500 rpm

- Version with 2 independent Z-axes
- 2x clamping bridge supports
- High-pressure pump 70 bar
Pump upgrade to 70 bar / 49 l/min / 11 kW
including infinitely variable pressure control
controllable via the CNC programme
- Automatic flushing cycle for loading chamber
- for workpiece / clamping device in the loading chamber
- via M-Funktion and push-button operation
- Stand-alone cooler
Central cooling unit for coolant system
for cooling the emulsion,
for ambient temperatures <45°C
- Automatic loading door (I-shape),
loading chamber open at the top
- Position control, basic module
- Tool life monitoring and automatic selection of replacement tools
- Inductive tool breakage detection

h3>1. Travel ranges (axes)

- X-axis: 400 mm
- Y-axis: 500 mm (optionally extendable to 775 mm)
- Z-axis: 425 mm (with independent Z-axes for each spindle)

2. Spindle unit

- Number of spindles: 2 (arranged horizontally)
- Spindle spacing: 400 mm
- Tool holder: HSK-A63
- Spindle speed: Standard range 1 to 17,500 min⁻¹
- Power & torque: Depending on spindle type (e.g. up to 27 kW / 200 Nm or up to 45 kW / 125 Nm)

3. Dynamics & Feed Rate

- Rapid traverse (X / Y / Z): approx. 55 / 70 / 70 m/min (in some newer or different configurations, up to 100 m/min)
- Max. acceleration (X / Y / Z): approx. 8 / 8 / 12 m/s² (varies depending on generation and model)
- Feed force (X / Y / Z): 15,000 / 15,000 / 12,000 N

4. Tables & Pallets

- Table system: Swivelling rotary planetary tables (2 or 4 satellites with torque drives)
- Load capacity: 2 × 450 kg (per satellite/table)

5. Tool magazine

- Magazine type: Pick-up system, modularly expandable
- Tool positions: From 2 × 36 positions as standard (expandable to larger capacities such as 2 × 60 or more)
- Max. tool weight: 10 kg
- Max. tool diameter: 80 mm (or 160 mm if adjacent positions are free)
- Max. tool length: 300 mm

6. Automation

Knoll 800 K-1 scraper conveyor

- Suitable for chip lengths < 100 mm
- Conveyor width 800 mm
- Discharge height 1100 mm
- Waste water pump 400 l/min
- Coolant capacity approx. 0.3 m³

Knoll PW100/100 -710 compact band-pass filter

7. Dimensions & weight

- Machine weight: approx. 14,500 kg (up to 18,000 kg depending on peripherals and configuration)

Delivery time	immediately
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Price	on request
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