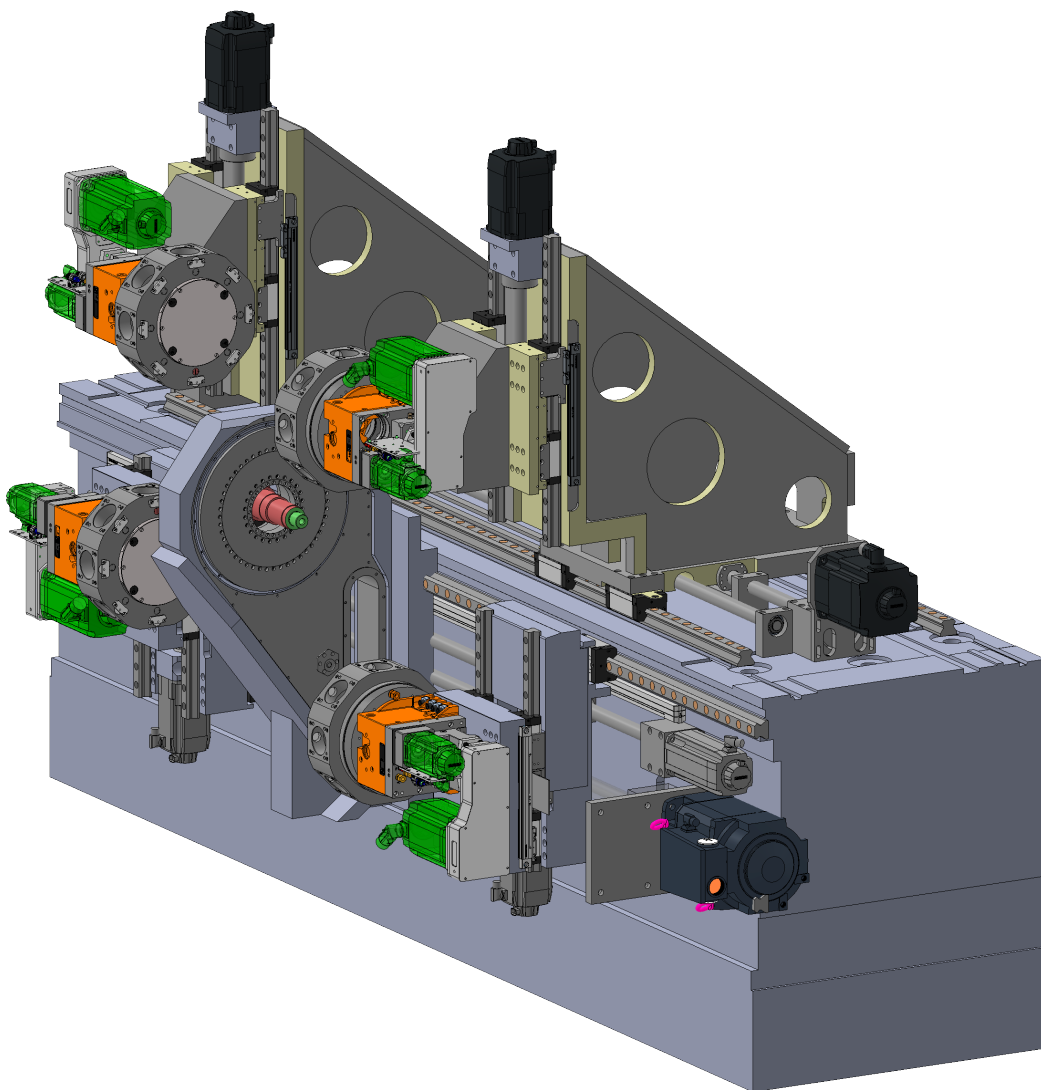




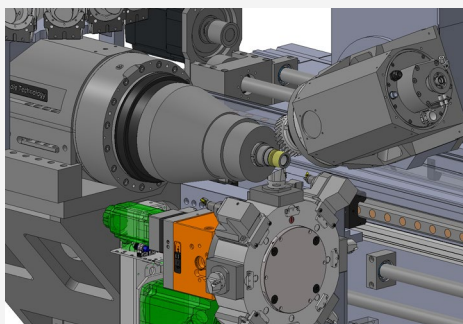
V300 CT

Center Drive Machine with 4 Turrets

The modular system of the V300 enables the realization of robust, rigid and precise machine variants with high availability.

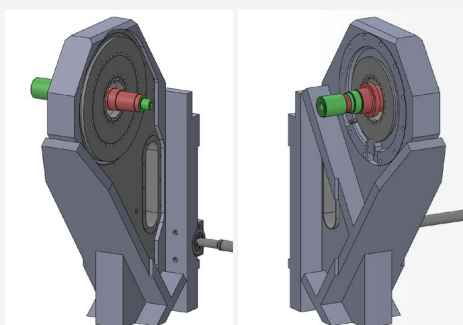


Highlights



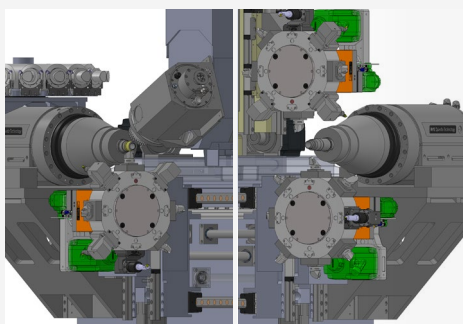
Turning, milling and gear cutting of shafts in one set-up

skiving and hobbing up to module 6 with the robust motorized milling spindle.



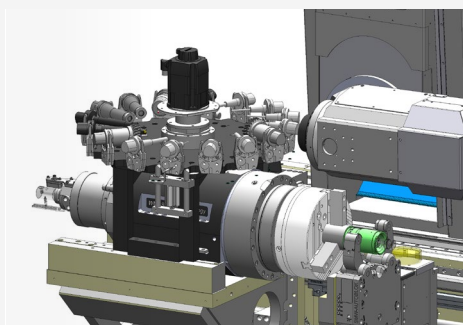
Center drive technology

highly efficient complete machining of shafts by simultaneous machining of both shaft ends by turning, milling and gear cutting



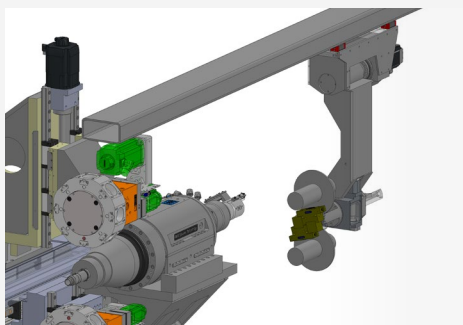
6-side machining

with robust and powerful motorized milling spindles and turrets on main and counter spindles



Automatic tool change in 7 sec.

by disc magazine at the work area - supported by background magazine if necessary



Integrated automation for fast workpiece change

Workpieces



E-rotor shaft	
Material	20 MnCr5
Workpiece dimensions	ø 58 × 303 mm
Processing time	05:55 min
Highlight	6-sided complete machining incl. gear cutting



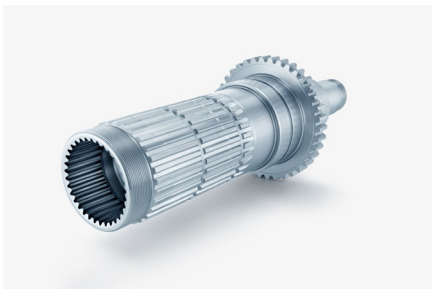
Gear shaft	



Truck transmission shaft	
Material	16MnCr5
Workpiece dimensions	ø 275 × 385 mm
Processing time	05:15 min
Highlight	Complete turning fully auto- matic



Truck transmission shaft	
Material	42CrMo4
Workpiece dimensions	ø 186 × 462 mm
Processing time	08:30 min
Highlight	6-sided complete machining incl. gear cutting



Truck transmission shaft	
Material	16MnCr5S
Workpiece dimensions	ø 125 × 500 mm
Processing time	03:00 min
Highlight	Complete turning machining in OP10 and OP 20

Technical Specifications

6-side workpiece machining in one chucking

2 ZX upper turrets with optional Y-axis and optional life tools

2 ZX lower turrets with optional life tools

Highly efficient machine to machine the ends of shaft in one chucking with highest accuracy

Machine dimensions

Length without (with) chip conveyor	[mm]	4500 (6550)	
Height	[mm]	2850	
Depth without (with) e-cabinet chiller	[mm]	2950 (3100)	
Weight	[kg]	21000	

Max. workpiece dimensions

Max. workpiece length	[mm]	800	
Max. Workpiece diameter	[mm]	100	

W1+W2: Upper ZYXB slide with milling spindle

Z1 Upper slide Z travel	[mm]	650	
Y1 Upper slide Y travel	[mm]	200	OPTION
X1 Upper slide X travel	[mm]	300	

W3+W4: Lower ZX turret slide

Z3 Lower slide Z travel	[mm]	525	
X3 Lower slide YX travel	[mm]	215	

Axis force / feed

Slides			
Max. acceleration	[m/s ²]	5	
Max. feed speed	m/min	30	
Continuous / max. feed force	[N]	7500 / 15000	

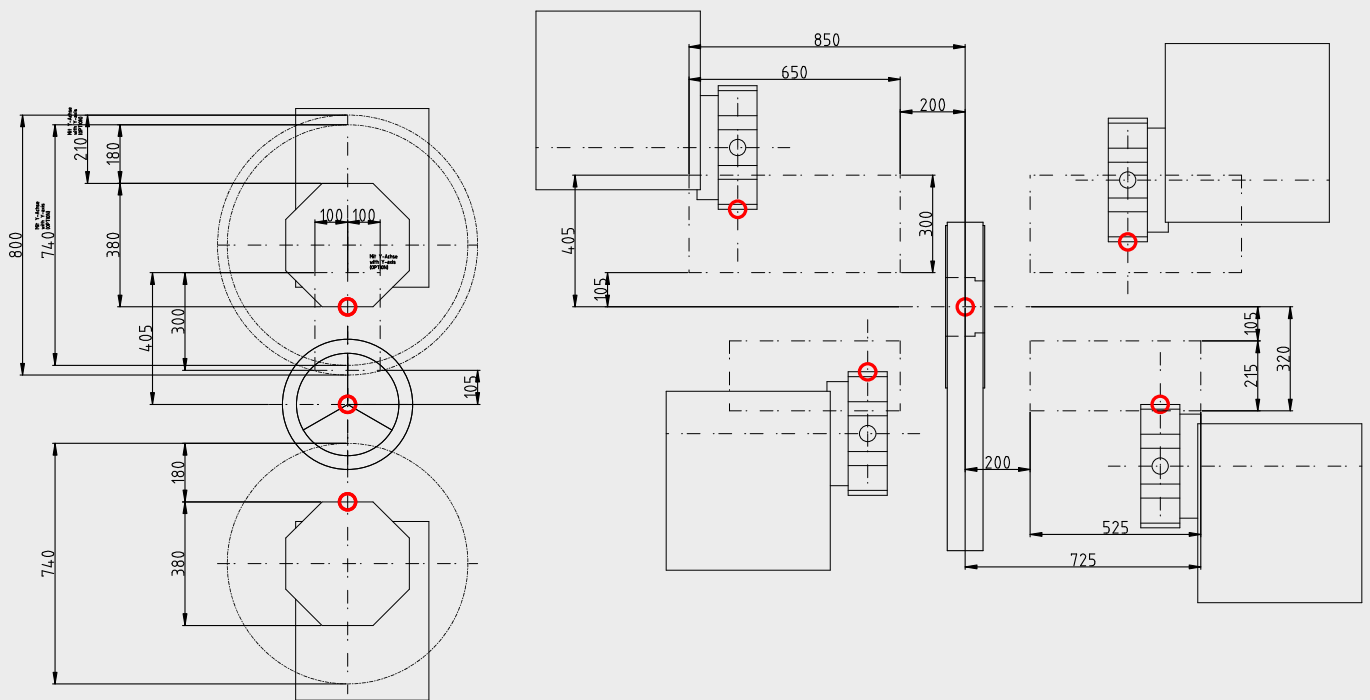
Center Drive with hydraulic clamping and unclamping by media coupling in standstill

Center Drive 1 (202D)	[1/min]	5000	
Bearing ID	[mm]	200	
Spindle inner diameter (to integrate chuck)	[mm]	180 / 160	
max. clamping diameter (depending on chuck)	[mm]	100	
Center drive width (=minimum workpiece length)	[mm]	120	
Continuous / max. torque	[Nm]	110 / 220	
Continuous / max. power	[kW]	30 / 30	

Center Drive 2 (1145)	[1/min]	3500	
Bearing ID	[mm]	240	
Spindle inner diameter (to integrate chuck)	[mm]	210 / 200	
max. clamping diameter (depending on chuck)	[mm]	140	
Center drive width (=minimum workpiece length)	[mm]	200	
Continuous / max. torque	[Nm]	290 / 400	
Continuous / max. power	[kW]	90 / 100	
Milling Spindles			
Milling spindle 202B, C8 (HSK100), grease lubrication	[1/min]	4500	
front bearing ID	[mm]	120	
continuous / max. torque	[Nm]	136 / 210	
continuous / max. power	[kW]	24 / 32	
clamping torque for turning / MultiTool-Operation	[Nm]	900	OPTION
Milling spindle AS180, HSK63/C6, oil-air-lubrication	[1/min]	20000	
front bearing ID	[mm]	80	
continuous / max. torque	[Nm]	85 / 130	
continuous / max. power	[kW]	25 / 35	
clamping torque for turning / MultiTool-Operation	[Nm]	600	OPTION
Spindles for inner / outer grinding available on request			
ATC			
Tool disc magazin			
no. of tools C8 / HSK63	[-]	16	
max. tool diameter / length (depends on the size of neighbour tools)	[mm]	120 / 300	
max. tool weight	[kg]	10	
Higher tool capacity by background ATC (on request)			
no. of tools HSK63 / C6	[-]	60 / 90 / 120	
no. of tools HSK100 / C8	[-]	24 / 48 / 72	
max. tool dimensions / weight		see above	
Turrets (examples)			
VDI 40 Turret			
no. of tools / interface	[-]	12 x VDI 40	
max. tool length upper / lower slide	[mm]	240 / 180	
continuous / max. torque	[Nm]	25 / 45	OPTION
continuous / max. power	[kW]	5 / 10	OPTION
tool drive max. rot. speed	[1/min]	4000	OPTION
VDI 50 Turret			
no. of tools / interface	[-]	12 x VDI 50	
max. tool length upper / lower slide	[mm]	240 / 180	
continuous / max. torque	[Nm]	28 / 55	OPTION
continuous / max. power	[kW]	6 / 12	OPTION
tool drive max. rot. speed	[1/min]	4000	OPTION
CDI-, CAPTO-Interfaces on request			

Work area

AXIS DIAGRAMM / WORKING AREA UPPER ZYXB SLIDES



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