

### TECHNICAL DATASHEET

#### CNC – Heavy Duty BED TYPE MILLING MACHINE

manufacturer	CORREA <b>ANAYAK</b>
type	<b>VH Plus-4000 HS</b>
control	<b>HEIDENHAIN iTNC 530</b>
built	<b>2008</b>



#### Travels

Longitudinal movement (X-axis)	4.000 mm
Lateral movement (Y-axis)	1.700 mm
Vertical movement (Z-axis)	1.500 mm

#### Clamping table

Clamping surface	4.200 x 1.100 mm
Max. work piece weight	10.000 kg
Number and size of T-slots	7 x 22 mm H12
Spacing of the T-slots	150 mm

### Feeds

X-, Y- and Z-axis, stepless	2 - 10.000	mm/min.
Rapid feed X / Y / Z	22.500	mm/min
Max. feed forces X-Y-Z axis	31.400	N

### Correa Universal-NC-Milling Head UAD

Swivelling front/rear plane	automatic	
Indexing	0,02 x 0,02 °	= 162 Mio. Positions!
Clamping force internal Hirth coupling	Approx. 22.000	kg
Motor power	30	kW
Max. torque	1.500	Nm
Number of gear steps	2	
Max. gear reduction	1:5,5	
Speed range, stepless	60 - 6.000	min-1 without time limit
Tool holder	SK50	DIN 69871
Pull stud		DIN 69872-A
Head lubrication	Air-oil mixture with separate automatic lubrication pump	
Cooling system for spindle bearings	yes	
Cooling system for gearbox	yes	

### Automatic Tool Changer ATC

Tool places	60	Plätze
Tool diam. max	125/200	mm
Tool length max..	400	mm
Tool weight max.	25	kg

### Guides, drive and measuring systems

- All axis drives with digital drives manufacturer HEIDENHAIN
- Direct measuring systems for X,Y, and Z axis manufacturer HEIDENHAIN
- X-, Y- and Z-axis guidance using high-precision linear guides for maximum precision and dynamics
- Precision ball screw with preloaded nuts in X-, Y- and Z-axis

### Coolant equipment with band filter

- Coolant exit at the front of the milling head
- Internal coolant supply, approx. 36 bar and 30 l/min
- Tank capacity approx. 350 l
- Coolant pump with delivery capacity approx. 20 l/min at 4 bar

### Chip conveyor

- 2 chip conveyors along the machine table
- ascending conveyor with coolant tank and lifting pump to the left of the machine, ejection at the rear, ejection height approx. 1,000 mm

### Measurement, weight

Floor space required	ca. 11,0 x 6,0	m
Machine height	ca. 4,6	m
Machine weight	ca. 30.000	kg

### cnc-control HEIDENHAIN iTNC 530

Digital numerical sequence control, including digital drive control, hard disk memory, 15" TFT colour screen

#### Machining cycles:

Standard drilling and milling cycles, deep drilling, thread cutting with and without compensating chuck, milling of slots, rectangular and circular pockets, rectangular and circular journals, boring, drilling milling (helical path), chamfering, drilling patterns, head swivelling, reverse countersinking, shifting and/or rotation of the coordinate system, mirroring, dimension factor also axis-specific,

Linear interpolation on 3 axes, circular interpolation on 2 axes and on 3 axes with rotated working plane, swivelling working plane, shell milling

**HR 410 - Electronic handwheel for operating all axes**

### Electrical supply data

Operating voltage	3 x 400	V
Operating frequency	50	Hz

### Equipment / Accessories

- Universal milling head UAD, 0.02x0.02°, positioning via internal Hirth serration
- Spindle speed max. 6,000 min<sup>-1</sup>
- Axis drives via precision ball screws and digital servo motors
- CNC control HEIDENHAIN iTNC 530
- Electronic handwheel HEIDENHAIN HR 410
- 3D touch probe m&h
- Swivelling control panel for machine operation in front of or behind the machine
- Automatic tool changer with 60 magazine positions
- Dual-circuit coolant system with belt filter and 350 liter capacity, 36 bar high-pressure pump and internal coolant supply through the spindle
- Three chip conveyors, including two chip conveyors in the work area
- Telescopic steel cover for the X-axis
- Vertical guide at the bottom covered with steel curtain
- Work area paneling closed on the sides.
- The manual sliding doors at the front of the machine can be opened along the entire length of the clamping table.
- Preparation of 4th axis for integrating a rotary table into the CNC control
- Additional rotary table Ø 1,250 mm for mounting on the machine table

- Lighting of the work area
- Paintwork RAL 7035 light grey / RAL 7016 anthracite

### Service package "RECONDITIONING" – Included additional services

- Comprehensive and thorough cleaning of the machine and all accessory components
- Technical assessment and inspection of the machine by our specialists
- Recognizable defects or defective parts found during the inspection are professionally repaired or replaced by our experienced service team
- Overhaul of the telescopic covers
- Replacement of scrapers
- Inspection and overhaul of the milling head including spindle bearings
- The eye-catcher for your production - New painting with high-quality and robust 2K machine paint protects the machine structure and guarantees an attractive appearance
- Don't buy a pig in a poke - function test under power in our showrooms before delivery

Machines that have undergone our "RECONDITIONING" service package can no longer be compared technically and visually with standard used machines on the market!