

**TECHNICAL DATASHEET**  
**CNC-BED MILLING MACHINE**

manufacturer	<b>SORALUCE</b>
type	<b>TA-35 A</b>
control	<b>HEIDENHAIN iTNC 530</b>
built	<b>2012</b>



**Travels**

X-axis (longitudinal)	3.500 mm
Y-axis (vertical)	1.250 mm
Z-axis (cross)	1.200 mm

**Clamping table**

Clamping surface	3.700 x 1.000 mm
Max. workpiece weight	2.500 kg/m <sup>2</sup>
Width of t-slots	7 x 24 mm H12
Distance between t-slots	140 mm

**Feeds**

Working feed X-, Y- and Z-axis	10.000 mm/min.
Rapid feed X / Y / Z	25.000 mm/min

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Max. thrust of shaft to cutting unit 10.000 N

### Universal Milling Head

Swiveling area vertical/diagonal level	2,5 x 2,5 °	144 x 144 positions
Power on 100% ED	32 kW	
Speed, stepless	15-3.000 Min-1	
Tool taper	SK 50 – DIN 69871-AD	

### Automatic Tool Changer ATC

Tool places	20 Places
Tool diam. max.	125/200 mm
Tool length max.	250 mm
Tool weight max.	15 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 recirculating roller bearing and guideway assemblies for maximum precision and dynamics
- Precision ball screw with preloaded nuts in X-, Y- and Z-axis

### Coolant supply system and chip conveyor

- Coolant outlet at the front side of the milling head via manually swiveling nozzles
- Internal coolant supply
- Tank volume approx. 500 l
- Normal coolant supply 50 l/min at 5 bar
- High pressure pump for internal cooling 20 l/min at 20 bar
- Coolant tank incl. paper belt filter
- Hinged belt chip conveyor along the X - axis of the machine

### CNC-Control HEIDENHAIN iTNC 530

Digital numerical sequence control, including digital drive control, hard disk memory, 15" TFT - color screen.

#### Machining cycles:

Standard drilling and milling cycles, deep drilling, tapping with and without compensation chuck, milling of slots, rectangular and circular pockets, rectangular and circular studs, boring, drilling milling (helical path), line-off, drilling patterns, head tilting, backward tilting, shifting and/or rotation of the coordinate system, mirroring, dimensional factor also axis specific, Linear interpolation on 3 axes, circular interpolation on 2 axes and on 3 axes with rotated working plane, tilt working plane

### HR 410 - Electronic handwheel for operation of all axes

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### Measurement, weight

Machine space required	ca. 10,4 x 4,8	m
Machine height	ca. 4,20	m
Machine weight	ca. 21.500	kg

### Electrical supply data

Installation power	49	kW
Nominal current	88	A
Operating voltage	400	V
Cable section	35	mm <sup>2</sup>
Operating frequency	50	Hz

### Equipment & Accessories

- Universal milling head, positioning via Hirth coupling, diagonal level 2.5°, vertical level 2.5°  
*\*Head is refurbished in 2022 by the manufacturer\**
- Spindle speed max. 3.000 min-1
- Axis drives by means of precision ball screws and digital servo motors
- CNC control HEIDENHAIN iTNC 530
- Electronic handwheel HEIDENHAIN HR 410
- Swiveling operating panel for machine operation in front or back of the machine
- Automatic tool changer with 20 magazine positions
- Coolant tank with 500l capacity, paper band filtration system and two coolant circles:  
50 l/min at 5bar for external cooling  
20l/min at 15 bar for internal cooling
- Chip conveyor in the working area, ejection right, height ca. 1.000mm
- Precision ball screws in all axes
- Telescopic steel cover of the X-axis
- Vertical guide covered at the bottom with steel curtain
- Working area enclosure 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.
- hydraulic system
- work area lighting
- Painting RAL 7035 light grey / RAL 5011 steel blue