

TECHNICAL DATASHEET

CNC–Lateral-Milling- and Boring-Center

manufacturer	SORALUCE
type	FP 6000
control	HEIDENHAIN iTNC 530
built	2008



Travels

X-axis (longitudinal)	6.000 mm
Y-axis (vertical)	2.100 mm
Z-axis (lateral)	1.300 mm

Floor Plate

dimension	7.000 x 2.500 mm	Width 300 mm
T-slot size	28 H 12 mm	
Distance between T-slots	250 mm	

Feeds

X-, Y- and Z-axis, stepless	5 - 12.000	mm/min.
Max. feed power X-, Y- and Z-axis	11.000	N
Rapid feed in X / Y / Z	35	m/min

Working spindle with automatic milling head

AC-main drive with ZF gear box		
power 100% ED	30	kW
Gear steps	2	
Speed, stepless	20 – 4.000	1/min
Max. torque	1.140	Nm
Tool taper	SK 50 – DIN 69871 Form AD	
Clamping bolt	DIN 69872 Form A	
Spindle diam. in front bearing	90	mm 5-fold bearing
Milling head tilting in both levels	2,5	° 144 pos. each level
Auto. Tool clamping	20.000	N Clamping force

Automatic Tool Changer ATC

Tool places in magazine	30	Places
Changing positions	Vertical + horizotal	
Tool diam. max.	250 / 125	mm Neighbour places free /occupied
Tool length max.	400	mm
Tool weight max.	20	kg

CNC-control

HEIDENHAIN, iTNC 530

Combined with digital drive control, hard disk storage, 15" TFT – color screen, 6 GB hard disc, external machine control panel, standard drilling and milling cycles, threading without compensation chuck, linear interpolation, circular interpolation, processing level swivel, helical curve etc. HEIDENHAIN tool management for managing tools and tool magazine, electronical handwheel HR 410, USB-interface, diagnostic system, Various milling-cycles

Chip conveyor

- Installed between machine and floor plate
- Ejection right or left
- Discharge high ca. 1.250 mm
- Integrated coolant tank with lifting pump

Guides, drive and measuring system

- All axis drives with digital servomotors
- Direct measuring system for X-, Y- and Z-axis
- X-, Y- and Z-axis with INA high-precision linear guides for maximum precision and dynamics
- Steel covers of the X-axis
- Pinion and rack drive in X-axis with "Master/Slave" system
- Precision ball screws in Y- and Z-axis

Coolant equipment

- Cooling through spindle including paper band filter
- Clean water tank ca. 1.000 l,
- Normal coolant supply 50 l/min 5 bar
- High pressure pump 8 bar
- Internal coolant through spindle centre taper DIN 69871 Form AD
- Clamping bolt DIN 69872 Form A

Measurement, weight

Floor space incl. floor plates	ca. 11,8 x 6,3	m
Machine height	ca. 5,1	m
Machine weight	ca. 30.000	kg

Electrical supply data

Total connected load	50	kVA
Operating voltage	400	V
Operating frequency	50	Hz

equipment

- Autom. Milling head 2,5° positioning
- ZF gear-box 2-fold
- Cooling unit for ZF gear-box
- 3-D-Compensation for thermal extension of the milling unit
- Spindle drive 30 kW, SIEMENS
- X-, Y- and Z-axis with INA high-precision linear guides
- Direct measuring system for X-, Y- and Z-axis
- Pinion and rack drive in X-axis with "Master/Slave" system
- Precision ball screws in Y- and Z-axis
- Floor plate 7.000 x 2.500 mm
- Radio touch probe manufacturer M&H-20.00 incl. autom. measuring cycles
- CNC-Control HEIDENHAIN iTNC 530 with digital drive control
- Electronical handwheel HR 410
- Autom. Tool changer
- Moveable, closed working area for the operator
- Coolant equipment with external coolant circuits and internal coolant through spindle
- Chip conveyor
- Working hours: Main switch ON: 31.350h, Machine ON: 27.785 h, Operating: 10.945 h

ADDITIONAL OPTIONS

NC-Rotary-Table FIBRO

Positioning	360.000 °	NC-Axis
Clamping table size	1.600 x 1.600 mm	
Max. work piece weight	10.000 kg	
Weight of the table	3.800 kg	

Clamping Cube with magnetic clamping plate

Quantity	3 Pcs	
Dimension Clamping Cube	800 x 800 mm	
Dimension magnetic clamping plate	490 x 360 mm	„BRISC“, Type PSP-B
Magnetic force	100 kN	
Incl. Auto-Shim Pole Extension Set		

Horizontal Milling Extension

Diameter	200 mm
Length	480 mm
Max. Power	30/37 kW
Max. speed	4.000 min-1
Additional Angle Milling Head	HENNINGER

Tool Holder Equipment

Numerous equipment of tool holders and milling and boring tools.
Value when new ca. EURO 80.000,--