

**Used Production line with 2x 5-axis vertical machining centre and 1 level, 14 pallets pallettech system**

**Machine 1:**

**Make: Mazak**  
**Modell: Variaxis 500-5x incl. Pallettech**  
**Machine Number: 164499**  
**Build in: 5-2003**  
**CNC Control: Mazatrol PC-Fusion-CNC 640 5X**

**Technical specifications MACHINE :**

Pallet size		400 x 400 mm
Table load		300 kg
Table working height		800 mm
X-Axis travel		510 mm
Y-Axis travel		510 mm
Z-Axis travel		460 mm
Min./max. centre to pallet surface	(Table Horizontal)	190-650 mm
Min./max. spindle nose to pallet centre	(Table Vertical)	140-600 mm
A Axis travel		-120 - +30 °
C Axis travel		+ / - 360 °
Maximum workpiece dimensions	diameter x height	ø 500 x 405 mm
Swivel Index (A-Axis)		0,001
Time needed for A-Axis index 90°		1,9 sec
Table Index (C-Axis)	NC Table	0,001 °
Time needed for C- Axis index 90° / 180°		1,5 / 2,1 sec
Pallet change time		sec.
Maximum cutting feedrates X-, Y- en Z-Axis		50000 mm/min
Rapid traverse X-,Y- en Z-Axis		50 m/min
Index speed table		tr/min.
Number of tool stored in magazine		30
Tool change time (tool to tool)		sec.
Tool change time (Chip to chip)		4,5 sec.
Maximum tool diameter with adjacent tool		80 mm
Maximum tool diameter without adjacent tool		125 mm
Maximum tool length		300 mm
Maximum tool weight		8 kg
Spindle speed		35-12000 tr/min.
Spindle tool taper		DIN 69871A
Spindle motor	30 min/contineous rating	22/15 kW
Maximum torque on spindle		99 Nm
Required floorspace	lenght x width	2805 x 2885 mm
Machine height		2800 mm

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 BIC : ABNANL2A  
 IBAN : NL13ABNA0440186617

BTW nr. NL006566157B01  
 KvK Breda nr. 20031737

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**Equiped with:**

Spindle speed 45-12.000 RPM with High torque 196 Nm  
 Toolmagazine with 120 positions  
 Machine prepared with 70 Bar coolant through, Knoll type  
 ARO Beltfiltration unit Type P1000/2000 E2 with tank 1500 Ltr  
 - 1 electr. Cabinet for 3 machine pumps and 1 level pump  
 - 1 High pressure pump BS 238/40 2,6 Kw 18 l / 40 bar  
 - 1 Pump high quantaty TE 145/500 2,2 Kw 100 l / 5 bar  
 - 1 Pump TC 63/560 1,7 Kw 65 E90l / 5 bar  
 - 1 Levelingspump TL 410/140  
 EIA/ISO Macro for Tool Break Registration (TBR) and and  
 Auto Centering (MMS)  
 Mazak Monitoring B (MP10, Optic) including Probe  
 2 Palletcharger  
 Chipconveyor Hinge type Rear right side  
 Auto Pecking cycles wit load detection  
 Circulair interpolation  
 PCMCIA Card64 MB-II  
 Performance CNC Option Package  
 - Additoinal variables (600 sets)  
 - Mazak Tapping /Boring Tornado (EIA)  
 - Synchronous Tapping  
 - EIA/ISO code input function  
 - Additional EIA/ISO  
     Spiral interpolation (G02.1, G03.1)  
     Scaling (G50, G51)  
     Correctuur of 3 D tool (G40-G42)  
     EAI/ISO Constant feedrate (G93)  
     EIA/ISO Tool Length Measurement (G37)  
     EIA/ISO Sequense number comperison stop  
     Mazacc 2-D (Mazatrol & EIA/ISO)  
         High Accuracy Machining with high speed feedrates,  
         Acceleration/decelaration before interpolation, active  
         feed, optimum corner deceleration and fine vector  
         interpolation  
     Additional workpiece coordinatesG 54.1 P1-48) 48 setz  
     Treasing function (G 33)

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**Machine 2:**

**Make:** Mazak  
**Modell:** Variaxis 500-5x incl. Pallettech  
**Machine Number:** 180794  
**Build in:** 2005-10  
**CNC Control:** Mazatrol PC-Fusion-CNC 640 5X

**Technical specifications MACHINE :**

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Table working height		800 mm
X-Axis travel		510 mm
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A Axis travel		-120 - +30 °
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Maximum tool length		300 mm
Maximum tool weight		8 kg
Spindle speed		35-12000 tr/min.
Spindle tool taper		DIN 69871A
Spindle motor	30 min/contineous rating	22/15 kW
Maximum torque on spindle		99 Nm
Required floorspace	lenght x width	2805 x 2885 mm
Machine height		2800 mm
Machine weigt		13500 kg

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**Equiped with:**

Spindle speed 45-12.000 RPM with High torque 196 Nm  
 Toolmagazine with 120 positions  
 Niagara Coolant  
 Machine prepared with 70 Bar coolant through, Knoll type  
 Chipconveyor Mayfran Consep 2000 Hinge type Rear right side  
 incl. Integrated Filterturret Filtration 25 mu  
 Clean water tank 800 liter  
 Economy High pressure package 1 step, including Mebram pump  
 20 l/min at 70 Bar, overpressure safty valve  
 Dynamic compensation type 2 (EIA/ISO)  
 EIA/ISO Macro for Tool Break Registration (TBR) and and  
 Auto Centering (MMS)  
 Mazak Monitoring B (MP10, Optic) including Probe  
 2 Palletcharger  
 Chipconveyor Mayfran Consep 2000 Hinge type Rear right side  
 incl. Integrated Filterturret Filtration 25 mu  
 Auto Pecking cycles wit load detection  
 Circulair interpolation  
 PCMCIA Card64 MB-II  
 Performance CNC Option Package  
 - Additoinal variables (600 sets)  
 - Mazak Tapping /Boring Tornado (EIA)  
 - Synchronous Tapping  
 - EIA/ISO code input function  
 - Additional EIA/ISO  
 Spiral interpolation (G02.1, G03.1)  
 Scaling (G50, G51)  
 Correctuur of 3 D tool (G40-G42)  
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**Palletech System controlled by Mazatrol machine Nr 1 control**

Systemconfiguration:	2003
Number of Pallets	6
Loading robot	1
Loading station	1
Extension with second machine	2005
Additional pallets	8