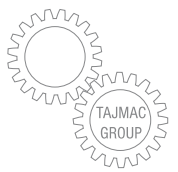




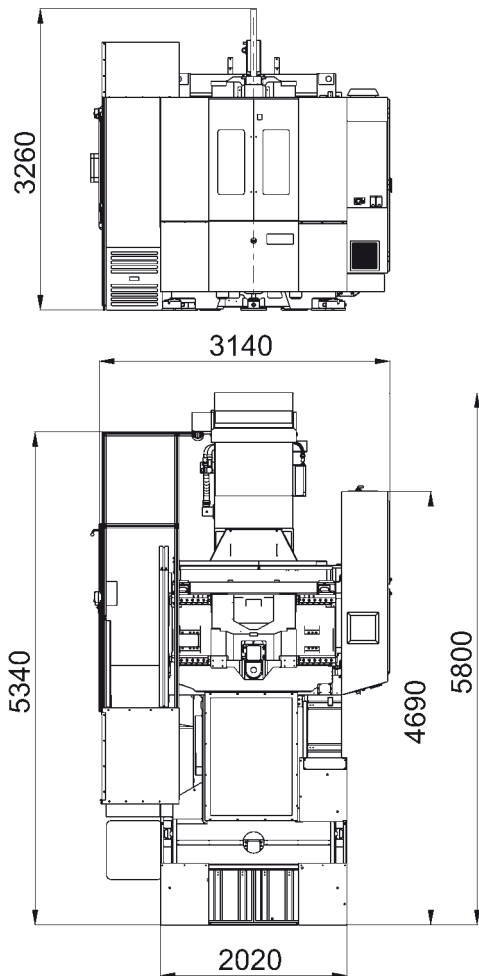
- Highly productive machine
- High dynamic and thermal stability
- High accuracy at machining
- Linear guideways in all axes
- Direct measuring in all axes
- Flexibility of usage of spindle units
- Very quick positioning of pallet
- Machining in 4 – 5 axes
- Utilization of HSC technology
- Very ecological operation
- Ergonomical solution of machine
- Ecologically friendly

H 630

SPECIFICATIONS



The **H 630** is a horizontal milling centre equipped with pallet changer with two pallets and with tool magazine with automatic tool changing. The machine is determined to a productive complex machining of moulds, dies and components of flat or box shapes from steel, grey cast iron and light metal alloys clamped on the operating pallet. It enables to perform the milling operations in three mutually perpendicular coordinate axes (X, Y, Z). The rotary table (B-axis) enables the machining from more sides.



Working travels

X, Y, Z axes	750 × 700 × 770 mm
B-axis – table positioning	360 °

Working table – pallet

Pallet size	630 × 630 mm
Pallet load	800 kg
Workpiece max. dimensions – dia. × height	750 × 800 mm
Height of pallet working surface above floor	1 100 mm
Min. distance of spindle nose to table axis	130 mm
Min. distance of spindle nose to table surface	50 mm
Deviation of height of pallet	0.01 mm
Deviation of pallet position in X, Z plane	0.01 mm
Max. torque of B-axis	2 165 Nm

Feeds

Working feed / rapid traverse in X, Y, Z axes	50/50 m/min
Acceleration in X, Y, Z axes	5 m/sec ²

Spindle

Clamping taper	HSK-A63	ISO 50	HSK-A100
Maximum speed	18 000 rpm*	8 000 rpm	14 000 rpm*
Transmission type	planetary gearbox	electrospindle	
Power output S1/S6 – 40 %	25/31 kW	20/30 kW	25/37 kW
Torque S1/S6 – 40 %	159/197 Nm	306/458 Nm	159/236 Nm

Accuracy (VDI/DGQ 3441)

Measuring system in X, Y, Z, B axes	direct
Positioning accuracy (P) of X, Y, Z axes	0.008 mm
Positioning accuracy (P) of B-axis	6 arc sec
Repeatability (P _{smax}) of X, Y, Z axes	0.005 mm
Repeatability (P _{smax}) B-axis	3 arc sec

Tool magazine

Number of tool pots	56
Tool in magazine maximum diameter:	
– at adjacent tool pots occupied	125 mm
– at adjacent tool pots not occupied	250 mm
Tool maximum length	450 mm
Tool maximum weight	25 kg
Max. load of magazine	600 kg
Tool interchange time	3.1 sec

Automatic pallet changer

Number of pallets	2
Pallet interchange time	10 sec

Pneumatic unit

Air pressure at inlet	0.6 – 0.8 MPa
Operational pressure	0.55 MPa

Electric power requirements

Connection voltage	3 × 400 V/50 Hz
Operational power input	35 kVA
Current at machine full working load	86 A

Complementary data

Machine weight (including tool magazine)	17 000 kg
Control system	SINUMERIK, HEIDENHAIN*

STANDARD VERSION

- SIEMENS digital drives
- Direct measuring
- Planetary two-speed range gearbox
- SK 50 clamping taper
- Automatic pallet changer
- 2 pallets 630 × 630 mm
- Automatic tool changer – 56 tool pots
- Coolant unit with tool cooling system
- Tool holder automatic air blasting
- Chip conveyor
- Worm gear drive of rotary table (B-axis)

OPTIONAL EQUIPMENT*

- Tool cooling with coolant through spindle axis
- Tool cooling with air through spindle axis
- Coolant unit with filtration unit for tool cooling through spindle axis
- Tool cooling with oil mist
- Automatic tool changer with capacity of 76 or 244 tools
- Workpiece dimension checking probe
- Tool dimension checking probe
- Work zone washing-off
- Work zone manual washing-off
- Other type of chip conveyor
- Chip bucket (300 kg)
- Vapour exhaustion from work zone
- Machine 5-axis version
- Rotary table with torque motor
- Spindle for BIG-PLUS tools
- Remote diagnostics

Descriptions of illustrations and specifications may not always correspond with the machine latest version.

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