

4. Technical information SB6

Ram force	300 kN
Number of tool stations in turret	30 pcs
Max. punch diameter	89 mm
Max. material thickness, punching	3.5 mm
CNC Index Tool:	
Number of Index Tool stations, max.	15 pcs
Punch diameter, max	89 mm
Tool rotation, max.	167 r/min
Integrated Right Angle Shear:	
Material thickness, max. (shearing)	
aluminium	3.5 mm
steel Fe52 / Fe37	3.5 mm
stainless steel	2.5 mm
Material thickness, min.	0.5 mm
Full stroke shear, X x Y mm	1000 x 1528 mm
X-blade	1005 mm
Y-blade	1532 mm
Blade clearance setting	automatic (ACS)
Max. blank weight ⁽¹⁾	130 kg
Clamps pneumatic	4 pcs
Max. sheet size	1528 mm x 3061 mm
X-traverse	6370 mm (X-825 ... X 5545)
Y-traverse	1586 mm (Y-25,5 ...Y 1560,5)
Axis speed (X-axis)	max. 180 m/min
Axis speed (Y-axis)	max. 140 m/min
Positioning speed	max. 228 m/min
Hit speed max. ⁽²⁾	
1.0 mm between holes	1100 1/min
25 mm between holes	520 1/min
250 mm between holes	220 1/min
Punching accuracy according to LKP-7100: ⁽³⁾	
Hole location deviation (X/Y axes), max.	0.1 mm
Hole-to-hole distance deviation (X/Y axes), max.	± 0.05 mm
Angular deviation (CNC Index Tool), max.	± 0.1°
Positioning accuracy according to VDI/DGQ 3441: ⁽⁴⁾	
Positional deviation Pa (X/Y axes)	0.02 mm (± 0.01 mm)
Positional scatter Ps (X/Y axes)	0.015 mm (± 0.008 mm)
Turret rotation	23,8 r/min
Tool change time	0.5 ... 3.5 s
CNC control	Siemens Sinumerik 840D
Program memory	2000 MB
Machine weight	39 000 kg
Electric cabinet weight	800 kg
Hydraulic unit weight empty	750 kg
Oil tank volume	330 l
Power supply	max. 55 kVA
	avarage 35 kVA
Compressed air consumption, max.	9 NI/s
Compressed air pressure, min.	6 bar
Oil cooler, cooling cap. max.	30 kW
Oil cooler air flow	2,9 m ³ /s

Notes

- 1) Acceleration/deceleration rate of X and Y axes dependent on sheet weight.
- 2) Hit speed is dependent on the programmed stroke length, ram speed and acceleration/deceleration rate and speed of the axes.
- 3) Punching accuracy is tested according to the Finn-Power standard LKP-7100 by punching holes in a 1 m x 1 m sheet with 100 % speeds and by measuring the location (X/Y) and angle (CNC Index Tool) of the punched holes from the sheet.
- 4) Positioning accuracy is measured according to the VDI/DGQ 3441 standard, using a laser-interferometer measurement system, from the X- and Y-slides of the coordinate table of the machine.

We reserve the right to change technical specifications without prior notice.