



- High accuracy during bulk and serial production
- High temperature stability
- Rigidity comparable to cam-machines
- 8 independent AC spindle drive units
- 32 controlled CNC axes in total
- 24 auxiliary CNC axes for special equipment control
- 2 control CNC systems SINUMERIK 840D solution line
- Own technological software TMis
- Great selection and flexibility of fast exchangeable tool holders
- Auxiliary functions controlled by hydraulic or pneumatic means
- Compliance with EU Council Directive 89/392 EEC

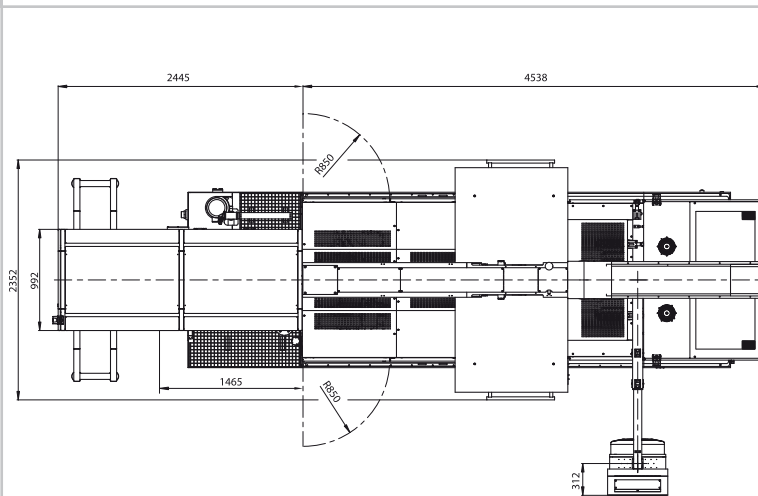
TECHNICAL DATA

STANDARD MODEL

- Reinforcement of the spindles drum with three rims with frontal toothing
- 8 spindle motors
- 8 longitudinal slides
- 7 cross slides (power slides in working pos. 1 & 2, axes X1 & X2)
- 1 cut-off slide
- 1 spindles drum indexing axis, fastening and feed of material
- 2 control CNC systems SINUMERIK 840D solution line
- 32 control and 24 auxiliary CNC axes for special equipment control
- Motors and drive units with stepless speed control SINAMICS by SIEMENS
- Material clamping and stop in working pos. 1

OPTIONAL EQUIPMENT

- Pick-up spindle with CNC controlled speed and collet fixing with hydraulic control
- Other auxiliary equipment for longitudinal machining
- Auxiliary equipment for profile openings
- Slide for machining from cut-off side (1st tool holder)
- Y-axis for cross slides in working pos. 3, 4, 5, 6, 7
- Tool for radial and axial drilling and milling operations from the cut-off side
- Driven tools with CNC controlled speed
- Material feed at 1st operating position
- Material clamping and stop at 5th operating position
- Material feed at 5th operating position
- Pneumatic parts-catching attachment
- Great selection of chip conveyor systems
- Great selection of high-pressure tool cooling systems
- Great selection of equipment for drilling, reaming, milling, extrusion, thread cutting and machining of polygons
- Complete machinery adjustment and acceptance of the machine at TAJMAC-ZPS premises



CNC OPTIONS

Slide for machining from cut-off side with 1 tool holder (X8 axis)

| | | max. |
|-------------------------|-------|-------|
| Fast traverse | m/min | 15 |
| Radial elevation | mm | 90 |
| Force | N | 3 000 |
| Ball screw thread pitch | mm | 5 |

Slide for machining from cut-off side with 3-tool holder (X8, Y8 axis)

| | | max. |
|---|-------|-------|
| Fast traverse | m/min | 15 |
| Radial elevation (X) | mm | 95 |
| Force | N | 2 900 |
| Radial elevation (Y) | mm | 110 |
| Quantity of toolholders (solid or rotating) | | 3 |

Drives for longitudinal rotary equipment (axes S01 to S08)

| | | max. |
|--------|-----|-------|
| Speed | rpm | 6 000 |
| Torque | Nm | 20 |

Drive units for driven tools (axes ST01 to ST08)

| | | max. |
|--------------------|-----|--------|
| Quantity available | | 8 |
| Speed | rpm | 12 000 |
| Standard torque | Nm | 22 |

Drives for machining of inner profiles (axes U1 to U7)

| | | |
|-------------------|-------|--------|
| Working positions | | 1 to 7 |
| Fast traverse | m/min | 30 |
| Force | N | 2 500 |
| Radial elevation | mm | 340 |

Machining of polygons and thread cutting

| | | |
|--------|-----|-------|
| Speed | rpm | 4 500 |
| Torque | Nm | 11 |

Systems of fast tool-changing

| | |
|------------|----------|
| CAPTO | C3, C4 |
| KENNAMETAL | K32, K40 |

SK52 BZI collet bar diameter

| | | min. | max. |
|---|----|------|------|
| With automatic feeder and bar end finishing | mm | | Ø 52 |
| With automatic feeder without bar end finishing | mm | | Ø 48 |
| With magazine | mm | Ø 11 | Ø 42 |
| Material feed length (with magazine) | mm | | 180 |

DIN 9112 E collet bar diameter

| | | min. | max. |
|---|----|------|------|
| With automatic feeder and bar end finishing | mm | | Ø 49 |
| With automatic feeder without bar end finishing | mm | | Ø 45 |
| With magazine | mm | Ø 10 | Ø 42 |
| Material feed length (with magazine) | mm | | 180 |

Bar dimensions

| | | min. | max. |
|--------------|----|------|---------|
| Bar diameter | mm | | 42 (52) |
| Bar length | m | | 3 (4) |

Spindles (axes S1 to S8)

| | | nominal | max. |
|---------------------------------|-----|---------|-------|
| Spindle pitch diameter | mm | | 480 |
| Speed | rpm | | 4 500 |
| Spindle motor performance | kW | 7 | 11 |
| Total spindle motor performance | kW | 56 | 88 |
| Spindle torque (at 1,000 rpm) | Nm | | 66 |

Drum indexing (CMI axis)

| | | | |
|-----------------------------------|---|--|---|
| Time to index by 1 position (45°) | s | | 1 |
|-----------------------------------|---|--|---|

Longitudinal slides (axes W1 to W7 and Z8)

| | | | max. |
|-------------------------|-------|--|-------|
| Quantity | | | 8 |
| Fast traverse | m/min | | 30 |
| Force | N | | 3 400 |
| Thrust | mm | | 425 |
| Ball screw thread pitch | mm | | 10 |

Cross slides (axes X1 to X7 and Z1 to Z7)

| | | | max. |
|-----------------------------------|-------|--|--------|
| Quantity | | | 7 |
| Fast traverse (radial X, axial Z) | m/min | | 15, 30 |
| Axial thrust (axes Z1 to Z7) | mm | | 200 |
| Axial force (axes Z1 to Z7) | N | | 3 600 |
| Radial thrust (axes X1 to X7) | mm | | 80 |
| Radial force (axes X1 to X7) | N | | 3 200 |
| Thread pitch | mm | | 5, 10 |

Cut-off slide (U8 axis)

| | | | max. |
|-------------------------|-------|--|-------|
| Fast traverse | m/min | | 15 |
| Force | N | | 3 000 |
| Thrust | mm | | 70 |
| Ball screw thread pitch | mm | | 5 |

Machine dimensions

| | | |
|-----------------------------|--------|-----------------------|
| Length × width × height | mm | 4 538 × 2 352 × 3 238 |
| Machine weight | kg | 16 600 |
| Electric cabinet weight | kg | 2 400 |
| Electric cabinet dimensions | mm | 5 000 × 600 × 2 268 |
| Coolant volume | litres | 1 400 |

Description, illustrations and numerical data may not always correspond with the machine latest version.

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