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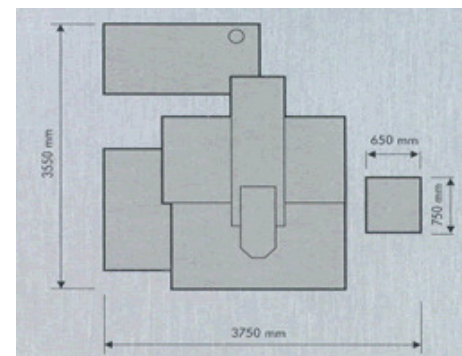
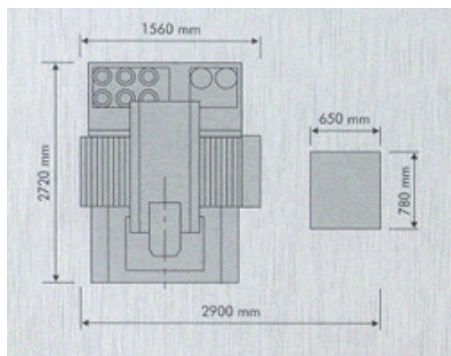
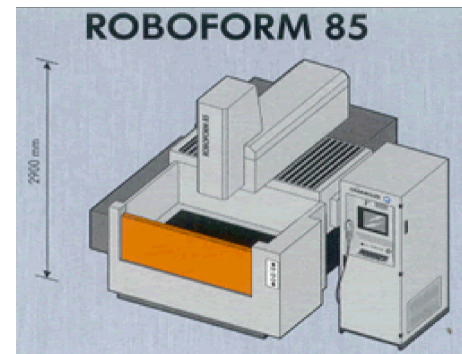
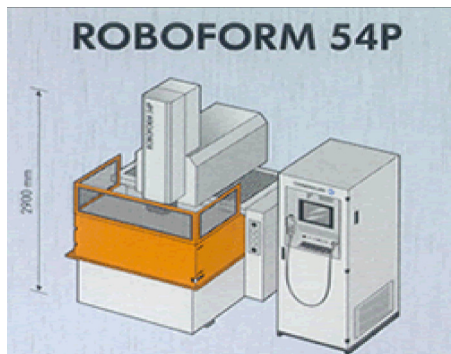
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ROBOFORM 35P, 54P, 55P, 85



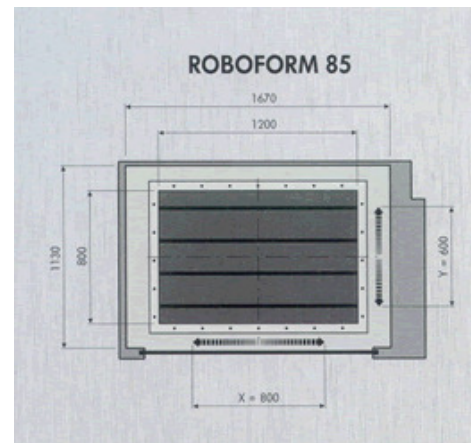
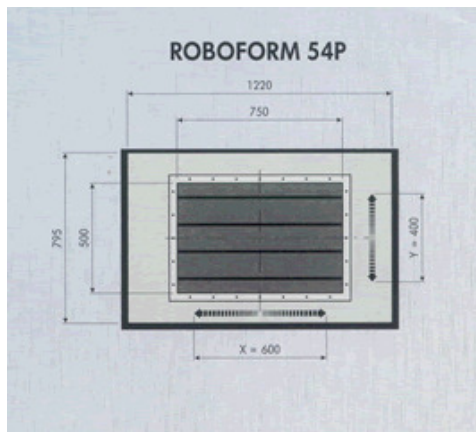
Technical Specifications

Technical Specifications



Machine		ROBOFORM 54P	ROBOFORM 85
Architecture		Short C-frame, with fixed table	Short C-frame, with fixed table
Dimensions of the ce equipment (width x depth x height)	mm	2960 x 2720 x 2900	3750 x 3550 x 2900
Total weight of the equipment (without dielectric)	kg	3600	5000
"Machines, safety and health" directive		89 / 392 / EEC	89 / 392 / EEC
"Electromagnetic compatibility" directive		89 / 336 / EEC	89 / 336 / EEC
X, Y, Z and UV axes			
X, Y, Z travel	mm	600 x 400 x 450	800 x 600 x 500
System for measurement of movements		Linear glass scales	Linear glass scales
X, Y, Z measurement resolution	µm	0.5	0.5
Work area			
Type of tank		Fixed tank with 2 doors	Automatic drop tank
Dimension of tank (width x depth x height)	mm	1220 x 795 x 465	1670 x 1130 x 600
Dielectric level min / max	mm	135 / 425	275 / 470
Dimension of table (width x depth)	mm	750 x 500	1200 x 800
Dimension of grooves (number)	mm	12 (4)	12 (8)
Electrode and workpiece			
Max electrode weight	kg	100	350
Max workpiece weight	kg	1600	4200
Max workpiece dimension	mm	1200 x 775 x 385	1600 x 1100 x 430
Min / max distance between chuck and table	mm	150 / 600	230 / 730

Dielectric system			
Type of filter		6 paper cartridges	8 paper cartridges
Volume of reservoir	l	725	1600
Modules			
C axis			
Max inertia of electrode	kg cm ²	2000	2000
Measurement resolution	°	0.001	0.001
Electrode weight	kg	50	50
Spindle chuck			
System 3D		MACRO / Combi	MACRO / Combi
EROWA		ITS / Combi	ITS / Combi
HIRSCHMANN		H8.11.7	H8.11.7
Linear Tool Changer (Standard tooling)		6-position, Ø70 mm x length 425 mm max	7-position, Ø70 mm x length 425 mm max
Linear Tool Changer (Combi tooling)		6-position, Ø60 mm x length 425 mm max	7-position, Ø60 mm x length 425 mm max
Rotary Tool Changer (Standard tooling)		24-position, Ø75 mm x length 250 mm max	24-position, Ø70 mm x length 250 mm max
Rotary Tool Changer (Combi tooling)		48-position, Ø36 mm x length 250 mm max	48-position, Ø36 mm x length 250 mm max
Multicavity flushing		6 outputs	8 outputs
Additional power module	A	64	-
Autorestart		Option	Standard
K-HM		-	-
Z-AC		Option	-
BA (Basic Automation) robot adaptation kit		-	-



Generator		
Type		ISOPULSE
Standard machining current	A	FO 35P, 54P, 55P : 64 FO 85 : 128
PILOT-EXPERT 2 and 3: Optimization and automatic supervision of machining parameters		Standard
POWER CONTROL EXPERT: Machining current, self-adapting according to the electrode geometry		Standard
MICRO-MACHINING*: Mastery of electrode wear in applications of small dimensions		Standard
SPAC: System of protection against short circuits		Standard
Numerical Control		
Screen		CRT 14" colour
Remote control		Standard
Disk drive		3.5" DOS, 1.44 MB
Axes controlled		X, Y, Z and C simultaneously
PROGRAM-EXPERT: Automatic program generation and adjustment of the generator on the NC		Standard
Autorestart / Polishing Ra 0.1µm (CH 0)* / Contouring / M functions / Machine autodiagnostic / DNC1 and DNC3 communication interface / Servo-controlled thermostabilization ±1°		Standard
*Available for ROBOFORM 35P, 54P, 55P		Standard
Electrical supply		
Incoming 3-phase voltage	V	400
Main network frequency	Hz	50 or 60

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