

4.2. Punch/shear centre TRS6

Ram force	300 kN (Korea: 29.4 ton = 288 kN)
Number of turret stations	20 pcs
Number of tool stations with 2 Multi-Tools	30...66 pcs (optionally more)
Punch diameter, max.	89 mm
Material thickness, max. (punching)	8 mm
CNC Index Tool:	
- Number of index tool stations, max.	10 pcs (2 pcs included in delivery)
- Punch diameter, max.	89 mm
- Tool rotation, max.	58 r/min
Upward forming cylinder (option):	
Force	250 kN
Stroke	12 mm
Integrated right angle shear:	
- Material thickness, max. (shearing)	
aluminium	5 mm
steel Fe52 / Fe37	4 mm
stainless steel	3 mm
- Material thickness, min	0.5 mm
- Full stroke shear, X x Y, max.	800 mm x 1528 mm
- Blade clearance setting	manually by screws (optionally automatic)
Blank weight, max. ¹⁾	200 kg
Sheet clamps	pneumatic, 3 pcs
Sheet size, max. (X x Y)	3061 mm x 1528 mm
X-traverse	2584 mm (X-42...X2542)
Y-traverse	1560 mm (Y-25...Y1535)
Axis speed (X axis), max.	90 m/min
Axis speed (Y axis), max.	60 m/min
Traversing speed, max.	108 m/min
Hit speed, max. ²⁾	
1 mm between holes	1000 1/min
25 mm between holes	430 1/min
250 mm between holes	150 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 P _a (X/Y axes)	0.08 mm (+/- 0.04 mm)
Positional scatter P _s (X/Y axes)	0.04 mm (+/- 0.02 mm)
Turret rotation	23.8 r/min
Tool change time ⁶⁾	1...3 s
CNC control	Siemens Sinumerik 840D or Fanuc 16iPA or Fanuc 18iPB (series 11.2)
Program memory Fanuc	512 kB
Siemens	1.5 MB
Machine weight	22.000 kg
Electrical cabinet weight	800 kg
Hydraulic unit drained weight	750 kg
Oil tank volume	330 l
Power supply	50 kVA
Power consumption, average ⁵⁾	30 kW
Compressed air consumption, max.	5 NI/s
Compressed air pressure, min	6 bar
Oil cooler, cooling capacity max.	30 kW
Air flow in oil cooler	2.9 m ³ /s