

3. Technical information

3.1. Turret punch press C5

Ram force	300 kN
Punching stroke	servo hydraulic
Number of tool stations in turret	20 pcs
Tools	Thick Turret
Punch diameter, max.	89 mm
CNC Index Tool:	
Number of index tool stations	standard 2 pcs (max. 10 pcs)
Punch diameter, max.	89 mm
Tool rotation, max.	166 r/min
Upforming cylinder (option):	
Force	250 kN
Stroke length	12 mm
Material thickness, max.	8 mm
Sheet weight, max. ⁽¹⁾	200 kg
Clamps	pneumatic, 2 pcs (optional 3 pcs)
Sheet size X x Y, max.	2530 mm x 1270 mm
X-traverse	2584 mm
X-traverse, axis speed max.	90 m/min
Y-traverse	1317 mm
Y-traverse, axis speed max.	60 m/min
Positioning speed, max.	108 m/min
Hit speed, max. ⁽²⁾	
1 mm between holes	1100 1/min
25 mm between holes	420 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 ⁽⁵⁾	1 ... 3 s
Work chute (option), max. part size	500 mm x 500 mm
CNC control	Siemens Sinumerik 840D / Fanuc 18iPB
Program memory Siemens:	1.5 MB
Fanuc:	512 KB
Ethernet connection	Yes
Machine weight	10 500 kg
Hydraulic unit drained weight	1000 kg
Oil tank volume	400 l
Oil cooler, cooling capacity max.	30 kW
Oil cooler air flow	2,9 m ³ /s
Electrical connection (E1):	
Average power consumption ⁽⁶⁾	35 kVA / 30 kW
Requirements for connection power ⁽⁷⁾	80 kVA
Fuse	3 x 100 A (with voltage 3 x 400 V)
Compressed air connection (P1):	
Min. air pressure	6 bar
Max. air consumption	5 NI/s
Average air consumption ⁽⁸⁾	2,5 NI/s