



- 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

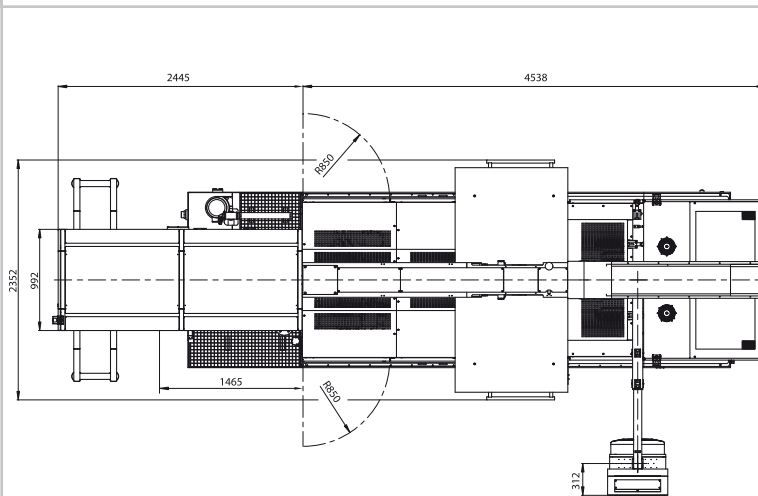
## TECHNICAL DATA

### 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 (1<sup>st</sup> 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 1<sup>st</sup> operating position
- Material clamping and stop at 5<sup>th</sup> operating position
- Material feed at 5<sup>th</sup> 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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