

Pos.	Qty.	Article Description	Price / €
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Complete machine description

- 1 1 **Vertical CNC-machining centre model STAMA MC 531**
Completely refurbished pre-owned machine
Year of construction: 1998,
Weight: 8.000 kg



(Picture similar)

Machine-No. 1113

Scope of delivery:

Technical Data:

Travel:

X-Axis

Y-Axis

Z-Axis

800 mm

400 mm

350 mm

Spindle Unit

Water cooled spindle motor

Tool register ISO 40

Spindle speed:

Standard 12000 rpm

S1 14 KW at 100 % ED

S6 21 KW at 20 % ED

Clamping surface 1.300 x 430 mm

Additional table load 1200 kg

3 T-slots 14 H12 for mounting on fixture, etc..

Tool places 42, SK 40, DIN 69871 + 72

Safety equipment

Working area lamp

Electric cabinet cooler

Automatic oil central lubrication

Installation elements



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SIEMENS CNC-control 840D

(MMC 102 / NCU 572.2, 10 measuring cycles) with integrated hard disc
 (min. 200 MB for free disposal)
 incl. 10,4" TFT colour screen
 full keyboard / control panel OP010S
 NC-memory
 Hard disc
 for eradication of parts programming after DIN 66025
 drilling cycles G81-G89
 M- and T- functions
 circular interpolation (360 degrees)
 re-start into program
 Subroutines, parameter programming
 simultaneous programming
 contour programming
 support through cycles
 polar coordinates
 tool offsets for geometry, wear
 tool radius correction for
 intersection computing
 crossing radius
 4 zero offsets G54-G57
 30 zero shifts programmable with G-functions
 3D and helical interpolation
 screen switch off
 mirror function
 scaling function
 insert of chamfer and radius
 Universal interface RS 232C (1 x V24) at control panel
 orientated spindle stop
 drip feed function through V24 interface
 dimension metric or inch
 software limit switch
 NC-diagnosis
 machine-diagnosis
 absolute indirect path measurement systems
 power meter in screen
 look ahead function

Siemens input device OP 08 T on Tool – loading place



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STAMA Powersafe

Software package for selective shutdown of installed consumers like axis motors, drives, spindles, seal air, airsensing and ancillary equipment in production breaks or during programmable points in time using a shift calendar. Definable point in time at which the machine starts demand-oriented automatically with a variable warmup program to recovery the production readiness.

Preparation for interior coolant feed after DIN 69871 30 bar

Chip conveyor
Scraping belt
Discharge height 1200 mm

Installation for coolant purification with paper ribbon filter PF100

Tank capacity 500 ltr.
ND-pump 100 ltr/min. at 2,1 bar
HD-pump 20 ltr/min. at 30 bar
Partial current cleaning of the HD-circles via paper ribbon filter PF100

Wash gun

Full enclosure of the working area

Preparation exhausting connection
for connection on customer side exhausting fan
diameter 150 mm / 200 mm

Preparation 4. axis ready to plug in

Documentation

Operating manuals, programming and operating manuals 1-fold on a USB-Stick.
Please refer to the manufacturer's instructions for each component.

Machine colour

Standard painting: 3-coloured light grey/umbra/pink
RAL 7035/7022 with pink stripes

Main circuit

total power supply 400 / 230V \pm 10 %, 50 cycles N/PE,
neutral conductor, load possible, pressure supply
6 bar, \pm 1 bar at all procedures,
room temperature max 40°



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Information Export

We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.

Information Machine safety

The machine is designed and built in accordance with the European machine guideline, according placing the product on the first time onto the market.

Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.

Information Coolant lubrication

The machine is designed for standard water soluble coolant and fully enclosed at the standard version. The machine must be equipped with fume extraction.

The machine contents different plastics, varnish, resin and glue, which are selected carefully for using coolant and cutting oil.

The use of aggressive coolant and additive could cause major damages and machine stops.

Contact in any case your coolant supplier before machine set-up and installation.

