

Pos.	Qty.	Article Description	Price / €
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Complete machine description | STAMA MC 326 no. 2041

- | | | | |
|---|---|--|--|
| 1 | 1 | <p>Completely refurbished vertical CNC-machining centre model STAMA MC 326
 Year of construction: 2001, weight: 5.600 kg</p> | |
|---|---|--|--|

Machine-No. 2041



Machine image similar.
The equipment of the sample photo isn't binding.

GB | Data sheet | ref 326.2041.docx

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Steuer-Nr. 21101/01726, Ust.-Id.-Nr. DE 812948040
IBAN : DE42653700750220814800
SWIFT : DEUTDESS653



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Scope of delivery:			
100	1	Traverse Ranges Spindle distance A: 266 mm X axis 520 mm Y axis 300 mm Z axis 360 mm Feed Thrust: X-Y axis 4000 N Z axis 8000 N	
200	1	Traverse Rates - Axes Dynamic Rapid traverse in X- Y- and Z- axes 60 m/min Feed rate X- Y- and Z- axes 1-10000 mm/min Axis dynamics: a max. (m/sec ²) X=5.0; Y=8.0; Z=12.0	
300	1	Swivel Table Swivel drive pneumatically controlled. Pneumatically pull down in crown gear Clamping area 2 x 700 x 350 mm Distance table-spindle nose min./max. 200/560 mm Number and size of T-slots per clamping area: 2 x 14 H12 Number and diameter of location holes per clamping area: 4 x ø16 F7 Acceptable table load 2 x 450 kg Indexing time approx. 1,9 sec.	
400	1	Spindle Units Tool holder HSK A 63 Draw bar pulling force 8000 N Spindle diameter 65 mm Spindle speed: Standard 12.000 rpm Incl. automatic blowing facility for process safety taper cleaning during tool change. retention force 18000 N Special spindle bearing configuration. Electronically balanced spindle. Balancing after fitting to spindle head.	
500	1	Performance Data 37 kW Torque constant up to 2500 rpm: At 100% cont. duty 65 Nm; at 20% cont. duty 142 Nm Driving power over 2500 rpm: At 100% cont. duty 17 Kw; at 20% cont. duty 37 Kw	



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| 600 | 1 | <p>Tool Magazine
 Tool places standard 2 x 21
 Tool diameter maximum:
 all places used \varnothing 88 mm
 with empty adjacent tool place \varnothing 125 mm (at 100 mm length)
 Tool length max. 250 mm
 Tool register HSK A63 DIN 69893
 Tool weight max. 5 kg
 Chip-to-chip time approx. 2,4 sec.</p> | |
| 700 | 1 | <p>Tool data management OP 08T
 Menu guided tool data management.
 To each tool are assigned direct:
 8-digit tool ident. no.
 For length and radius offsets
 service life guideline
 Data input:
 At inserting station with input panel or
 menu guided direct at the display of the control or
 via interface of the tool presetting</p> | |
| 800 | 1 | <p>Measuring System
 X-Y-Z axis, digital pulse coder (Siemens absolut)
 Absolute measuring value processing resolution 0.001 mm</p> | |
| 900 | 1 | <p>Installation Data
 Space required for machine approx. 7 m²
 Weight approx. 5.600 kg
 Control voltage 24 V DC
 Valve voltage 24 V DC
 Customers side requirement:
 Working voltage 3x400 V \pm10%; 50Hz; N/PE.
 Connected rating machine 40 KVA
 Fuse before master switch 3 x 80 A
 Connected cross section 4 x 25 mm²
 Required air pressure min. 6 bar
 ISO 8573-1 Klasse 4
 Necessary connection inner diameter \varnothing13mm</p> | |
| 1000 | 1 | <p>Guarding Equipment
 Enclosure of working area</p> | |
| 1100 | 1 | <p>Axis movement with open safety door
 If the safety door is open, axis movement and spindle rotation are just possible during setting mode.
 Speed of axis max. 2 m/min. Spindle RPM max. 800 1/min.
 Actuated by press-button and confirmation key.</p> | |



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| 1200 | 1 | Lamp in Working Area | |
| 1300 | 1 | Coolant equipment with swarf Conveyor
Ejection height 850 mm on left side of MC.
Integrated wedge wire sieve box, changeable, gap width: 350 µm.
Tank for 300 l.
External coolant supply integrated in spindle head with adjustable nozzles.
If mainly cast iron or light metal has to be machined, additional coolant concentration units are necessary. | |
| 1400 | 1 | Wash gun
For manual cleaning of the loading area. | |
| 1500 | 1 | Additional Rinsing in 1 Loading Area
Additional coolant pipes for cleaning of clamping fixture and workpiece in 1 loading/unloading area.
When actuated rinsing is done after each pallet change.
Rinsing time is adjustable from 0-10 sec. | |
| 1600 | 1 | Additional rinsing of Work area
Additional rinsing pipe for rough cleaning of clamping- fixture and workpiece .
Installed at working area with adjustable nozzles.
Controllable by M-function. | |
| 1700 | 1 | Machine Supports without Coolant Tray
for levelling and fixing the machine on the ground.
Including all mounting elements. | |
| 1800 | 1 | Control Siemens 840D (POWER LINE)
TFT Colour display 10,4", NCU 572.5, PCU 50
NCK user memory 768KB (approx.. 256 KB freely available)
Universal interface RS-232C (V24)
4 x USB, 2.0
2 x Ethernet °10/100 Mbit/s interface | |

Max. 24-digit alphanumeric programmed names
Forming of sub-routines according to DIN or standard
Language and parameter max. nesting 7 times
3D-lin. interpolation G1 (max. 4 axes simultaneously)
Circular interpolation G2/G3, helical interpolation
Polar or Cartesian coordinates measuring system
49 zero point shifts direct by G-function
Inclusive of additive zero point shift
Turning of coordinates; Mirror; Scaling factor
Insertion of chamfer or radius



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Siemens standard drilling and milling cycles
 (additional G81 - G86 same as Siemens 840C)
 Rigid tapping
 32-digit alphanumeric tool identification
 Tool data input by program or direct with input panel
 at inserting station
 Tool life monitoring wear or number of parts
 Cutter radius compensation G41/G42 by calculation of
 intersection points or transition radius
 Restart of program
 Prompt facility
 Editing and programming during machining
 Conversational programming according to DIN 66025
 including graphical generating of contour
 up to 3 axis.
 Diagnostic displ. and operating feed back in clear text
 Oriented spindle stop
 Measuring system: digital absolut incremental encoders
 Screen saver

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| 1900 | 1 | Direct Measuring System X-Y-Z-Axis
Measurement to VDI/DGQ 3441 | |
| 2000 | 1 | Coolant Filtration Paper
Inner rim filter, installed on additional 600 l coolant tank
Compact construction, filter paper width 720 mm
Middle filter mesh nominal < 50 microns.
Filter performance 200 l/min - emulsion.
With feed-back facility in the event of paper shortage.
Paper transport actuated by level switch. | |
| 2100 | 1 | Internal Coolant through Spindles 70 bar
Internal coolant supply through work spindles for
tool adaptors to DIN 69871 (ISO) form AD or B, or for
tool adaptors to DIN 69893 (hollow taper shank) form A
> 70 bar high-pressure pump for coolant (22 l/min.)
> Incl. Vario valve, pressure is programmable in 7
steps by M-functions.
(Applicable only in combination with coolant filtration
system filter mesh 50 microns). | |



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2200	1	<p>Hydraulic Basic Equipment Necessary in case of hydraulically actuated clamping fixtures. Consisting of: > High pressure aggregate system pressure 250 bar. > 1 hydr. block for 1 circuit double action (2 controlled lines). The clamping line is equipped with a manual pressure adjustment 30-200 bar incl. pressure control (unclamping line 250 bar) Lines are installed up to machine table. > Electrical soft- and hardware. > Additional control panel added to main control panel with funct. clamping, control lamp clamping pressure reached and unclamp fixtures.</p>	
2300	2	<p>Hydraulic connection for 200 bar with 2 connecting couplings A+B and hydraulic installation up to outside of machine bed, incl. valve to control 1 double acting clamping circuit with pressure switch for electrical clamping control and electrical control for clamping OPEN-CLOSED</p> <p>Remark: 2 x A + B Standard, 2 x A+B additional and x 2 A + B per table side Total: 4 x A + B</p>	
2400	1	<p>Additional Hydr. Circuit Double Action Extension of hydraulic basic equipment by 1 circuit (2 controlled lines) with throttle check valve. Workmanship is the same as in the basic equipment.</p>	
2500	1	<p>STAMA Variable Clamping Logic For the definition of different clamping and releasing sequences, for a maximum of 10 functions with a maximum of 8 steps. Considering of time delay and monitoring of clamping circuits e.g. through pressure switches or airsensing. The storing of the configuration and reloading, allows fast changeover.</p>	



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2600	1	<p>Parts location air sensing for rough sensing with energy-efficient pressure control by using 1 pressure switch, incl. pneumatic and electric installation Remarks: Maximum 3 nozzles per switch. Additional rotary feedthroughs may be necessary at rotary table and at standard fixture for rotary table Remark: 1 per table side</p>	
2700	1	<p>Distributor Swivel Table 10-fold distributor for oil supply to clamping fixtures mounted on one or two sides of swivel table. Central space-saving installation in the middle of the swivel table. Supply through middle of swivel table. The oil-distributor is prepared for the additional supply to electrical units on the swivel table.</p>	
2800	1	<p>Automatic Loading Door Automatic opening and closing of loading door/s. According to valid german safety regulations (UVV) and electrically safeguarded.</p>	
2900	1	<p>Mini operating panel on the loading side</p>	
3000	1	<p>Full Enclosure of Working Area As protection against swarf and fumes the working area of the machine is completely closed. The drive units are placed outside of the capsule. A suction unit is recommended.</p>	
3100	1	<p>Preparation for suction unit Preparation of machine for connection to customer's suction unit. 1 connection nozzle Ø 200 for 1 working area Incl. deflector in the working area</p>	
3200	1	<p>Signal Lamp 3 Colours mounted on machine guard. red = machine stop yellow = advance warning green = Automatic cycle</p>	
3300	1	<p>Adapter for hand-wheel</p>	
3400	1	<p>4. axis, ready for plug-in</p>	



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| 3500 | 1 | Interface automatic loading system (Profi-Bus)
The data transfer takes place over the profi bus system
The interface includes a DP/DP coupler
and two pcs. hardware connectors for
potential free emergency stop and safety door signals | |
| 3600 | 1 | Documentation (standard offer)
1 x safety regulations in a folder in german.
1 x complete documentation on a USB as PDF
Language of the operating manuals and safety in German | |

Machine colour

Standard painting: 3-coloured light grey/basalt grey
 RAL 7035/7012/4010 with telemagenta stripes

Main circuit

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

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.

