

## STAMA MT 733 two - Technical data - German

- **Technical design X-axis**  
travel: 615 mm  
Rapid traverse speed: 65 m/min  
Acceleration max. : 7 m/s<sup>2</sup>  
feed force : 4.000 N  
Feed drive version: ball screw  
To achieve a higher cutting performance, the X1 axis is controlled in the gantry system.
- **Technical design Y-axis KGT**  
traverse path: 290 mm  
Rapid traverse speed: 65 m/min  
Acceleration max. : 9 m/s<sup>2</sup>  
feed force : 4.000 N  
Version feed drive: ball screw
- **Technical design Z-axis**  
travel: 500 mm  
rapid traverse speed : 65 m/min  
Acceleration max. : 13 m/s<sup>2</sup>  
feed force : 8.000 N  
Version feed drive: ball screw
- **Main spindle unit left**  
Motorized milling spindle HSK-T63 12.500 1/min  
tool holder: HSK-T63  
feed force: 18 kN  
diameter spindle bearing: 80 mm  
Max. Speed: 12.500 1/min
- **Performance data:**  
Drive power 20% ED: 61 kW from 2,910 1/min  
Drive power 100% ED: 61 kW from 3,880 1/min  
Torque 20% ED: 200 Nm up to 2,910 1/min  
Torque 100% ED: 150 Nm up to 3,880 1/min  
Main spindle unit incl. automatic blowing/rinsing device for process-safe cleaning of the tool holder during the change process and automatic tool infeed control by means of analog sensor.
- **Clamping of milling spindle**  
Mechanical clamping of the motorized milling spindle to increase the possible infeed and turning precision.

- **Tool magazine left**

Tool magazine for automatic tool change in low-wear design. For stocking tools for the left milling spindle. Tool magazine in the following design:

Number of available magazine positions: 64

Tool diameter max. when fully loaded: 78 mm Tool diameter max. with free secondary places:

140 mm Tool length max. : 300 mm

tool holder: HSK-A/T63

tool weight max. : 10 kg

Total chain load max. : 115 kg

The maximum weight per tool can vary depending on the tool contour. Chip-to-chip time according to VDI 2852: approx. 2.9 s

- **Rotary swivel unit clamping position 1**

3-axis NC unit for all-round machining of workpieces with complicated shapes and angular positions in one clamping position. The rotary/swivel unit is mounted on the linear slide unit of the X 1 axis and is designed for 5-axis operation in milling operations. To increase positioning accuracy, the rotary axes are equipped with direct measuring systems. The rotary/swivel unit consists of the following components: Swivel unit RGM 175 precision Design of the B-axis in the form of a backlash-free and highly torsionally rigid geared rotary axis. Technical data:

Swivel angle: -30 to +90 degrees

Repeat accuracy of swivel axis:  $\pm 1''$ .

Speed of swivel axis max.: 61 1/min

Clamping torque tangential swivel axis: 3,000 Nm Clamping torque tangential counter bearing: 1,800 Nm

**Rotating spindle FT Technical data:**

Interface to optional clamping system: short taper mounting according to DIN ISO 702-1 A2

No. 8 Clearance turning spindle max. : no clearance Repeatability turning spindle:  $\pm 8''$ .

Speed max. : 4.200 1/min

Rated speed : 2.300 1/min

Clamping torque tangential turning spindle: 1.400 Nm Torque 15% ED: 180 Nm Torque 100% ED: 100 Nm

Driving power 15% ED: 43 kW

Drive power 100% ED: 24 kW

Tensile/compressive force min. : 11 kN

Tensile/compressive force max. : 46 kN

- **Mains connection**

Supply voltage machine 3x400 Volt± 10%

Neutral conductor loadable

Protective conductor present

Frequency 50 Hz

Voltage socket 230 Volt± 10%

Socket type VDE-SCHUKO

Machine weight approx. 28,000 kg

Compressed air connection min.: 6 bar

Air purity according to ISO 8573-1 class [4:4:4].

Supply line cross-section inside min. : 13 mm

The machining center is equipped with electric and mechanical components, which their functionality within a prescribed temperature range between 18°C and 35°C.

