

03

Technical data . C 22

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03.1

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Working area	Traverse	X axis	450 mm		
	Traverse	Y axis	600 mm		
	Traverse	Z axis	330 mm		
	Rapid linear traverse (dynamic)	X-Y-Z	30 (50) m/min.		
	Linear acceleration (dynamic)	X-Y-Z	8 (15) m/s ²		
	Linear feed force	X-Y-Z	4500 N		
Main spindle drive	Speed	15000 rpm	SK 40	●	
	Main power/Torque	40% c.d.f.	25 kW / 80 Nm		
	Speed	18000 rpm	HSK A 63 / HSK A 50	○	
	Main power/Torque	40% c.d.f.	25 kW / 80 Nm		
	Speed	30000 rpm	HSK A 50	○	
	Main power/Torque	40% c.d.f.	38 kW / 33 Nm		
	Speed	42000 rpm	HSK E 40	○	
	Main power/Torque	20% c.d.f.	30 kW / 16 Nm		
Control unit	Heidenhain	iTNC 530 ●			
	Siemens	Sinumerik 840 D sl ○			
Tool changer (pick-up)	Interface	SK 40 / ● HSK A 63 ○	HSK A 50 ○	HSK E 40 ○	
	Magazine pockets	55	65	65	
	Chip-to-chip time*	approx. 4.5 s	approx. 4.5 s	approx. 4.5 s	
	*(chip-to-chip times for 3-axis units were calculated in keeping with German standard VDI 2852, page 1)				
	Max. tool length	250 mm	250 mm	250 mm	
	Max. tool diameter	Ø 80 mm	Ø 80 mm	Ø 80 mm	
	with empty adjacent pockets	Ø 125 mm	Ø 125 mm	Ø 125 mm	
	Max. magazine load	220 kg	195 kg	162.5 kg	
	Extension of tool storage capacity	Additional magazine with 43 or 87 additional pockets ○			
		Interface	SK 40 / HSK A 63	HSK A 50	HSK E 40
Max. tool length		250 mm	250 mm	250 mm	
Max. tool diameter		Ø 80 mm	Ø 80 mm	Ø 80 mm	
with empty adjacent pockets		Ø 125 mm	Ø 125 mm	Ø 125 mm	
Max. tool weight		8 kg	6 kg	2.5 kg	

● Included in standard delivery

○ Available upon request

Table variants	NC swivelling rotary table	Ø 320	Ø 320	○
	Table plate with clamping surface	Ø 320 mm	Ø 320 mm	
	Swivelling range	+/- 135°	+/- 135°	
	C-axis drive mode	torque	worm	
	Swivelling axis A speed			
	Mechanical one-sided	25 rpm	25 rpm	
	Mechanical tandem	55 rpm	-	
	Torque tandem	80 rpm	-	
	Rotary axis C speed	80 rpm	40 rpm	
	Max. table load	150 kg	300 kg	
	T grooves	4 units / 14H7 star-shaped	4 units / 14H7 star-shaped	
	Table plate with clamping surface	-	Ø 450 x 360 mm	
	Installation clamping device	-	SK 50	
	Installation clamping device	-	HSK 100	
	System table			
	Zero-point system / pallet clamping system			
	Rigid clamping table			●
Clamping surface		600 x 630 mm		
Max. table load		750 kg		
T grooves		10 units / 14H7 parallel		
Position measuring system, direct	Resolution		0.0001 mm	●
Positional tolerance	Tp in X-Y-Z axes according to VDI/DGQ 3441 (calculated at a constant ambient temperature of 20 °C +/-1 °C. Our products are subject to the German Export Law and require authorization since the attainable precision may be less/greater than 6 µm.)		0.008 mm	
Chip chute	Space-saving mounting on the left or right Capacity		210 l	●
Chip conveyor	Scraper belt or hinge conveyor			○
	Chip conveyor, left or right (short version) Capacity		300 l	
	Chip conveyor to the rear (long version) Capacity		280 l	
	Chip conveyor ejection height		1160 mm	
	Chip cart		450 l	
Internal coolant supply with Paper band filter	Capacity of base container		88 l	○
	Capacity of cooling lubricant tank		650 l	
	Pressure (manually adjustable up to)		max. 80 bar / 18 l/min	
	Mains connection (ICS)		400 V / 50 Hz	
	Power consumption (ICS)		17 kVA	
Hydraulics	Operating pressure		120 bar	●
Central lubrication	Minimum grease lubrication quantity			●
Connected loads (machine)	Mains connection		400 V / 50 Hz	
	Power consumption		40 - 55 kVA	
	Compressed air		6 bar	
Weight	(standard version without optional extras, workpieces and coolant)		Approx. 8.5 t	