

Floor-type machines

GRATA

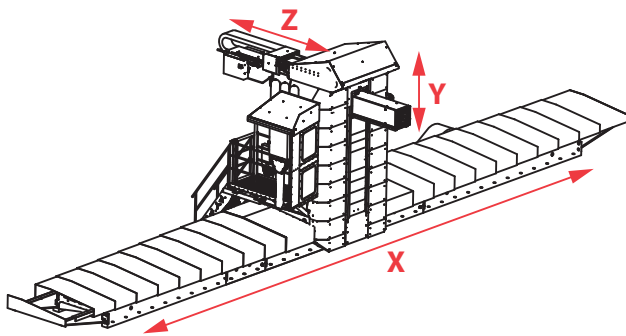


The GRATA floor-type machine tools are designed for precise line-coordinate milling, drilling, boring, milling and thread cutting. They are particularly suitable for machining of box- and plate-type workpieces and complicated workpieces from cast-iron, steel cast-iron, steel and other machinable materials, mainly large as well as the largest sizes and weights.

The machines are equipped with an extensible tool-holding slide, which can be fitted with a broad range of

additional devices that significantly enhance the machine's potentialities.

The machines are suitable for series manufacture as well as demanding technological applications. They are continuously controlled in three basic coordinates (X, Y, Z) or other axes according to the used special equipment by the machine's control system.



Machine configuration

- basic version
- machine with automatic tool change
- machines are controlled in 4 axes (X, Y, Z and V – rotary table)
- Headstock with spindle extension
- Headstock with milling heads (see page 64)

TECHNICAL PARAMETERS

Headstock

Termination of the RAM with an interface for application of the technological devices.

RAM size	mm	500 x 500
Main motor speed range	1/min	10 – 5 000
Main motor power (at permanent operation of S1)	kW	37
Torque on the driving shaft (S1)	Nm	1 584

Column

Column longitudinal travel X	mm	5 000 – 25 000 (in steps of 2 000 mm)
Headstock vertical travel Y	mm	1 600, 2 000, 2 500, 3 000
RAM stroke Z	mm	1 500

Feeds

Range of feeds (working and rapid traverse) – X, Y	mm/min	1 – 25 000
– Z	mm/min	1 – 15 000

Example of crankshaft machining at a Chinese customer, customised technology was turnkey delivered with a complete set of tools and special accessories.

