

SPADDA  
TRANSFER TECHNOLOGY

multi   
compact  
PATENT PENDING

*World innovation*





## II MACCHINA A CONTROLLO NUMERICO NC MODEL MACCHINA IDRAULICA HY MODEL

Stazioni standard 6-8-10-12-14-16  
barre da  $\varnothing 4$  a  $\varnothing 100$

- Modularità
- Cartuccia di foratura aggiuntiva
- Cartuccia di foratura maschiatura aggiuntiva
- Cartuccia di tornitura aggiuntiva
- Predisposizione unità frontali
- Predisposizione unità frontali a 3 assi
- Possibilità di 3 unità per singola stazione
- Cambio utensili
- Cambio utensili su ogni unità di lavoro
- Lavorazione doppio scatto
- Lavorazione in morsa fino a  $\varnothing 30/60$  mm
- Lavorazione in pinza
- Lavorazione due pezzi contemporaneamente
- Lavorazioni con pezzi in rotazione oltre i 20.000 rpm
- Lavorazioni con coppie superiori a Nm 100 rpm 2000
- Lavorazione con tavola asse verticale
- Nessuna conseguenza sulle lavorazioni dal posizionamento asse tavola
- Possibilità di bilanciamento dei tempi ciclo di lavorazione pezzi
- Caricatore barra singola in rotazione
- Precisione di lavorazione +/- 10  $\mu$

## GB NC MODEL HY MODEL

Standard stations 6-8-10-12-14-16  
bars from  $\varnothing 4$  up to  $\varnothing 100$

- Modularity (later upgrade possible)
- Additional drilling cartridge
- Additional threading cartridge
- Additional turning cartridge
- Optional front unit
- Optional front 3-AXIS NC-CENTER
- Up to 3 units per station
- Tool change
- Tool warehouses heach working unit
- Double step machining
- Machinable area up to  $\varnothing 30/60$  mm
- Chuck clamping option
- Twin machining
- Part rotation speed over 20.000 rpm
- Machining capacity up to Nm 100 at rpm 2000
- Vertical axis table machining
- Advantages with vertical axis table on machining
- Independent machining parameter setting (time balancing of cycle operations)
- Single bar loader on rotation
- Machining precision +/- 10  $\mu$

## TUR NC MODEL HY MODEL

Çap 4'den 10'a kadar 6-8-10-12-14-16  
standart İstasyon

- Sonradan değişiklik mümkün
- Matkap ünitesi eklenebiliyor
- Diş Çekme Ünitesi eklenebilir
- Torna ünitesi eklenebilir
- Ön ünite opsiyonel
- Ön tarafta 3 Eksen NC (opsiyonel)
- Tüm istasyonlar 3 bölüme kadar çıkartabilir
- Takım değiştirme
- Tool warehouse heach working unit (tam karşılığını bulamadım)
- Çift kademeli işleme özelliği
- 30mm'den 60mm'e kadar işleme alanı
- Ayna churning opsiyonu (churning anlamamını bulamadım)
- Çift işleme
- 20.000 devire kadar parça değiştirme hızı
- Makinanın kapasitesi 100 Nm 2.000 devir
- Dik işlem çalışma özelliği
- Dik işlem işleme özelliklerinin avantajları
- Her işleme de tek tek parça ayarlama özelliği
- Çubuk sürücü ile çalışma özelliği
- Makine hassasiyeti +/-10u

# multi

## compact

6 - 8 - 10 - 12 - 14 - 16 STATIONS



### ☐ MACHINE A CONTROLE NUMERIQUE NC MODEL MACHINE HYDRAULIQUE HY MODELE

**Standard 6-8-10-12-14-16 stations  
barres de Ø 4 à Ø 100**

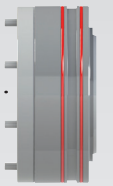
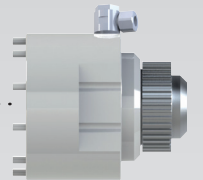
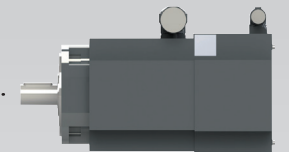
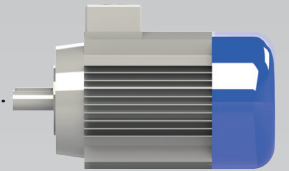
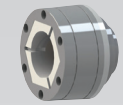
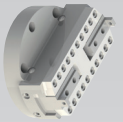
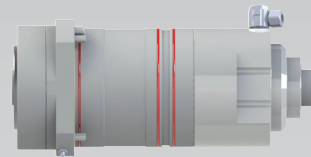
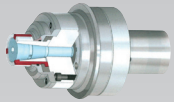
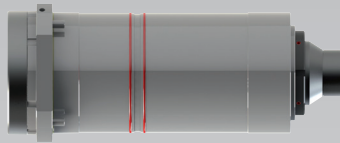
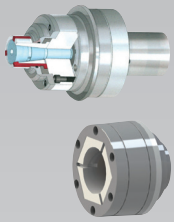
- Modularité, il est possible de modifier à volonté l'équipement selon les besoins de la pièce
- Cartouche de perçage supplémentaire
- Cartouche de perçage taraudage supplémentaire
- Cartouche de tournage supplémentaire
- Prédiposition d'unité frontale
- Prédiposition pour montage d'unité frontale à 2 ou 3 axes
- Possibilité de 3 unités pour chaque station
- Changeur d'outils
- Magasins d'outils sur chaque station d'usinage
- Usinage en double indexage à la demande selon la pièce
- Usinage en mors jusqu'au Ø 30/60 mm
- Usinage en pince type hainbuch pince expansible etc...
- Usinage de 2 pièces simultanément
- Usinage supérieur à 20.000 rpm (on ne supporte pas la barre sur la broche, pas de vibrations), Meilleure qualité.
- Usinage avec un couple supérieur à Nm 100 à rpm 2000
- Usinage avec la table à axe verticale

- La table est équipée à chaque station d'une broche horizontale
- Aucune conséquence sur l'usinage par ce positionnement de la Table. Les copeaux descendent bien vers le bas de la machine et facilite ainsi l'usinage de tous les outils
- Possibilité de balancer le temps de cycle d'usinage de la pièce, d'un poste à l'autre et ainsi équilibré les temps de chaque stations.
- Embarreur avec une seule barre en rotation
- Précision d'usinage de +/- 10 µ

### ☐ MASCHINE MIT NUMERISCHER STEUERUNG HYDRAULISCHE MASCHINE

**Standard Stationen 6-8-10-12-14-16  
Stangen von ø 4 bis ø 100**

- Modularität
- Zusätzliche Bohrspatrone
- Bohrspatrone zusätzliches gewindebohren
- Zusätzliche drehbearbeitungspatrone
- Vorbereitung frontale einheiten
- Vorbereitung frontale 3-Achs-Einheiten
- Möglichkeit von 3 einheiten für jede einzelne Station
- Werkzeugwechsel
- Werkzeuglager pro arbeitsstation
- Bearbeitung im schraubstock bis zu ø 30/60 mm
- Bearbeitung mit selbstzentrierendem schraubstock
- Bearbeitung mit spannsystem
- Bearbeitung im spannsystem
- Arbeiten zwei stücke gleichzeitig
- Bearbeitungen über 20.000 Rpm
- Bearbeitungen mit drehmomenten über Nm 100 Rpm 2000
- Bearbeitung mit vertikalem tisch und achse
- Keine konsequenz für die bearbeitungen durch die tischpositionierung
- Möglichkeit der zeitausgleichung der taktzeit der teilebearbeitung
- Beladen einzelner stangen im rotationszustand
- Bearbeitungsgenauigkeit von +/- 10 µ



**Attacchi disponibili**

ASA 3 - 4

Speciali a richiesta

**Available spindle standards**

ASA 3 - 4

Customized upon request

**Uygun İş Mili Standartları**

ASA 3 - 4

İsteğinize göre düzenlenebilir

**Attachements disponibles**

ASA 3 - 4

Spécial sur demande

**Verfügbare Anschlüsse**

ASA 3 - 4

Spezialanschlüsse auf Anfrage

**Carri X / Z**

Corsa minima "asse X" di 50 mm - Corsa minima "asse Z" di 50 mm

Speciali a richiesta

**Slides X / Z**

50 mm "X axis" minimum stroke - 50 mm "Z axis" minimum stroke

Customized upon request

**Slides X / Z**

X/Z Kızakları - X ve Z hareket alanı 50 mm

**Chariot X / Z**

Course minimum "axe X" de 50 mm - Course minimum "axe Z" de 50 mm

Spécial sur demande

**Wagen X / Z**

Min. Hub "X-Achse" von 50 mm - Min. Hub "Z-Achse" von 50 mm

Spezialanschlüsse auf Anfrage

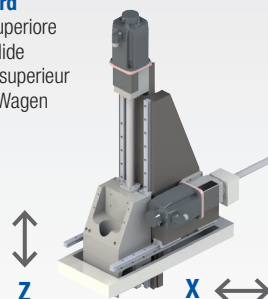
**Standard**

Carro superiore

Upper slide

Chariot superieur

Oberer Wagen

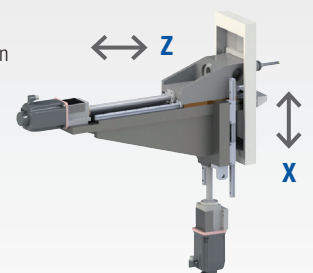


**Carro radiale**

Radial side

Chariot frontal

Radialer Wagen



## UNIT 32

## UNIT 65

Range diametri barra (nominale) Bar diameter range (nominal) Çubuk Çapı (nominal) Gamme diamètre de barre (nominal) Range Stangendurchmesser (Nominal)	4-32	32-65
Concentricità [mm] Precision class [mm] Hassasiyet Sınıfı [mm] Concentricité [mm] Rundlaufgenauigkeit [mm]	IT6	IT6
Velocità max [rpm] Max speed [rpm] Max Devir [rpm] Vitesse maxi [rpm] Max. Gechwindigkeit [rpm]	30000	12000

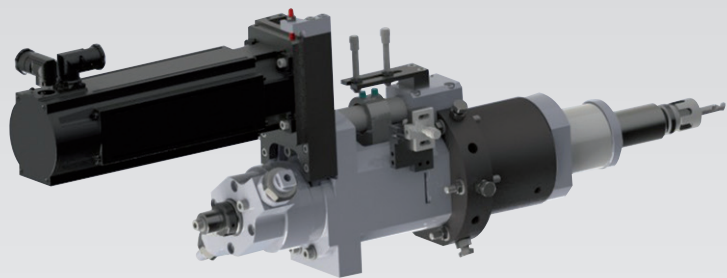
### Motorizzazioni - Motors - Motorisation - Motorisierung

	Taglia Size Taille Schnitt	Potenza Power Puissance Leistung [KW]	Velocità Speed Vitesse Geschwindigkeit [rpm]	Taglia Size Taille Schnitt	Potenza Power Puissance Leistung [KW]	Velocità Speed Vitesse Geschwindigkeit [rpm]
<b>Elettromandri Electrospindles Elektro işmili Electro broche Hochfrequenzspindel</b>	from to	10 25	8000 30000	from to	15 25	6000 12000
<b>Asincroni Asynchronous Senkronize olmayan Asynchrone Asynchron</b>	from to	1,5 10	10000 10000	from to	7 15	4000 8000
<b>Sincroni Synchronous Senkronize olan Synchrone Synchro</b>	from to	6 10	8000 10000	from to	10 20	5000 8000

**Comandi idraulici regolabili doppio effetto**  
**Adjustable hydraulic clamps double effect**  
**Hidrolik sıkma özelliğiyle iki kat daha kuvvetli**  
**Commande hydraulique réglable double effet**  
**Einstellbare Hydrauliksteuerung Doppelleffekt**

**Gruppo freno mandrino**  
**Spindle brake system**  
**İş Mili Fren Sistemi**  
**Groupe frein de broche**  
**Spindel-Brems-Gruppe**

**Encoder**  
**Kodlayıcı**



### Unità di tornitura / foratura / maschiatura

Disponibilità. Sostituzione della cartuccia per passare da tornitura a foratura o maschiatura (disassate)

### Turning / boring / milling / threading cartridges

Available. Cartridge replacement allows switching from turning operation to boring/milling/threading operations

### Tornalamak / Delmek / Diş Açma Ünitesi

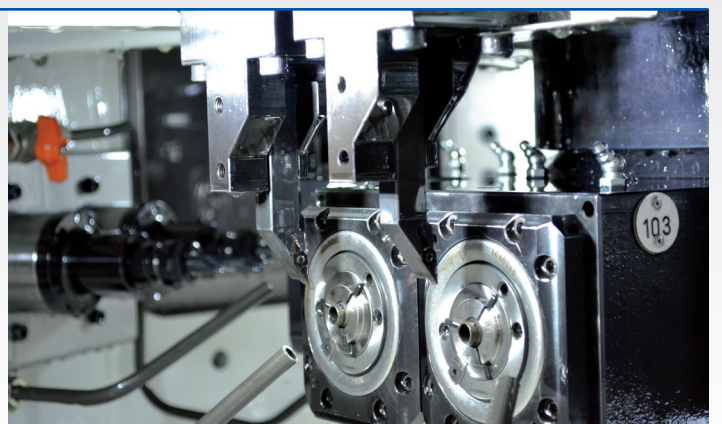
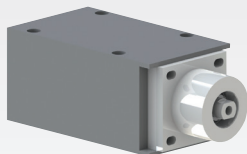
Otomatik olarak opsiyonlar içinde değiştirme

### Unité de tournage / perçage / taraudage

Disponibilité. Substitution de la cartouche pour passer du tournage au perçage au taraudage (dissocié)

### Dreheinheit / Bohreinheit / Gewindebohrereinheit

Verfügbarkeit. Patronenaustausch zwecks Übergang vom Drehen zum Bohren od. Gewindebohren (ausserachsig)





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