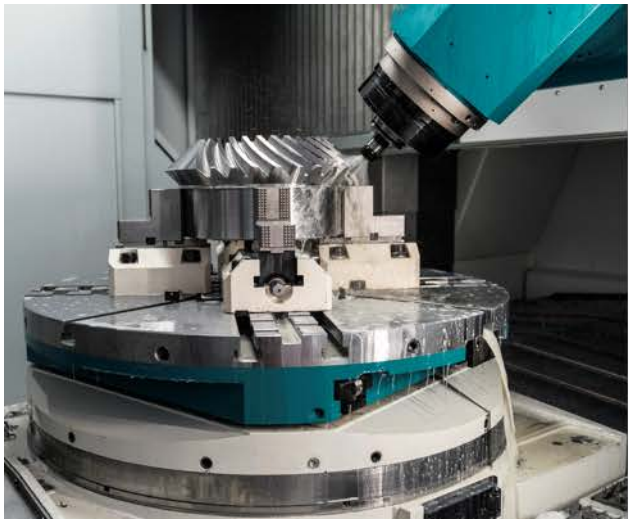
PAMA

Twój dostawca rozwiązań



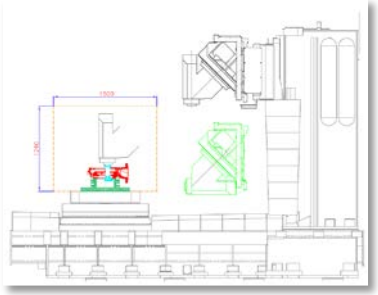
pama tech center

CENTRA OBRÓBCZE

Jakie usługi PAMA TECH CENTER oferuje klientowi?

1. NAUKA TECHNOLOGII OBRÓBKI
2. WYKONANIE TESTÓW OBRÓBKI
3. KONTROLA PRZEDMIOTU OBRABIANEGO
4. WYŻYWIENIE I ZAKWATEROWANIE

1. NAUKA TECHNOLOGII OBRÓBKI



"ESTIMATED MACHINING CYCLE TIME"

MILLING OPERATION

CUSTOMER: PAMA

PART NAME: Discharge casting c-painted DRAWING N°:EMP59920

SET UP N° : 2	
MATERIAL: EN-GJS-250	STOCK REMOVAL : 10 mm on plane, 10 mm on radius
MACHINE: VMT2 TECH CENTER	CNC: SIEMENS
NUMBER OF TOOLS : 16	NUMBER OF ATTACHMENT : -

RE: REMARKS TO WORKING CYCLE.
The enclosed cycle time has been worked out taking into account what follows:
- Unless outherwise specified, stock removals have been considered of (10 mm.) on surface and of (10 mm.) on radius;
- All drilling operations have been considered by full blank component;
- Materials: as per drawing definition;
- Conditions of blank components: machined, inclusion less, without surface failures and suitable structural stability;
- Possibility to carry out further machining operations, for references during machining, anchoring and clamping as well as controls during machining;
- Tools according to Pama's specification;
- Correctly pre-set tools and non reckoners to be ready for their use close to the operator;
- Suitable clamping fixtures so as to guarantee maximum stability and allow the use of technological parameters mentioned on working cycle;

The worked out times include:
- Chip removal times;
- Positioning times;
- Tool change and attachment heads times;
- Table and attachment head indexing times.

The following times are not included:
- Times of fixtures preadjusting, for alignment and clamping;
- Times for workpieces assembly and disassembly;
- Check time during and after work process;
- Any other machine's stop due to insernal organizing procedures,failure or maintenance, operator absence.
- Calculated time can be affected by max. error of about +/- 10%

Pama garanted cycle time only in a complete "turn key" solution: Fixture , tools , part-program provided by Pama.

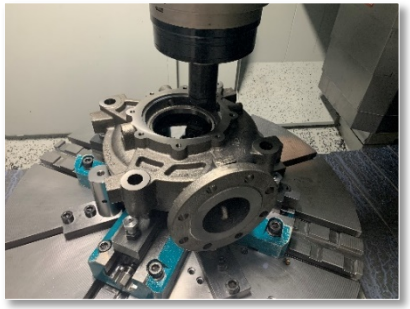
TIMES :

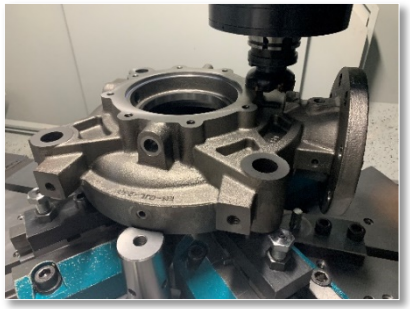
	1° SET-UP	2° SET-UP
IDLE TIME (min.) :	10.98	8.66
MACHINIG TIME (min.) :	16.45	17.54
SINGLE SET-UP TIME (Hours) :	0.46	0.44
TOTAL TIME (Hours) :	0.89	

PREPARED BY : MK

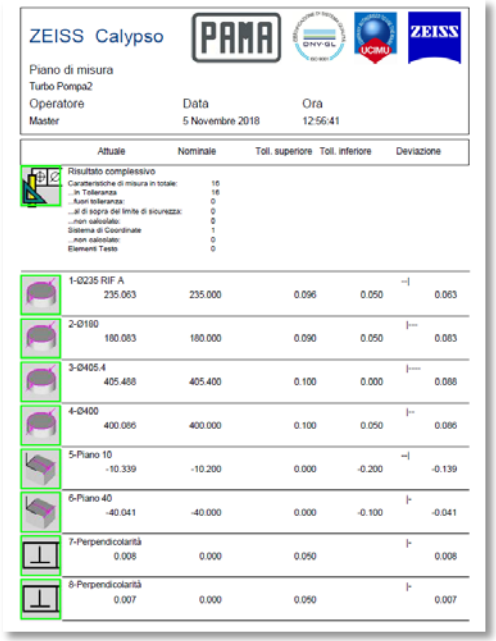
DATE : 08/08/2018

2. WYKONANIE TESTÓW OBRÓBKI





3. KONTROLA PRZEDMIOTU OBRABIANEGO



ZEISS Calypso

Piano di misura

Turbo Pompa2

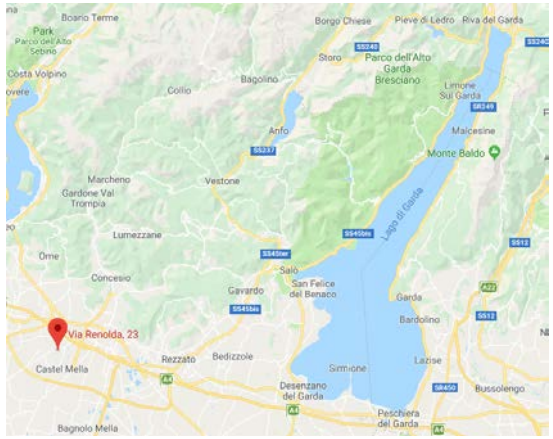
Operatore: Master | Data: 5 Novembre 2018 | Ora: 12:56:41

	Attuale	Nominale	Toll. superiore	Toll. inferiore	Deviazione
Risultato complessivo					
Caratteristiche di misura in totale:	16				
...in Tolleranza	16				
...fuori tolleranza:	0				
...al di sopra del limite di sicurezza:	0				
...non calcolato:	0				
Sistema di Coordinate	1				
...non calcolato:	0				
Elementi Testo	0				
1-Ø235 RIF A	235.063	235.000	0.096	0.050	0.063
2-Ø180	180.083	180.000	0.090	0.050	0.083
3-Ø405.4	405.488	405.400	0.100	0.000	0.088
4-Ø400	400.066	400.000	0.100	0.050	0.066
5-Piano 10	-10.339	-10.200	0.000	-0.200	-0.139
6-Piano 40	-40.041	-40.000	0.000	-0.100	-0.041
7-Perpendicolarità	0.008	0.000	0.050		0.008
8-Perpendicolarità	0.007	0.000	0.050		0.007

4. WYŻYWIENIE I ZAKWATEROWANIE

SPEEDMAT VMT2 5 osiowe wielozadaniowe centrum obróbcze frezarsko & tokarskie

PAMA TECH CENTER



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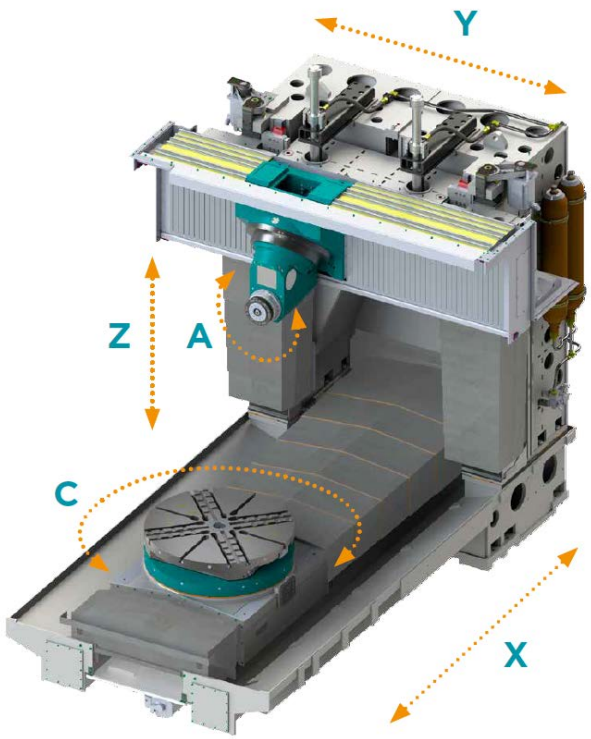
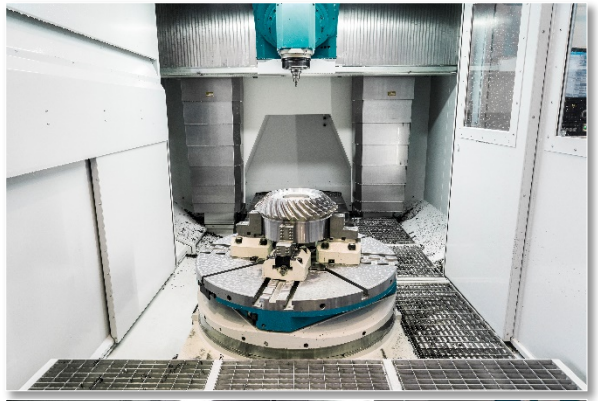
SPEEDMAT VMT2 TECH CENTER PARAMETRY

PAMA TECH CENTER

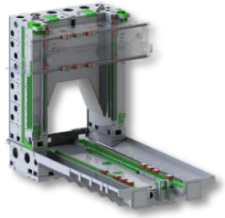


KARTA TECHNICZNA MASZYNY

STREFA OBRÓBKI		
X/Y/Z ZAKRES	mm	2000/2000/1300
ŚREDNICA PRZEDMIOTU	mm	2000
PRZESUW OSI		
PRZESUW SZYBKI	m/min	50/40/40
PRZYSPIESZENIE OSI	m/s²	3
CIĄG OSI	kN	15
GŁOWICA HVA-ES		
STOŻEK WRZECIONA	HSK	100 T
MAX PRĘDKOŚĆ WRZECIONA	rpm	12500
MAX MOC WRZECIONA (S6)	kW	75 (85)
MAX MOMOENT OBROTOWY (S6)	Nm	286 (450)
STÓŁ TRT		
Ø PALETY	mm	1250
NOŚNOŚĆ STOŁU	t	6
MAX PRĘDKOŚĆ FREZOWANIA	rpm	10
MAX PRĘDKOŚĆ TOCZENIA	rpm	350
MAX MOC	kW	50
MAX MOMENT OBROTOWY	Nm	5000
ŁAŃCUCHOWY MAGAZYN NARZĘDZI		
STOŻEK	HSK	100 T
WYDAJNOŚĆ NARZĘDZI	n°	40
MAX WAGA NARZĘDZI	kg	20
CN SIEMENS 840 SL OPERATE		

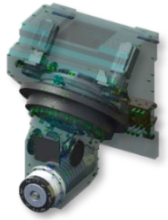


OBRABIARKA TYPU PORTAL



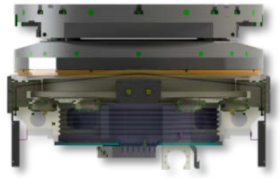
+ WYSOKA DYNAMIKA STALOWEJ KONSTRUKCJI
+ SYSTEM BALANSU RAMY

GŁOWICA Z PŁYNNĄ OSIĄ A



+ BEZPOŚREDNI NAPĘD WRZECIONA
+ OŚ A Z PODWÓJNYM NAPĘDEM
+ OŚ A Z SYSTEMEM MOCOWANIA
+ WRZECIONO Z SYSTEMEM BLOKOWANIA
+ TRZYOSIOWY WIBRACYJNY CZUJNIK MONITOROWANIA

TOKARSKO – FREZARSKI STÓŁ OBRÓBCZY



+ OBROTOWY STÓŁ HYBRYDOWY
+ OŚ C Z TECHNOLOGIĄ BEZPOŚREDNIEGO NAPĘDU
+ OŚ X Z SYSTEMEM MOCOWANIA

SMART P ORAZ SOFTWARE

+ MSM (Monitorowanie czujnika maszyny)
+ PMP (program konserwacji PAMA)
+ PGE (PAMA Ogólna wydajność)
+ PAMA Zaawansowanie frezowanie
+ PAMA TOP frezowanie
+ MONITOROWANIE MOCY (kontrola adaptacyjna)
+ VERT_CRL (Kontrola wektorów)
+ PTB (Balans stołu PAMA)

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COMPANY WITH QUALITY SYSTEM CERTIFIED BY DNV GL = ISO 9001 =