



CNC Special Machines

### Technical Data CR 27 Standard

Details	
Controlller	Siemens 840 D with integrated PC in mobile panel alternatively BWO 920-C with prepared network interworking
Routing spindle	HSK F 63, water-cooled, 12 kW available from 6,000 rpm, infinitely variable speed regulation from 1,000 up to 24,000 rpm
Unit	Universal unit with Z axis stroke 800 mm, A 540°, B +/- 98°, A/B mounted at an angle of 50°
Extraction	Dust and chip collecting basket mounted to the unit, vertically adjustable via CNC, extraction connection 1 x dia. 300
Axis drive technology:	X axis toothed rack Y axis toothed rack Z axis recirculating ball screw
Machine table	4 supporting bars in Y axis direction
Clamping station	Vacuum clamping device, 1 vacuum clamping circuit per table
Protection device	Swivel doors at the front, safety guard with 1 door at the rear side, safety blind between the tables, roller shutters
Working envelope in 3- and 5-axis operation	
Conditions:	Tool dia. 160 mm, total tool length 160 mm X = 1,500 mm, Y = 1,500 mm, Z = 420 mm
Travel speeds	X = 45 m/min, Y = 45 m/min, Z = 24 m/min, A/B = 10,000 °/min
Driving dynamics	
Acceleration:	X, Y, Z: idle running 3 m/sec <sup>2</sup> , operation feed 1.5 m/sec <sup>2</sup>
Tool changer	
Features:	Chain-type tool magazine, with 12 tool places (standard) 16, 24, 32 optional, dia. 160 mm, total length 160 mm. (dia. 90 with magazine with 24, 32 tool places) tool weight max. 6 kg a saw blade with a max. dia. 350 mm, pick-up tool place for saw blade dia. 450 mm
Installation details:	
Machine weight:	approx. 10,000 kg with Z axis stroke 1,500 mm
Required space:	approx. 8,100 x 5,800 x 3,600 (w x d x h) incl. operation and safety space.

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CNC Special Machines

# CR 27



**CNC Machining Centre  
with 5-Axis Technology**  
for high-speed machining  
of wood-derived products  
and aluminium



Subject to technical alterations. 04/2005/3009/pdf

# CR 27

## CNC Machining Centre with 5-Axis Technology

for high-speed machining of wood-derived products and aluminium



### Fields of application

The design of the CR 27 is based on a field-proven concept. Machines with stationary gantry enable high travelling dynamics and thus stand for first-class routing results. This series meets the high standard of those manufacturers requiring three-dimensional machining and machining on multiple sides.

This machining centre has been designed for precise machining operations and is used in the vehicle and vehicle equipment industry, by manufacturers of components for technical products as well as by manufacturers of furniture.

The CR 27 for the machining of aluminium is of special design and specifically

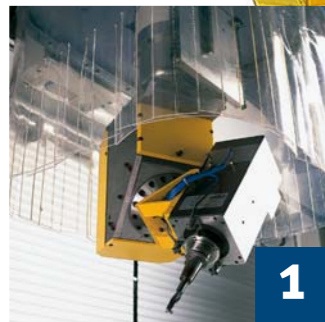
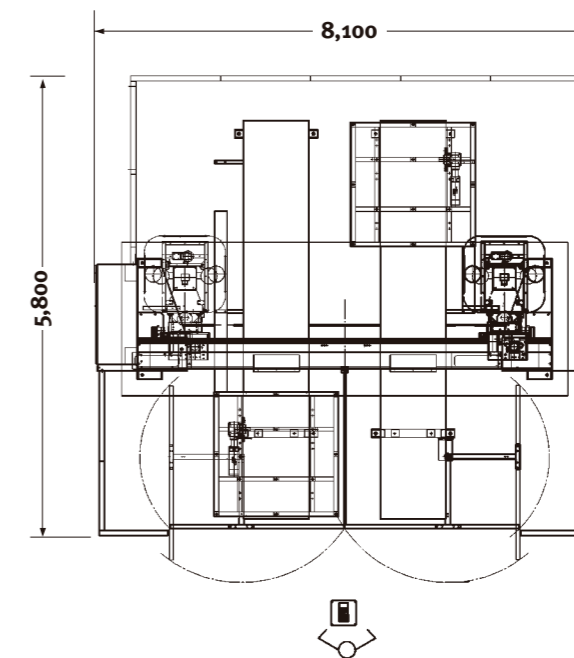
suited to the requirements of light metal machining.

Dynamic rigid design, a high-duty routing unit and a large tool magazine together with the field-proven 5-axis technology allow complete machining operations with only one clamping. Due to the machine design with mobile tables, precision is achieved with high dynamics. A special tool place for a saw blade with a max. dia. of 450 mm can optionally be provided in the chain-type tool changer. A vertically adjustable protection and extraction bin reduces the danger from ejected chips and dust.

### Required space

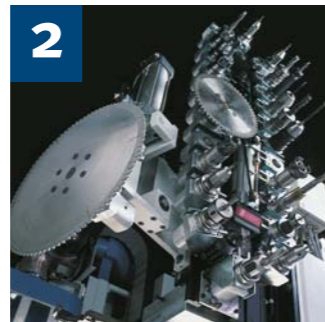
approx. 8,100 x 5,800 x 3,600 (w x d x h)

**Machine weight** approx. 10,000 kg with Z axis stroke 1,250 mm



### Routing unit

As standard-type spindle we offer the HSK F 63 spindle. Other spindle types are available on request



### Tool magazine

Chain-type tool magazine with 12, 16, 24, 32 tool places are possible



### Machine table

Top table, alternatively with supporting bars



### CNC controller

Latest controller generations: Siemens 840 D or BWO 920



Dust and chip collecting basket mounted to the routing unit, vertically adjustable via CNC



### Aluminium machining:

Vacuum fixture for the machining of skateboard blanks