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Ref. No.:
1231-08011840

Overview and Technical Data:

SW BA-400-2 4 Axis Twin Spindle Milling

[SW](#)

SWM

Year of Build:
Jan 2000

Description:

Used SW BA-400-2 CNC 4-Axis Double-spindle horizontal machining centre

CNC Controls Siemens Sinumerik 840D

Spindle 2 was renewed in 09/2021!

Technical Data:

- Travels:
 - X-Axis: 400 mm
 - Y-Axis: 450 (700) mm
 - Z-Axis: 400 mm
 - Max. cutting feed in X/Y/Z: 50/50/50 m/min
 - Feed force X/Y/Z: 9250 N
 - Linear glass scales
- Spindle
 - Spindel Speed range :50-12500 rpm
 - Torque: 2 x 120 Nm
 - IKZ 40 bar
 - Tool interface for hollow shank taper
 - Tool taper: r DIN 69 893-HSK A-63
 - Spindle distance 400 mm
- Tools:
 - Chain-type tool magazine 2×30 stations
 - Max. tool diameter 75 mm
 - Max. tool diameter without adjacent tools 160 mm
 - Max. tool length 300 mm
 - Max. workpiece weight 10 kg
 - Chip-to-chip time 3,8 s
- Coolant system
- Chip conveyor
- Knoll filter fineness 0.060 mm
- 1 set of clamping bridge supports to hold
 - 1 clamping bridge / with 4-fold hydraulic and 5-fold pneumatic connection
 - 9-way plug-in coupling
- High pressure pump 70 bar/30 l
- Automatic loading doors
- Memory extension 256 Kbyte
- Electronic handwheel
- Extension of the machine hydraulics for clamping workpieces up to p=150 bar at Q= 121/min.
- Tool breakage control Laser system Fabr. Blum
- Scope of delivery:
 - 50 tool holders
 - 2 pcs. clamping bridge supports
- Dimensions
 - Total power requirement 68 kVA
 - Space requirement of the whole equipment: (LxWxH) approx. 3000x4700x3000 mm
 - Machine weight approx.: 12000 kg

The machine is in good condition and can be inspected under power at any time.

The advantage of multi-spindle machining is simultaneous machining of several workpieces thus considerably reducing costs. It is also possible to assign several workpieces to one spindle. In SW clamping fixtures, designed and manufactured in our plant.

Possible Milling Products will benefit from a SW multi-spindle machine center

- Exhaust manifolds
- Common Rail pump housings
- Hydraulic housings
- Wheel hubs for trucks
- Brackets
- Motor blocks
- Brake calipers
- Hinged tie bars
- Bearing caps
- Clamping chucks
- Caliper brackets
- Engine and gearbox housings

Since its launch the SW BA series is setting standards in the field of multi-spindle, heavy machining. Due to the excellent accessibility of the loading area from the front and from the top the machine can be loaded and unloaded manually or via an automated system - again in parallel with the machining process. For these machines SW is offering the multiple cnc controls

Efficiency.

There are many ways to machine steel and cast iron workpieces. But there are only a few allowing to reach an optimum result in view of the given situation. The SW BA class offers a machining center which has set standards in its class with regard to efficiency and performance and which will continue to do so. The BA 400 and BA 600 centers available with 2 or 4 spindles, with 4 and 5 axes which can be loaded in parallel with the machining process provide for the appropriate concept for your machining process.

Technical Data:

Technical Data:

Control:

[SINUMERIK 840D](#)

Spindle Speed:

12.500 rpm

Tool Holder:

[HSK-A63](#)

Tool Capacity:

60 x

Travels:

X-Axis:

400 mm

Y-Axis:
450mm
Z-Axis:
400 mm

Dimensions and Weight:

Height:
3.000 mm
Width:
4.700 mm
Length:
3.000 mm
Weight:
12.000 kg

Buyer Information:

Condition:
[Very good condition](#)
Availability:
[Sold](#)
Sold as:
[EXW \(Ex Works - Incoterm\)](#)
VAT:
[19 %](#)
Buyers Premium:
[18 %](#)
Location:
Germany

Images:



1



2









CE

2000

SW



Schwäbische
Werkzeugmaschinen GmbH
Seedorfer Straße 91
D-78713 Schramberg-Waldm.

Typ / Masch.-Nr.
Type / Machine No.
Modèle / No Machine

BA 400-2

E-Plan Nr.
Circuit diagram no.
Schéma No

Nennbetriebspannung
Nominal operating voltage
Tension de service nominale

3/PE AC 400V/50Hz

Spindel
Spindle
Broche

S1 25kW

Nennbetriebsstrom
Nominal working current
Tension de service

108 A

Anschlußleistung
Total connected rating
Puissance total connectée

75 KVA

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Assessment and Sale of Used Assets world wide

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