



Ref. No.:  
1231-08011840

**Overview and Technical Data:**

**SW BA-400-2 4 Axis Twin Spindle Milling**

**SW**



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 tape: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  $Q= 121/\text{min}$ .
- Tool breakage control Laser system Fabr. Blum
- Scope of delivery:
  - 50 tool holders
  - 2 pcs. clamping bridge supports
- Dimentions
  - Total power requirement 68 kVA
  - Space requirement of the whole equipement: (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:**

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



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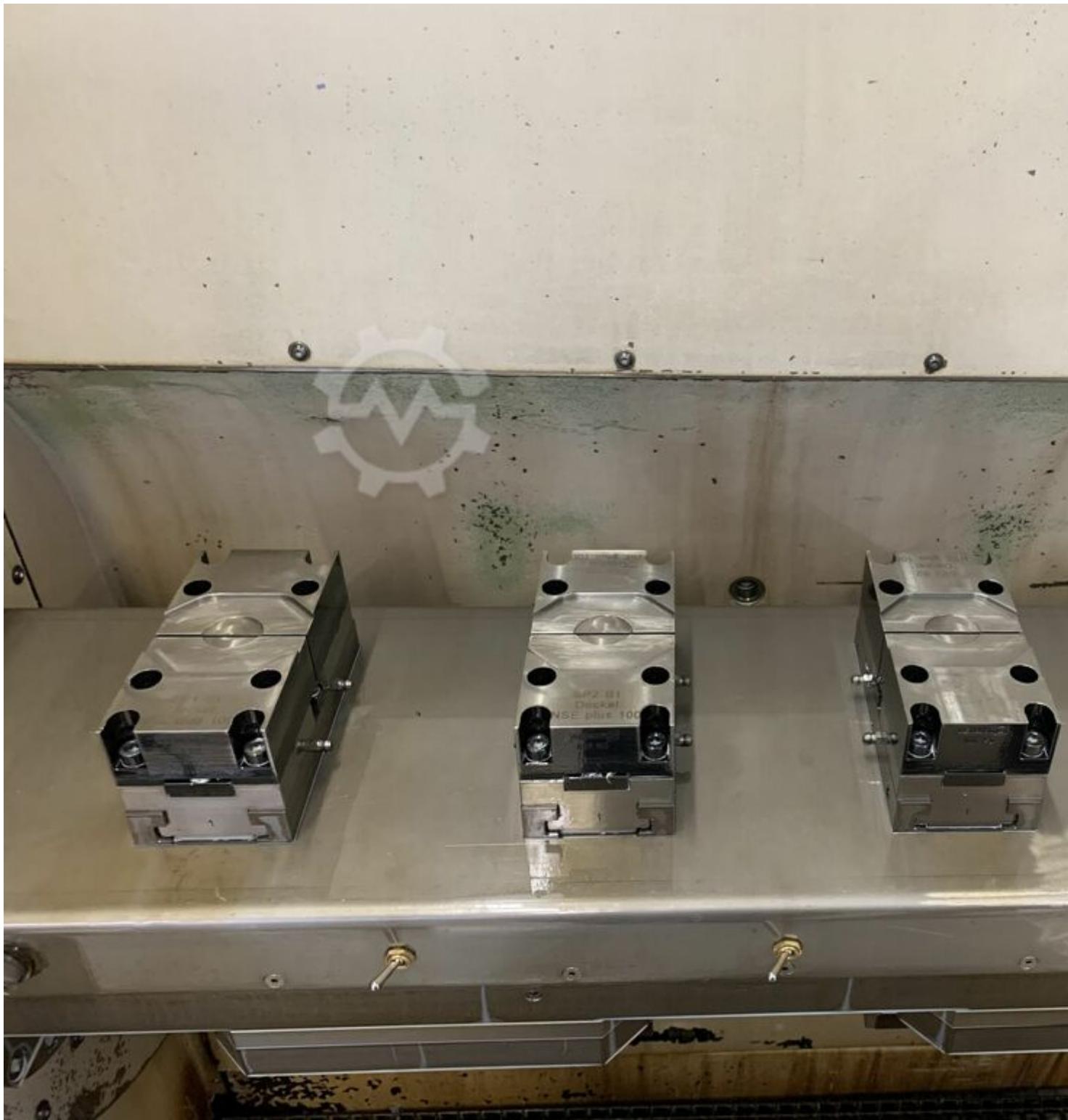


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CE 2000

SW



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

Typ / Masch.-Nr.  
Type / Machine No.  
Modell / No Maschine

BA 400-2

E-Plan Nr.  
Circuit diagram no.  
Schéma No

3/PE AC 400V/50Hz

Nennbetriebsspannung  
Nominal operating voltage  
Tension de service nominale

S1 25kW

Spindel  
Spindle  
Broche

108 A

Nennbetriebsstrom  
Nominal working current  
Tension de service

75 KVA

Anschlussleistung  
Total connected rating  
Puissance total connectée



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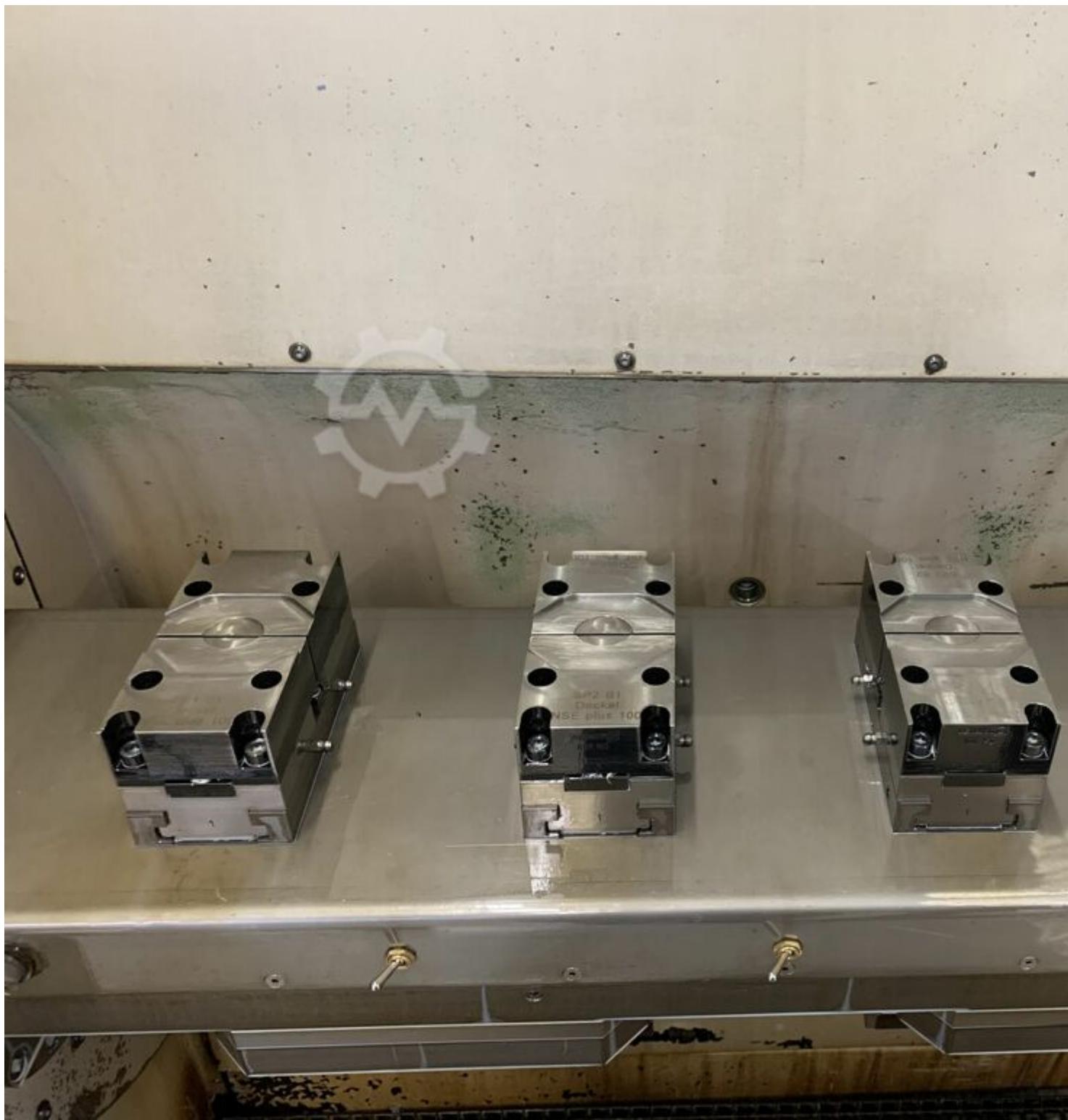


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BA 400-2

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Circuit diagram no.  
Schéma No

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