

Horizontal CNC lathe for metal machining

Technical specification

No.	Description of a parameter	Value
Functional and qualitative parameters		
1	Distance between centers	Not less than 2000 mm
2	Swing over bed	Not less than 750 mm
3	Maximum cutting diameter	Not less than 550 mm
4	Maximum cutting length	Not less than 2000 mm
5	Maximum bar through spindle diameter	Not less than 170 mm
6	Maximum spindle power while in S1 duty cycle	Not less than 30 kW
7	Maximum spindle power while in S6 duty cycle 30 min	Not less than 35 kW
8	Maximum spindle torque at 100 rpm and S1 duty cycle	Not less than 2200 Nm
9	Maximum spindle speed	Not less than 1000 rpm/min
10	Quantity of tool stations in a turret	Not less than 8 pcs
11	Automatic tool length pre-setter	Yes
12	Speed of a rapid traverse in the x axis	Not less than 10 m/s
13	Speed of a rapid traverse in the z axis	Not less than 14 m/s
14	Manual, hydraulic or pneumatic chuck 18 inches diameter or bigger, with bar diameter capacity through a bore of the chuck not less than 170 mm. The chuck is supplemented with an additional set of jaws suitable to clamp a 30 mm diameter bar	Yes
15	Tailstock with	Yes
	- maximum workpiece weight capacity	Not less than 1000 kg
	- hydraulic or pneumatic clamping of the workpiece	Yes
	- live center	Yes
16	Steady rest with	Yes
	- the lower limit of a clamped diameter	Not more than 30 mm
	- the upper limit of a clamped diameter	Not less than 400 mm
	- maximum workpiece weight capacity	Not less than 1000 kg
	- 2 pcs. of steady rests are allowed	Yes
17	Workpiece cutting zone is fully enclosed while in operation	Yes
18	Pressure of a coolant pump	Not less than 5 bar
19	Coolant supply through each individual tool station of the turret	Yes
20	Oil skimmer	Yes
21	Chip conveyor(s) with an unloading box	Yes
22	Air blower for chip removal	Yes
23	Oil mist filtering device activated by a M code from the machine controller	Yes
24	Power supply transformer	Yes
25	Weight of the machine	Not less than 10000 kg
Control parameters		
26	SIEMENS SINUMERIK 828D or HEIDENHAIN CNC PILOT 640 controller	Yes
27	SIEMENS ShopTurn or HEIDENHAIN smart.Turn software package	Yes
28	Intranet interface connection module	Yes
Other requirements		
29	The equipment must be new (unused) and manufactured no more than 3 years before the date of purchase.	Yes
30	CE declaration of conformity in English	Yes

31	Safety requirements in English and Lithuanian	Yes
32	Operating manual in English and Russian, both paper and electronic copy	Yes
33	Service manual with electrical and hydraulic schemes and spare parts catalogue in English	Yes
34	Warranty period for the controller, motors, drives and electrical part elements	Not less than 24 months
35	Warranty period for the hydraulic and mechanical elements	Not less than 12 months
36	Commissioning costs of the equipment are included	Yes
37	Delivery costs to Ulonų g. 33, 62161 Alytus, Lithuania are included (without unloading costs)	Yes
38	Training costs for the Buyer's personnel are included. Teaching comprises minimum 16 working hours program and finishes after the Supplier issues training certificates to the Buyers personnel.	Yes
39	Costs of an acceptance test of precision of the machine are included. During the precision testing, the representative of the Supplier must machine the part which drawing is attached as Annex No 2 to the Tender Terms and Conditions. After the machining, the part will be measured. If all dimensions of the part fall within tolerances set by the drawing, the precision acceptance protocol shall be signed by both parties. Shall the machined part fail to meet the drawing requirements, the Supplier shall be provided with an additional workpiece and an attempt to fulfill them. The Supplier can also delegate to perform the precision test to the Buyer as the latter has qualified turning operators himself. In either case, responsibility to successfully pass the precision test falls solely to the Supplier in spite of whose operator will perform the machining of the part. The precision test will be performed at the Buyer's site in a place where the lathe will be installed. The Buyer will prepare the required quantity of workpieces for machining.	Yes
40	Set of all tools and tool holders needed to machine the above mentioned part is supplied with the machine and their costs are included in a delivery package.	Yes
41	Costs of creating and setting the CNC program for the machining of the above mentioned testing part are included	Yes