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Ref. No.:

1231-080111900

## **Overview and Technical Data:**

# **SW BA-400-2 5-Axis Twin Spindle Milling**

[SW](#)

# SWM

Year of Build:

Jan 2001

**Description:**

# Used SW - BA 400-2 CNC 5-axis horizontal double spindle machining centre

Control: Siemens Sinumerik 840 D

Equipped with coolant system & chip conveyor

Technical data:

- Travel:
  - X-axis: 400 mm
  - Y-axis: 450 mm
  - Z-axis: 400 mm
  - Max. cutting feed in X/Y/Z: 40/40/40 m/min
  - Feed force X/Y/Z: 9250 N
- Spindle:
  - Spindle Speed range: 50 - 12,500 rpm
  - Torque: 2 x 120 Nm
  - Power (S6/40%ED): 2x 35 kW/2600 rpm
  - IKZ 40 bar
- 2-axis swivel unit consisting of:
  - NC swivel axis (A-axis)with face plate: D=225
  - 2 NC-tables (B-axis) approx. D=240 installed in a common traverse, as well as a tangential mandrel of min.800 Nm per B-axis
  - hydraulically clamped counter bearing
  - 5-fold rotary distributor (A-axis)
  - 5-fold rotary distributor (B-axis)
- Tools
  - Tool holder: HSK 63 DIN 69893
  - Number of places in the tool changer: 2 x 60 pieces
  - Standard: 70 mm
  - with one free neighbouring place each: 140 mm
  - with two free neighbouring places each: 160 mm
  - Chip-to-chip time 3,8 s
- Scope of delivery:
  - approx 50 tool holders
  - approx. 2 clamping bridge supports
  - NC rotary table: 2 NC tables (B axis), Ø approx. 240 mm
  - 1 swivel bridge 4 axes, 1 swivel bridge 5 axes
- Additional equipment:
  - Extension of machine hydraulics for clamping workpieces up to 250 bar at Q=9 l/min.
  - Oil distributor for NC rotary table
  - Extended coolant system
  - High pressure pump 70 bar/30 L
  - Automatic loading door
  - Signal light
  - Tool breakage control Laser system Blum
  - Memory extension 256 KByte
- Space requirement of the whole equipment (LxWxH) approx.: 3000x4700x3000 mm
- Machine weight approx. 13800 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:

120 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:  
13.800 kg

### **Buyer Information:**

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

### **Images:**



SINUMERIK

SIEMENS

700048 | ERBROCHENE ROHR GESCHLOSSEN

WKS	Funktion	Arbeitsbereich	Maßstab	S1
X	0.000 mm	0.000	0 U/Am	
Y	0.000 mm	0.000	0 U/Am	
Z	0.000 mm	0.000	0 grad	
A			100.0	
B	175.000 grad	0.000		

Maßstab: 1:1

Werkzeug: [ ]

Werkzeuglänge: [ ]

Werkzeugradius: [ ]

Werkzeugoffset: [ ]

Werkzeugradiusoffset: [ ]

Werkzeugradiusoffset 2: [ ]

Werkzeugradiusoffset 3: [ ]

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Keypad with alphanumeric keys (A-Z, 0-9), function keys (F1-F12), and navigation keys (Home, End, etc.).



Secondary keypad with alphanumeric keys (X, Y, Z, A, B, U, V, S1, S2, W, Q, R, T, H, I, J, K, L, M, N, O, P, S, T, U, V, W, X, Y, Z) and function keys.



Control panel with various buttons, switches, and keys, including a red emergency stop button and a key switch.

HLUNG  
AHL BÜCKEN  
ASSE 2

Technical drawing or table with columns and rows, partially visible.



Schreiber 01.04.2008





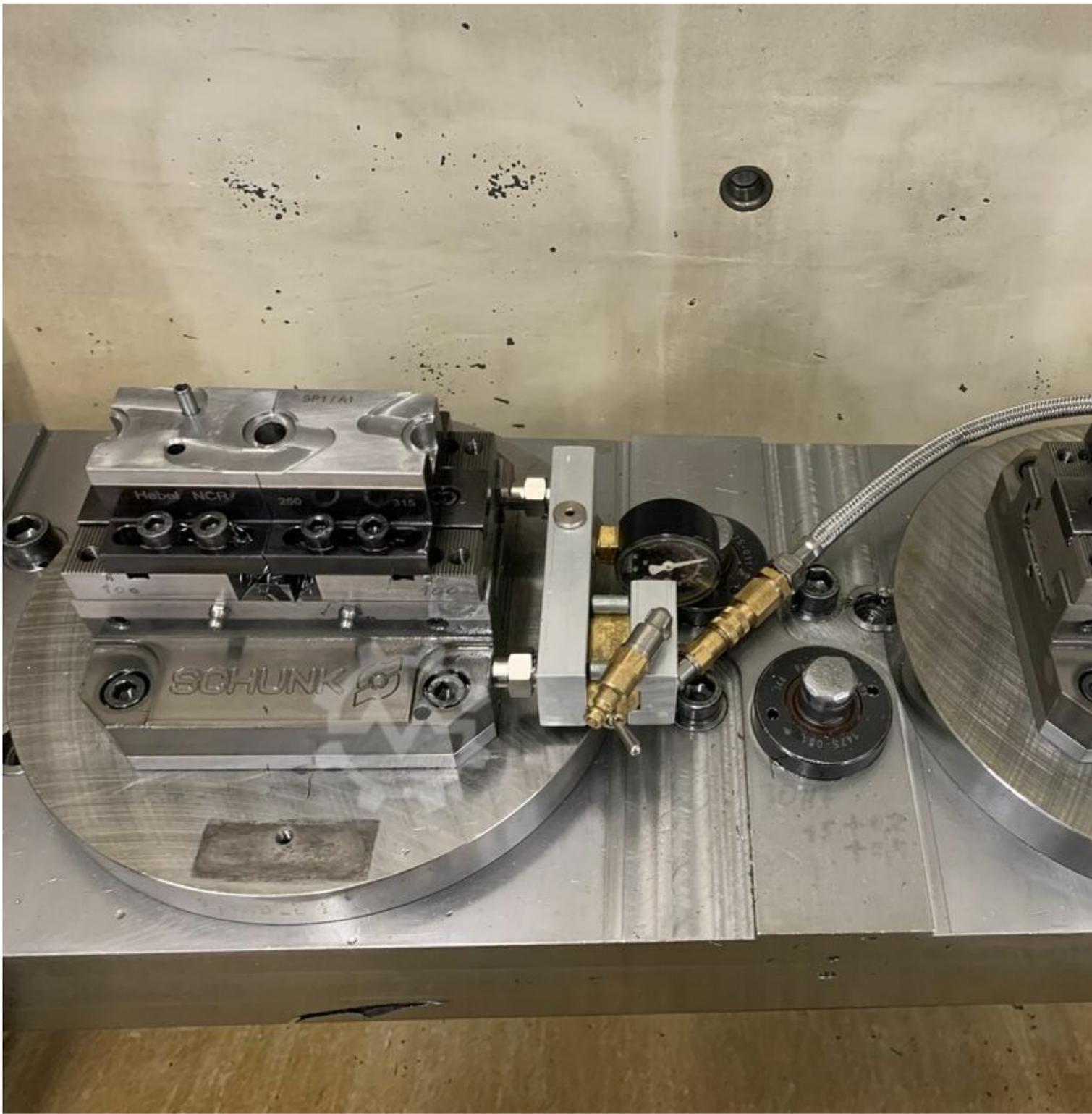
3



4









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 électrique no

Nennbetriebsspannung . . . . .  
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

08-021



2001

8



Asset-Trade

Assessment and Sale of Used Assets world wide

Am Sonnenhof 16

47800 Krefeld

Germany

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Fax.: +49 2151 65 29 22

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Web.: <https://mail.asset-trade.de/en>

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400 mm

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450mm

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400 mm

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3.000 mm

Width:

4.700 mm

Length:

3.000 mm

Weight:  
13.800 kg

## **Buyer Information:**

Condition:  
[Very good condition](#)

Availability:

[Sold](#)

Sold as:

[EXW \(Ex Works - Incoterm\)](#)

VAT:

[19 %](#)

Buyers Premium:

[18 %](#)

Location:

Germany

## **Images:**









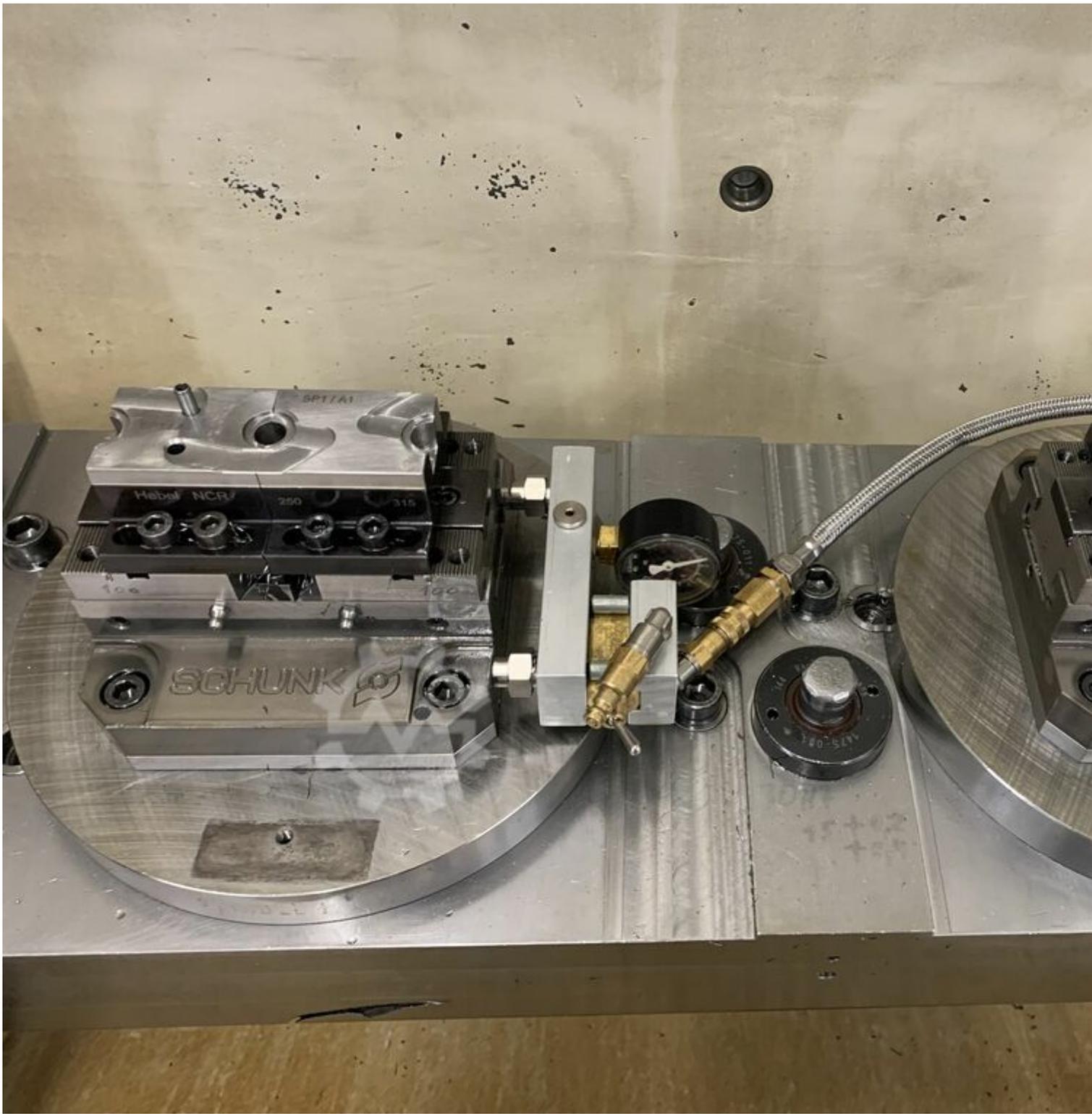
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