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Ref. No.:

1447-11141134

## Overview and Technical Data:

# DÖRRIES SCHARMANN Solon 3 with 7 Pallettes

## DÖRRIES SCHARMANN



Year of Build:

Sep 1990

Rebuild year:

Jan 2007

## Description:

### Used DÖRRIES SCHARMANN Solon 3 - CNC machining center with 7 pallets

The Dörries Scharmann Solon 3 CNC machining center offers outstanding high precision for machining complex workpieces. With a Siemens 840D control and a 7-pallet system, it optimizes production through quick pallet changes and significantly reduces idle times. Its CNC machining enables precise travel paths and a high spindle speed of up to 4500 rpm. This machine is ideal for companies that want to machine large workpieces with high efficiency and accuracy. Benefit from a reliable, high-performance solution for your production processes.

2007 Complete modernization to Siemens 840D control

## Technical data Solon 3 BAZ:

- Travel paths:
  - X-axis from 800 to +800 = 1600 mm
  - Y-axis from +50 to +1050 = 1000 mm
  - Z-axis from +250 to +1290 = 1000 mm
  - Rapid traverse 25 m/min

- Number of tools: 110
- Automatic pallet changing system
- Tooling:
  - Number of tools: 110x
  - Tool change possible while the machine is running
  - Tool management system (TIS) = Automatic tool change system
  - Tool change time 8 seconds
  - Length/breakage control - Renishaw probe for all types of measuring programs possible
- Spindle with 3 gear levels:
  - Level 1: 0 - 532 rpm
  - Level 2: 532 - 1600 rpm
  - Level 3: 1603 - 4500 rpm
  - Spindle power: 37kW
  - Spindle mount: SK50 taper
  - Efficiency 95%
  - Cooling water pressure through the spindle: 30 bar

### Technical data HBC:

Control version: 850 M

- Table pallets:
  - Number of pallets: 7 - STS. Linear pallet transport system
  - Table dimensions: 1.000mm x 800 mm
  - equipped with 7 T-slots 18 x 30 mm deep 30 mm
  - Max workpiece weight on the table: 2500 kg
  - Rotary table in the machine
- Maximum width :
  - Product is 1600 mm (because of the shower nozzles in the machine)
  - and 1075 from front to back
  - Front max 150 mm above table
  - Back 125 mm above table (because of the big door)
  - Front max 190 above table, but then the big Door must be open when moving in and out, otherwise the door will hit the product when moving out and the product will go through the windows when it is at station
- Max. height of product that can go into the machine because of the large door = 1300 mm (measured from the table)
- Oil tanks outside the machine so they can be filled without interruption
- Fixed loading station so we don't have to lug clamping devices back and forth Closed machining cabin, because of smoke and flying cooling water Tool magazine change when machine is rotating

Tools can be purchased separately!!!

Machine can be viewed under power.

The DÖRRIES SCHARMANN Solon 3 machining centre is a high-performance machining centre that can process large and complex products with precision and efficiency. It has a Siemens 840D control system and a rotary table with seven 1000 x 800 mm tables. The machine has three traversing axes: X-axis of 1600 mm, Y-axis of 1000 mm and Z-axis of 1000 mm. The machine can reach a maximum spindle speed of 4500 rpm and a cooling water pressure of 30 bar. The machine has a tool magazine with 110 tools and a Renishaw probe for length and breakage control. The machine also has oil tanks outside the machine, a fixed loading station and an enclosed machining cabin. The DÖRRIES SCHARMANN Solon 3 machining centre is ideal for machining long products with high accuracy and quality. The 7-pallet station is one of the features that make the DÖRRIES SCHARMANN Solon 3 machining centre an excellent machining centre for large and

complex products. The machine can switch between different pallets without interrupting the machining process, which reduces non-productive time and increases productivity.

## **Technical Data:**

## **Technical Data:**

Control:

[SINUMERIK 840D](#)

Spindle Speed:

4.500 rpm

Tool Holder:

[SK50](#)

Tool Capacity:

110 x

## **Travels:**

X-Axis:

1.600 mm

Y-Axis:

1.000mm

Z-Axis:

1.000 mm

## **Dimensions and Weight:**

Height:

4.800 mm

Width:

4.800 mm

Length:

8.500 mm

Weight:

6.500 kg

## **Buyer Information:**

Condition:

[Very good condition](#)

Availability:

[Immediately](#)

Sold as:

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

VAT:

[21 %](#)

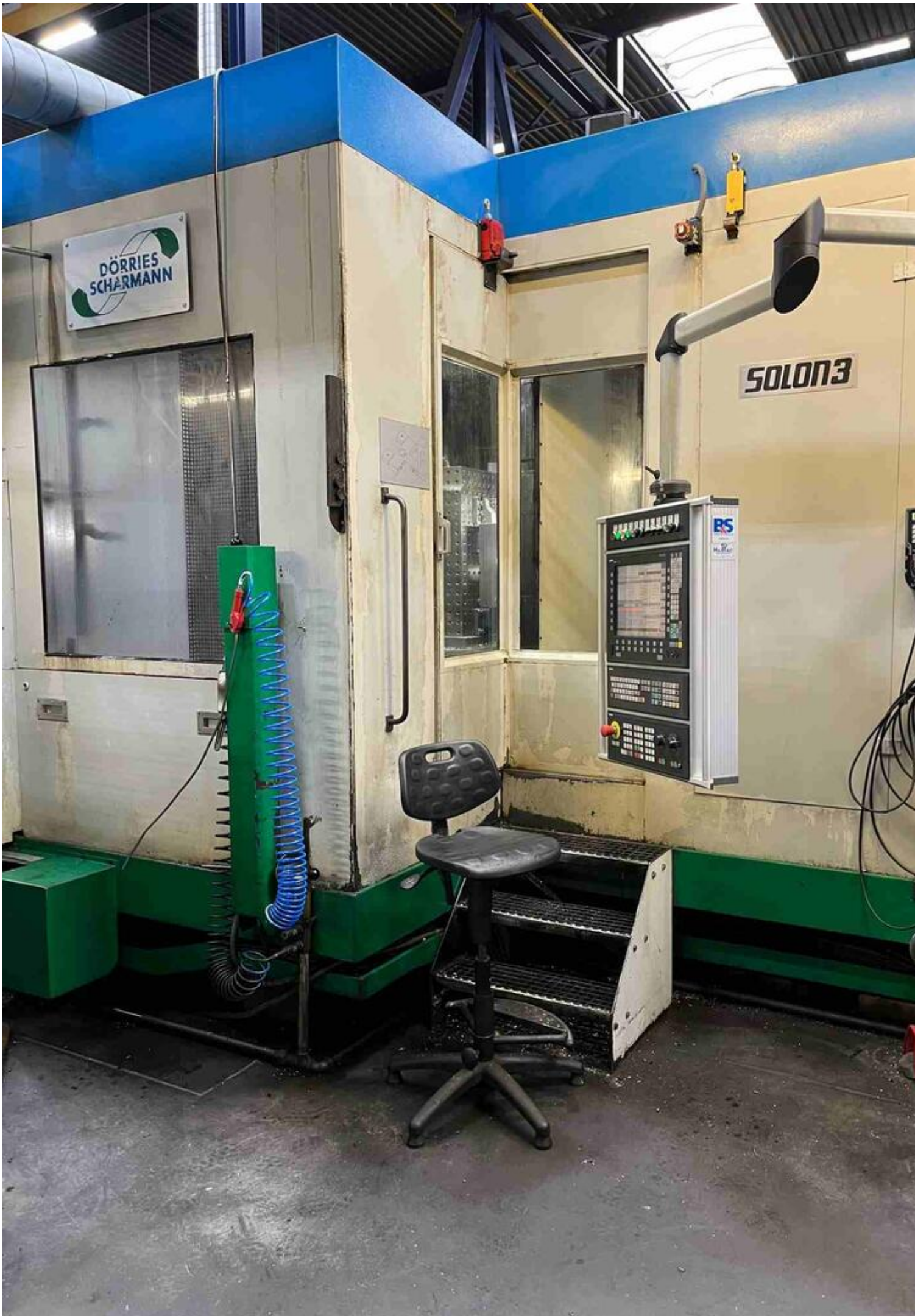
Buyers Premium:

[18 %](#)

Location:

Netherlands

**Images:**



DÖRRIES  
SCHARMANN

SOLON3

BS  
MAG















**SOLON3**

















5209  
F-200





























EB 22



8

TOP











6

5

5

СИМЕНС 2















Gekapseltes Längenmessgerät  
Sealed linear encoder

LC183

Messlänge Measuring length	1740 mm
Identnummer Identification number	657679-17
Seriennummer Serial number	32536881 N
Genauigkeit Accuracy	± 5,0 µm
Referenzmarkenlage Reference mark position	/ mm

Three Siemens labels for linear encoders, each with technical specifications and a QR code.

- Label 1 (xas):** SIEMENS xas. Part number: 657679-17. Serial number: 32536881 N. Accuracy: ± 5,0 µm. Reference mark position: / mm. Dimensions: 1740 mm length.
- Label 2 (yas):** SIEMENS yas. Part number: 657679-17. Serial number: 32536881 N. Accuracy: ± 5,0 µm. Reference mark position: / mm. Dimensions: 1740 mm length.
- Label 3 (zas):** SIEMENS zas. Part number: 657679-17. Serial number: 32536881 N. Accuracy: ± 5,0 µm. Reference mark position: / mm. Dimensions: 1740 mm length.

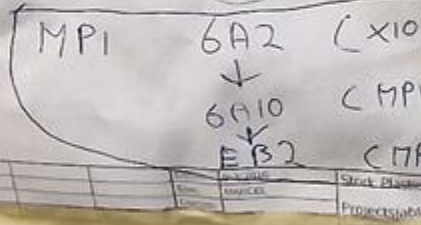
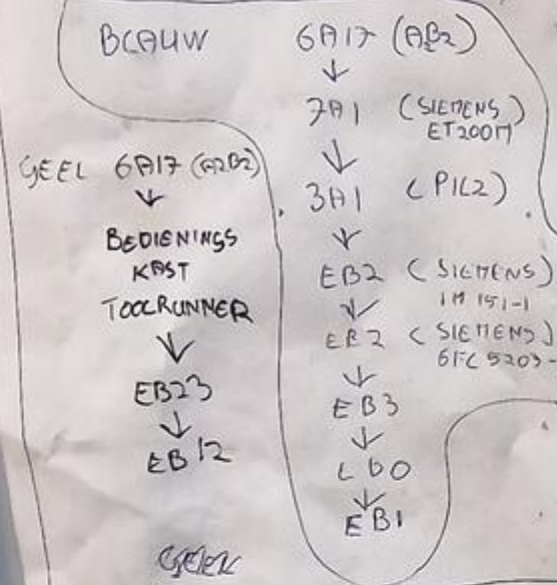
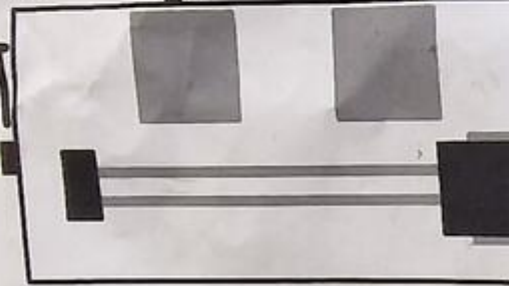


.viceleur 2

EB5  
E-box

EB6  
E-box

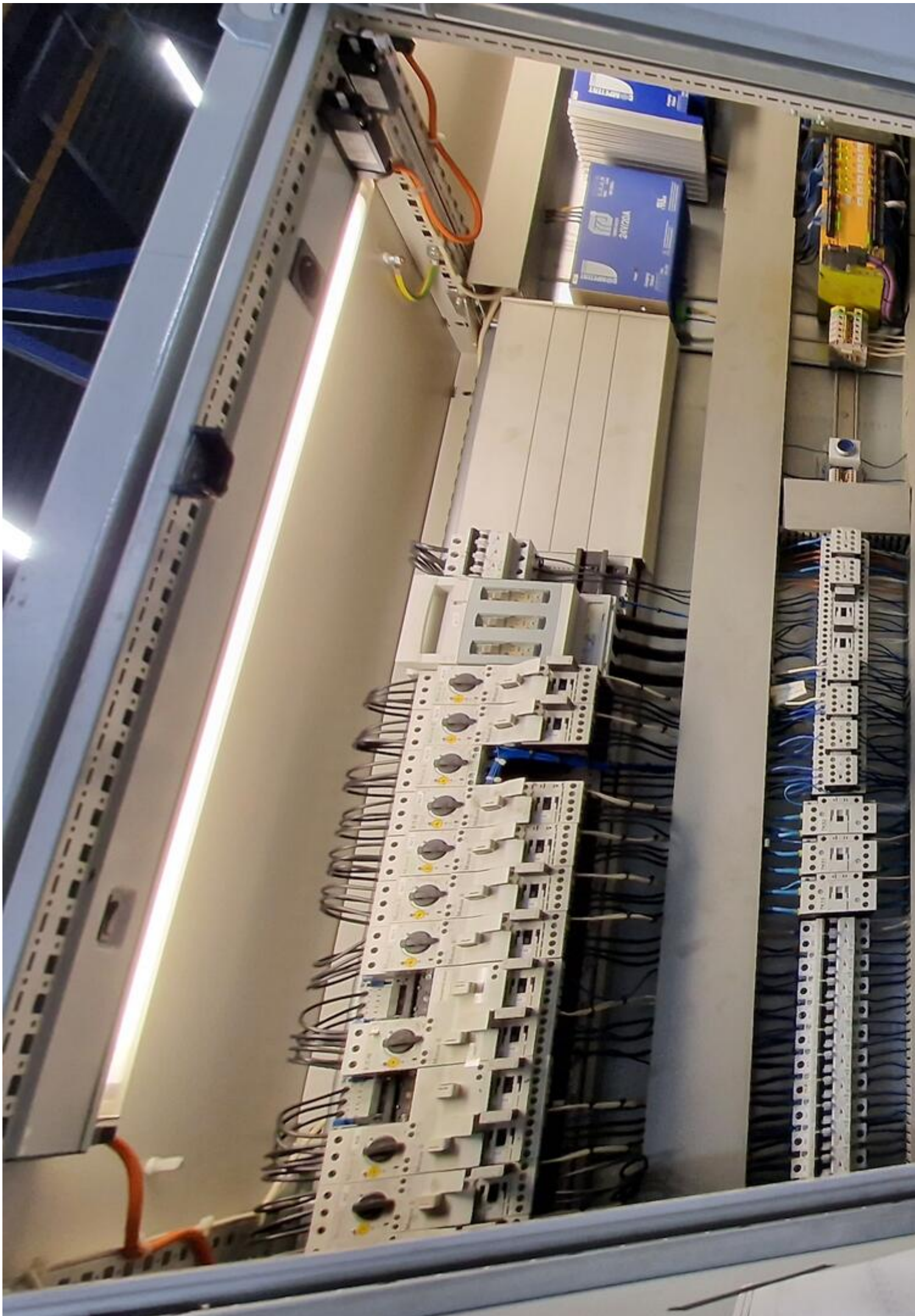
E-box  
EB4



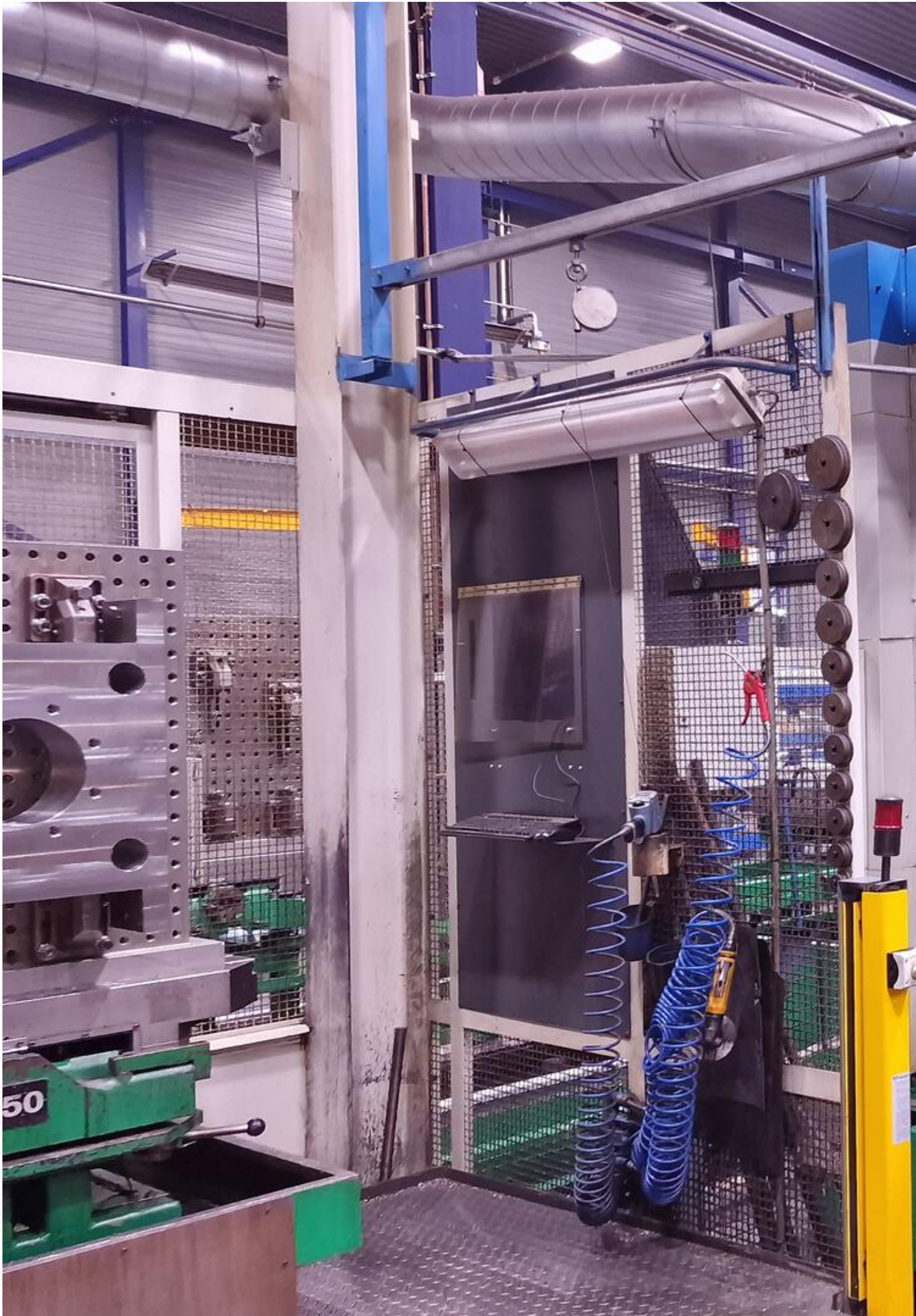




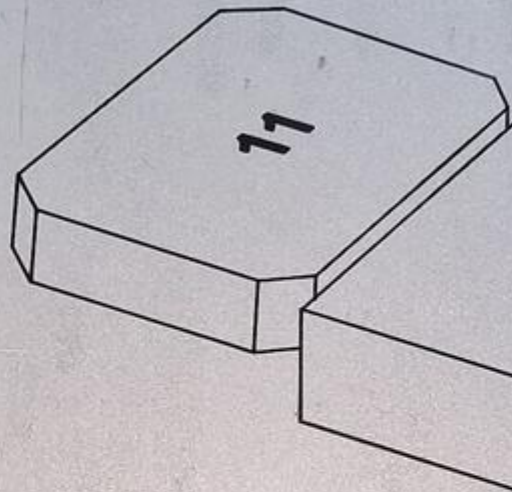




















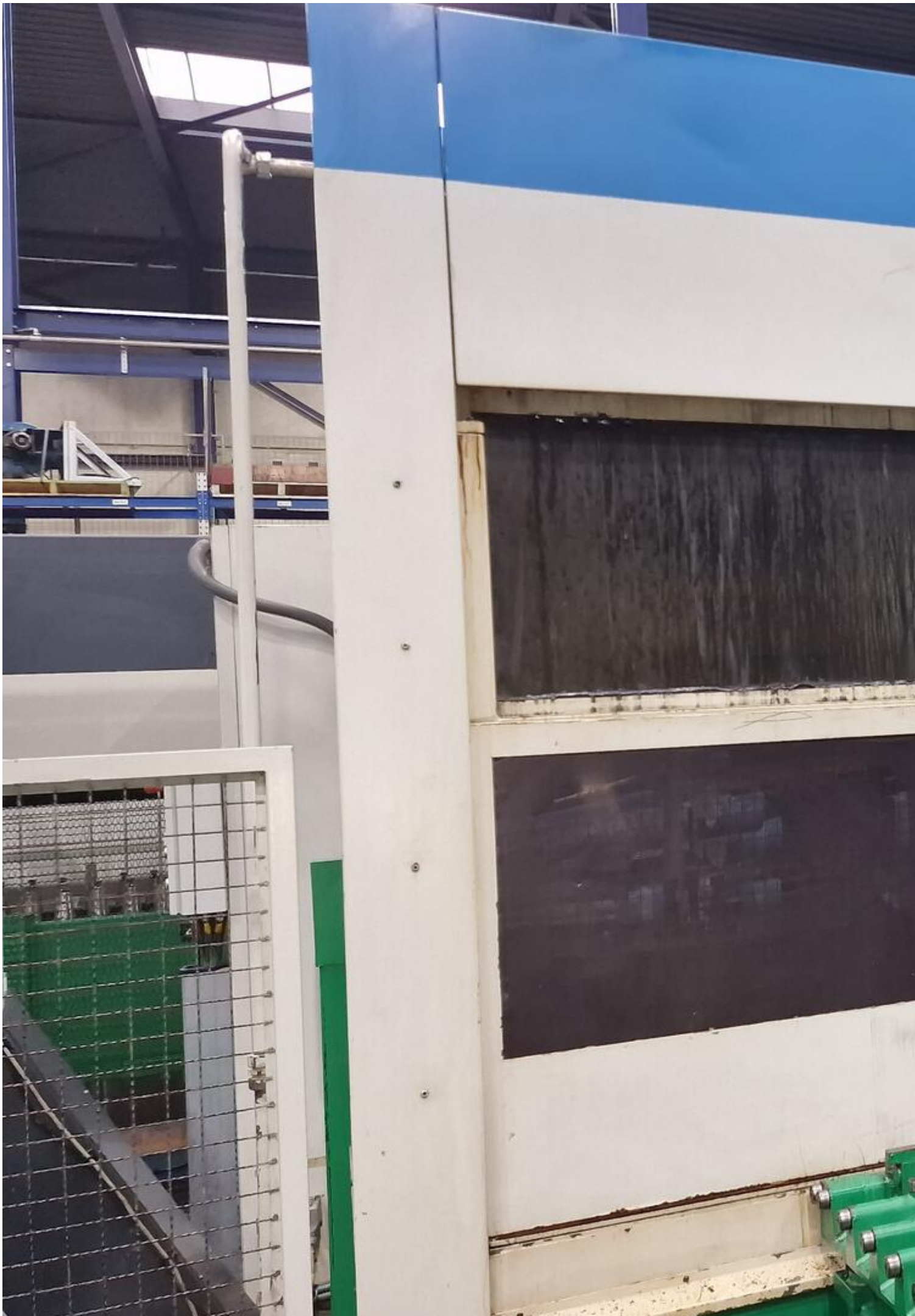








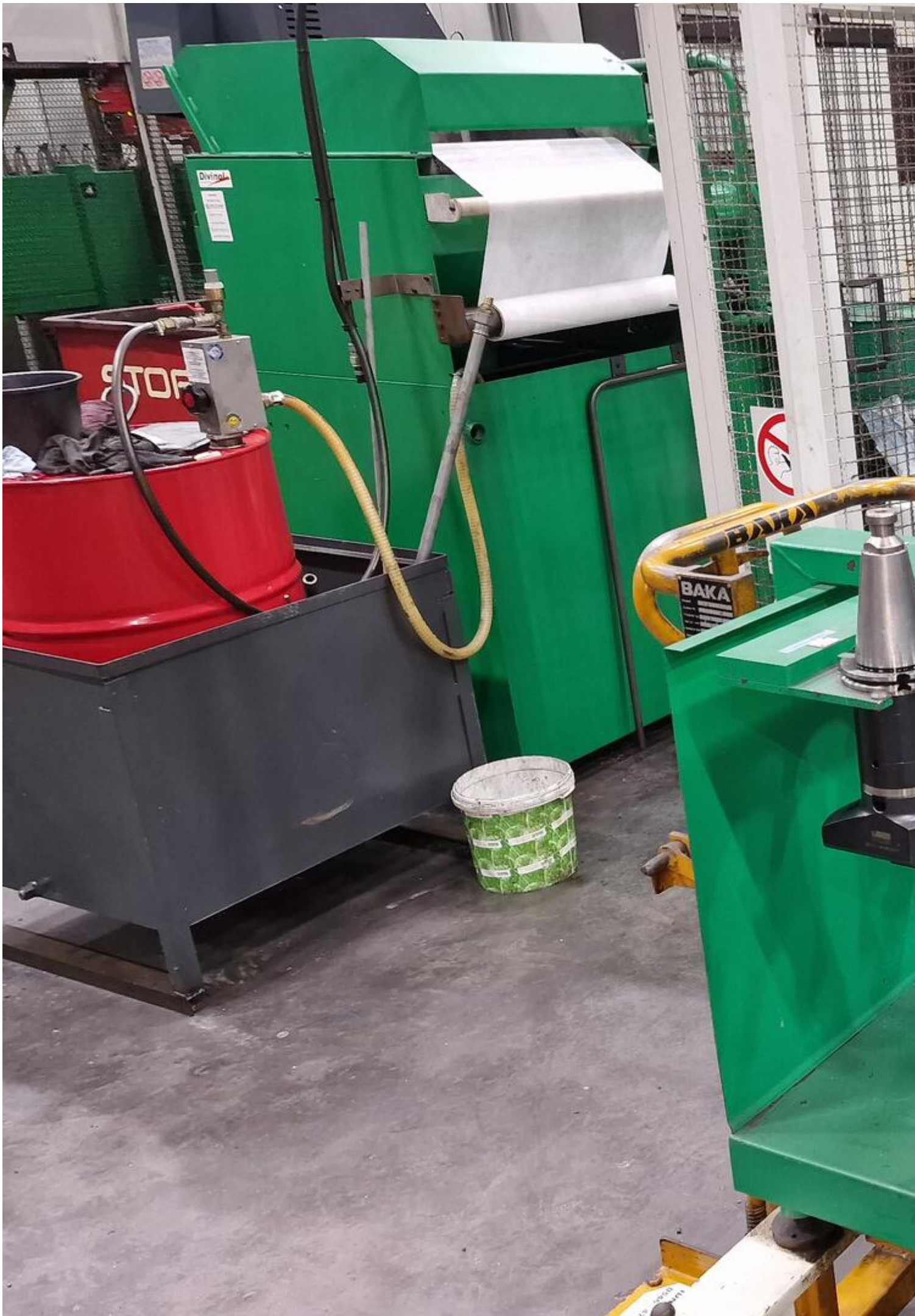












33

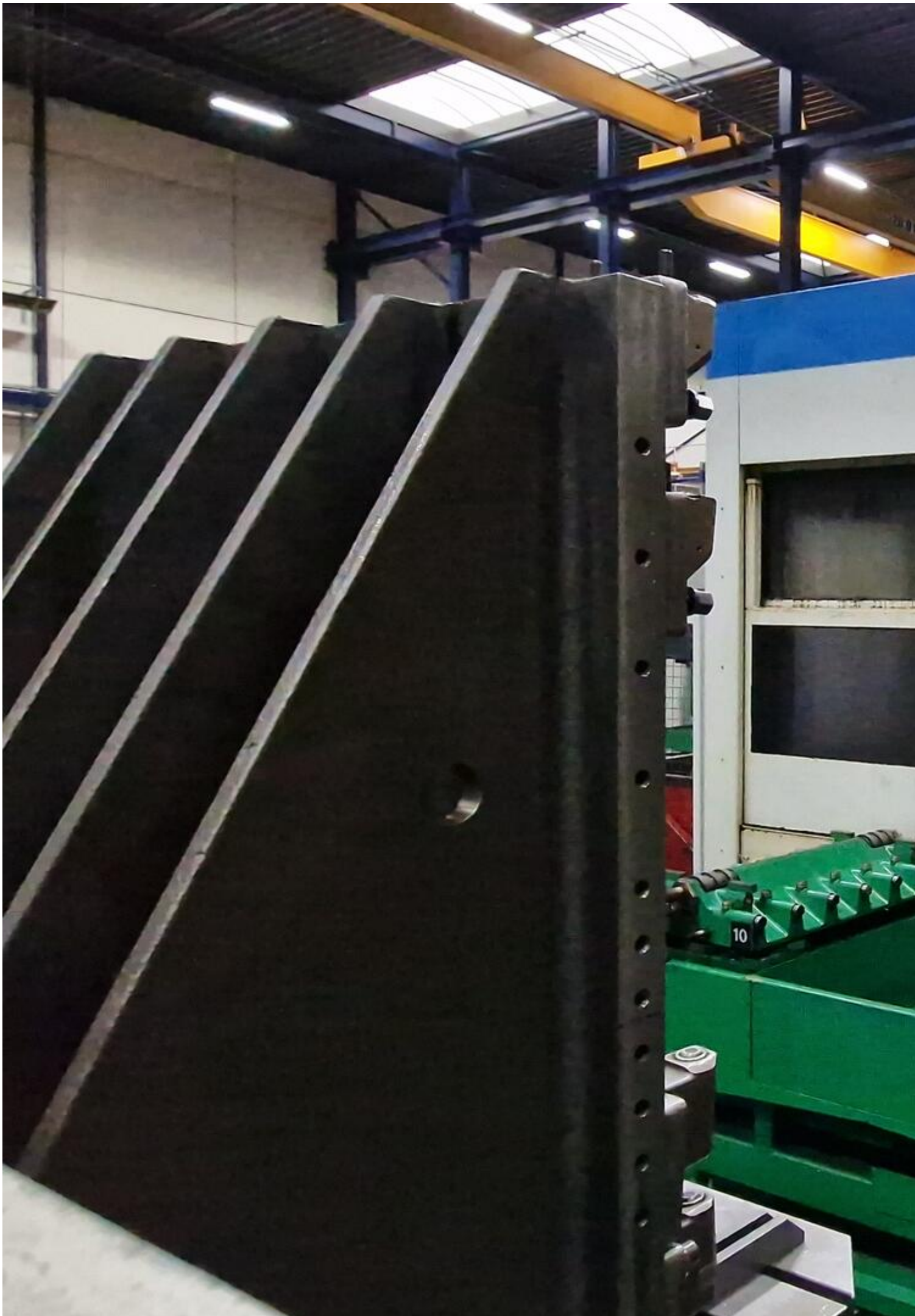
Diving

STOP

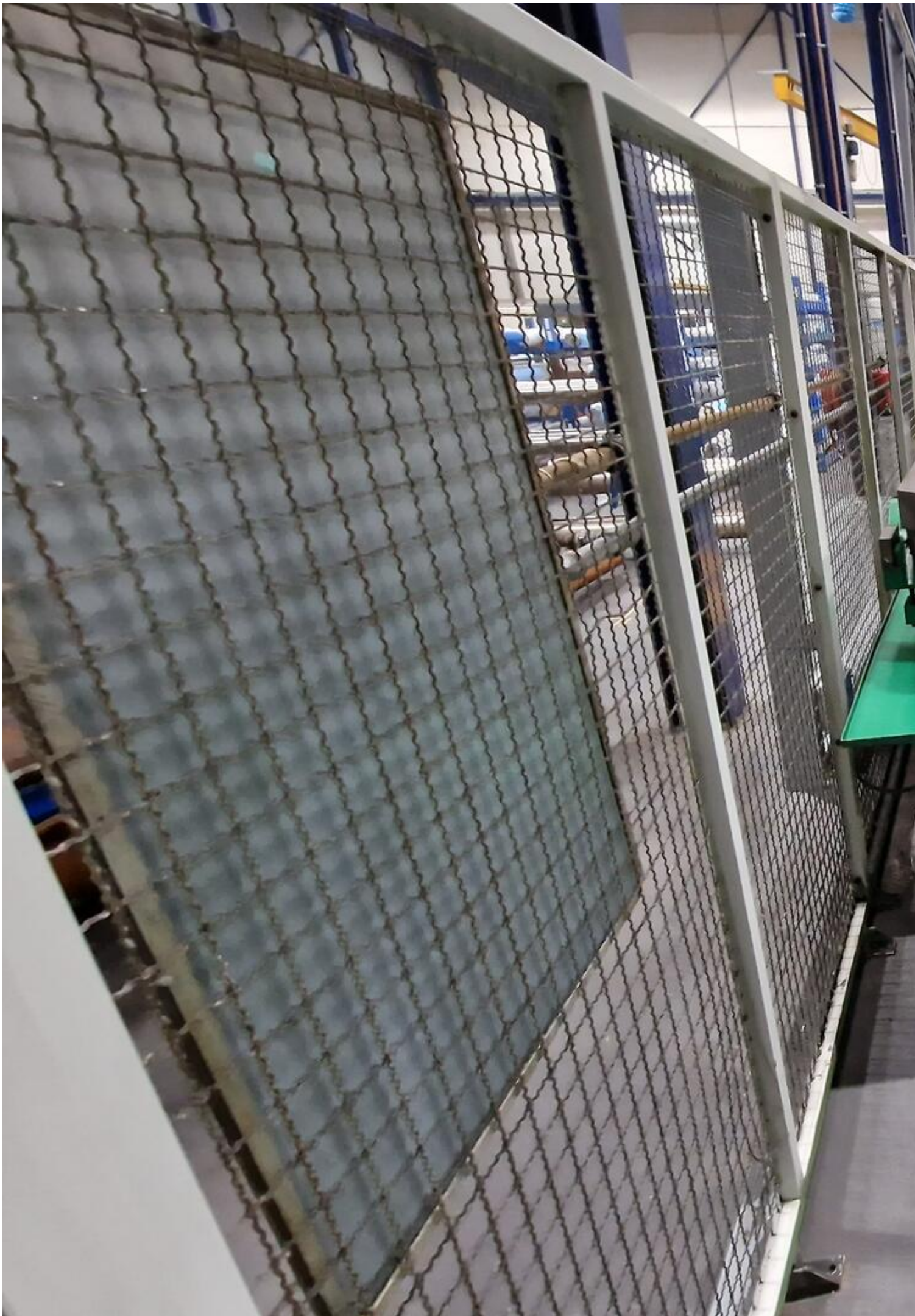
BAKA







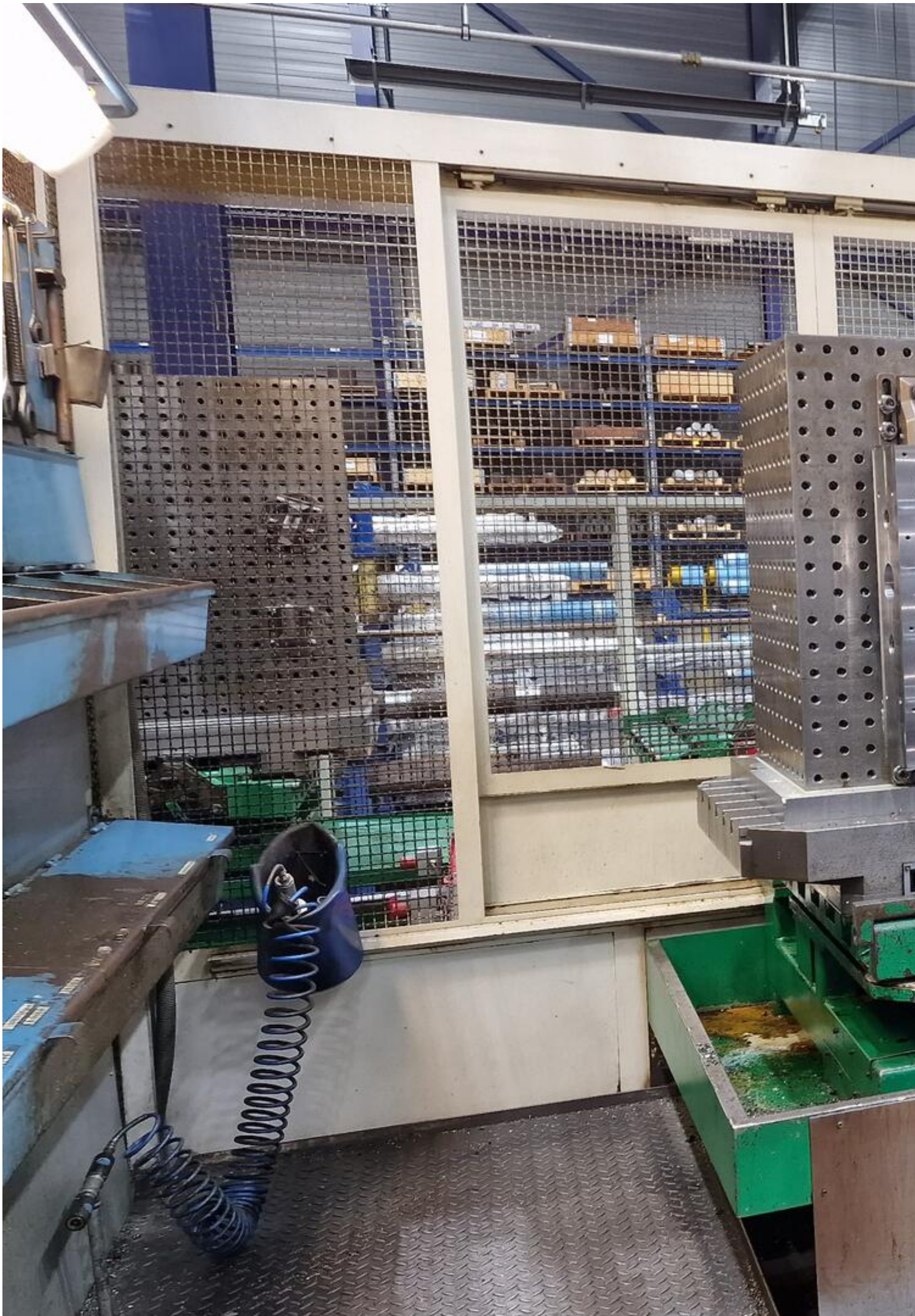






















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[SINUMERIK 840D](#)

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4.500 rpm

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[SK50](#)

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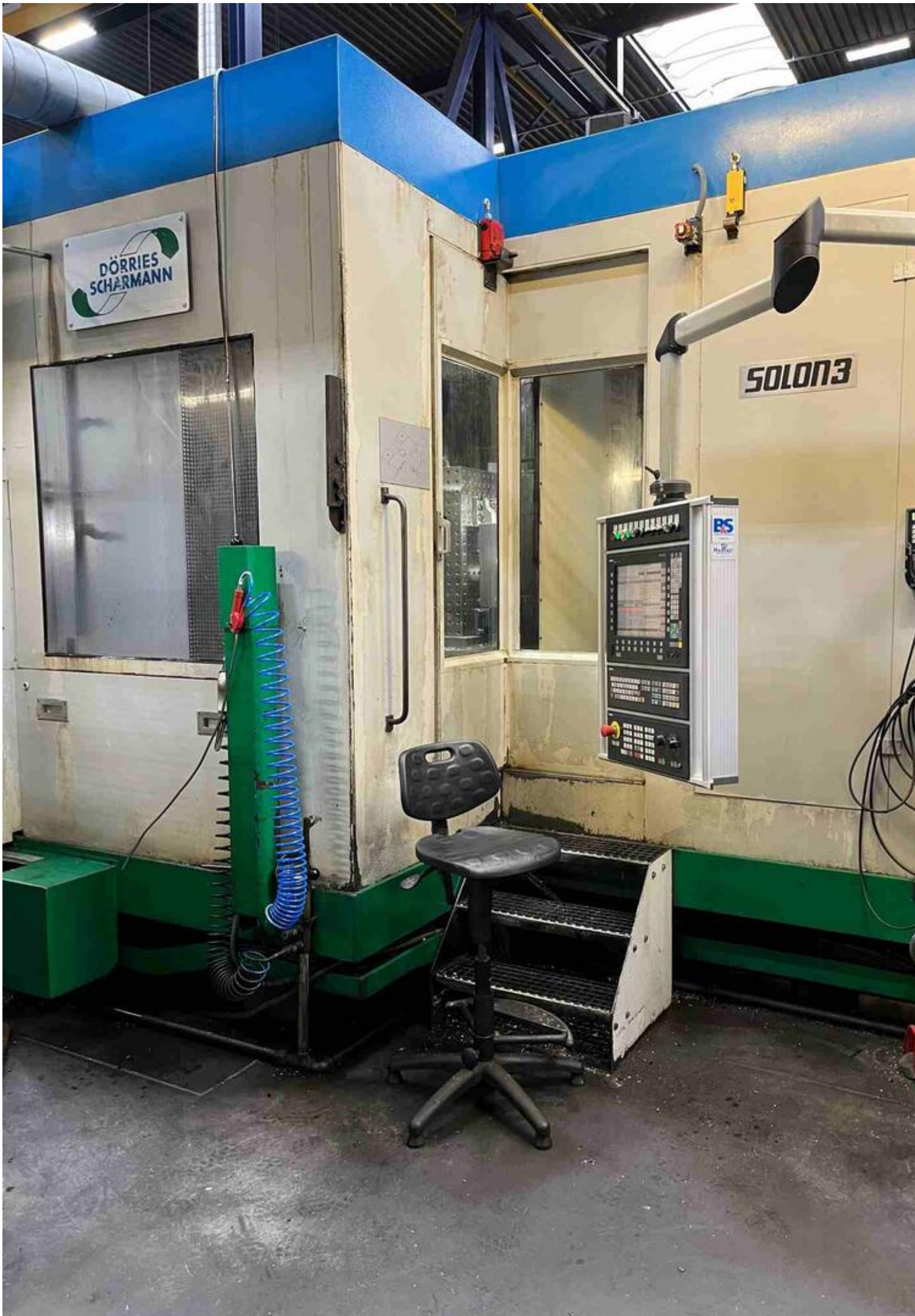
Buyers Premium:

[18 %](#)

Location:

Netherlands

## **Images:**



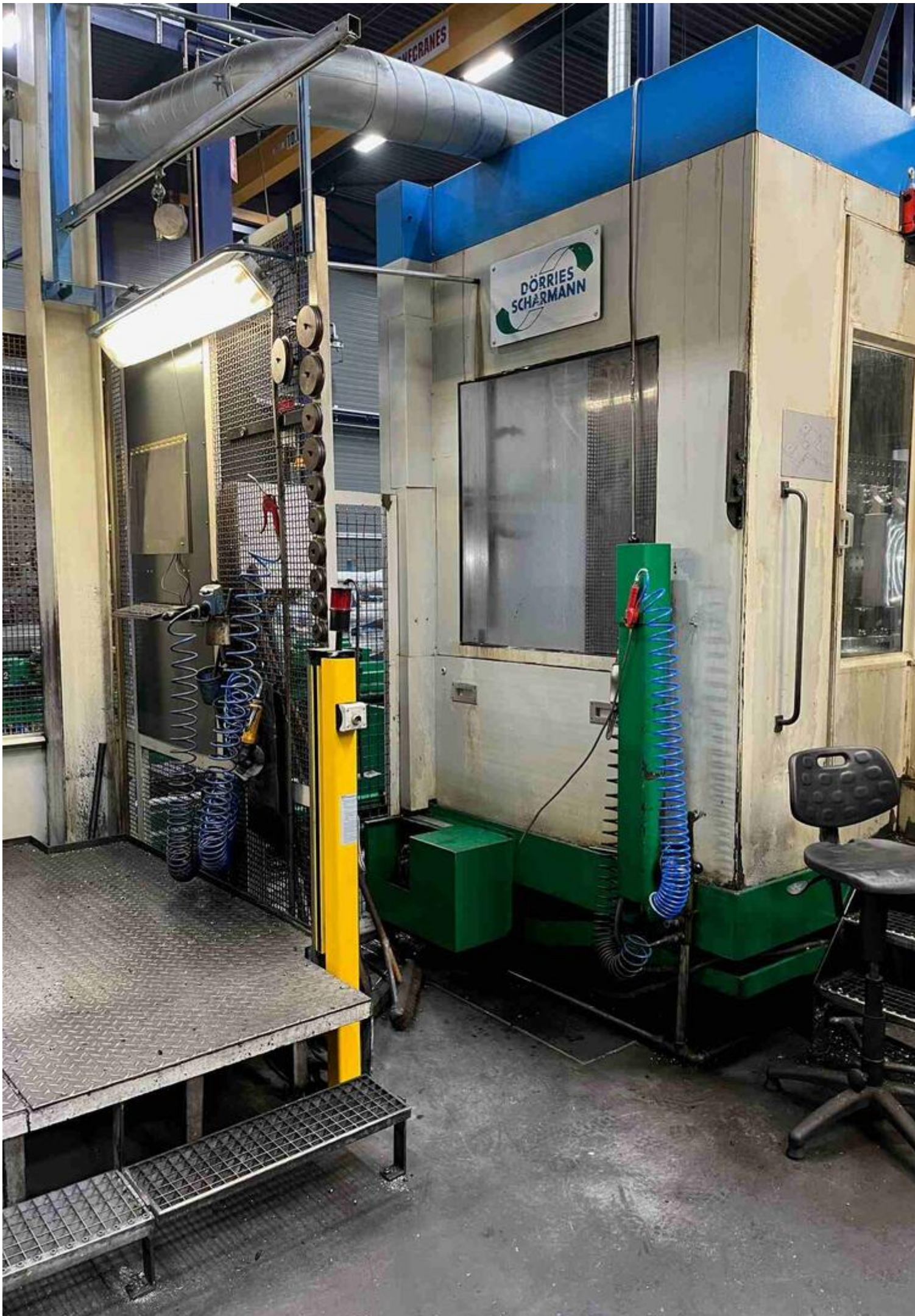
DÖRRIES  
SCHARMANN

SOLON3

Control panel with a screen and buttons. The screen displays a grid of data. The panel has a red emergency stop button and a yellow start button. The brand name "BS" is visible on the right side of the panel.



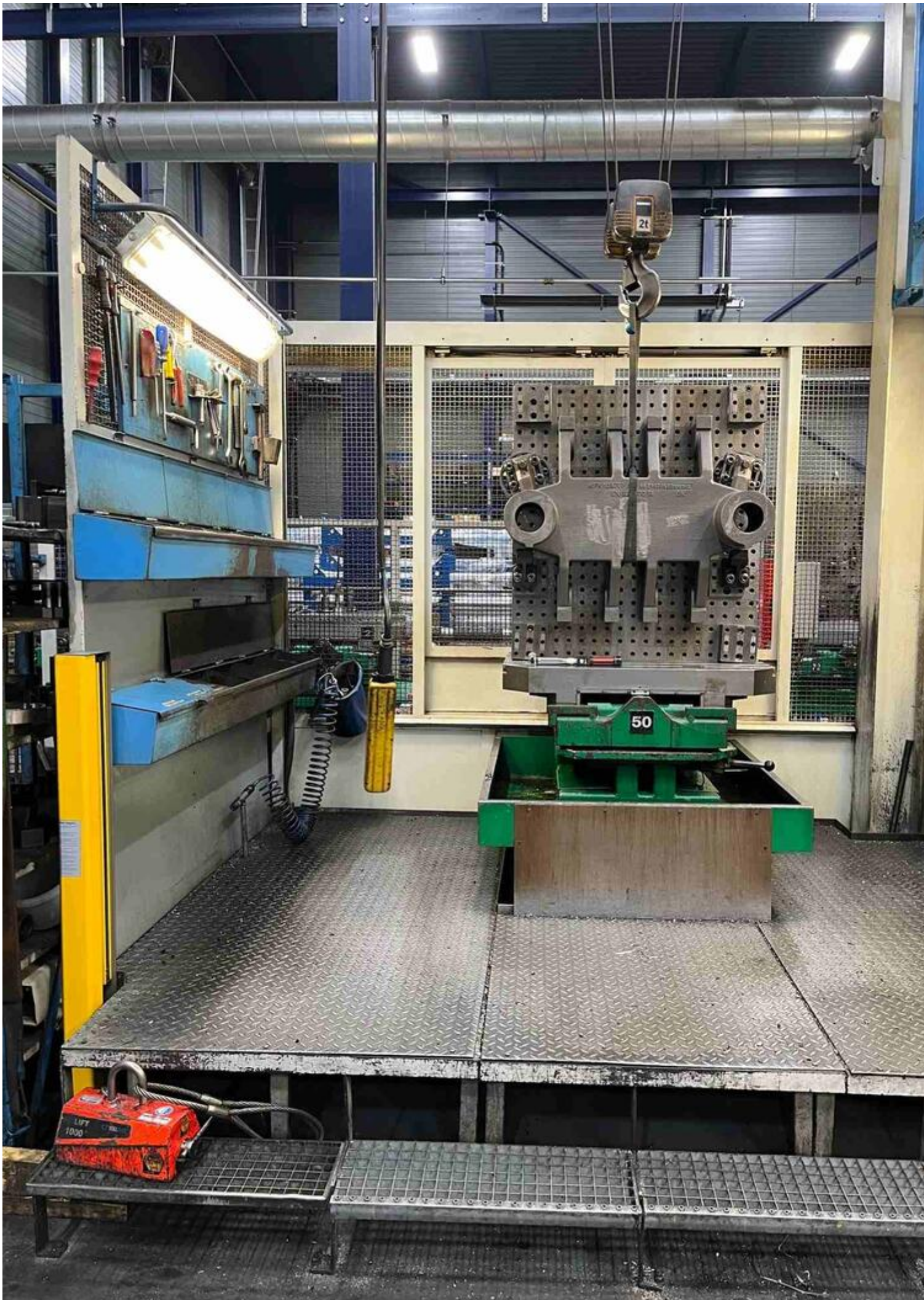




MECRANES

DÖRRIES  
SCHÄRMANN



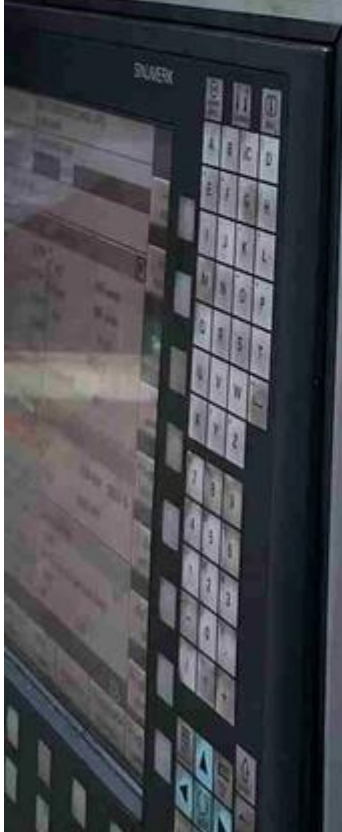








**SOLON3**

















5209  
F-200















SOLON

EB 11















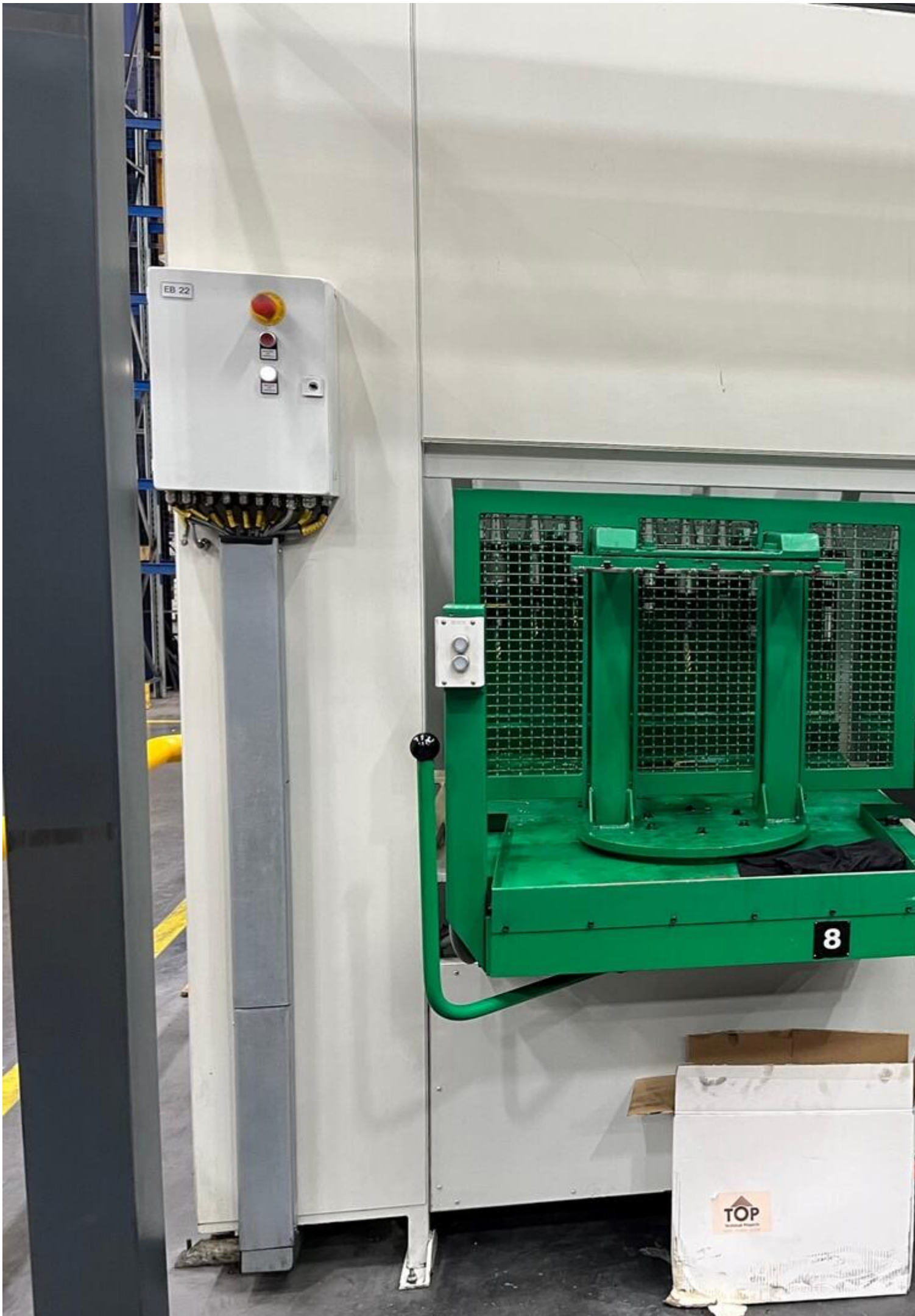


EB 22



8

TOP







DÖRRIES  
SCHARMANN

2  
2 3

LA PROTEC  
SCHARMANN  
DÖRRIES



2



2





6

5

Control panel interface with a central display showing a data table, a numeric keypad, and a row of emergency stop buttons.

Item	Value	Unit	Unit
1	100	mm	mm
2	100	mm	mm
3	100	mm	mm
4	100	mm	mm
5	100	mm	mm
6	100	mm	mm
7	100	mm	mm
8	100	mm	mm
9	100	mm	mm
10	100	mm	mm
11	100	mm	mm
12	100	mm	mm
13	100	mm	mm
14	100	mm	mm
15	100	mm	mm
16	100	mm	mm
17	100	mm	mm
18	100	mm	mm
19	100	mm	mm
20	100	mm	mm
21	100	mm	mm
22	100	mm	mm
23	100	mm	mm
24	100	mm	mm
25	100	mm	mm
26	100	mm	mm
27	100	mm	mm
28	100	mm	mm
29	100	mm	mm
30	100	mm	mm
31	100	mm	mm
32	100	mm	mm
33	100	mm	mm
34	100	mm	mm
35	100	mm	mm
36	100	mm	mm
37	100	mm	mm
38	100	mm	mm
39	100	mm	mm
40	100	mm	mm
41	100	mm	mm
42	100	mm	mm
43	100	mm	mm
44	100	mm	mm
45	100	mm	mm
46	100	mm	mm
47	100	mm	mm
48	100	mm	mm
49	100	mm	mm
50	100	mm	mm

5

510000 2















Gekapseltes Längenmessgerät  
Sealed linear encoder

LC183

Messlänge Measuring length	1740 mm
Identnummer Identification number	657679-17
Seriennummer Serial number	32536881 N
Genauigkeit Accuracy	± 5,0 µm
Referenzmarkenlage Reference mark position	/ mm

The image shows three Siemens XAS linear encoder labels. Each label contains technical specifications and a QR code. The labels are oriented vertically in the image.

- Label 1 (top):** XAS, SIEMENS, 1740 mm, 657679-17, 32536881 N, ± 5,0 µm, / mm. Includes a QR code and the text "SIEMENS XAS".
- Label 2 (middle):** XAS, SIEMENS, 1740 mm, 657679-17, 32536881 N, ± 5,0 µm, / mm. Includes a QR code and the text "SIEMENS XAS".
- Label 3 (bottom):** XAS, SIEMENS, 1740 mm, 657679-17, 32536881 N, ± 5,0 µm, / mm. Includes a QR code and the text "SIEMENS XAS".

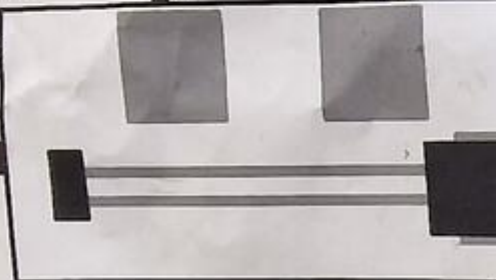


.viceleur 2

EB5  
E-box

EB6  
E-box

E-box  
EB4



BLAUW

6A17 (AB2)

↓

7A1 (SIEMENS ET2007)

↓

3A1 (PILZ)

↓

EB2 (SIEMENS IM 151-1)

↓

EB2 (SIEMENS 6ES7 520-1)

↓

EB3

↓

L60

↓

EB1

GEEL 6A17 (AB2)

↓

BEDIENINGS

KAST

TOOLRUNNER

↓

EB23

↓

EB12

GEEL

MPI

6A2 (XIO)

↓

6A10 (MPI)

↓

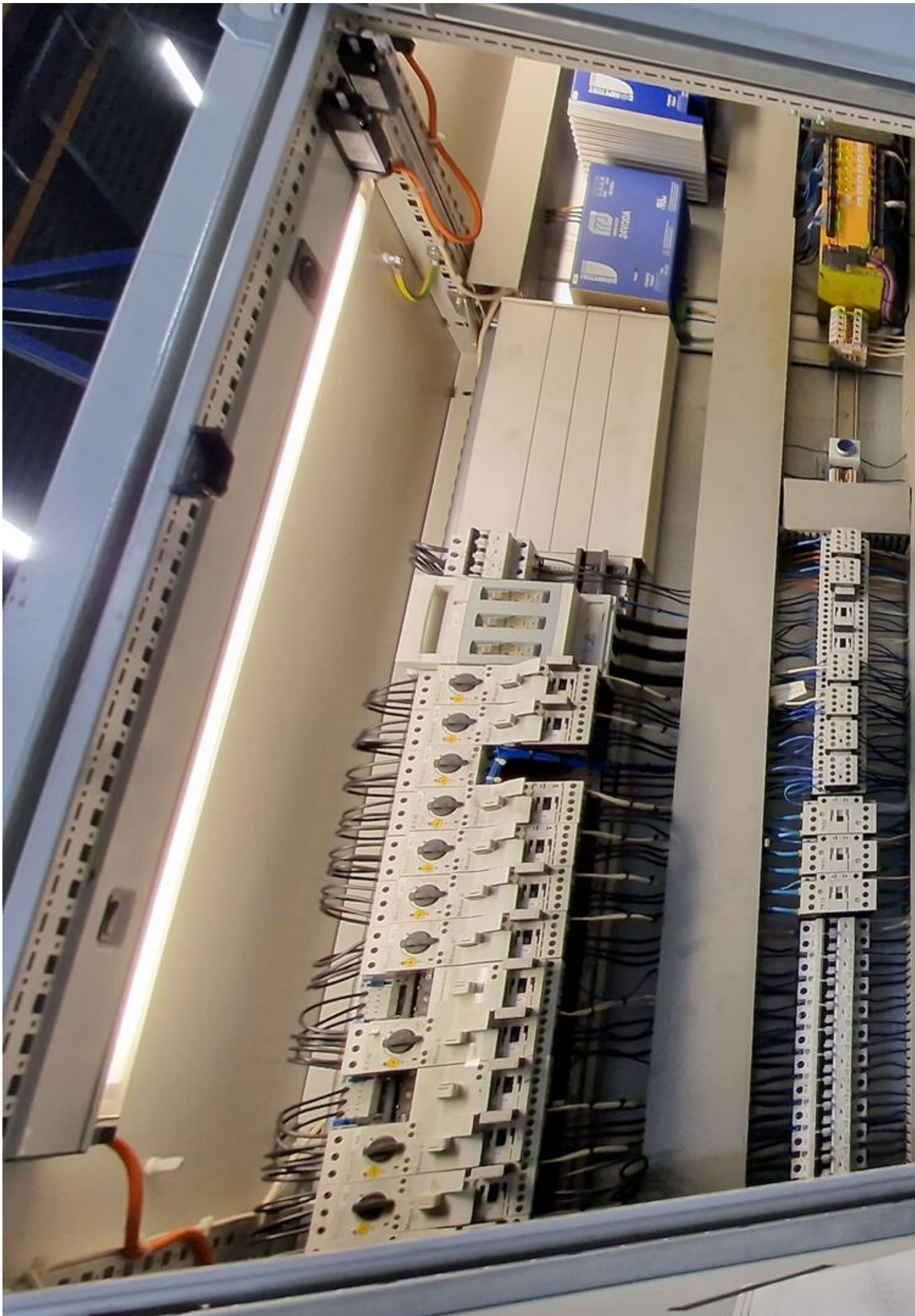
EB2 (MPI)

Project	Stock	Planned





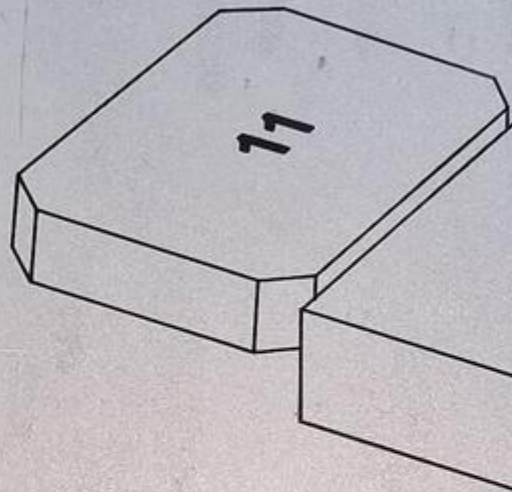




























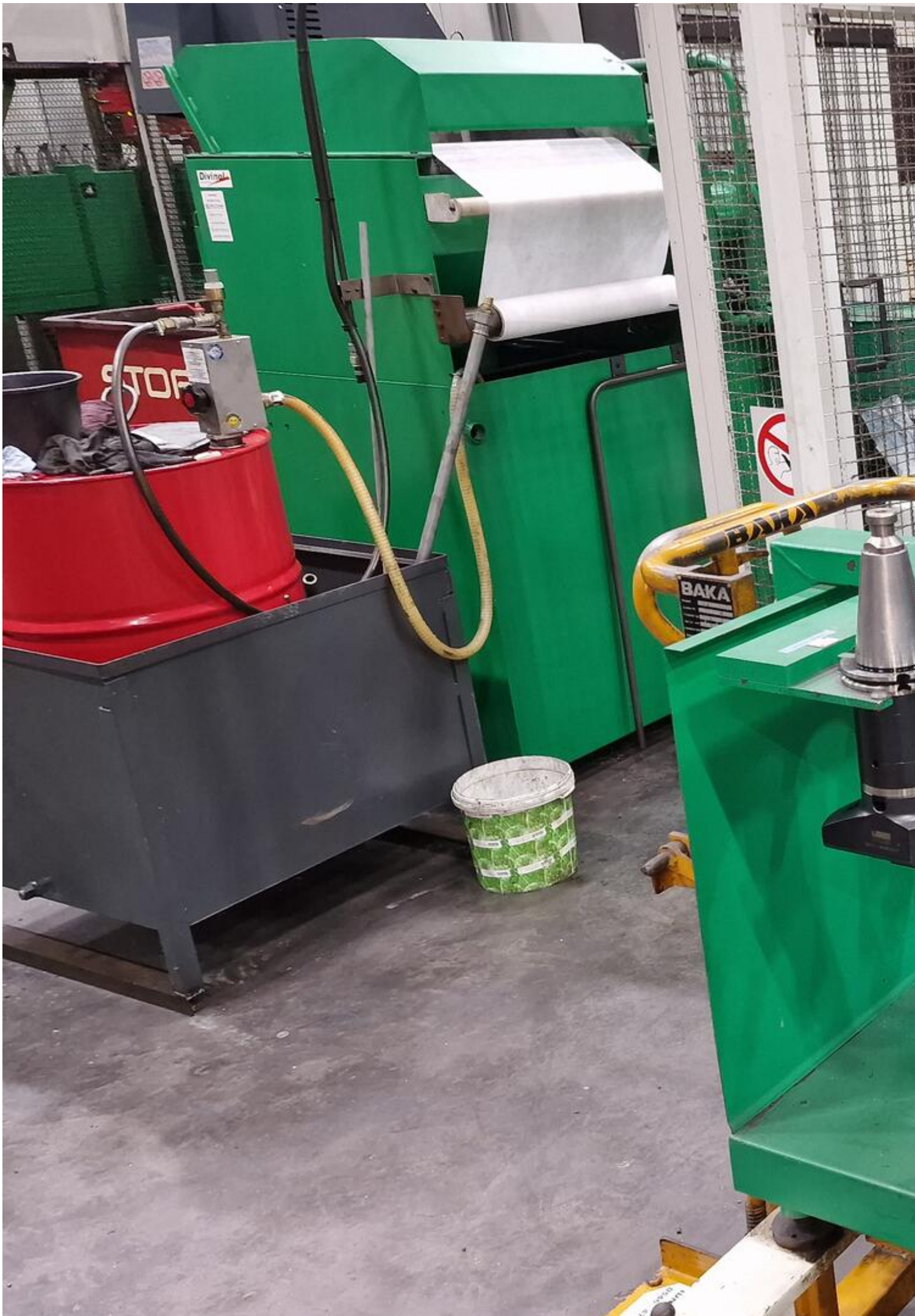












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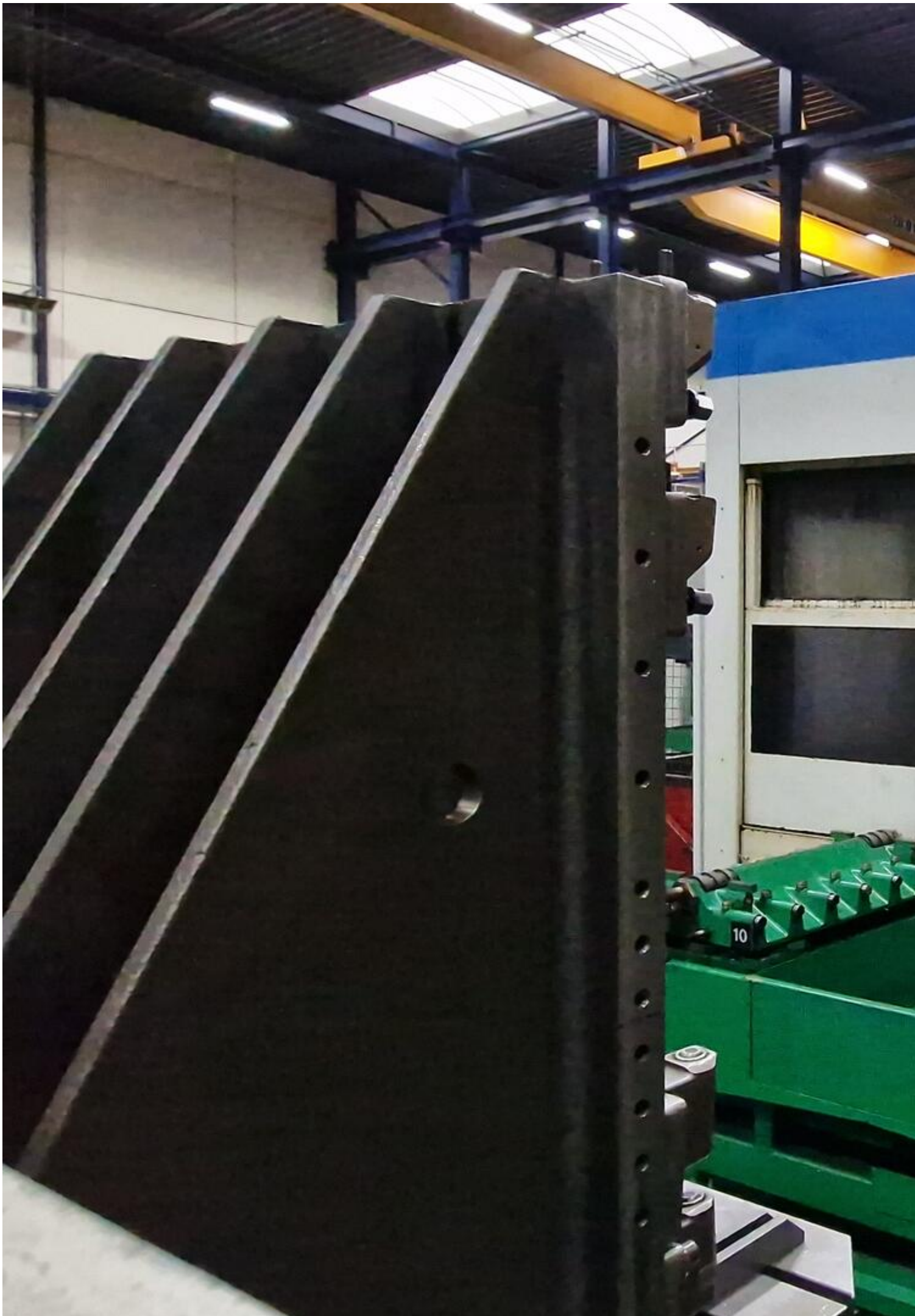
Diving

STOP

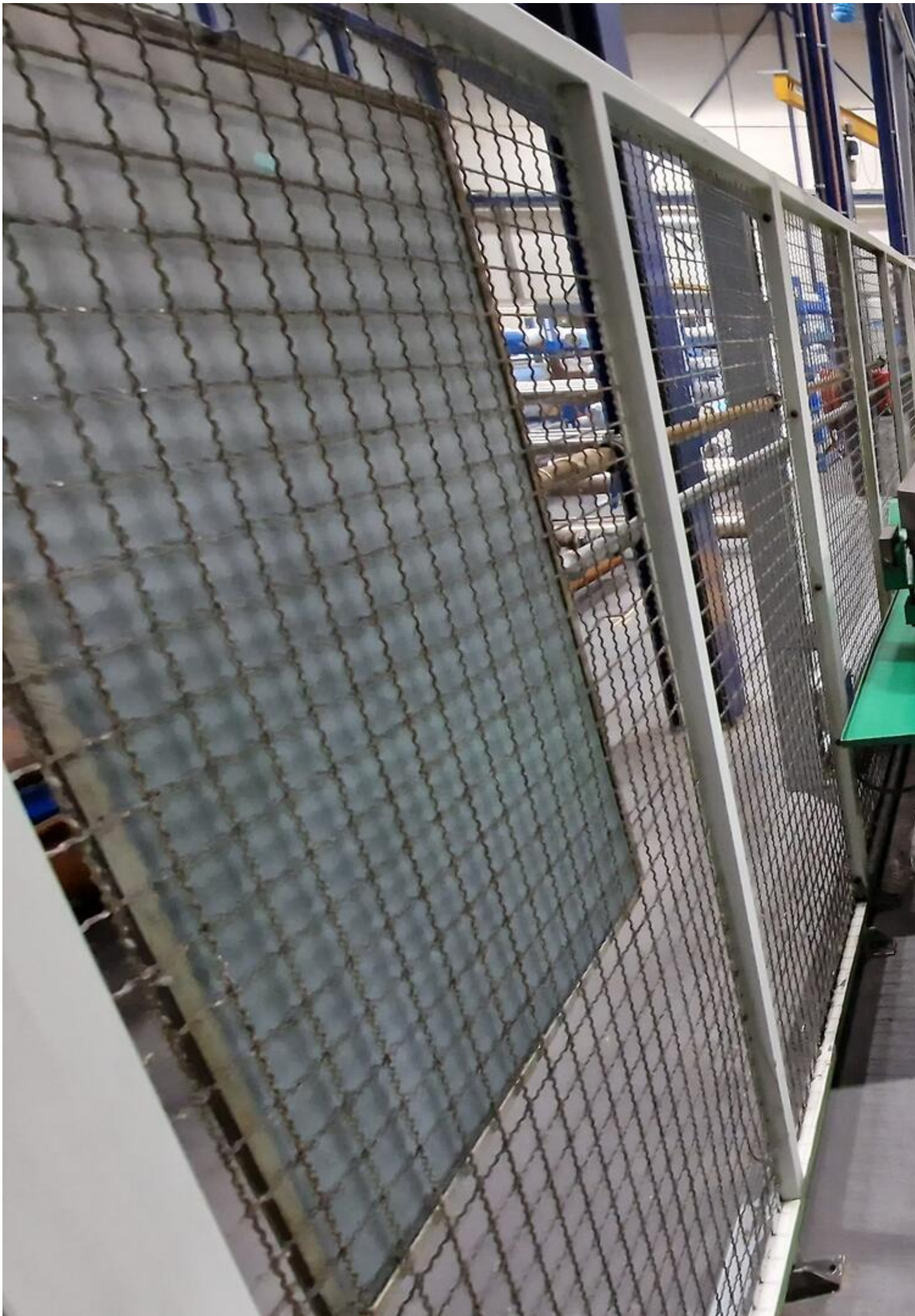
BAKA







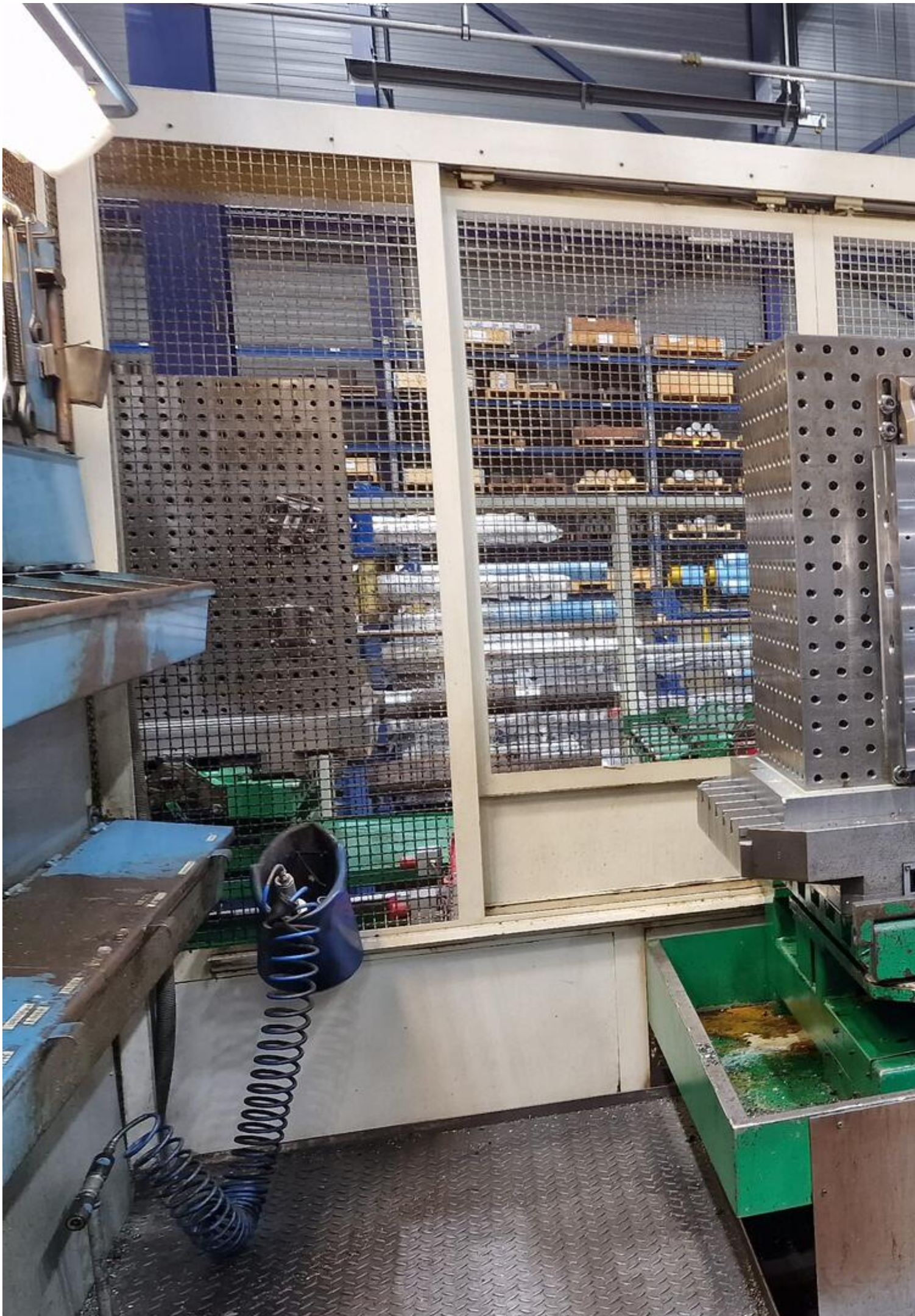






















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