

MACH4METAL

metalworking machinery

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CNC Heavy Duty WALDRICH SIEGEN Line boring bar lathe for casings

- Make : Waldrich - Siegen - Germany
- Type : HB 4500 x 100 NC x 6000
- Age : 1977
- No : 16040
- Minimum turning $\varnothing$: 320
- Maximum turning $\varnothing$: 4.500
- Max. travel X on bed : 6.000
- Work piece load : 100.000 KG
- Boring bar bed width : 1.900
- 2 bed way Bed length : 9.000
- Drive power : 75 kW
- Speed 1 drive: 0,5 - 9 - 32 Rpm
- Speed 2 drive: 1,6 - 30 - 104 Rpm
- Torq on boring bar 7.000 kpm
- Feed in X travel : 0,05 - 100 mm/min.
- Rapid in X travel: 100 - 3.000 mm/min.
- Travel boring bar on bed : 3.500 mm
Guiding Hydrostatic
- Drive facing job feed: 0,05 - 50 mm/min.
- Drive facing job rapid: 50 - 300 mm/min.
- **Boring bar $\varnothing$ 450**
- Inside $\varnothing$: 325
- Length : 13.900
- Split able in 2 pieces
- 2 drives
- To 1e drive = 4.900 to 2e drive from 1e = 3.000



- **Boring bar Ø 300**
- Inside Ø : 205
- Length : 12.400
- Split able in 2 pieces
- 2 drives
- To 1e drive = 4.400 to 2e drive from 1e = 2.



- **Fixed Boring bar steady rest on X travel**
- Length : 660
- 4 x hydrostatic ring bearing
- 2 x ring support bar Ø 450 + Ø 300
- Travel on lower bed : 3.700 mm
- Travelling speed : 1.000 mm/min.



- **Movable Boring bar steady rest II**
- Length : 1.200
- 4 x hydrostatic ring bearing
- 2 x ring support bar Ø 450 + Ø 300
- Travel on lower bed : 3.700 mm
- Travelling speed : 1.000 mm/min.



- **Movable Boring bar steady rest III**
- Length : 660
- 2 x hydrostatic ring bearing
- 2 x ring support bar Ø 450 + Ø 300
- Travel on lower bed : 1.000 mm
- Travelling speed : 1.000 mm/min.

- 2 Guide way Bed for steady rest II & III
- Bed width : 2.600
- Length : 7.000
- Thickness : 400



- **Int. Boring bar heads for Ø 450 No.1**
- Tool holder 1 460 - 640
- Tool holder 2 540 - 720
- Tool holder 3 620 - 800
- Stroke max. 90

- **Int. Boring bar heads for Ø 450 No.2**
- Tool holder 1 780 - 1.020
- Tool holder 2 860 - 1.100
- Stroke max. 120

- **Int. Boring bar heads for Ø 450 No.3**
- Tool holder 1 1.020 - 1.420
- Tool holder 2 1.100 - 1.500
- Stroke max. 200



- **Ext. Boring bar heads for Ø 450 No.4**

- Tool holder 1 1.450 - 1.850
- Tool holder 2 1.800 - 2.200
- Stroke max. 200

- **Ext. Boring bar heads for Ø 450 No.5**

- Tool holder 1 2.150 - 2.950
- Tool holder 2 2.500 - 3.300
- Stroke max. 400

- **Int. Boring bar heads for Ø 300 No.1**

- Tool holder 1 310 - 430
- Tool holder 2 390 - 510
- Tool holder 3 470 - 590
- Stroke max. 60

- **Int. Boring bar heads for Ø 300 No.2**

- Tool holder 1 680 - 780
- Tool holder 2 660 - 860
- Stroke max. 100

- **Int. Boring bar heads for Ø 300 No.3**

- Tool holder 1 840 - 1.220
- Tool holder 2 920 - 1.300
- Stroke max. 190

- **Ext. Boring bar heads for Ø 300 No.4**

- Tool holder 1 1.250 - 1.650
- Tool holder 2 1.600 - 2.000
- Stroke max. 200

- Many boring bar tool Quadratics
- Rebuild to NCT in ca. 2000
- Precision 0,001 mm over NC

