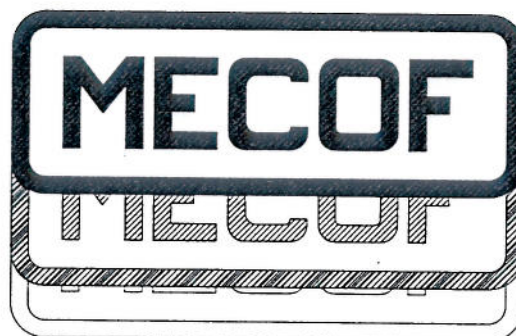


**OPERATING
USE/MAINTENANCE
MANUAL**

Unica CR15/Speed

***HIGH SPEED
MILLING MACHINE
WITH MOVING TABLE***





MECOF S.p.A. - via Molino, 2
15070 Belforte Monferrato (AL) - Italy





MACHINE IDENTIFICATION DATA

Machina type : **UNICA CR 15 /Speed**
Job order : **M1072**
Serial number : **050046**
Customer : **FORD Deaborn**

Mecof Technical Assistance Service:

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Documentation reference : **1072ING**

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1.1 / GENERAL CHARACTERISTICS

Power supply machine	3 ~ 575 V - 60Hz
Numerical control	Fidia M2
Machine safety	CE Norms
Longitudinal axis travel (X)	2500 mm
Cross axis travel (Y)	1000 mm
Vertical axis travel (Z)	1200 mm
Linear axes feedrate: - feed rate - axes accuracy X,Y,Z (*) (*) check execute according VDI DGQ 3441 P - acceleration	0÷15000 mm/min P=10+2 (L-500)/500 µm 1000 mm/s ²
Rotary platform: - positions - rotation amplitude - external diameter - accuracy positioning - axial clamping force	360 ± 180° 315 mm ± 0.02/300 mm 173000 N
Ram: -section - max.spindle power	390x390 mm 20 kW
Automatic universal milling head: - max.power - rotation speed - speed at constant torque - speed at constant power - max. torque - tool taper - tool clamping system - tool clamping force - axial clamping force body - accuracy positioning	20 kW 10÷4500 g/min 10÷250 g/min 250÷4500 g/min 760 Nm CAT50 Automatic 20000 N 85000 N ± 0.02/300 mm
Electrospindle holding with E28 electrospindle - max.power - max.torque - rotation speed - speed at constant power - tool taper - tool clamping system	15 kW 12 Nm 500÷21000 rpm 12000÷21000 rpm HSK 50-E according DIN 69893 Automatic
Table holding workpiece: - dimensions - working plate dimensions - planarity - "T" slots - tolerance of the "T" slots - tolerance of the reference slot - distance between the "T" slots - max.load (uniformly distributed)	2700x900 mm 2500x900 mm < 0.05 mm 7 da 22 mm H11 H7 125 mm 8000 kg



Cooling system:	
- tank capacity	240 lt
- pump capacity	100 l/min
- working capacity	10÷15 l/min
- working pressure	0.5÷1.5 bar
- filtering degree	60 µm