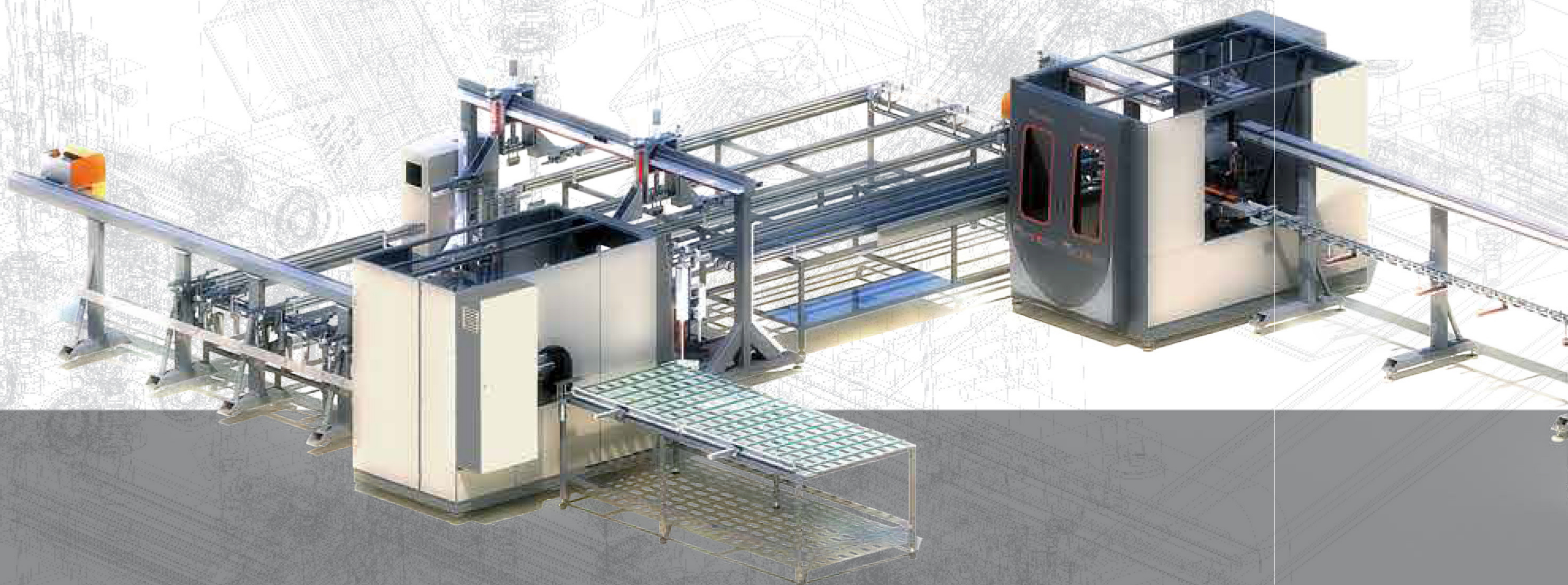


Schtec Profile Machining and Cutting Centers



CSML 240

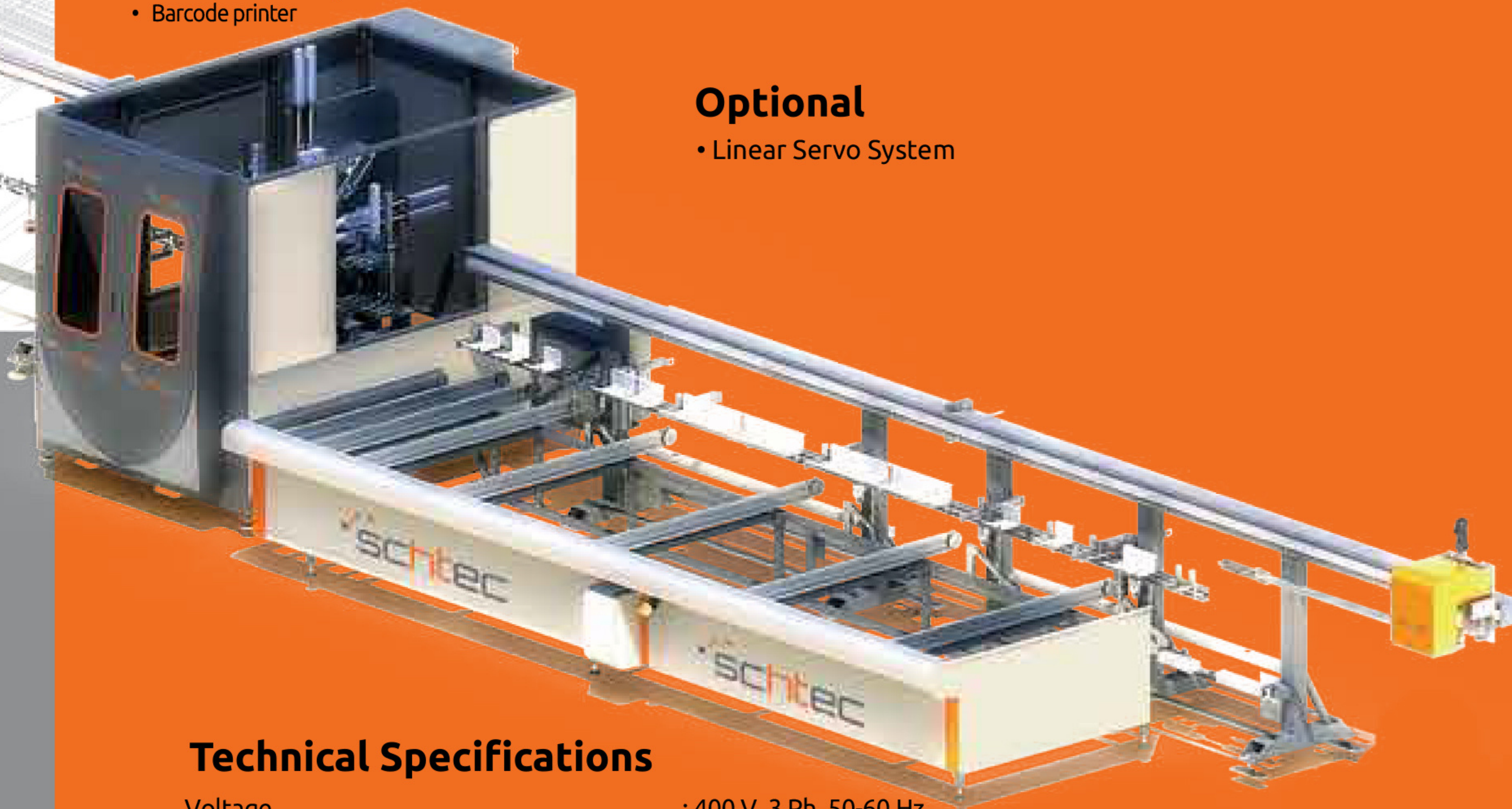
Fully Automated Processing Center

Standard Features

- All gripper stations on the machine are with high-speed Linear Axis control.
- Gripper axis is equipped with 90 degrees rotating axis in order to minimize the issues in gripping of different types of profiles.
- All channel, drilling, marking, barrel and door handle hole processes on PVC profiles are done without reinforcement metal by CNC controlled 11 tools on high precision L designed 2 separate tool rings.
- In processing station without reinforcement steel two separate L groups are controlled totally by 6 CNC axes.
- While reaching each and every spot on profile, pressing groups are also controlled by 2 different axes for profile fixing.
- 10 tools are used in processes with reinforcement steel. All processes on PVC profiles are done by totally 21 tools with high precision.
- All tools on processing stations can be set at 4 different speeds according to the type of process.
- Cutting of all angles between 45 - 135 degrees with 0.1 degree precision with servo axis controlled 2 pcs. 550 mm and 1 pc. 600 mm diameter blades.
- Fast and rigid cutting with servo axis controlled blade axis that is capable of automatic positioning according to profile height.
- Minimum processing time on door profiles with Milling Unit with reinforcement steel.
- Total profile loading capacity 10 + 2 bars with profile elevator system on loading station: (10 pcs. on the loading table, 1 pc. on the elevator and 1 pc. in running process) (max. 6.5 meters Length)
- Incorrect profile loading is prevented by controlling of profile width and length values with precise magnetic encoders that is used to minimize user errors.
- All time losses arising from loading time are minimized with elevator systems on loading stations and with independent movement of profile loading stations.
- Cutting and processing of special type of profiles belonging to French, Dutch and English window systems.
- V, Arrow Head and Reverse Butt cutting.
- Cut pieces are swiftly transferred to next station with linear axis movement unloading station.
- Simultaneous screwing process is done with 2 full automatic 5 servo axis controlled separate screwing units that are capable of duplex screwing.
- Servo controlled tables and screwing unit provide time saving from screwing of profiles with different heights.
- Seamless and full compatible working with all window drawing programs thanks to the special interface developed by Schtec software department.
- Machine can optimize on waste profiles by itself thanks to simultaneous optimization on machine.
- High performance industrial PC with 15" touch screen and Windows 10 Embedded operating system working between 0°C - 55°C without a fan
- Industrial PC based control system. (Beckhoff)
- User friendly interface and IQ, online diagnostic and troubleshooting through pneumatic systems BUS control.
- Loading of work files through USB and network and remote connection to the machine.
- Central lubrication system that facilitates machine maintenance.
- Barcode printer

Optional

- Linear Servo System



Technical Specifications

Voltage	: 400 V, 3 Ph, 50-60 Hz
Power Consumption	
Machining Station	: 12 kW / 30 A
Cutting Station	: 14 kW / 35 A
Screwing Station	: 4 kW / 10 A
Machining Station with Reinforcement	: 12 kW / 30 A
Max. Profile Processing Height	: 215 mm
Min. Profile Processing Height	: 40 mm
Max. Profile Processing Width	: 145 mm
Min. Profile Processing Width	: 35 mm
Max. Profile Bar Length	: 6.500 mm
Max. Process Length for Profile	: 6.000 mm (up to 6.500 mm)
Min. Process Length for Profile	: 700 mm
Maximum Cutting Length	: 4.500 mm (can be increased up to full bar length)
Minimum Cutting Length	: 400 mm
Tool Diameter	: 6 mm / 8mm / 10 mm / 12 mm Carbide Fast Tool (Two different type of diameter can be select for each working surface)
Tool Rpm	: 900 / 6000 / 12000 / 18000 rpm
Max. Axis Speed (Processing)	: 50 m. / min.
Max. Axis Speed (Saw)	: 100 ° / sec.
Max. Axis Speed (Carrier)	: 40 m. / min.
Air Pressure	: 6-8 bar
Air Consumption	: 1075 lt. /min
Machine Height	: 2.300 mm
Machine Length	: 25.930 mm
Machine Width	: 10.800 mm
Machine Weight	: 11.000 kg
Standart Tool Count	: 21 pieces high speed special design air cooling spindles (4 different RPM can be set for each process separately)

