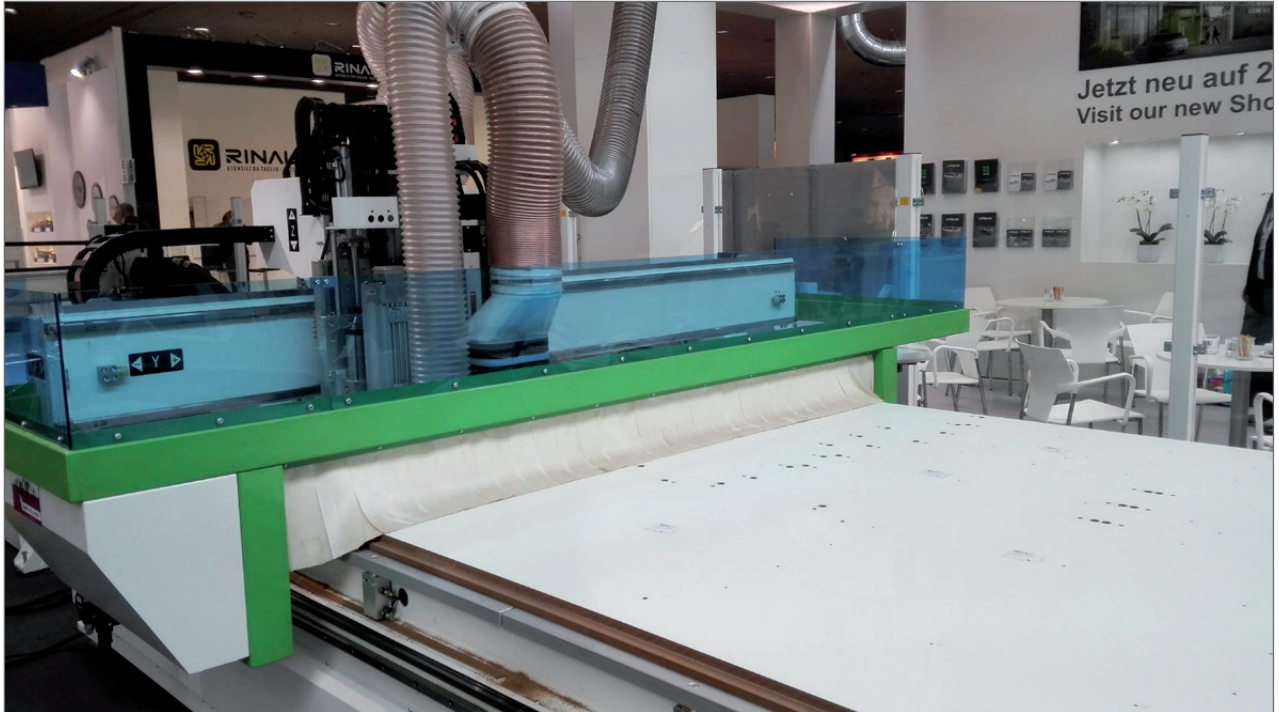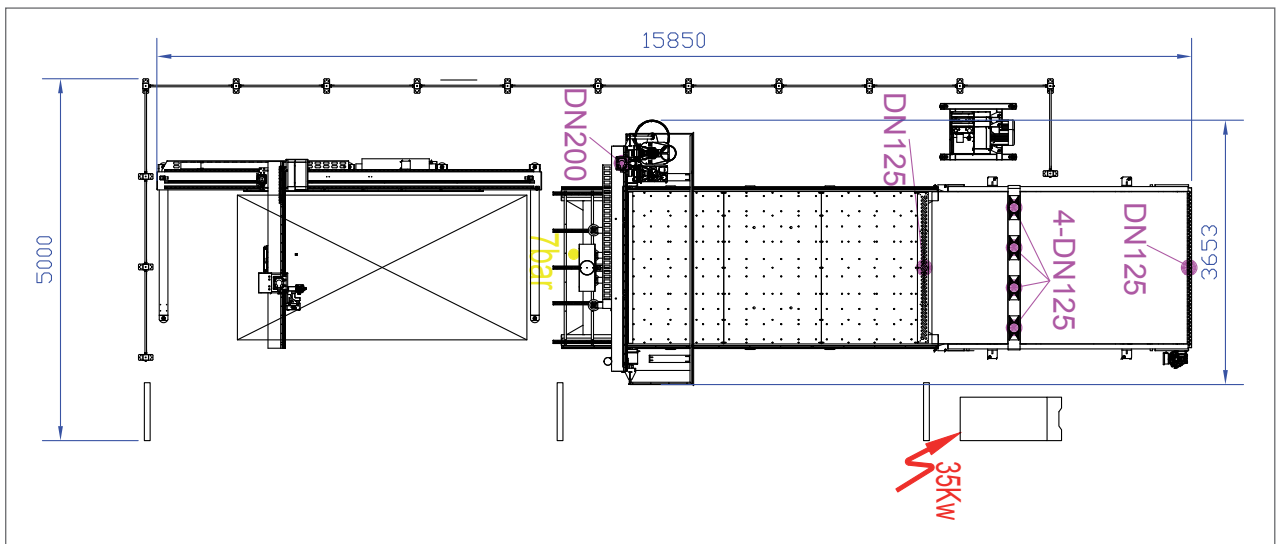# CNC Machining Center BAZ 895n IQ

* Due to the continuous improvements of our products, some machine changes may apply.

NOTICE: In order to achieve the maximum loading height of the lift table it is necessary to dig a pit for the lift table or raise the main machine and unloading device accordingly.

Features

- Use of OSAI control system, fully automatic production from labeling, loading, drilling, nesting grooves and cuts and unloading
- Powerful nesting software for patterning workpieces within the panel, optimizing process, remaking any single workpiece, putting individual label on workpieces, working perfectly with the machine; adopted international standard XML file and fully opened port possible making connection to almost all furniture software
- Heavy duty gantry frame; X axis driven by double servo motors synchronizing for accurate movement
- Equipped with high precision tool setting probe
- Only one time to load panel ready to work, improving the production efficiency
- Use of HSK tool coupler; ATC magazine controlled by servo motor choosing from 8 tools, high speed and precision.

Equipment

Main parts

- Fully automatic production including 3 parts:
  Auto load with labeling, CNC machining center and Auto unload
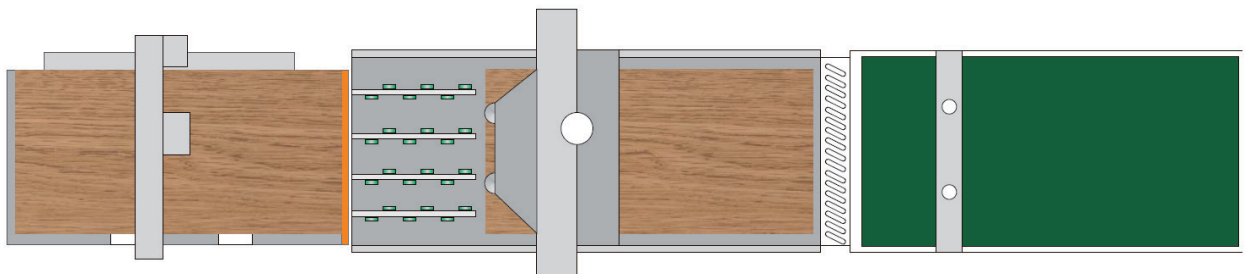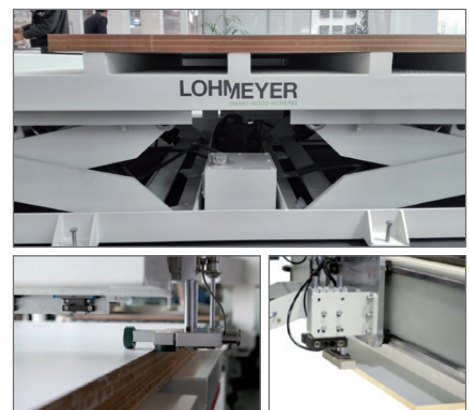

| Auto load with labeling | CNC machining center | Auto unload |

Auto load

- Hydraulic lift table with capacity of 3,000 kg automatically lifts the panel up to the processing level of the main machine
- Recesses for panel loading with forklift
- pneumatic loading device

Auto label device

- Error-free and quick labeling
- Perfect time arrangement: auto labeling and nesting processing are carried out simultaneously

Label

- There are workpiece size, barcode, customer name, order info., edge banding info. and reference point of next process on the label, including all the necessary information for intelligent production
- Label format can be customized
- Also can use the QR code
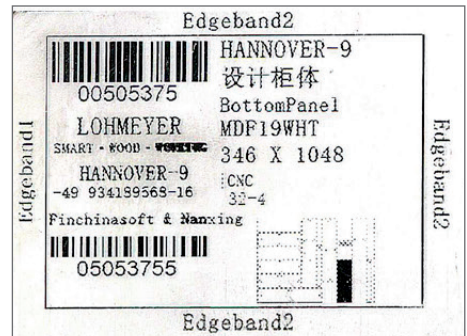
Loading device

- Four vacuum cups firmly grasp and transport the workpiece to working table
- A compact roller table can transport the workpiece without damage its surface due to minimum friction by rollers.

CNC machining center

Transmission mode
- X axis: rack and pinion
- Y axis: rack and pinion
- Z axis: ball screw

Servo motor
- The accurate movement of each axis is ensured by the high quality servo motors
- Servo motor brand: Yaskawa

Main spindle

- Italy HSD air cooling spindle: high precision, stability, and long life
- Spindle power: 9kW
- Coupler type: HSK-63F

Automatic tool changer

- Controlled by servo driver
- The 8-position ATC ensures quick changing of tools and continuous processing of workpiece

Drilling unit

- 10 vertical drills
- Diameter of drill shank: 10 mm
- Max. borehole diameter: 35 mm
- Center distance of drills: 32 mm

Working table

- Grid table for housing MDF base board (panel dimensions 2,070 x 2,800 mm)
- Optimized vacuum suction due to crisscrossed grooves and vacuum areas
- Each vacuum area on working table controlled independently by computer, so that even small panels can be fixed tightly while processing

Side positioning device

- The positioning device installed laterally supports the alignment of the panels

Auto unload

- Conveyor belt for transporting the workpieces
- Opto-electronic sensor ensures that the panels stop at exact position and does not fall off the conveyor belt
- 4 dust extractions decrease dust effectively

Vacuum pump

- Two vacuum pumps ensure the powerful suction
- Type: air-cooling
- Power: 2 x 7.5 kW
- Suction flow rate: 2 x 250 m^3/h

Automatic lubrication

- Auto load device and CNC machining center are all equipped with lubrication system that reduces the need of maintenance by operators.

Tool probe and locker

- The tool probe effectively improves accuracy and efficiency of tool setting
- The tool locker makes change tools easily

Dust extraction

- Centralized dust outlets, grouped each pipe together for easy connecting to the dust extraction system
- Table dust extraction device make good quality dust extraction from working table during discharging the workpieces to unload table
- Bottom and upper dust extraction device effective collect the dust after the processed workpieces coming out the table
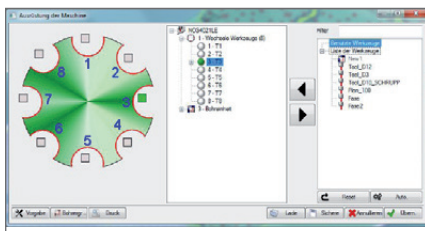
Electric equipment

- Independent electric cabinet with air-condition
- OSAI control system
- IPC with Windows 7 system
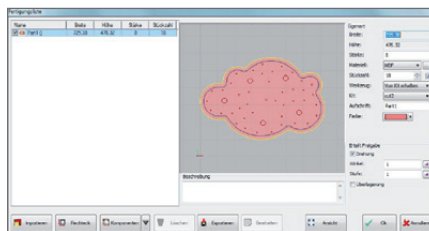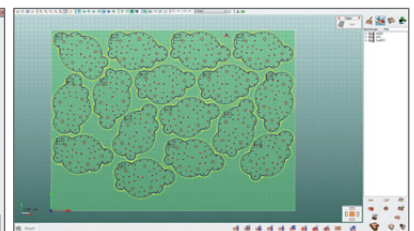- USB port

Control system

- easy to operate
- DDX Easy Wood – Nesting Application for a shop floor oriented programming or office programming
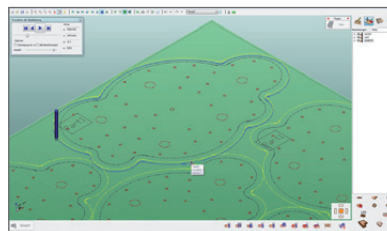

Equipment

Processing list

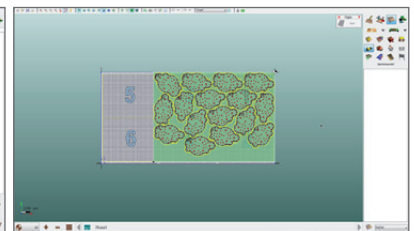Free form Nest

Simulation

Table setting

Option

12 position automatic toolchanger

- HSK 63, servo driven, moving in X direction

Note: The standard 8 pos. toolchanger form the basic machine will be taken off

LOHMEYER
SMART·WOOD·WORKING

Technical Data

Travel distances	X axis	4,600 mm
	Y axis	2,550 mm
	Z axis	200 mm
Working range	X axis	4,000 mm
	Y axis	2,100 mm
	Z axis	max. 30 mm
Working table		4,000 × 2,150 mm, grid table
Max. traveling speed	X axis	50 m/min
	Y axis	50 m/min
	Z axis	20 m/min
Main routing spindle	no. of main spindle	1
	main spindle speed	24,000 rpm
	power	9 kW
	tool holder type	HSK-63F
	collet type	ER32
Automatic tool changer	no. of positions	tool magazine with 8 positions
	control	servo
Drilling block	no. of vertical drills	10
	max. drill diameter	35 mm
	power	1.7 kW
	rotating speed	4,000 rpm
Vacuum pump	quantity	2
	power	2 x 7.5 kW
	suction flow rate	2 x 250 m^3/h
	cooling	air cooling
Compressed air	required air pressure	6-7 kg/cm^2
Dust extraction	pipe diameter	1 x 200 mm, 6 x 125 mm
	min. dust extraction speed	min. 28 m/s
	extraction connection	Ø 250 mm, height 2,400 mm
	extraction capacity	min. 4,950 m^3/h
	pressure loss	min. 2,200 Pa
	Note: Weight relief at extraction hose!	
Power supply	power	35 kW/68A
	frequency	50 Hz
	voltage	400 V, 3 phases
Machine dimension	dimensions	15,850 × 5,000 × 2,700 mm
	machine weight	9,000 kg

Security and Safety

- CE Regulation according to the EC Machinery Directive

Documentation

- Documentation and Maintenance Instructions in print and CD-ROM version