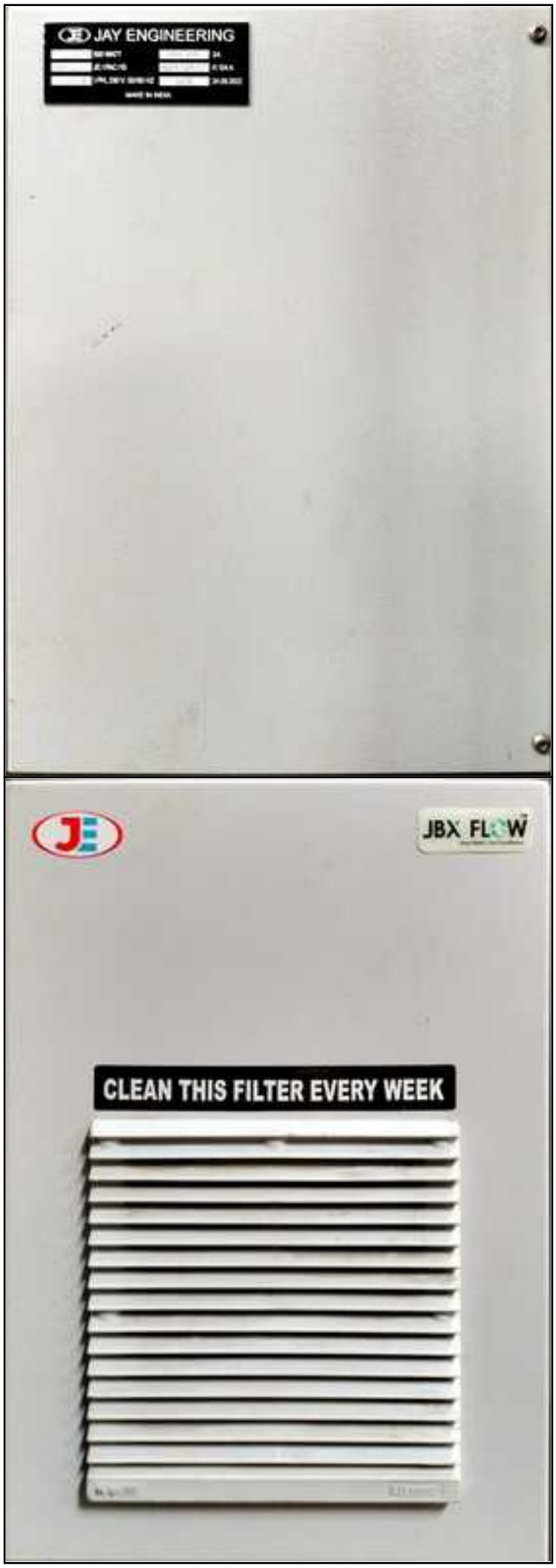
Farrell Engineering Ltd
Westbury House, 23-25 Bridge Street, Pinner HA5 3HR United Kingdom
Tel. : 0044-208-3432 3291 Fax : 044-208-9657586
Email : chan@farrellengineering.com


D 11


SINUMERIK
CYCLE START
EMERGENCY RETURN
NC ON
TAILSTOCK UP / DOWN
WORKPIECE UNCLAMP
CYCLE STOP
NC OFF
HOB SHIFTING IN / OUT
12:54:18
2023/04/27
UserMask
SIEMENS
Farrell
ENGINEERING
** PROUTER :-
* CNC (2-axes) GEAR HOBBER
* MODEL NO.PA320, SW.NO.26 142
* PROJECT NO.320
** CAPACITY :-
* Max.WORKPIECE DIA.: 350mm
* Max.MODULE: Module-8
* Max.HOB DIA.: 163mm
* Max.HOB LENGTH: 230mm
* Max.HOB SHIFT LENGTH: 170mm
** WORKING RANGE :-
* RADIAL: 40 TO 265mm (Centre distance between Hob & Job)
* AXIAL : 200 TO 450mm (Min./Max.Center distance between Hob & Tab
* HOB SPINDLE SPEED: Max.330rpm
INPUTS-1
INPUTS-2
INPUTS-3
OUTPUTS-1
OUTPUTS-2
Main


SIEMENS
SINUMERIK
CYCLE START
EMERGENCY RETURN
NC ON
TAILSTOCK UP / DOWN
WORKPIECE UNCLAMP
CYCLE STOP
M/C LAMP OFF ON
NC OFF
HOB SHIFTING IN / OUT


JAY ENGINEERING
JBX FLOW
CLEAN THIS FILTER EVERY WEEK

Category	**:-**	**Gear Related Machines**	**Serial No**	**:-**	
Model	**:-**	**PA 320 CNC**	**Country**	**:-**	**Germany**
Make	**:-**	**Pfauter**	**Type of Machine**	**:-**	**3 Axis Gear Hobbing Machine - Vertical**
Year	**:-**	**REBUILT MACHINE 2023**	**Weight**	**:-**	**0.0**
Dimensions	**:-**		**Power**	**:-**	
Location	**:-**	**Mumbai Warehouse,India**	**Asking Price**	**:-**	**On Request**

Specification :-

Type of machine :- 3 Axis Gear Hobbing Machine - Vertical
Make :- Pfauter PA 320CNC

Three Axis CNC Controlled with Siemens 808 (brand new 2023)

Max. workpiece Ø350 mm
Max. modulus f. hobbing cutters 8 mm
Max. addendum circle Ø163 mm
L max. 230 mm (depending on cutter arbour Ø)
Cutter cutter Ø22, 27, 32, 40 mm
Mounting taper MK5
Radial carriage travel 225 mm
Tangential carriage travel 170 mm
Axial carriage travel 250 mm
Max. cutter head pivoting angle +30°...-40°
#workpiece spindle outside Ø350 mm
Workpiece spindle bore 150 mm
Counter holder travel 550 mm
Counter holder bore 150 mm
Speed - tool 120-400 rpm
Speed - tool spindle 1-40 rpm
Rapid speed on X axis 5,000 mm/min.
Rapid speed on Y axis 750 mm/min.
Rapid speed on Z axis 1,000 mm/min.
Automatic. workpiece feeding unit
Cooling lubricant system
Oil mist extraction and filtering system

Additional information

complete with change gears, etc
complete , handbooks and machine manuals etc.
fully rebuilt with BRAND NEW 2023 YOM
Siemens 808 , Digital drives and AC servo motors

CNC Controlled Axis X and Z + hob shifting,
Free standing Electrical Cabinet fitted .
Suitable for Spur , Helical , Crowning &slightly tapered gears both for batch and heavy production of components
Machine Features
•Hydraulic Clamping &Tailstock ,
•Automatic Hob shift
•Full change gear set
•One 1.25' hob Arbor, outboard bearing, Arbor wrench
•Two copies of the machine operators manual
•Two copies of all electrical and mechanical prints
•Can be tooled up to customers as per customers requirement
•Machine is ready for immediate delivery subject to prior sale.

The Advantages of New Siemens 808 Advance System are as below:-

The benefits are as per below:-

1. It is close loop system so positioning accuracy of axis is far better.

2. It has Auto servo tuning (AST) facility so that load can be tuned with servo motor for better performance with torque.

3. It has Direct servo control (DSC) by Drive Bus communication so that drives can perform better with controller commands.

4. It has friction compensation facility.

5. Servo motors available up to 40Nm whereas in 808D it was only 4,7,10Nm only.(e.g. for Z-axis we used 15Nm

6. Absolute encoder available with Servo motor so that referencing is not required (like 828D)

7. It has Ethernet communication port so that PLC and Data Upload/Download is much faster.

8. It has Ethernet Interface so that it can be monitored remotely (like 828D) for

a. Transfer of Part program, user cycles, Machine data, R-parameter, PLC data, HMI data etc..

b. PLC Logic can be monitored

c. PLC upload/download

d. Part program send/receive

e. Execute part program

f. Screen shots can be taken.

This machine is recontrol or recertification with SIEMENS 808 Advance System Exactly as per Pfauter Standards.
All recontrolled and recertified machines are fully cleaned.
All moving slides, spindles and parts handling systems are inspected for problems.
Any gibs or adjustable backlash systems are adjusted to the best possible settings.
All hydraulic, coolant, lubrication and pneumatic systems are checked for proper functionality and leaks.
All filters are replaced. All worn hoses, broken cables, connectors, buttons, lamps and wires are replaced.
All guarding is installed and checked.
All machine cycles are tested. Parts are cut to verify the machine capability.
Charts from the test cutting are documented for your viewing.

Description :--

The gear hobbing machine pfauter PA 320 CNC was designed as a universal tool machine to produce gears used in building and construction machines, wind turbine gearboxes, machine tools, mining equipment, aircraft, textile machinery, etc. it can be used for individual and small batch production, as well as for mass production. As part of the modernization process the machine is being dismantled completely and then retrofitted according to the latest findings and technologies to become an up-to-date high-performance hobbing machine, equipped with the modern CNC-control system siemens 808.
The figures are showing a CNC retrofit, completely modernized, designed for maximum performance and accuracy in flexible manufacturing, acceptance testing according to DIN and manufacturer's standards, including the control system SIEMENS 808 and the digital drive technology from SIEMENS.