High precision and production lathe
842

Technical data

	842	842Mi	842Mi-Y	
Spindle A2-5 (ISO 702/I / DIN 55026)				
Spindle axial and radial runout	< 1	< 0.7	< 0.7	[µm]
Recommended maximum turning diameter		300		[mm]
Distance between spindle nose and headstock cover	36	56		[mm]
Maximum distance between spindle nose face and turret	536	486	455	[mm]
ISO spindle nose		A 2-5		
Spindle speed		0 - 6'000		[min⁻¹]
Power, continuous / intermittent	7.5 / 15	24 / 30		[kW]
Continuous torque spindle / intermittenly	47 / 126	72 / 90		[Nm]
Spindel throughbore (without drawbar)		56		[mm]
Max. bar capacity with B32 collet		Ø24		[mm]
Max. bar capacity with B45 collet		Ø36		[mm]
Max. bar capacity of the "HAINBUCH Gr 42" clamping head		Ø42		[mm]
Max. bar capacity of the automatic chuck		Ø42		[mm]
Recommended max. swin		170		[mm]
Adjustable axial hydraulic clamping force		250 - 2'500		[daN]
Pneumatic spindle interlock, interlocking moment at 5 bar		440		[Nm]
C axis				
Programmable increment		0.0001		[°]
Interpolation	X - Z - C		X - Y - Z - C	
Rapid feed		36'000		[°/min]
Positioning accuracy		± 0.016° / ± 58''		
Positioning repeatability		± 0.008° / ± 29''		
Cross slide				
Transverse stroke, X axis		200	155	[mm]
Programmable increment, X axis (on diameter)		0.0001		[mm]
Longitudinal stroke, Z axis		400		[mm]
Programmable increment, Z axis		0.0001		[mm]
X and Z axes, AC motor drive, power	1.8	2.5		[kW]
X and Z axes, torque, continuous/intermittent	11 / 27	12 / 46		[Nm]
X and Z axes, ball screw, Ø x pitch		28 x 10		[mm]
Positioning accuracy [P] X axis *		5		[µm]
Positioning accuracy [P] Z axis *		6		[µm]
Positioning repeatability [PS] X axis *		2		[µm]
Positioning repeatability [PS] Z axis *		3		[µm]
Y axis				
Transverse stroke			+/- 40	[mm]
Programmable increment			0.0001	[mm]
AC motor drive, power			2.5	[kW]
Torque, continuous/intermittent			12 / 46	[Nm]
Ball screw, Ø x pitch			28 x 10	[mm]
Positioning accuracy [P] Y axis *			5	[µm]
Positioning repeatability [PS] Y axis *			3	[µm]

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High precision and production lathe
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Technical data

	842	842Mi	842Mi-Y	
Feed				
Cutting feedrate, X, Z and E axes		10		[m/min]
Rapid feed, X, Z and E axes	20	30		[m/min]
Feed force, X, Z and E axes, continuous	622	678		[daN]
Tooling : Turret with rotary tools				
Tool holder	Axial	Radial		
Number of tool stations	16	12		
Number of stations for rotary tools	16	12		
Standardized mounting of tool holders	VDI 30	SAUTER	VDI-30 + TRIFIX	
Drive of the rotary tools according to the standards	DIN 5482	SAUTER	DIN 5480	
Max. cross section of tool shank	20 x 20	20 x 20		[mm]
Spindle speed	0 - 4'000	0-12'000		[min⁻¹]
Power, continuous/intermittent	1.1 / 3.7	3 / 6	6.7 / 11.7	[kW]
Torque, continuous / intermittent	7 / 23.6	4 / 8	16 / 28	[Nm]
Positioning accuracy	3.7	5	5	[µm]
Positioning repeatability	1.5	2	2	[µm]
Counter-spindle A2-4 (ISO 702/I / DIN 55026)				
Spindle axial and radial runout		0.5		[µm]
Spindle for «Schaublin» collets		B32		
Spindle speed		0 - 5'000		[min⁻¹]
Spindel throughbore (without drawbar)		39		[mm]
Possibility to built on a 3 jaws chuck		✓		
Recommended maximum turning diameter		140		[mm]
Adjustable axial pneumatic clamping force		450-1'150		[daN]
Pneumatic spindle interlock, interlocking moment at 5 bar		69		[Nm]
Max. longitudinal stroke, E axis		445		[mm]
Max. distance between spindle noses		640		[mm]
Programmable increment, E axis		0.0001		[mm]
AC motor drive, power		2.5		[kW]
Torque, continuous/intermittent		12 / 46		[Nm]
Ball screw, Ø x pitch		32 X 10		[mm]
C axis				
Programmable increment		0.0001		[°]
Interpolation		X - Z - C	X - Y -Z - C	
Rapid feed		36'000		[°/min]
Positioning accuracy		± 0.016° / ± 58''		
Positioning repeatability		± 0.008° / ± 29''		
Motor-driven tailstock				
Internal taper of the sleeve		Morse 3		
Max. longitudinal stroke, E axis		445		[mm]
Programmable increment, E axis		0.0001		[mm]
AC motor drive, power	1.8	2.5		[kW]
Torque, continuous/intermittent	11 / 27	12 / 46		[Nm]

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Technical data

	842	842Mi	842Mi-Y	
Motor-driven tailstock (continuation)				
Ball screw, Ø x pitch	32 x 10			[mm]
Positioning accuracy [P] E axis *	6			[µm]
Positioning repeatability [PS] E axis *	3			[µm]
Coolant supply				
Tank capacity	200			[l]
Coolant flow	83l/min @ 2.4bar			[l/min]
Pneumatic consumption				
Min./max. pneumatic pressure	5-14			[bar]
Type of connection	G1/4"			[G]
Quality of the air	Clean and dry			
Electrical power supply				
Voltage	400			[V]
Tolerated fluctuations	+/- 5			[%]
Other Voltage	Option			
Frequency	50			[Hz]
Tolerated fluctuations	+/- 5			[%]
Rated current	40			[A]
Protection at mains end	83 (63)			[A]
Power consumption of the machine	28			[kVA]
Obstruction and weight				
Overall dimensions: length x depth x height	1'895 x 1'783 x 1'947			[mm]
Approx. net weight of the machine (including oil)	4'400		4'550	[kg]
Floor load	10			[kg/cm2]
Load per square meter for one machine	1000			[kg/m2]
Dimensions of the pallet	2'450 x 2'005			[mm]
Weight of the pallet	280			[kg]
Spindle center height over floor	1060			[mm]
Lubrication of linear guideways and ball screws				
Kind of linear guideway and ball screws lubrication for axes X, Z and E	Automatic			
Kind of grease	LUBE LHL-X100			
Various				
Color of the machine: SCHAUBLIN standard color 2 colors, color 1 Grey	RAL 7015			
Color of the machine: SCHAUBLIN standard color 2 colors, color 2 White	RAL 9010			
Noise level under load at the operator's station	76			[dB$_A$]
Machine and equipment in accordance with the CE safety standards	✓			
Operating temperature	+15 ⇨ +30			[°]
Relative humidity	10 ⇨ 75			[%]

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Technical data

	842	842Mi	842Mi-Y	
Control unit				
Type of control unit		Fanuc 0i-TF		
Screen		10.4" LCD color		
Manual Guide i		Option		
Memory		512 Kb ext. à 2 Mb		
Number of programs		400		
Tool offsets		128 etx. 200		
Programmable increment		0.0001		
Axis feedrate override		0-120		[%]
Spindle override		50-120		[%]
M codes in one block		3		
Background editing		✓		
Constant surface speed control		✓		
Spindle positioning		✓		
Rigid tapping (with Spindle)		✓		
Multiple threading		✓		
Taper thread cutting		✓		
Continuous threading		✓		
Variable lead threading		✓		
Custom Macro B		✓		
Polar coordinate interpolation		✓		
Cylindrical interpolation		✓		
Helical Interpolation option		Option		
Polygon turning		✓		
Inch/Metric		✓		
Fanuc Picture (Personnal customer page)		✓		
Languages control unit				
French		✓		
German		✓		
English		✓		
Italian		✓		
Spanish		✓		
Portuguese		✓		
Dutch		✓		
Swedish		✓		
Danish		✓		
Russian		✓		
Polish		✓		
Czech		✓		
Hungarian		✓		
Turkish		✓		
Japanese		✓		
Korean		✓		
Chinese (simplified characters)		✓		
Chinese (traditional characters)		✓		
Interface control unit				
Interface RS232-C		✓		
Interface PCMCIA		✓		
Interface Ethernet		✓		
Interface USB		✓		
Data Server		Option		

* According to DIN /DGQ 3441

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