

1. Machine description

Manufacturer :

Water Jet Sweden AB
Teknikvägen 4
372 38 Ronneby
Sweden

Phone: 0046 457 455 440
Fax: 0457-192 01
E-mail: waterjet@waterjet.se
Homepage: www.waterjet.se

Customer :

Scania CV AB
UTPWE/3731 By. 102
151 87 SÖDERTÄLJE

Time of delivery : 2007-11-06

Machine type : NC 3015 EB

Serial number : 95397

Year of manufacture : 2007

Cutting table area : 3200x1750

Weight of the machine (empty): 3000 Kg

Maximum load on the cutting table : 500 Kilos/m²

Controlsystem : GE Fanuc 18 i

CAD/CAM program: IGEMS

X-movement : 2250 mm

Y-movement : 1540 mm

Z-movement : 175 mm

Pos. accuracy : +/- 0.050 mm on every 1000 mm

Rep. Accuracy : +/- 0.025 mm

Positioning speed (XY) : 10 000 mm/min

Z-direction : 4000 mm/min

Total number of cutting heads : 2

Abrasive : 2

Beam length: 1640

Beam for nozzles: 1

Length of the nozzle pipes

Abrasive :	200 mm
Water:	250 mm

Maximum distance between the grating and the nozzle (abrasive cutting) : 160 mm

Dimension of the grating : 3 x 1045x1750x50

Min. distance between the nozzles : 90
Max. distance between the nozzles : 1510

Abrasive feeders : 2 x SM 3000

Mud pump : Sandpiper

Abrasive pressure vessel : 200 litres

The High Pressure Pump : KMT 37kw/50hp std (Air cooling)
Maximum flow of the high pressure water : 3,8 litres/min
Maximum flow of the coolingwater:

Hydraulic oil : Mobile DTE heavy medium turbine oil
 ISO-VG68 (Also see the recommendations from the manufacturer)

Electrical connections for the high pressure pump: 3x400 V, 100A, 50 Hz
Electrical connections for the machine : 3x400 V, 25A, 50 Hz, with a neutral conductor

Maximal air consumption : 600 litres/min at 6.5 bar

Pneumatic working pressures

Incomming air to the machine :	6.3 bar
Incomming air to the high pressure pump :	6.3 bar
Pressure vessel :	2-6 bar
Safety barrier :	3.0 bar
High pressure pump :	6.0 bar

Quality of the abrasive : Quartz free
 60-80 mesh for the 1.05 mm nozzle
 80-120 mesh for the 0.76 mm nozzle

Noise measurement Operator seat : Lp=88 dB(A) Lw=101 dB(A)
 The high pressure pump : Lp=75.5 dB(A)

Color : Blue, RAL 5015

Machine protection : Wire protection x 3

Extra equipment :

