



Vertical Machining Centers Portalo C 3022 CNC

SKU : 170144

Machines of the Portalo C CNC series are specifically designed for precision machining of large and heavy workpieces. The machine frame features a fixed gantry and a movable table. The machines in this series are perfect solutions for heavy-duty machining and high-speed machining of complex dies and forms. An extensive assortment of standard equipment allows for easy adaptation for specific requirements.

- High workpiece weight
- Large work area
- Rigid fixed portal
- Quick-action tool changer
- Renishaw measuring systems for tool and workpiece



TECHNICAL SPECS

WORKING AREA

Table dimensions	118 in x 71 in
Table load capacity (max.)	22000 lbs
Spindle nose-to-table surface distance	8 in - 47 in
Column distance	87 in

TRAVELS

Travel X-axis	126 in
Travel Y-axis	98 in
Travel Z-axis	39 in

HEADSTOCK

Spindle speed	6000 rpm
Spindle mount	SK 50 ISO 7388-1 (DIN 69871)
Spindle diameter	7 in

RAPID FEED

X-axis rapid feed	39.24 fpm
Y-axis rapid feed	39.24 fpm
Z-axis rapid feed	32.7 fpm

FEED

Work feed	315 in/min
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TOOL HEAD

Number of tool stations	24 positions
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ACCURACIES

Positioning accuracy	0,0002/11,8 in
Repeatability	0,0002/39,37 in

DRIVE CAPACITY

Motor rating main drive	34.9 Hp
Main drive, continuous load	29.5 Hp

MEASURES AND WEIGHTS

Overall dimensions (length x width x height)	315 in x 201 in x 193 in
Weight	66000 lbs



PRODUCT DETAILS

The movable set-up table and a fixed gantry allow machining of large and heavy workpieces

Gantry

- The large machining area and long travel distances require an extra rigid gantry and guide solutions for the most stringent requirements
- A combination of linear guides and box ways ensure a long service life plus higher machining speeds and steadfast rigidity
- High-quality preloaded ball screws and proven Siemens servo-motors provide dynamic feed and rapid feed on all axes

Main spindle

- High drive power and a wide speed range ensure availability of the necessary torque reserves during heavy-duty machining

Tool Changer

- The robust 24-station tool changer features a dual-arm gripper for maximum flexibility and quick tool changes during production

Control

- The Siemens 828 D provides intuitive, easy to learn programming features and comes with excellent support and service
- Siemens Shopmill software is included in the standard equipment. With this software even the most complex contours and workpieces can be produced with ease.

Equipment

- The workspace features large sliding doors in the machine enclosure for great accessibility and easy tooling
- Renishaw measuring systems for tool and workpiece gauging and measuring significantly increase the machine's efficiency by providing more flexibility, shortening down-times, eliminating manual input errors and reducing waste
- A powerful coolant system combined with the included chip conveyor ensure chip disposal
- An automatic central lubrication system simplifies maintenance

CONTROLS & SOFTWARE

Siemens 828 D control

SINUMERIK 828 D - The workhorse in the compact class of CNCs

Highlights

- Compact, robust, maintenance-free control panel-based CNC
- Comfortable program and parameter input via QWERTY keyboard
- Maximum machining precision
- Intelligent kinematic transformations for machining of cylindrical parts, and for angled workpiece levels
- SINUMERIK MDynamics with the new Advanced Surface feature: for perfect part surfaces and shortest machining times in mold making applications
- ShopMill: shortest programming time for single parts and small batch productions
- ProgramGUIDE: fastest machining time and maximum flexibility for large series productions
- Unique spectrum of technology cycles - from milling contours with residual material recognition to process measurements
- Animated Elements: unique operation and programming assistance with animated sequences
- Modern data transfer options via USB stick, CF card and network (Ethernet)
- Easy Message: maximum machine availability due to process monitoring per texting (SMS)

CNC hardware

- Control-panel based high-performance CNC Control
- Robust front control panel made of magnesium die-casting
- Integrated full-size QWERTY keyboard
- 10.4" TFT color monitor
- Maintenance-free design (no buffer battery required)

CNC performance data and functions

- SINUMERIK MDynamics package with Advanced Surface for mold making applications
- Tool changing time: ~2 ms (PPU 260/261) / ~1 ms (PPU 280/281)
- Number of Look Ahead sets: 100 (PPU 260/261) / 150 (PPU 280/281)
- Jerk-limited acceleration
- Dynamic feed-forward control
- 4-axis simultaneous interpolation (X, Y, Z and rotary axis)
- Linear, circular and helical interpolation
- Tapping without compensating chuck, plus thread cutting
- Oriented spindle holder
- Toggle between inch and metric units
- FRAME concept for individual coordinate transformations, rotations, scaling and mirroring
- 100 adjustable zero offsets
- Synchronous actions and quick help function output

CNC technology cycles

- Technology cycles for programGUIDE and ShopMill work step programming are available
- Large selection of drilling cycles
- Large selection of milling cycles for standard geometry
- Large selection of position patterns for drilling and milling operations
- High-speed settings for mold making applications
- Geometry calculator for free contour input
- Machining cycle for contour pockets / contour spigots with isolated contours

Graphic features

- Animated Elements: input help for machining parameters with animated sequences
- Graphical online help system, similar to PC system
- Graphical CNC simulation with level display

CNC tool management

- Display of tool and magazine data on one screen
- Tool management with plain-text tool names
- Loading/unloading feature for easy magazine assignment
- Number of tool edges: 256 (PPU 260/261) / 512 (PPU 280/281)
- Tool management with tool life monitoring

STANDARD EQUIPMENT

Siemens 828 D control
Shopmill Software option for Sinumerik 828D
20-station tool changer
Spindle oil cooler
Electronic hand-wheel
Spiral chip conveyor
Workpiece measuring system Renishaw OMP 60
Renishaw TS27R tool measuring system
LED work lamp
Coolant gun
Compressed air gun
Coolant system
Automatic central lubrication
Operating tools
Operating manual

OPTIONAL EQUIPMENT

- 90° Angle cutter head, SKU : 253901
- Oil skimmer, SKU : 254166
- SKU : 254167
- Coolant flow through spindle 20bar, SKU : 254169