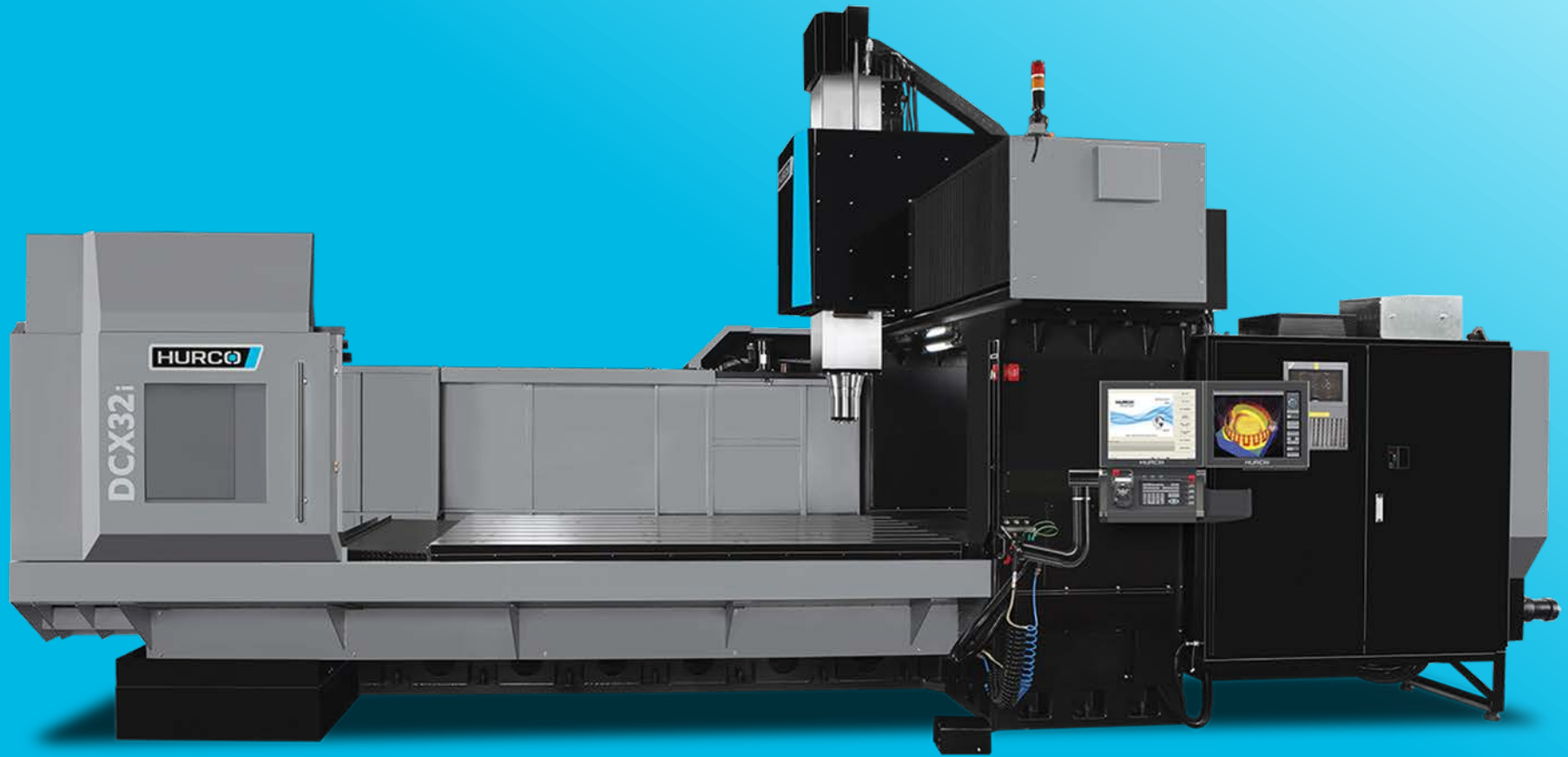


Dual Column Machining Center

DCX 32i



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Keydata



	DCX 32i
Travels (X/Y/Z) [mm]	3200 / 2100 / 920
Spindle Speed / option [1/min]	6,000 / 10,000
Spindle Power [kW]	60
Torque [Nm]	570 / 342
ATC stations	40

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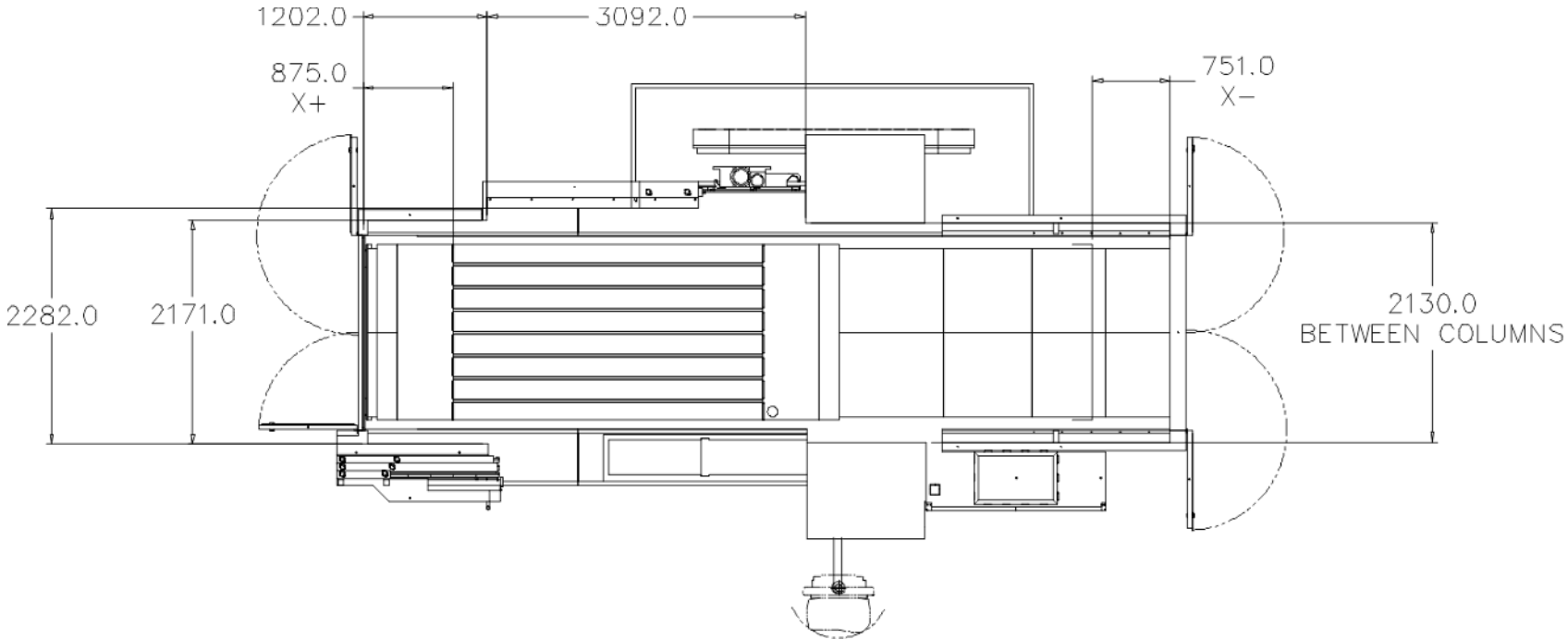
Technical Specification

Machine Capacity		Rapids X / Y / Z [m/min]	15 / 15 / 10
Travels X/Y/Z [mm]	3,200 / 2,100 / 920	Axis Thrust X/Y/Z [N]	61,000 / 41,500 / 40,600
Spindle Nose To Table [mm]	165 – 1,085	Automatic Tool Changer	
Table Working Surface W x D [mm]	3,000 x 1,700	Number of stations (optional)	40
T – Slots (DIN 650)	7 x 22 ^{H8} x 220	Max. Tool Diameter [mm]	125
Max. load (uniform distribution) [kg]	11,000	Adjacent Sides Empty [mm]	220
Spindle		Max. Tool length [mm]	300
Spindle Taper (DIN 69871 A)	SK 50	Max. Tool weight [kg]	15
Max. Speed / option [min ⁻¹]	6,000 / 10,000	ATC Time (Tool to tool) [sek.]	5
Max. Power [kW]	60	ATC Time (Chip to chip) [sek]	15
Max. Torque [Nm]	570	Service Requirements	
Retention knobs	ISO 7388/II B	Electrical	187 kVA / 270 A / 400V
Accuracy (VDI / DGQ 3441)		Air (Dry, clean air acc. DIN/ISO 8573-1, class 4)	7bar / 150 l/min
Positioning P _{max} [mm]	0.025 (Full travel)	Weights	
Repetability P ₅ [mm]	0.015	Machine Weight [kg]	35,000*
Feedrates		Shipping Weight (Both Containers) [kg]	41,000*
Cutting feedrate X / Y / Z [mm/min]	10,000 / 10,000 / 10,000		

*due to the position of the mass center of the machine, for unloading by forklift it is recommended to plan with a higher carrying capacity of 30%

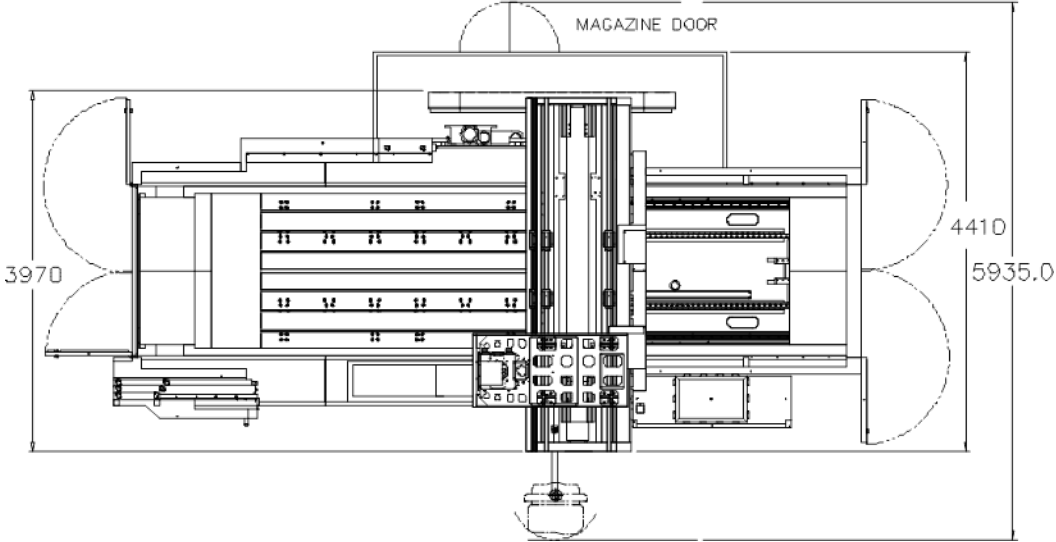
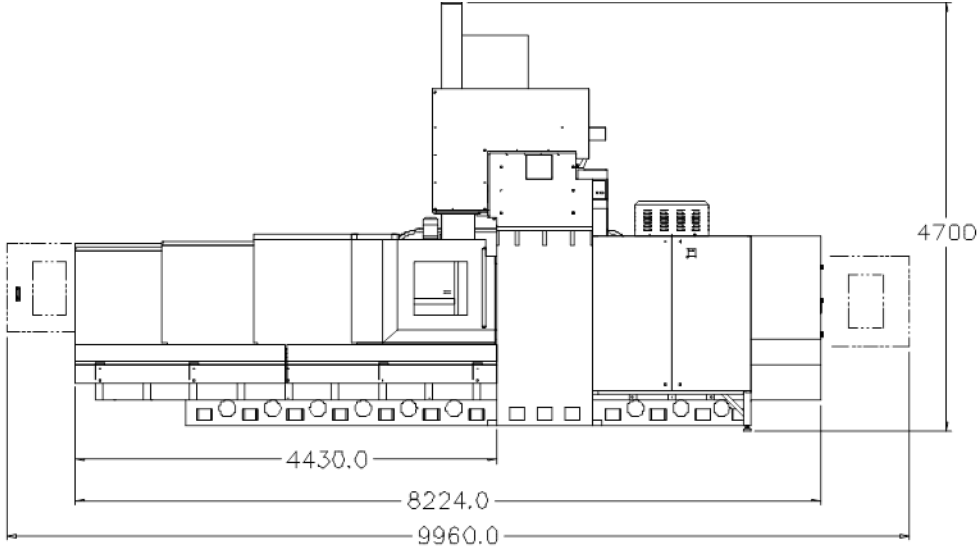
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Clearance Conditions



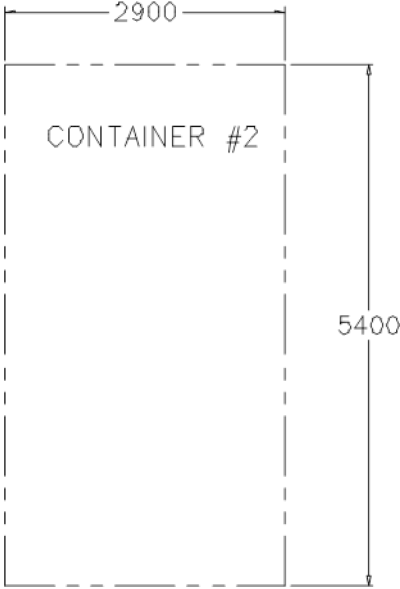
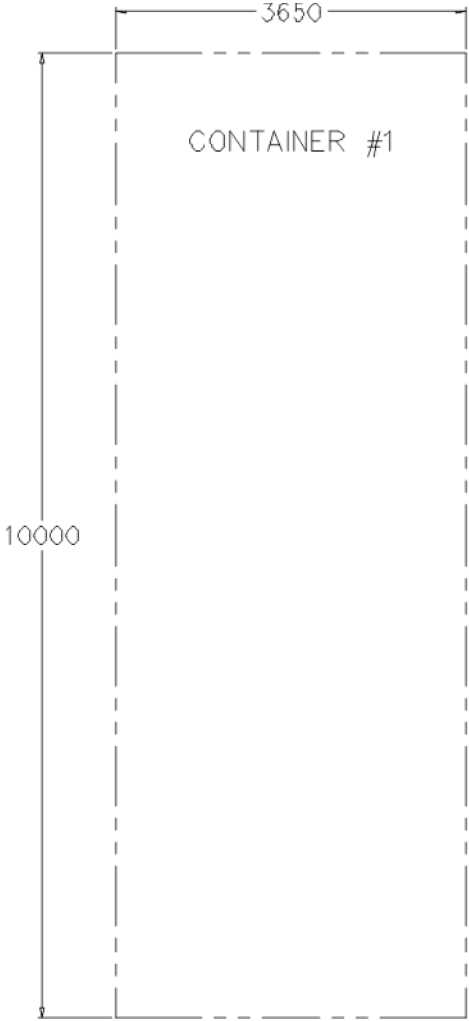
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Working Conditions



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Shipping Conditions



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Machine Options

- **Coolant air through coolant nozzles**
 - selectively coolant water or coolant air through coolant nozzles. Programmable as „Coolant 2“ or by M-function
- **Coolant air through Spindle**
 - as before, however supplying is through the spindle. Option „Coolant through Spindle“ (CTS) is required
- **BT-Arm**
 - for usage of BT-tool holders instead of SK holders
- **Part- and Tool Probing** [more](#)
- **Coolant through Spindle (CTS)** [more](#)
- **Production Package** [more](#)
- **Bypass Filter** [more](#)
- **Rotoclear**
 - The rotating pane throws off cooling emulsion, leaving the view free for the machine operator
- **Linear Scales**
 - Evaluation of axis position with a linear scale instead of rotary encoders (requires dry, clean air acc. DIN/ISO 8573-1, class 1, dew point 3°)

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Part- and Tool Probing

Partprobing

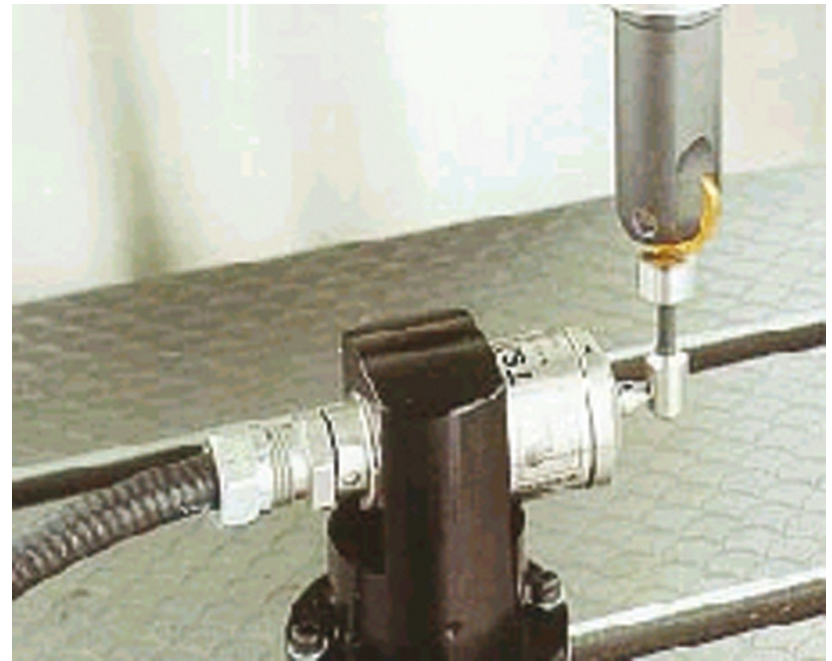
- Probing Part Zero:
 - Edge
 - Corner
 - Hole or Circle
 - Cylinder
 - Rectangular Pocket
 - Rectangular Solid
- Probing Skew Angle
- Measuring of Workpiece



Part- and Tool Probing

Tool Probing with Touch Probe

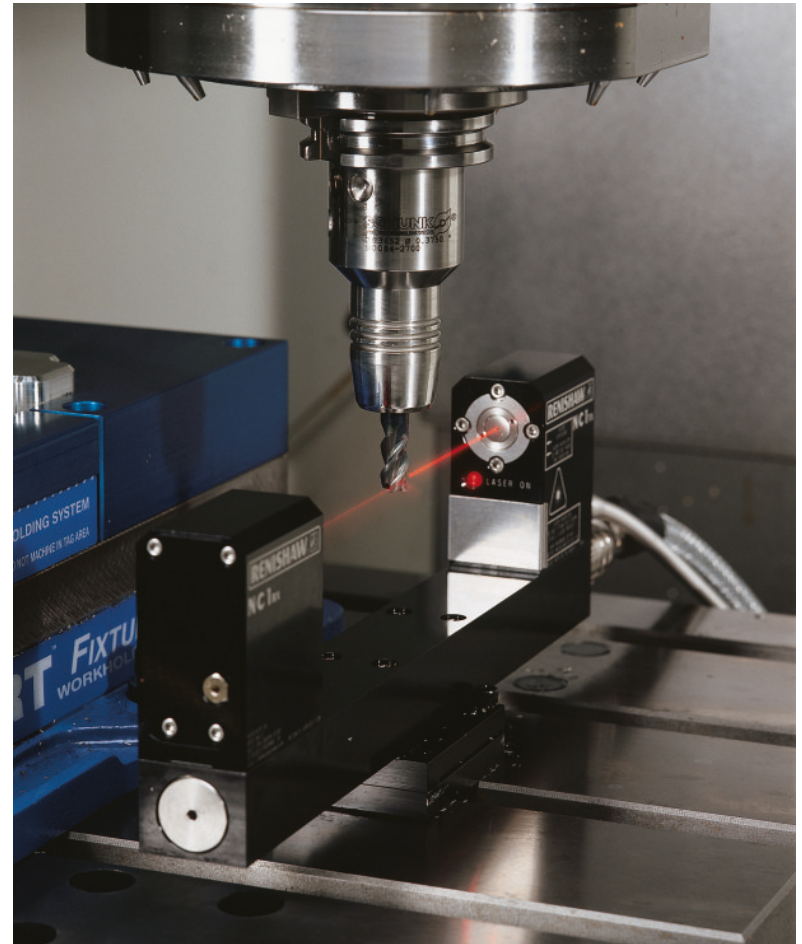
- Probing of Tool Length
- Tool Breakage Control of Tool Length and – if Tool is broken – Usage of a Spare Tool
- NO Probing of Tool Diameter



Part- and Tool Probing

Tool Probing with Laser

- Probing of Tool Length
- Probing of Tool Diameter
- Tool Breakage Detection and – if the Tool is broken – Usage of a Spare Tool
- Tool Wear Detection and Compensation



Part Probing and Tool Probing with Touch Probe

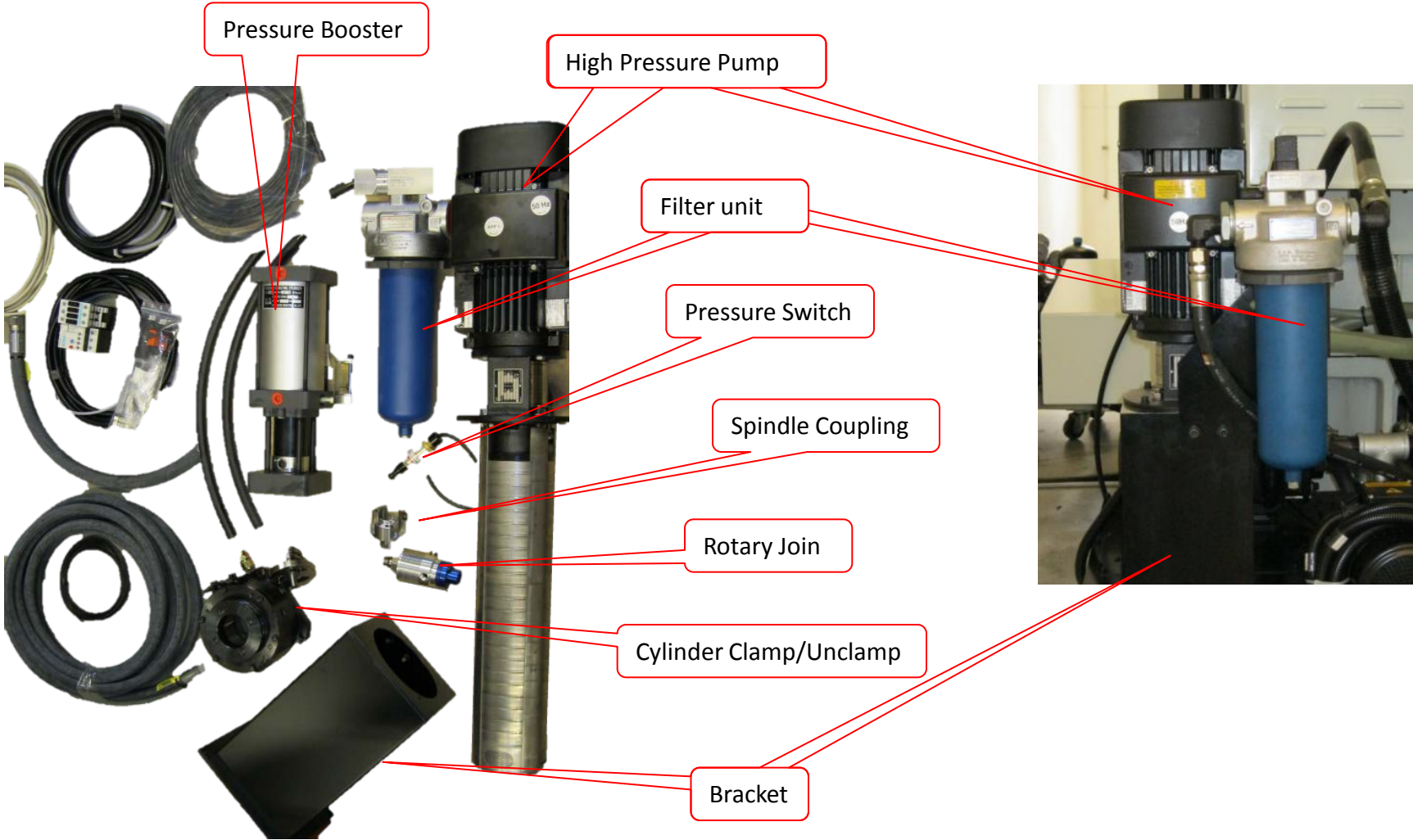


Part Probing and Tool Probing with Laser Probe



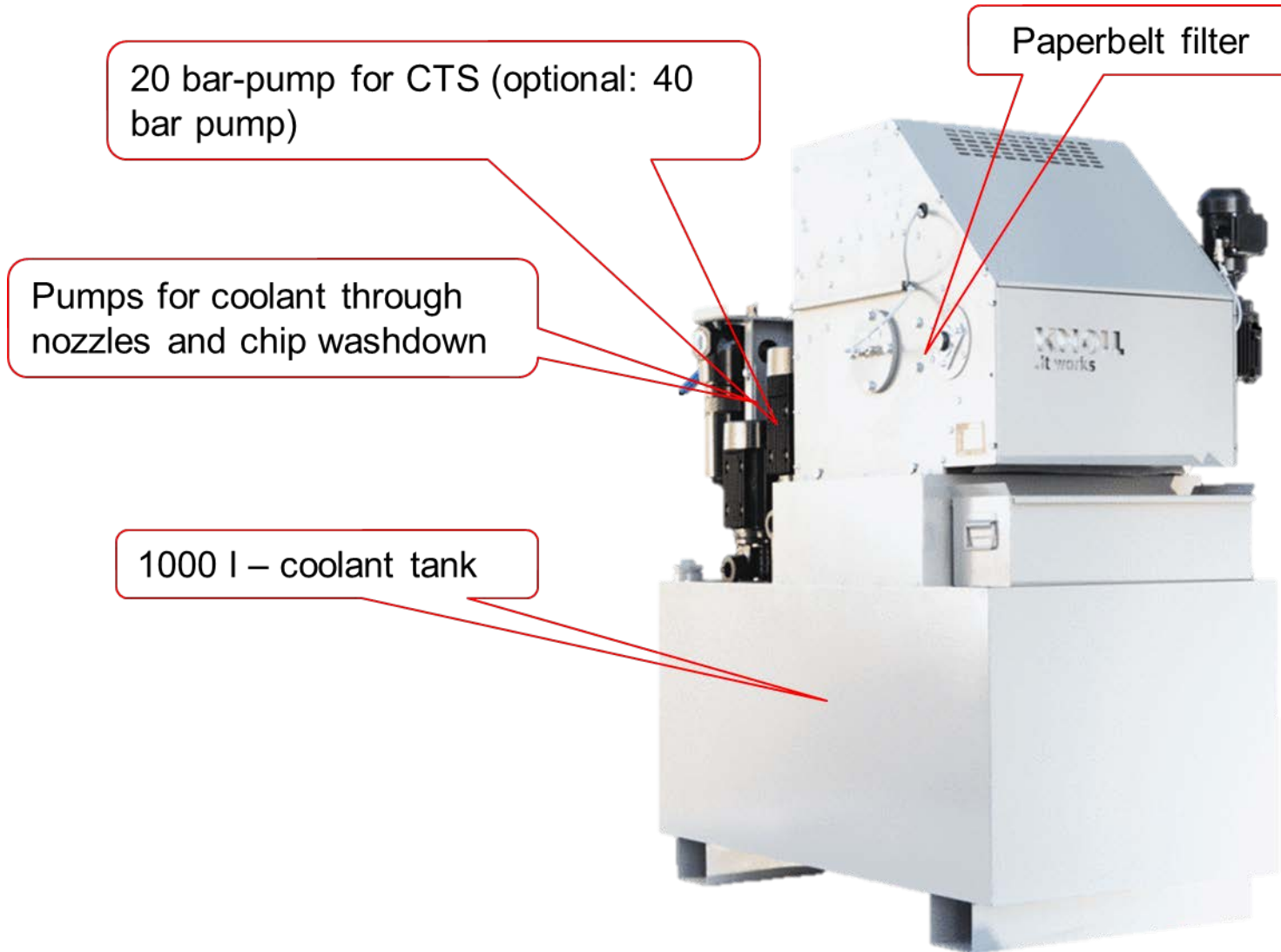
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Coolant through Spindle 20 bar



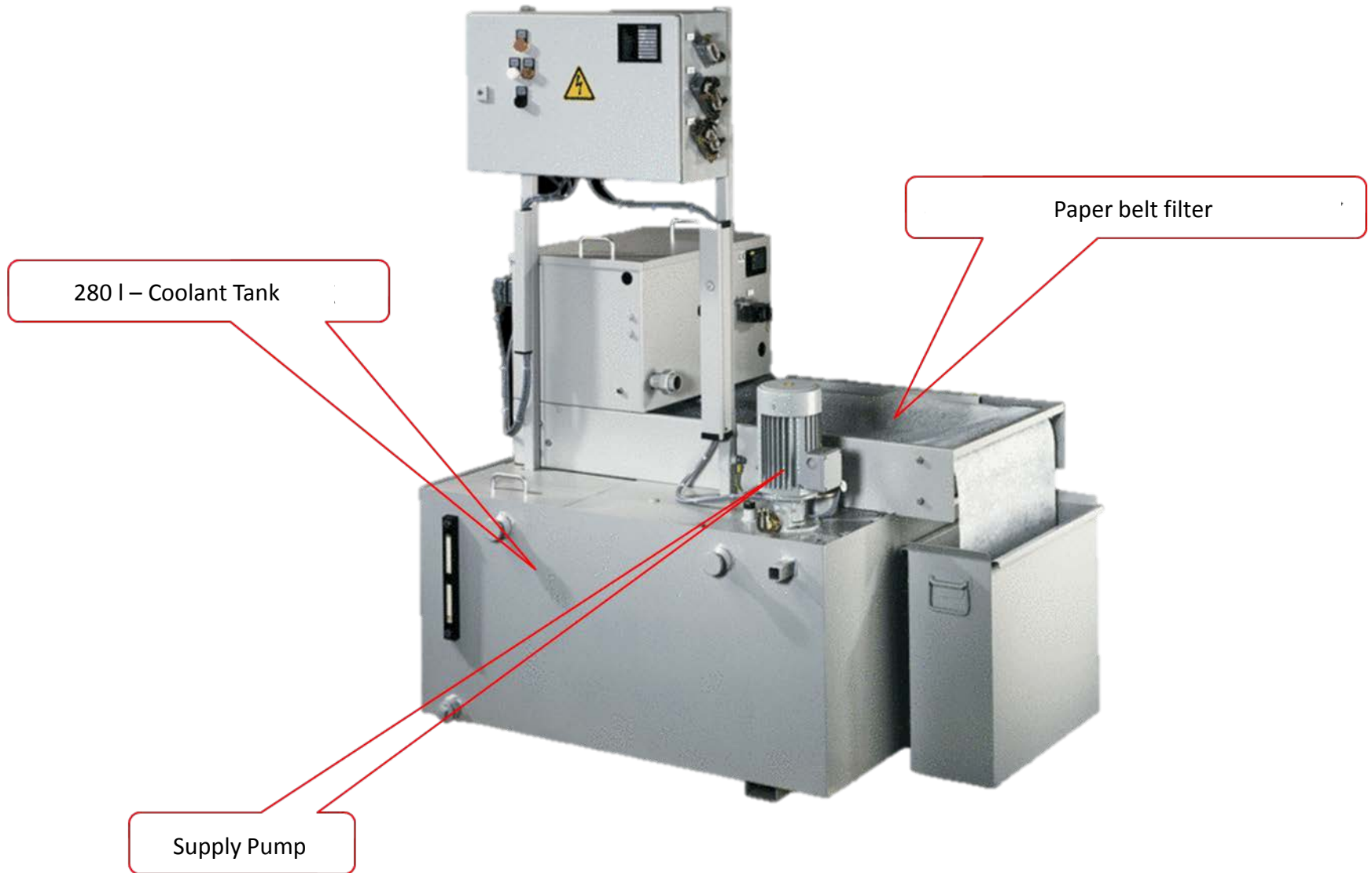
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Production Package KF400



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Bypass Filter



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Rotaries

	Rotary	Eligibility	Faceplate Diameter (mm)	Center Height (mm)	Spindle Bore (mm)	Clamping Torque (Nm @ 0,5MPa)
 <p>x well suited o after consulting - not suited</p>	GT 200	x	200	140	45	820
	GT 250	x	250	180	70	1600
	GT 320	x	320	225	105	2800
	TR 400	x	400	255	150	2500
	TR 500	x	500	310	170	3200
	TT 101	x	110	140	32	180 (4.) 300 (5.)
	TT 182	x	180	180	40	450 (4.) 800 (5.)
	TT 251	x	250	250	70	900 (4.) 1200 (5.)
	TT 321	x	320	255	110	2600 (4.) 2600 (5.)

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