

V631 SPECIFICATIONS

VB1250 SPECIFICATIONS

GRIPPER VB1250 / FULL-STOP VB1250

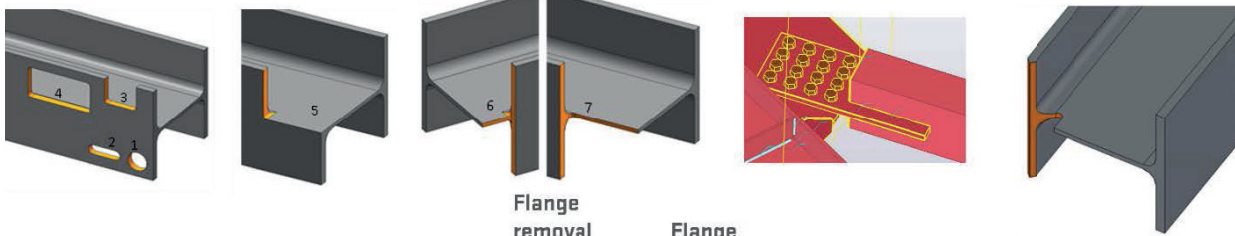
Operating range	mm inch	610 x 1.250 24 x 49
Positioning weight	kg lbs	19.800 43,650
Drilling		Direct drive motors
Positioning speed X	m/min f/min	54 165
Positioning speed Y	m/min f/min	30 100
Positioning speed Z	m/min f/min	30 100
Drilling units		3
Speed	rpm	0 - 4.500 stepless
Tool changer		3 x 8
Drill holder		SK40
Drill diameter	mm inch	5 - 40 13/64 - 1-9/16
Thread tapping	inch	M6 - M30 1/4 - 15/16
Cabin weight	kg lbs	Ca 14.000 30,800

Operating range 0°	mm inch	600 x 1.250 24 x 50
Operating range 15°	mm inch	600 x 1.200 24 x 47-1/4
Operating range 30°	mm inch	600 x 1.000 24 x 39-13/32
Operating range 45°	mm inch	600 x 850 24 x 33-1/2
Operating range 60°	mm inch	600 x 500 24 x 20
Feed		servo motor
Saw band drive	kW Hp	11 15
Saw band speed	m/min f/min	40 - 120 130 - 400
Saw band size	mm inch	67 x 1,6 2-5/8 x 1/16
Saw band inclination		5°
Weight	kg lbs	10.000 22,000

MAX. HEIGHT	Max. weight 9.000 kg / 19,840 lbs Gripper opening max. 43 mm		Max. weight 13.200 kg / 29,000 lbs	
	MIN.	MAX. 600 mm	MIN.	MAX. 600 mm
HEA	100	1000	100	1000
HEB	100	1000	100	1000
HEM	100	1000	100	1000
IPE	80	750	80	750
IPN	100	600	100	600
HD	260x54,1	400x314	260x54,1	400x1299
HP	200x43	400x231	200x43	400x231
UPE	80	400	80	400
UNP	80	400	80	400
T	70	140	70	140
L-equal	80/80/5	300/300/35	80/80/5	300/300/35
L-unequal	100/65/7	200/100/16	100/65/7	200/100/16
SHS	80x80x5	400x400x17.5	80x80x5	400x400x17.5
RHS	80x40x5	500x300	80x40x5	500x300
FL	10x50	25x500	10x50	25x500

V631 MILLING FEATURES

Overview of the supported features:



Profile type	Holes (1, 2, 4)	Block-outs (3)	Flange removal without web (5, 6)	Flange removal web (7)*	Knife Cut	Weld Preps	Rat Holes
H/I	✓	✓	✓	✓	N/A	✓	✓
U (channels)	✓	✓	✓	✓	N/A	✗	N/A
C (channels)	✓	N/A	N/A	N/A	N/A	✗	N/A
M (tubes)	✓	✓	✗	✗	✓	✗	N/A
L (angles)	✓	✓	✓	✓	N/A	✗	N/A
B (flats)	✓	N/A	N/A	N/A	N/A	✗	N/A
RO/RU (round)	✗	N/A	N/A	N/A	✗	✗	N/A
T (tees)	✓	N/A	N/A	N/A	N/A	N/A	N/A

*Other ball-nose than 10 mm
*With relief hole
*Not discarded in radius

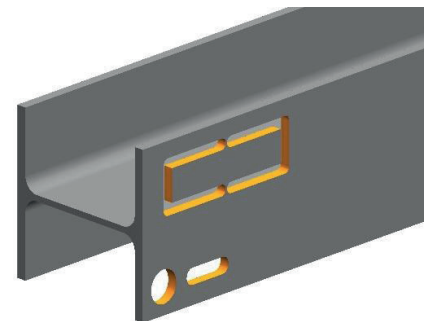
The milling features are delivered in three software modules:

BEAM MILLING 1

This milling package enables the machine to process inner contours.

The following features are included in this package:

- Slotted, round, and square holes without stitches
- Large round holes or square holes with stitches.

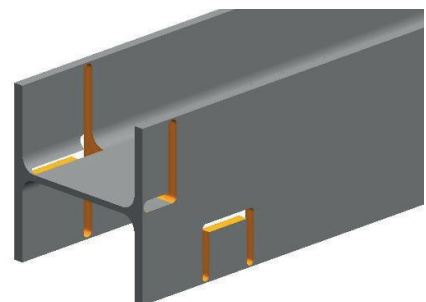


BEAM MILLING 2

This milling package enables the machine to process outer contours.

The following features are included in this package.

- Block-out halfway a flange
- Partial flange removal
- Complete flange removal (without web)
- Flange and web removal (block-out)
- Knife cut (slotted hole at the start/end of a tube)



BEAM MILLING 3

This milling package enables the machine to process weld preparations and weld access holes (rat holes). The following features are included in this package and supported in H/I profiles:

- Positive flange bevel
- Negative flange bevel
- Positive web bevel
- Negative web bevel
- Rat hole shape

