+GF+ AgieCharmilles

Technical Data
AC Progress VP

		AC Progress VP2	AC Progress VP3	AC Progress VP4
Travels				
X/Y/Z axes	mm in	350x250x256 13.77x9.84x10	500x350x426 19.7x13.77x16.8	800x550x525 31.5x21.65x20.67
max. speed X/Y	m/min. ft/min.	3 9.84	3 9.84	3 9.84
U/V axes	mm in	±70 ± 2.7	±70 ± 2.7	800/550 31.5/21.65
Max. taper angle <°/height	mm in	30°/100 30°/3.93	30°/100 30°/3.93	30°/500 30°/19.68
Dual measuring System for X/Y axes		standard	standard	standard
Work area				
Max. workpiece dimensions L x W x H	mm in	750x550x250 29.5x21.6x9.8	1050x650x420 41.3x25.6x16.5	1300x1000x510 51.9x39.3x20
Max. workpiece weight, with bath (without bath)	kg lb	200/450 440/992.08	400/800 880/1763.70	3000 6613.86
Accessibility		front	front/top	front/top
Frontal drop door		manual	manual	manual
Universal clamping frame for best utilisation of the work zone		standard	standard	standard
Machining in bath	mm in	250 9.84	420 16.5354	525 20.669
Wire threading system				
Agiejet Threadable height	mm in	Up to 250 9.84	Up to 420 16.5	Up to 525 20.67
Threading nozzle	ø mm in	2 0.07	2 0.07	2 0.07
	ø mm in	1 0.039 option	1 0.039 option	1 0.039 option
	ø mm in	0.6 0.0234 option	0.6 0.0234 option	0.6 0.0234 option
Wire threading in small holes and start hole search	function ≤0.10 mm	option	option	option
Wire guides, Standard equipment	ø mm in	0.15-0.33 0.0059-0.0129	0.15-0.33 0.0059-0.0129	0.15-0.33 0.0059-0.0129
Kit 70, Extension kit	ø mm in	0.07-0.10 0.0027-0.0039	0.07-0.10 0.0027-0.0039	0.07-0.10 0.0027-0.0039
Kit 50, Extension kit	ø mm in	0.05-0.10 0.0196-0.0039	0.05-0.10 0.0196-0.0039	
Combination wire guide system	"V" guide	cylindrical up to 2°	cylindrical up to 2°	cylindrical up to 2°
	Toroid guide	2° up to 30°	2° up to 30°	2° up to 30°
Increased accuracy in tapered cut Agieconic Plus	option	option	option	
Wire drive, wire spool	kg	up to 25	up to 25	up to 25
Wire disposal		chopper	chopper	chopper
Generator				
High power generator IPG-VPC integrated	~ A	60	60	60
Wide range of tested tech. for common users work	piece materials	standard	standard	standard
Max. cutting rate with CCS Ø 0.33 mm wire	mm^2/min. in/h	> 500 47	> 500 47	> 500 47
Finishing quality, best roughness	Ra µm µin	0.2 8	0.2 8	0.2 8
Best Ra with SF modul, finishing power module	Ra µm µin	0.1 4 option	0.1 4 option	0.1 4 option
Duotec, technology for the use of two wires type in a single contour		standard	standard	standard
PCD Module, machining of PCD disks or cutting tools		option	option	option
Smoothsurf, best surface homogeneity, uniformity of the eroded surfaces		standard	standard	standard
Correction of the cylindrical residual error, AWO (Advanced Wire Offset)		standard	standard	standard
Dynamic path optimisation and process adaptation in the radii DCC		standard	standard	standard
Real time detection and correction of the wire bending WBC		standard	standard	standard
Automatic power optimisation Variocut		standard	standard	standard
Prodtec: technology for highest productivity		standard	standard	standard

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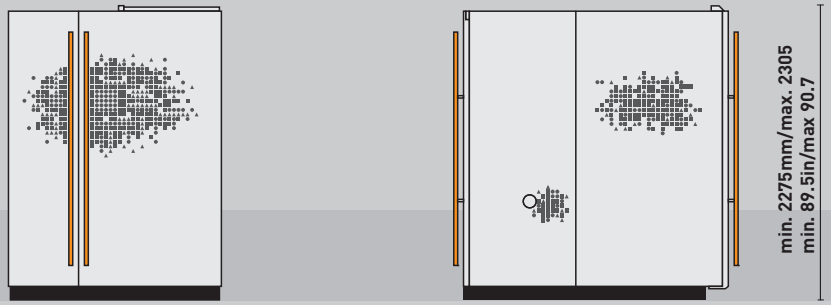
Dielectric conditioning unit				
Dielectric conditioning unit integrated	l us gal	750 200	1000 264	1600 423
Filter cartridges 4 canisters with 8 cartridge filters		standard	standard	standard
Filtrate quality	µm µin	5 197	5 197	5 197
Deionizing				
Deionizing bottle charge volume	l us gal	10 2.64	10 2.64	10 2.64
	l us gal	30 7.92 option	30 7.92 option	30 7.92 option
Cooling				
Generator and control unit with air/ water, and dielectric with water/ water heat exchanger		standard	standard	standard
System				
System dimensions L x W x H	mm in	1640x2040x2220 64.5x80.3x87.4	1940x2300x2600 76.4x90.5x87.4	2900x3050x2850 114.2x20.1x112.2
Net weight	kg lb	2580 5688	3460 7628	6000 13228
Weight ready-to-run	kg lb	ca. 3350 7385	ca. 4200 9260	ca. 11000 24250

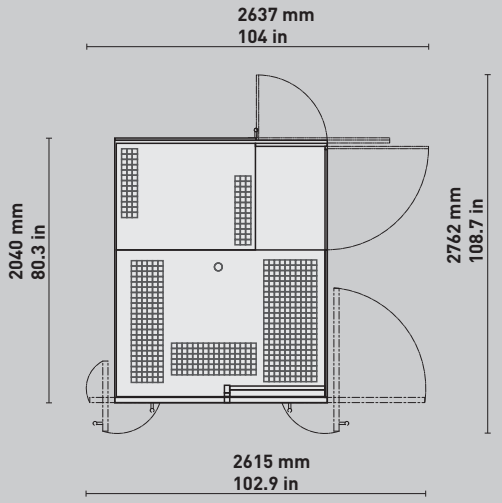
Control unit integrated, modules and functions	
Remote control with all setup functions	Agiejogger with electronic handwheel and LCD display
Operator interface system	15"-LCD-display, Keyboard and mouse
Control unit integrated	Agievision object oriented man-machine interface
Operating system	Multitasking Windows XP
Operating mode	Multiprocessor
CPU's	Pentium for CNC and operator interface
Servocontrolled axes	X/Y/Z/U/V
Supplementary servocontrolled axis	A axis
Smallest programmable step	0.0001 mm (0.000004 in)
Easy preparation of machining programs	Easywork
Automatic pickup cycles	Agiesetup 3D, for automatic determination of workpiece plane and position
Automatic technology selection based on machining objectives	Teccut
Import of job-specific data from CAD/CAM systems	Camlink
Predefined machining strategies	Autosequence
Predefined and user defined machining strategies	Usersequence
Simple 2D on-board geometry programming	IGES files Agiegeo with import of DXF and IGES files
Import in Agiegeo of third party ISO codes	Agiegeo Isoconverter
Quickly insert rush orders without effort	Pieceinsert
DNC port with Xon/Xoff and LSV2 protocols	DNC
Help functions, explanations with text and graphics	Help and online manual
Machining simulation 2D and 3D view	Graficheck
Automatic instructions and commands execution	Easyrun
Automatic machining sequence definition	Lotto for multiple workpieces clamping
Rethreading on wire break/on «no- thread» detection restart after power failure Rescue strategies	
Languages	English, CN, CZ, DE, DK, ES, FR, HU, IT, JP, NL, PL, RU, US, SE
Storage capacity	> 40 GB HD, 1 GB Ram
Interfaces	2 x RS232C, 1 x parallel, 1 LAN (Local Area Network), 1 USB
Data storage media	CD/DVD Rom for updates and on line manual, floppy-disk, USB

Interface for automation (only Progress VP2)	
Basic equipment for handling devices	Automation
Communication interface for handling devices	Robotcommand
Communication interface for cell computer connection	Hostcontrol

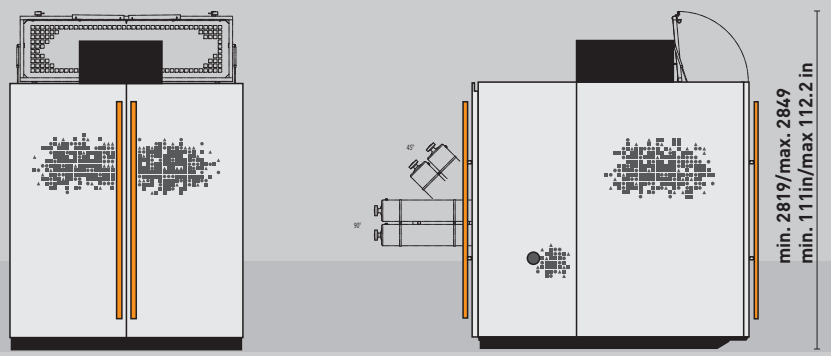
Connections	
Line power	12.1 kW
Line voltage	3 x 400 V
Compressed air	6 bar, 5 m^3/h (85 psi, 6.54 yd^3/h)
Cooling capacity required	9-11 kW

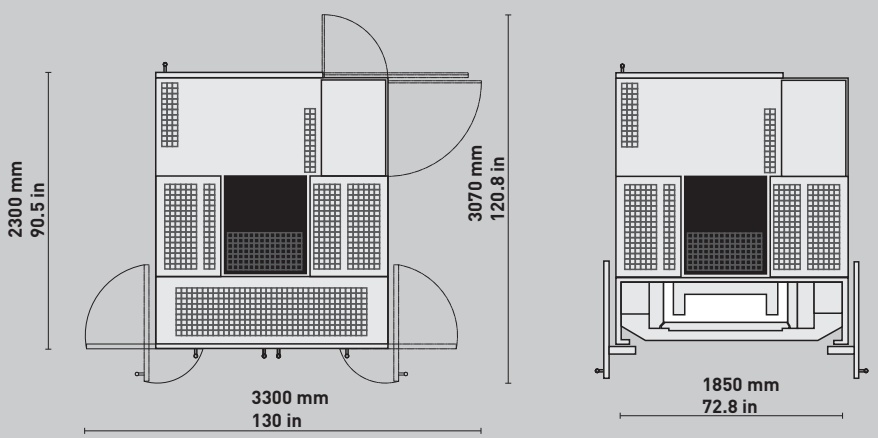
AC Progress VP2





AC Progress VP3





AC Progress VP4