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how to weld: in constrained position



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H-FSWC630

FSW UNIT FOR CONSTRAINED ACCESSIBILITY



Specifications

Driving innovative FSW welding solutions further, the H-FSWC630 in the horizontal build design is taking the lead for welding in constrained areas. The FSW units within the H-series are designed as 4-axis welding machines with integrated B-axis and built-in pallet change system with the possibility to weld on limited accessibility.

- ▶ STIRlytics process software for 100% traceability
- ▶ FSW force and position control system for optimum welding results
- ▶ suitable for all aluminum and die casting components
- ▶ automatic tool change system for 56 tool pockets
- ▶ additional pallets for simultaneous part loading and preparation for welding
- ▶ upgradeable milling functionality in a single production center

MACHINE INFORMATION

machine dimensions	3140 x 5340 x 3260 mm
spindle orientation	horizontal

ZUSÄTZLICHE ZEILE BEI DEN OPERATING TRAVELS (4-AXIS FSW UNIT)

X-axis binder	750 mm
Y-axis cross slide	700 mm
Z-axis slide ram	770 mm
B-axis	360°

FSW WELDING FORCES & FEED RATES

max. welding force in Z-direction	11,5 kN; spindle rotation speed 6.000 rpm
rapid traverse in X, Y, Z-axes	50.000 mm/min
positioning accuracy in X, Y, Z-axes	0,01 mm

CONTROL SYSTEM

control system	SIEMENS 840D sl / Sinumerik one
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MACHINING TABLE (DIMENSIONS)

table dimensions	630 x 630 mm
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- ✓ HV inverter housing, heat exchanger and structural parts with part size up to L 500 x W 500 mm
- ✓ high-volume production due to pallet change system
- ✓ ultra small machine footprint, fully protected workspace following CE-conformity