

## Profile and Keyseating / Machine Polymat NC/CNC Profile and Keyseating Tools



### Machine range

Polymat model		25 NC	32 NC	70 CNC	100 CNC	125 CNC
Cutting width	mm	25	32	70	100	125
Cutting length	mm	300	400	300/400/500/600 800/1000/1250	400/500/600 800/1000/1200	600/800/1000 1500
Cutting force	N	6.000	7.200	21.000	32.000	44.000
Workpiece weight	kg	10.000	10.000	20.000	25.000	25.000
Connected load – main drive	kW	3	4	7,5	11	15
Cutting speed - programmable	m/min	0-20	0-20	0-25	0-25	0-25
Return speed – fixed	m/min	20	20	40	40	40
Bore Ø to DIN 6885	mm	10-95	10-140	10-330	10-500	10-750
Advance	mm	0-5,0	0-5,0	0-5,0	0-5,0	0-5,0
Footprint incl. electrics	m x m	1,1 x 1,3	1,1 x 1,3	1,2 x 2,3	1,2 x 2,3	1,4 x 2,7

The Polymat keyseating machine can offer your company the following benefits:

#### Cost savings:

- Low cost of purchase
- Low cost of tools
- Easy to operate
- 10 year guarantee on the pistons and guides

#### Time savings:

- Workpieces can be stacked
- Programs can be saved and called up as required

#### Functionality:

- Easy to operate, using menu-based programming
- Error messages in plain English
- Freely programmable settings

#### Flexibility:

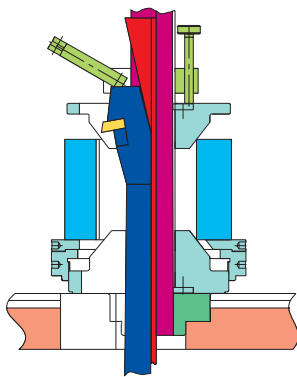
- Both drawing and routing
- Freely programmable depths of profiles
- Freely selectable profiles
- Profile repetition using manual dividing head

## Profile and Keyseating / Tools Polymat NC/CNC Profile and Keyseating Machine

### Standard centring sets, comprising:

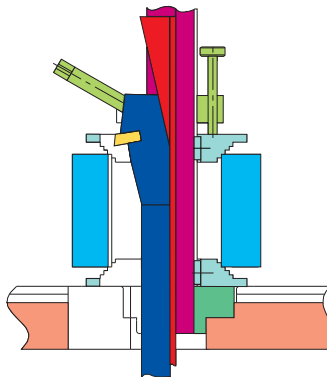
- Table insert bush
- Cutter advance bar
- Cutter
- Cutter guide bar
- Cutter bar / holder
- Centring
- Clamping piece

#### CONICAL CENTRING



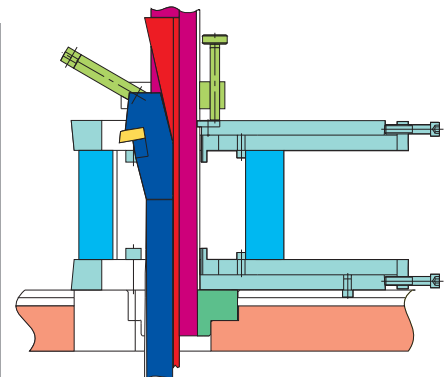
The workpiece end chamfers centre steplessly on the cones, positively locating them relative to the cutter tool.

#### STEPPED BUSH CENTRING



The workpiece end faces rest on the bush faces, whilst the workpiece bore is centred on the bush diameters positively locating it relative to the cutter tool.

#### ADJUSTABLE SUPPORT PLATE



The workpiece end faces rest on the support plates, whilst the workpiece bore is clamped using a three-point system with fixed and adjustable pins. The workpiece can be eccentric to the tooling whilst remaining positively clamped.

■ Machine table ■ Workpiece

### Standard tooling sets for Leistritz Hydraulic Profile and Keyseating Machines

Tooling sets (complete equipment)	WC 2	WC 3	WC 4	WC 7	WC 9c	WC 9	WC 10	WC 11
Max. cutting length (mm)	100	100	150	500	800	1000	1250	1500
Cutting width (mm)	2-3	3-6	6-12	12-22	22-50	22-50	56-100	100-150
Bore $\varnothing$ (mm)	10-13	13-20	20-40	40-85	80-230	85-260	200-500	230-750
Cutter guide bar $\varnothing$ (mm)	10	13	20	40	70	85	110	140

### Application ranges for workpiece bores by support system

Conical centring (mm)	10,5-13	14-20	21-40	41-85	80-230	85-260	-	-
Stepped bush centring (mm)	-	14-20	25-40	45-85	80-230	90-200	-	-
Adjustable support plate (mm)	-	-	40-160	60-200	100-300	130-400	200-500	200-500, 230-750

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