

Waterjet WJ 1630

€ 20.000,00	prijs per stuk / each		
€ -	totaalprijs / total amount	prijs / price	
code 1745-2		excl.	TRANSPORT / BTW / VAT/as is where is
Omschrijving/description	CAT A	ZH	

Complete **watersnijmachine WJ 1630** met een snijbereik van 1600mm x 3000mm x 180mm met 50 PK Intensiver pomp inclusief cnc gestuurde boor unit en software. Bouwjaar 2000. De Installatie is operationeel te bezichtigen. Alle manuals en onderhoudsgegevens zijn beschikbaar.

Complete **watercuttingmachine modell WJ 1630**. working area 3000mm x 1600mm x 180 mm with 50 HP Intensiver pump. With extra cnc driven drill and software. Year 2000. The equipment is in full operational state. Complete documentation and manuals are available.

Komplette **Wasserstrahlscneide Anlage WJ 1630** mit Arbeitsbereich von 3000mm x 1600mm x 180 mm mit 50 PS Intensiver pump. Inclusive extra cnc gesteuerte Bohrunite und software. Die Anlage ist funktionsfähig zu besichtigen. Komplette technische daten und Unterlagen stehen zur Verfügung.

www.waterjetcorp.com



DESCRIPTION OF THE EQUIPMENT

WORKING TABLE WJ 1630

TECHNICAL SPECIFICATION:

WORKING AREA:

X-AXIS	3.000 mm
Y-AXIS	1.600 mm
Z-AXIS.....	180 mm

TABLE DIMENSIONS:

X-AXIS	4.300 mm
Y-AXIS.....	2.300 mm
Z-AXIS...(without H.P. tubing).....	1.500 mm
WORKING TABLE HEIGHT.....	900 mm

MECHANICAL ACCURACY (entire lenght) ± 0,1mm

REPEATIBILITY: ± 0,1 mm

CUTTING SPEED:

X-AXIS	0 ÷ 20.000 mm. /min.
Y-AXIS.....	0 ÷ 20.000 mm. /min.

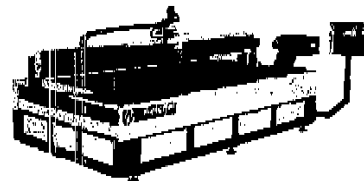


TABLE STRUCTURE:

- Full Stainless Steel Tank
- Square tubular frame of 120 mm with high strength and stiffness
- Internal location of the linear units inside the frame
- Proximity switches for Zero (reference) point and Extra Route
- Complete open area for the loading-unloading of material
- N.16 interchangeable galvanized grids table
- Abrasive Tank 50 Kg.
- Total weight (without water): Kg. 3.000

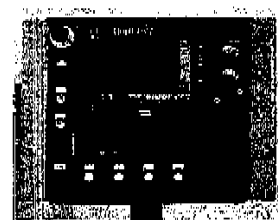
MOVEMENT SYSTEM:

- Sealed aluminium linear units with a **STAINLESS STEEL** carriage on a **STAINLESS STEEL** preloaded recirculating belt grinded guide
- **AUTOMATIC INTERNAL LUBRICATION** system of linear units
- Aluminium trasmission-shaft for the Y axis linear units
- Pneumatic CNC movement of the Z axis
- Epicycloidal gears with Brushless AC servo motors
- Double sealing protections by a rubber belt on the linear unit frame and by vertical external bellows
- Location of the linear units inside the table frame for an higher protection

NUMERICAL CONTROL

TECHNICAL SPECIFICATION:

- CNC axis control
- PC INDUSTRIAL
- 10 GigaByte HARD DISK
- RAM 64 Mb
- VIDEO A 10,4" FLAT
- DIGITAL DRIVERS
- GRAPHIC SIMULATION
- WATERPROOF AND DUSTPROOF KEYBOARD
- Floppy disk
- N. 2 Serial doors RS-232
- Ethernet Card 10 /100
- Automatic controlled acceleration and deceleration ramps



Waterjet s.r.l.

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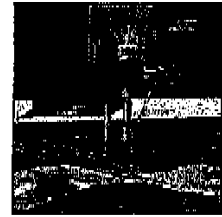
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SELF-POSITIONING DEVICE

The CNC controls automatically the selfpositioning sensor executing these following operations:

- 1- Self-automatic positioning of the cutting head next to the material WITHOUT any programming of the or of the thickness
- 2- Costant mantelning of the right distance between FOCUSING-MATERIAL by a programming checking (in mm.) operation of the sensor
- 3- 3D profile cutting by a continuous leaning checking of the sensor



LATHE ROTARY AXIS

The CNC rotary axis is used to cut tapered or cylindrical shapes (ex: tubes) interpolating a 4th axis with the X axis

The rotary device works with one cutting head only.

The lathe is installed in a dedicate area in the lenght or in the width of the tank without decreasing the original flat cutting dimensions

The software WaterCad - Cam supplied is already compatible for this device

MAX. TUBE LENGHT (lathe installed in the lenght): 2.400 mm

MIN. TUBE DIAMETER: 50 mm

MAX. TUBE DIAMETER 300 mm



OUTSIDE TABLE DIMENSIONS:

X-AXIS 4.300 mm

Y-AXIS 2.800 mm

N. 1 SELFALIGNING CUTTING HEAD "SELFJET"

TECHNICAL SPECIFICATION:

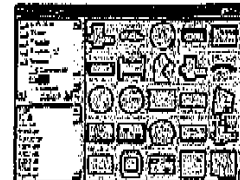
- Pneumatic Valve ON/OFF (Normally Closed)
- SELF-ALIGNING MIXING CHAMBER FOR THE ORIFICE AND FOCUSING
- N.1 mini-hopper next the cutting head



SOFTWARE WATERCAD-CAM

TECHNICAL SPECIFICATION:

- High performance CAD system
 - AUTOMATIC CAM software for an automatic ISO part program processing
 - AUTOMATIC NESTING
 - PART and SHEET LIST
- AUTOMATIC SYSTEMS**
- AUTOMATIC FINISHING SELECTION BY COLOR CHOOSE
 - AUTOMATIC LOOPING SYSTEM
 - AUTOMATIC TAGS INSERTION
 - AUTOMATIC COMMON CUT
 - AUTOMATIC SMALL BRIDGES INSERTION FOR A UNIQUE CUT
 - AUTOMATIC QUOTATION - Compatibility with any other CAD trough DXF



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- Time, Speed, Length and Cutting Costs tables for the shape
- ISO simulation of the cutting profile and personalization of the ISO sequence

GENERAL COMMERCIAL TERMS

INSTALLATION and TRAINING INCLUDED

One of our specialized technician will install the Waterjet Equipment and will train one of your technician to use and to maintain properly the Waterjet System, including the Software Watercad-Cam supplied. The total time INCLUDED IN THE CONTRACT is MAXIMUM 5 WORKING DAYS.

CUSTOMER RESPONSIBILITY AND EXPENSES:

1. Trip, board and lodging of our technician for the installation and training.
2. Medical assistance
3. Communication by phone and fax between your factory and Waterjet S.r.l
4. Transport of our technician from Hotel to the Factory

IMPORTANT: Before to start the Installation and training of the machine, the lay out of the equipment has to be prepared (Air pressure, Water, Electrical power, Etc.)

WARRANTY

The High Pressure Waterjet System is covered of a warranty for good running with these following conditions:

- 12 months warranty
- Spare parts free if the problem is under technical or electronical manufacturing defect with the condition of Ex Works Monza Factory: the parts replaced in warranty due to a manufacturing defect must be sent back to Waterjet s.r.l. at customer expense.
- The Warranty will terminate immediately if utilizing NOT ORIGINAL GENUINE consumable and spare parts SUPPLIED by **Waterjet S.r.l.**
- The warranty will not cover any natural event or accident produced from the customer's technicians
- During the warranty all the direct expenses of our technician are not included (Trip, board and lodging)
- **WARRANTY EX WORKS MONZA FACTORY** for spare parts and consumable

SUPPLY LIMIT NOT INCLUDED

- | | | |
|---|-------|----------------|
| 1. Compressed Air | (BAR) | 6 |
| 2. Electricity | V | 400 / Hz 50-60 |
| 3. Power | kW | 3 |
| 4. Unloading of the container or truck by crane (at your factory) | | |
| 5. Positioning of the machine inside of the factory | | |
| 6. Any special modification on the floor for the positioning of the machine | | |
| 7. Water filtration system on the overflow | | |
| 8. Any extra insonorisation system for the system. | | |
| 9. Any Cost for Legalization of documents | | |

CIVIL RESPONSABILITY

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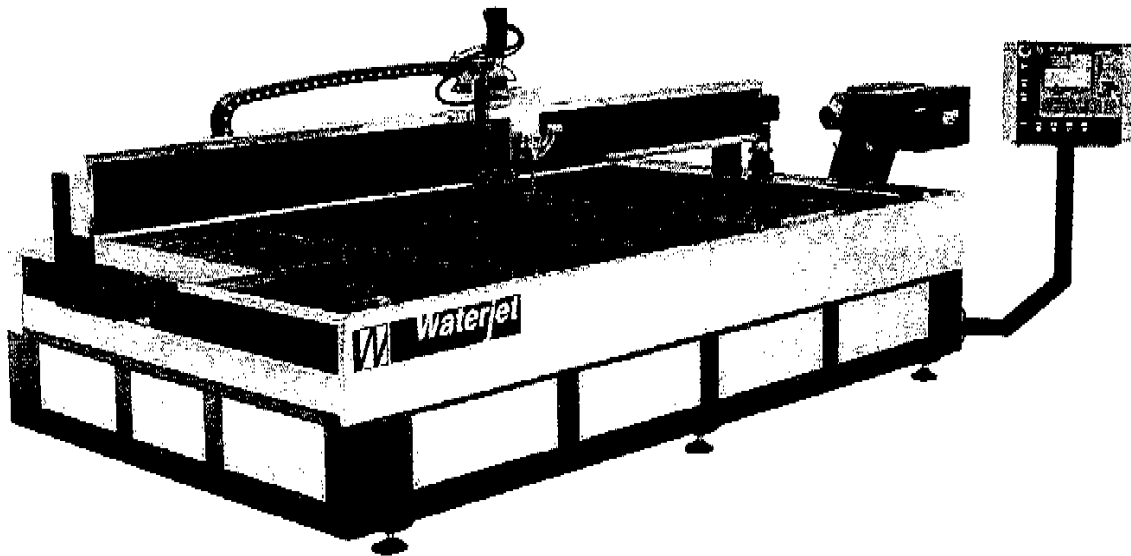
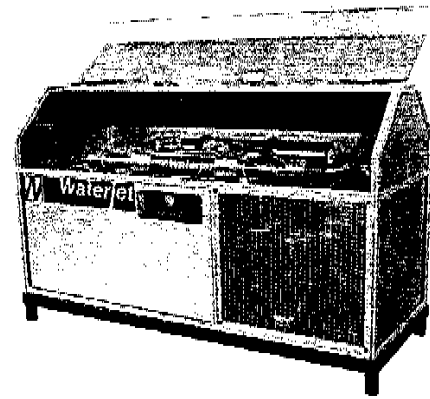
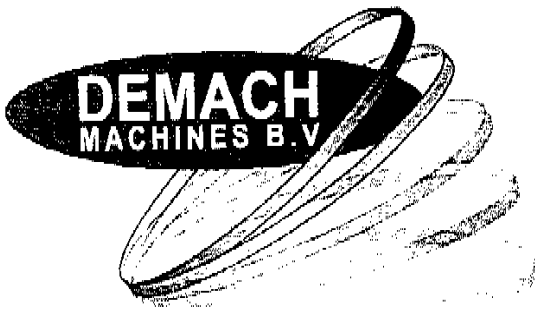
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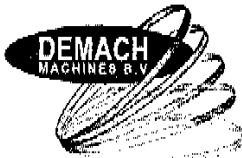
Materiaal	dikte	gem. snijsnelheid
Aluminium	5 mm	1.000 mm/min
	10 mm	600 mm/min
	15 mm	400 mm/min
Roestvast staal	5 mm	400 mm/min
	10 mm	200 mm/min
	15 mm	120 mm/min
Titanium	2 mm	800 mm/min
	5 mm	250 mm/min
	10 mm	120 mm/min
Keramiek	10 mm	5.000 mm/min
Plexiglas	5 mm	6.000 mm/min
	10 mm	3.500 mm/min
	20 mm	2.000 mm/min

Maximale materiaal dikte
150 mm

Pomp unit			
Max. druk: 4.130 atm			
vermogen		verbruik	nozzle
21 kW	30 Pk	2,2 lt/min	0,28 mm
45 kW	60 Pk	4,7 lt/min	0,40 mm
94 kW	125 PK	9,4 lt/min	2x 0,4n...



basis modellen			
	lengte	breedte	pomp
WJ 1212	1200	1200	45 kW
WJ 1630	1600	3000	45 kW
WJ 2030	2000	3000	45 kW
WJ 2040	2000	4000	45 kW
WJ 2060	2000	6000	45 kW
WJ 2560	2500	6000	45 kW
WJ 3060	3000	6000	45 kW



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ANALYSE VAN DE SNIJKOSTEN 2004

KOSTEN 30 - 60 HP	KOSTEN PER EENHEID	DUUR OF VERBRUIK	KOSTEN PER MINUTE
Elektriciteit	0,10 Euro/kW	22 Kw 45 kW	0.035 0.07
Garnet Abrassief <i>Abra-Jet 80 Mesh</i>	0.17 Euro / Kg.	200 [gr./min.] 400 [gr./min.]	0.032 0.065
Ruby Orifice <i>Tested</i>	24 Euro / stuk	> 100 [h]	0.001
Focusing Tube <i>Long Life</i>	85 Euro / stuk	> 100 [h]	0.015
Pomp kit Onderhoud	250 Euro	500 [h]	0.009
Totale snijkosten per minute [EUR]			0.09 0.16
Productiekosten per uur		30 HP 60 HP	~ Euro 5,5 ~ Euro 9,6

Prestaties

MATERIAAL	DIKTE [mm.]	SNELHEID SCHOON SNIJVLAK [mm / min]	SNELHEID MEDIUM SNIJVLAK [mm / min]	SNELHEID RUWER SNIJVLAK [mm / min]	DIAM. ORIFICE [0.40 mm = 0.016"]	POMP VERMOGEN [Hp] [4,7 lt/min]
MARMER	10	500	900	1.700	0.40	60
MARMER	20	250	650	1.100	0.40	60
MARMER	30	200	350	650	0.40	60
GRANIET	10	450	900	1.400	0.40	60
GRANIET	20	200	450	650	0.40	60
GRANIET	30	130	250	400	0.40	60
STA. STEEL	5	250	500	800	0.40	60
STA. STEEL	10	130	250	400	0.40	60
STA. STEEL	15	100	150	200	0.40	60
ALUMINIUM	5	900	1.300	2.200	0.40	60
ALUMINIUM	10	500	800	1.300	0.40	60
ALUMINIUM	15	250	500	800	0.40	60
GLAS	4	2.500	5.000	7.500	0.40	60
GLAS	10	1.000	2.000	2.500	0.40	60
GLAS	19	400	650	900	0.40	60