



Process machine for mold making

# EXPRESS 1250/2500

Horizontal Machining Centre with Deep Hole Drilling



## Company

Moldmak focuses its activity on the design / development, production and commercialization of CNC (Computer Numeric Control) machines to optimize the production process in the mold manufacturing sector.

Aware of the strong competitiveness of the worldwide market for machine tool production and bearing in mind the requirement for quality and commitment to efficiency and sustainability, Moldmak is the result of more than 35 years of experience, research and development in the manufacture of molds. In order to distinguish itself from the competition by creating even more efficient production solutions, at the technical and economic level, Moldmak comes to fill an absence of solutions in the market of mold's intelligent production systems.

Since its start, the company integrates a team with extensive national and international experience and with demonstrated results in the sector. In fact, it was the dissatisfaction with the functional limitations of the machines used in the mold industry, which created the opportunity to develop a new business project. Only with the accumulated experience of the team, the deep knowledge of the molds' production process and the domain in the development of high precision CNC machines, it is possible to raise the bar of the current state of the art, establishing a new product of great impact in the sector.



Horizontal Machining Centre with Angular capacity and Deep Hole Drilling



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## Commitment to mold machining process

The experience gained in the mold industry and the detailed understanding of the needs of the industry have given birth to MOLDMAK which today boils down to more than 35 years of mold making experience, research and development and aims to distinguish itself from the competition by creating productive solutions increasingly efficient at the technical and economic level.

## MOLDMAK is 30% faster than conventional solutions because:

- It reduces hand overs and setup times, leaving more available time to perform the multiple machining processes required for part execution.
- It shortens execution times due to the advantages of being a horizontal Spindle machine with vertical angular capacity and table rotations on the horizontal plane.
- Reduces cascade of nonconformities, because it can include at the end of each task dimensional control. This way, only one geometrically validated part advances to the next step or process.



Industry 4.0



IoT



Communication



Maintenance



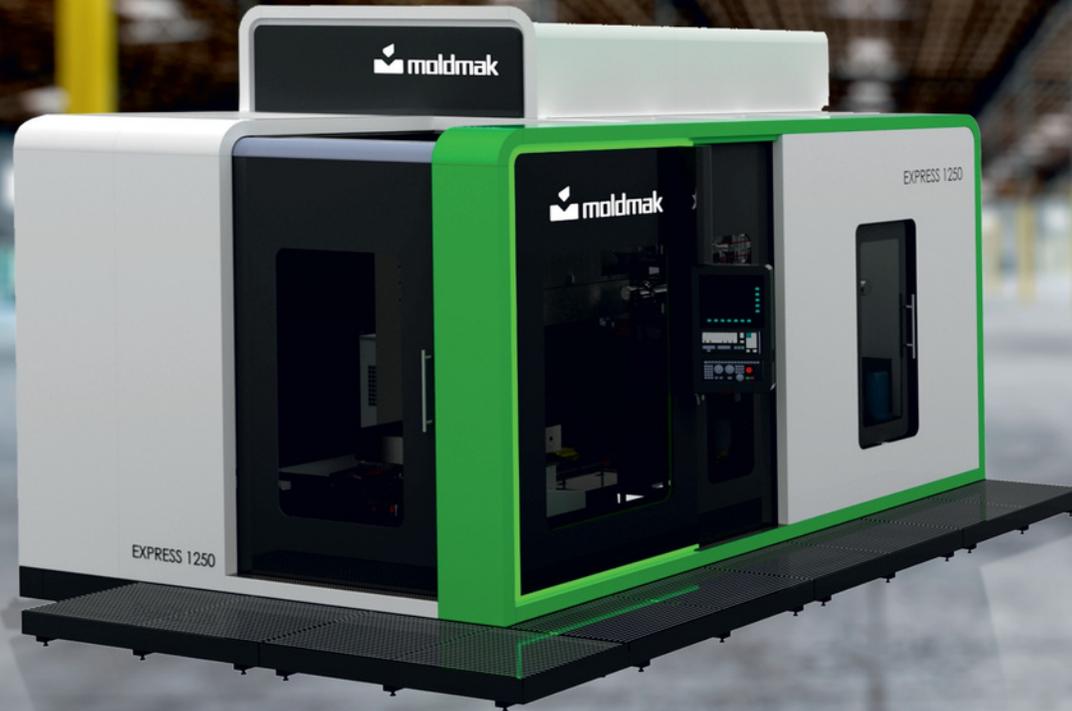
Management



Monorization

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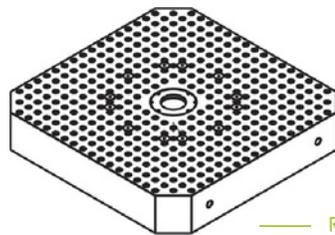
- The Express is suitable for deep hole drilling and milling for the mold sector. It has a structure entirely in cast steel with stress relief heat treatment and with strong internal ribs using advanced software with finite element analysis (FEA), so it is possible to reduce the torsion and vibration effects caused by the forces of the processes of machining and optimize thermal stability, rigidity and dimensional accuracy.



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with A axis

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Rotating Table

The rotary table has strong rigidity and precision, the top of the rotary table is made of Steel.

Large diameter bearing with high capacity to withstand radial and axial forces.

Table dimensions 1500 x 1500mm

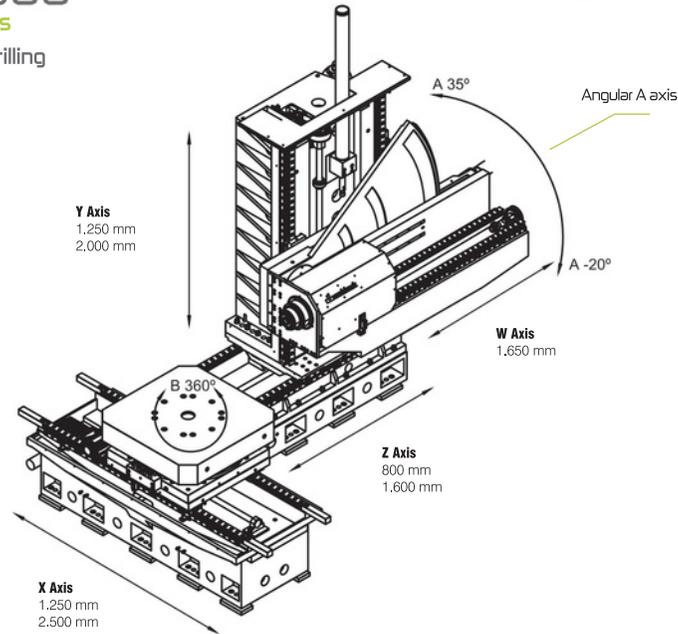
Movement 360 000 positions

Maximum centred load 5 ton / 12 ton

Maximum table speed 6.6 rpm

Turning accuracy  $\pm 5''$  Arc sec.

Repeatability 4 arc sec



## Spindle

Motor Spindle	13/26 kW
rpm	18.000
Torque Max	124 Nm
Taper	HSK63



## Machine Cover

Complete cover round the machine with sliding doors.

Easy access to operator's working area.

All peripherals within the machine.

Wide workpiece entry when transported with crane.



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#### MULTI-TASKING

Multitasking capability enables it to respond effectively to the needs of various machining operations



#### HIGH STIFFNESS = HIGH PRECISION

Extremely robust and vibration free structure, helps to reduce tool wear



#### ANGULAR CAPACITY

The angular capacity with the rotary table ability allows machining with shorter tools



#### ROTARY TABLE - B AXIS

The rotary table allows machining all around the part with the same setup



## DAPI - Drilling Adaptive Process Intelligence

The correct variable control is critical for machine's reaction during deep hole drilling operations.

When reaching intersection points the machine will automatically adjust the feed and rpms until all controlled parameters are stable again.

This automatic adjustment is generated by the machine without the use of CNC or CAM pre-programmed instructions.

This software application can be programmed to provide warnings when vibration or axial load level goes above the predefined set point.

This feature can also be used to program the machine to automatically change the tool (by a twin tool) when the predefined set point vibration level is reached (usually by tool wear).



Machining support software applications

## Moldmak Sensing Control Machine Parameters

- ✔ Tool penetration force
- ✔ Tool vibration
- ✔ Spindle power used in the process
- ✔ Force made during the process
- ✔ Power used in the linear axis
- ✔ Force required by the axes
- ✔ Emulsion monitoring

## In the deep hole drilling process:

- ✔ Allows to predict conditions for tool sharpening
- ✔ Avoid tool break
- ✔ Control for twin tool change
- ✔ Monitors and adjusts technological parameters in case of interceptions
- ✔ Allows presetting parameters by tool typology