



**COMBINED MACHINING CENTRE FOR PLATE
DRILLING, PUNCHING, MARKING AND CUTTING**

MAG B



MAG B

High speed combined machining centre for medium to thick plates drilling, punching, marking and (plasma and/or oxy) cutting

With a single handling, this combined machine allows the process and automatic unloading of all types of base plates and gussets.

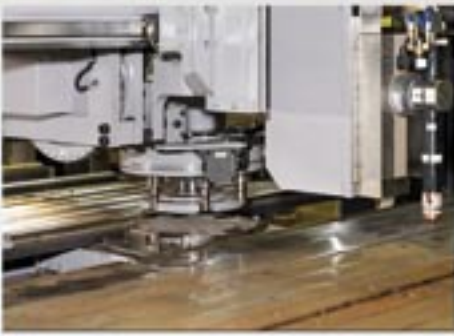
It thus becomes a key element of the productivity of any steel fabricating workshop and is characterized by:

- ✓ **Drilling, punching, marking and cutting of plates with only one handling**
- ✓ **Reliability and low maintenance in operation**
- ✓ **Simplicity and flexibility of use**
- ✓ **Maximum productivity guaranteed**

Important design factor:

The machine design allows to fit any customer's specific requests, by ensuring:

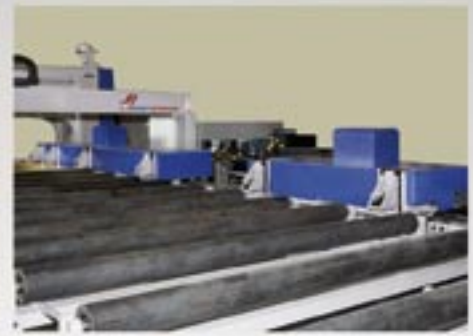
- ✓ **Extreme modularity in the choice of functions installed**
- ✓ **Flexibility in the machining and cutting processes (plasma and/or oxy)**
- ✓ **Robustness and accuracy**



Punching, marking and cutting assembly



11 kW drilling unit with rotating tool changer



NC controlled feed carriages



Control panel



Separate oxy cutting frame



Conveyor evacuating finished parts

Main technical characteristics:

- ✓ NC controlled feed carriages placed in the shape of the plate (compactness of the machine)
- ✓ Grippers with hydraulic clamping distributed on the whole plate length
- ✓ Drilling with rotation spindle speed up to 2700 RPM
- ✓ Possibility of scribing: after technical validation
- ✓ Powerful punching with 400 bar hydraulic pressure
- ✓ Rotating turret: 6 punches with diameter changing in spare time
- ✓ Disk marking unit (with optimum repositioning of marking on machined parts)
- ✓ Standard plasma cutting, optional separate oxy cutting
- ✓ Possibilities of continuous combined cutting and common cutting
- ✓ Integrated and optimized fume extraction system
- ✓ Smooth tilting unloading table for the smallest parts unloading
- ✓ Very easy unloading of machined parts: part by part or per area
- ✓ Plate lifting system installed on machine infeed and exit sides making the transfer easy and allowing optimal punching with the material resting against the die during punching
- ✓ Multi-application, standard and tested Nesting software
- ✓ Industrial PC with software PLC
- ✓ ProNC 32® programming software for programing under Windows:
 - Very user friendly
 - Numerous functions
 - Telemaintenance
- ✓ Hanging control panel with TFT 15" screen and tight keyboard with integrated mouse
- ✓ Air conditioning in control cabinet
- ✓ Network connection with machine files import



Characteristics	MAG B 320 / 325	MAG B 620 / 625	MAG B 1220 / 1225
Maximum capacities (plate width)	2000 mm / 2500 mm	2000 mm / 2500 mm	2000 mm / 2500 mm
Maximum capacities (plate length)	3000 mm	6000 mm	12000 mm
Minimum dimension of plate to be loaded	1000 x 300 mm	1000 x 300 mm	1000 x 300 mm
Minimum dimension of finished parts	80 x 80 mm	80 x 80 mm	80 x 80 mm
Maximum thickness (drilling/punching/plasma)	40/25/30 mm	40/25/30 mm	40/25/30 mm
Minimum thickness	5 mm	5 mm	5 mm
Number of reference pushing chains / carriages / grippers	2 / 1 / 4	3 / 2 / 6 (4+2)	5 / 3 / 12(3x4)
Maximum weight of plate	2000 kg	4000 kg	6000 kg
Punching: Power / Number of tools	110 t / 6 tools	110 t / 6 tools	110 t / 6 tools
Maximum diameters	50 mm	50 mm	50 mm
Maximum diameters in maximum thickness (400 N / mm ²)	32 mm in 25 mm	32 mm in 25 mm	32 mm in 25 mm
Drilling : Power / Number of tools on changing system	11 kW / 6 tools	11 kW / 6 tools	11 kW / 6 tools
Rotating speed	200 - 2500 RPM	200 - 2500 RPM	200 - 2500 RPM
Maximum diameter	40 mm	40 mm	40 mm
Internal and external lubrication	included	included	included
Marking unit	CNC disk	CNC disk	CNC disk
Plasma cutting: HT 2000 Plasma source	200 A, 30 kW	200 A, 30 kW	200 A, 30 kW
Torch and torch-holder + Fume extraction and filtration	included	included	included
Equipments			
Nesting software / MAG B Driver / Telemaintenance	●	●	●
DSTV Import on nesting software	●	●	●
Threading, pop-marking, tapping cycles on drilling unit	●	●	●
External and through the drill lubrication on drilling unit	●	●	●
Automatic measure of tool length on drilling unit	●	●	●
Chips brushing system	●	●	●
Air conditioning system in electrical cabinet	●	●	●
Automatic lubrication system	●	●	●
Plate lifting system on machine infeed and exit sides	●	●	●
Visual protective device of cutting torch	●	●	●
Multidirectional anti collision system on plasma torch	●	●	●
Plate scribing on drilling unit	●	●	●
Machine without drilling or without marking or without punching	○	○	○
Separate oxy cutting frame	○	○	○
Separate spindle for drilling plates up to 100 mm thickness	○	○	○
Chips conveyor on drilling unit	○	○	○
Conveyor evacuating finished parts	○	○	○
Plate preloading area	○	○	○
HPR 260 / HT 4400 Plasma source	○	○	○
Other plate sizes	○	○	○
MAG machine in tandem with cutting table	○	○	○

● Standard

○ Optional

● Optional after technical validation

VERNET BEHRINGER reserves the right to modify technical data without previous notice.
Characteristics are given for steel E24 / ST37

VERNET BEHRINGER range: complete range of equipments required for working plates and section profiles

HD High speed multispindle drilling lines for working profiles	RD Cutting lines for notching all types of profiles
HBP Bandsawing machines for profiles	PG / FG Punching-drilling machines for plates
MAP Punching-shearing lines for all types of profiles	MAG B Combined marking-punching-drilling-cutting lines for plates
VP Punching-drilling-shearing lines for angle sections	PS Punching-shearing machines for flat bars and angle sections
VF Punching-notching-shearing lines for angle sections and flat bars	UP / UPA Portable hydraulic punching units for all types of profiles



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