



**MULTISPINDLE HIGH SPEED DRILLING MACHINE FOR
MACHINING ALL TYPES OF PROFILES**

HD



HD

Multispindle high speed drilling machine
for machining all types of profiles:

- structural beams (H, I, U, Angle sections, Flat bars),
- simple structural sections (plate girders) or
with variable angle,
- rectangular hollow sections

Combined with a BEHRINGER band saw : HBP reference, the
machines constitute a key element of any efficient steel construction workshop:

- ✓ **Robustness,**
- ✓ **Reliability and easy maintenance,**
- ✓ **Simplicity and flexibility of use,**
- ✓ **Maximum productivity.**

Important design factor:

The specific original design (drilling spindles in frame axis and rigid guides eliminating all deflection during machining) ensures a perfect stability and allows to combine:

- ✓ **Very high speed of execution,**
- ✓ **Flexibility and accuracy of machining,**
- ✓ **Possibility to use all types of drills.**



Clamping vise for scribing option



Standard clamping vise



Hydraulic gripper : detail view



Scribing tool



CNC disk marking unit

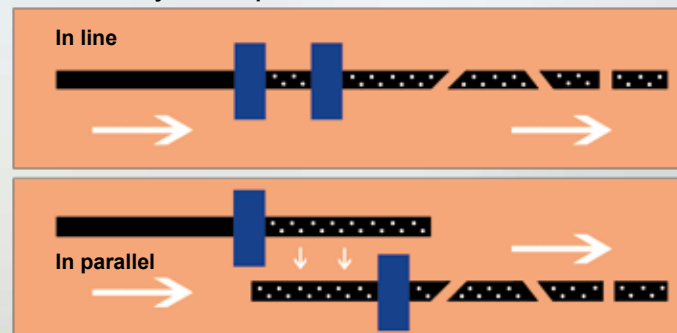


Tool changer

Main technical characteristics:

- ✓ Rigid and compact CNC propelling carriage with hydraulic clamping gripper
- ✓ Bar length measurement with optical cells
- ✓ Fast tool changer: 5 diameters, on each spindle or ergonomic manual quick-change chucks
- ✓ Positioning speed of drilling units: 20 m/mn
- ✓ Fast machining: spindle rotating speed up to 3500 RPM
- ✓ Possibilities of technical machining (scribing): to validate previously by our engineering departments
- ✓ Special cycles: Flowdrilling, flowtapping, boring for diameter up to 200 mm
- ✓ Industrial PC with software PLC
- ✓ ProNC 2® programming software under Windows:
 - Very friendly and easy-to-use
 - Numerous functions
 - Graphic and table mode
 - Nesting with optimization
 - Telemaintenance
- ✓ Hanging control panel with TFT 15" screen and tight keyboard with integrated mouse
- ✓ Air conditioning in control cabinet
- ✓ Standard network connection with DSTV file import

Various layouts are possible:



Characteristics	HD 300		HD 600		HD 900		HD 1200	
Minimum capacity (mm inches)	80 x 10	3" x 3/8"	80 x 10	3" x 3/8"	80 x 10	3" x 3/8"	80 x 10	3" x 3/8"
Maximum capacity (mm inches)	300 x 300	12" x 12"	600 x 400	24" x 16"	900 x 400	36" x 16"	1200 x 600	47 1/2" x 24"
Number of spindles	3		3		3		3	
Available spindle power	9.2 / 7.5 kW		12 / 9.2 / 7.5 kW		12 / 9.2 / 7.5 kW		12 / 9.2 / 7.5 kW	
Spindle type	SA 40		SA 40		SA 40		SA 40	
Possible drilling diameter, depending on tooling (mm)	minimum 8 / maximum 30		minimum 8 / maximum 40		minimum 8 / maximum 40		minimum 8 / maximum 40	
Spindle rotating speed, depending on tooling and motor powers (RPM)	minimum 200 / maximum 3500		minimum 200 / maximum 3500		minimum 200 / maximum 3500		minimum 200 / maximum 3500	
Maximum carriage speed	60 m/min		60 m/min		60 m/min		60 m/min	
Standard working height (mm inches)	830	32 2/3"	830	32 2/3"	830	32 2/3"	830	32 2/3"
Equipments	HD 300		HD 600		HD 900		HD 1200	
Hydraulic vertical adjustment of gripper	●		●		●		●	
Pop-marking, tapping, threading cycles	●		●		●		●	
Use of step drill	●		●		●		●	
External and through the drills lubrication	●		●		●		●	
Air conditioning system in electrical cabinet	●		●		●		●	
HD driver with new Pro NC 2 [®] software	●		●		●		●	
Telemaintenance / DSTV Import	●		●		●		●	
Bar length measuring cycle	●		●		●		●	
Automatic measure of tool length	●		●		●		●	
Anti collision system on carriage	●		●		●		●	
Automatic gripper raising system during carriage return	●		●		●		●	
Stripping and chips breaking cycle	●		●		●		●	
Profile scribing through the spindles	●		●		●		●	
Underneath profile scribing	●		●		●		●	
Automatic tool changer : 5 Ø per spindle (3 on HD 300)	○		○		○		○	
Sensing device for correct gripping	○		○		○		○	
Automatic Pre positioning of vertical spindle and clamp	○		○		○		○	
CNC length measuring back stop system	○		○		○		○	
Motorized gripper adjustment on 2 axes	○		○		○		○	
Video on carriage	○		○		○		○	
Horizontal and vertical profile sensing device	○		○		○		○	
Underneath pop-marking	○		○		○		○	
Flowdrilling, flowtapping, boring	○		○		○		○	
Chips conveyor	○		○		○		○	
Through the drills microlubrication system	○		○		○		○	
Hydraulic unloading system	○		○		/		/	
Lateral loading or transfer chain systems	○		○		○		○	
Lifts for loading or transfer	○		○		○		○	
CNC disk marking unit	○		○		○		○	
HBP (Behringer) bandsawing machine in line or parallel	○		○		○		○	

● standard ○ optional ● Optional after technical validation / Not applicable

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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