Built-in unit 322

Technical data sheet

- Marking area sizes: 40 x 50 mm, 100 x 50 mm, 100 x 100 mm, 150 x 100 mm, 150 x 150 mm, 200 x 100 mm (X/Y) – other sizes possible
- Built-in unit for the marking process: Scribe, stylus, dot-peening and Vibropeening
- DataMatrix coding (EC200)
- Dimensionally stable base body made of cast aluminium
- Backlash-free ball screws and guide carriages with revolving guide rails in both axes
- Compact, maintenance-friendly design
- Drive via powerful stepper motors
- Large variety of marking heads and marking tools (e.g. double marking head: the marking process and the marking pressure can be set individually for each marking head)

BMC controller (BORRIES marking-controller)

- Universal 2-/3-axis marking controller in compact housing
- With integrated full-graphic 10" touch display
- Dimensions: 355 x 225 x 236 mm
- Included in the scope of delivery

Application area

The 322 model is a very sturdy device designed for used in 3-shift operation. All components of this coordinate unit have been developed for continuous use and are constantly checked for consistent quality. Together with the marking head and a controller, this marking unit is used as a built-in system in our special equipment or by the system manufacturer for direct marking of the workpieces, etc. integrated in transfer lines, processing machines, measuring and test stations. The marking head is mounted directly under the coordinate unit.

Options

- Cover of the marking mechanism on the marking head side with bellows or dirt cover as dust protection or sheet metal cover (sheet metal cover is only possible with 100 x 50 mm and 100 x 100 mm)
- Different marking areas
- Electrical adjustment unit (100 mm, 150 mm, 200 mm stroke – optionally with brake)
- Pneumatic adjustment unit (50 and 100 mm stroke)
- Touch-on for dot-peening/DataMatrix marking heads (only in combination with electrical adjustment unit)
- Reliable standstill monitoring (from title block 100 x 50 mm)
- DMC camera
- Relocation of the reference point

Fig. The 322 built-in unit with bellows (here with double marking head)

Technical data 1/2

Property	Dimensions, unit, explanation
Dimensions of built-in unit With a marking area size (X/Y) of 100 x 100 mm (W x D x H)	325.5 x 255 x 173 mm (without marking head)
Dimensions of built-in unit With a marking area size (X/Y) of 100 x 50 mm (W x D x H)	325.5 x 205 x 173 mm (without marking head)
Dimensions of built-in unit With a marking area size (X/Y) of 40 x 50 mm (W x D x H)	266.5 x 205 x 173 mm (without marking head)
Dimensions of built-in unit With a marking area size (X/Y) of 150 x 100 mm (W x D x H)	393.5 x 255 x 163 mm (without marking head)
Dimensions of built-in unit With a marking area size (X/Y) of 150 x 150 mm (W x D x H)	393.5 x 330 x 163 mm (without marking head)
Dimensions of built-in unit With a marking area size (X/Y) of 200 x 100 mm (W x D x H)	473 x 255 x 163 mm (without marking head)
Optional: Various other title block sizes (X/Y)	

Technical data 2/2

Property	Dimensions, unit, explanation
Weight of the marking unit (marking area size 100 x 100 mm)	Approx. 13 kg
Marking speed (depending on character height and font format, marking process and motorisation)	Up to 10 characters/second (see marking times table)
Rapid traverse speed	Up to 0.5 m/second
Character height	from 0.5 mm (in 0.1 mm steps)
Documentation	German or English, other languages optional
Marking tip penetration depth (depending on the material to be marked, marking head and marking process)	Approx. 0.01–0.5 mm (see marking head data sheet)
Noise level during scribing	Max. 75 dB(A) (depending on the component)
PN supply system (regulator and monitor)	For on-site assembly On separate aluminium plate
Drive	Highly dynamic stepper motors

Media supply	
Power supply via BMC with connection cable	Wide-range power supply integrated in the controller
Compressed air connection (supply pressure) With technically conditioned compressed air	Min. 5 bar (min. 75 psi) Dried, oil-free, filtered with 50 µm
Working pressure (marking pressure)	Min. 2 bar up to max. 4 bar (30 psi to max. 60 psi)

Subject to technical changes.

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