







-  Conventional marking technology
-  Scribe, stylus and dot-peening marking technology
-  Type-wheel marking technology
-  Laser-marking technology
-  Traceability
-  Special-purpose machines

Workshop unit 322

Technical data sheet

- Marking area sizes 100 x 100 mm, 150 x 100 mm, 150 x 150 mm (X/Y)
- Deliverable marking process: Scribe, stylus, dot-peening and Vibropeening
- DataMatrix coding (ECC200)
- Universal and flexible marking machine for direct marking of workpieces
- Designed for continuous use
- Sturdy, durable and low-maintenance machine construction
- X/Y-axes of the coordinate unit with precisely ground linear guides
- Drive with powerful stepper motors and robust ball screws
- Bellows or dirt cover as protection against access and dust
- Manual height adjustment
- 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)



Fig. The 322 workshop unit









BMC controller (BORRIES marking-controller)

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



Application area

The 322 workshop unit is used for type plate marking and is used for particularly deep marking in single part or prototype production as well as for large series.

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Options







- Electrical height adjustment (only in combination with protective device)
- Different marking areas
- Customer-specific logos and special characters
- Special equipment with semi- or fully automatic parts handling
- Housing lettering (various diameters)
- Manual plate slider
- Barcode reader
- Control panel, 4-fold (emergency stop, start marking, home position, acknowledge fault)
- Protective housing
- Reliable standstill monitoring
- Plate sliding module
- Relocation of the reference point



Fig. The 322 workshop unit with optional manual plate slider



Fig. The 322 workshop unit with optional housing lettering unit

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Technical data

Property	Dimensions, unit, explanation
Dimensions	350 x 460 x 705 mm
Marking area size (X/Y)	100 x 100 mm, 150 x 100 mm, 150 x 150 mm
Adjustment range of the workshop unit (Z-direction)	max. 200 mm (manual)
Weight of the workshop unit	Approx. 33 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)
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.