



**HAGEN & GOEBEL**

Werkzeugmaschinen GmbH

Machine sample HG-820  
**Special machine to realise fit holes and automatic  
backside chamfering of opposite holes**



**Description of Hagen & Goebel machine design**

- Machine body in heavy welding design with chip pan in front area
- 180 degrees rotating system with workpiece specific fixture including pneumatic clamping unit
- Loading and unloading door for workpiece change, protected by magnetic switch
- 2 hydropneumatic boring units type BF3-H75/80-EA-EE, each with installed hydropneumatic cross traverse unit
- 2\* Cross traverse head with fine adjustable tool holder
- Minimal coolant system (spray) for 2 spindles
- Elektronik control on base of Siemens S7 with touch-panel
- Machine housing regarding UVV and CE regulation's to protect against chips and dust

Look for next page

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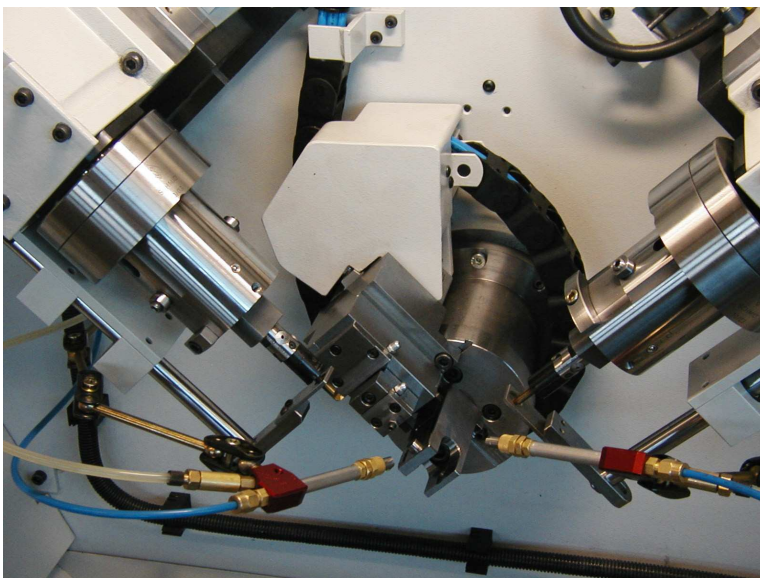
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Page 2

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## Special machine to realise fit holes and automatic backside chamfering of opposite holes



### Function and work cycle

By small loading door in front machine area the workpiece will be pushed on the special fixture.  
After closing the loading door the automatic machining cycle will be started automatically.  
The workpiece clamping will be realised by a pneumatic – mechanic system and will fix the workpiece in the specific fixture.  
Now both spindles will machine both fits in the already machined workpiece holes.  
At the end of axial stroke of the boring units, the tool will be moved by the cross traverse system to bigger diameter and chamfers will be made automatically.  
After that procedure both units go back to starting position and the workpiece will be rotated 180 degrees and the new fit and chamfer cycle can be started again.  
Now the boring units and rotating unit will go back to starting position and the workpiece becomes unclamped.  
Finally the loading door can be opened and the workpiece exchange is possible.  
A new workpiece can be machined.

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