#T-Time

5-AXIS MILL-TURN MACHINING CENTERS

This is who we are

GROB-WERKE

Technology at its best

STEP INTO A GREEN FUTURE WITH US

At GROB, we strive for continuous progress and improvement. Not only do we strive to develop outstanding solutions and products for our customers, but we also seek to make a contribution to our environment and future generations. This is firmly anchored in our corporate philosophy and lived every day.

We therefore utilize photovoltaics and geothermal energy in our locations and support a wide variety of social projects. But we also place great emphasis on SUSTAINABILITY in our internal departments. Our products are based on the highest energy efficiency and regenerative drive systems. We integrate our supplier network in reducing the carbon footprint.

Excellence in sustainable technology

OUR PRODUCT RANGE

#MachiningTechnology #UniversalMachiningCenters #AssemblyPlants #Electromobility #Automation #AdditiveManufacturing #Digitalization #NewAndQualityCheckedUsedMachines #Service

Concentrated competence worldwide

INTELLIGENT TECHNOLOGY IS HUMAN

For generations, we at GROB have lived and experienced this principle by making customer requirements the focus of our work. The result is sophisticated technology creating more efficient production processes worldwide and delivering highest quality.

RESEARCH & DEVELOPMENT

With a high degree of creativity and technical intuition, as well as the best engineering expertise, our developers have worked hard to earn the reputation of being a technology leader.

ASSEMBLY

From pre-assembly to machine assembly to process commissioning – our employees demonstrate their expertise with optimally coordinated workflows.

ENGINEERING

With method development and structured problem solving, our employees in Engineering develop innovative concepts representing milestones for precision, dynamics, and reliability.

COMMISSIONING

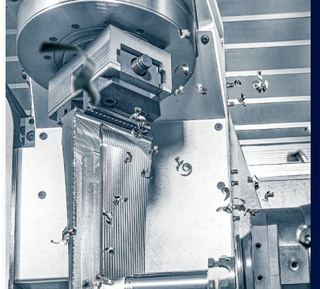
With simulation techniques and virtual commissioning, we achieve the highest adherence to delivery dates and product quality.

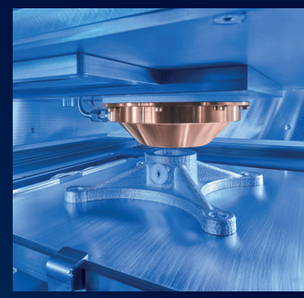
PRODUCTION

The high degree of vertical integration along the entire value creation chain, numerous machining technologies and our employees' distinctive specialist knowledge create the best conditions for state-of-the-art production.

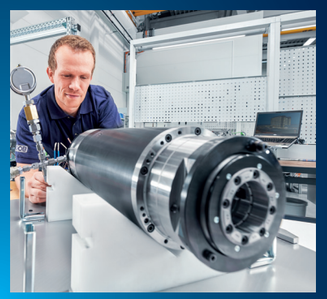
TECHNICAL APPLICATION CENTERS

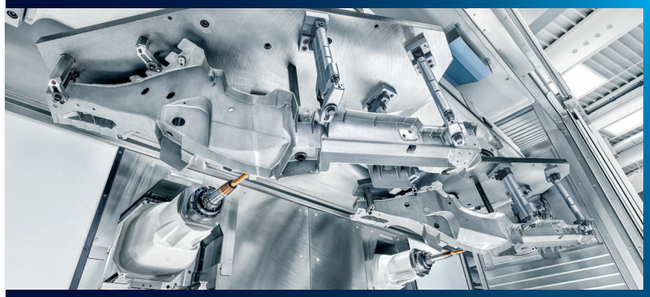
Our production plants in Germany, Brazil, the USA, China, Italy and India have technical application centers for the machining and electromobility sectors, where our customers can experience GROB technologies up close.

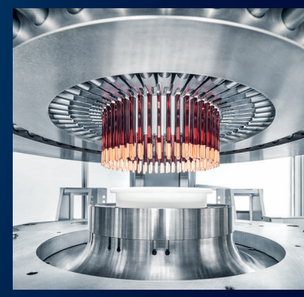


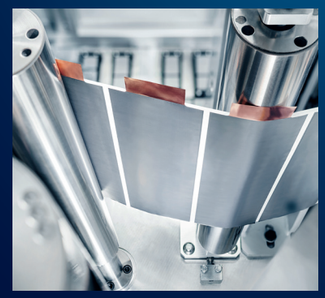













5-axis mill-turn machining centers by GROB

THE RIGHT CONCEPT FOR YOUR INDUSTRY

Complete machining with one setup

UNIVERSAL MACHINING CENTERS FOR PERFECT MILL-TURN MACHINING

Thanks to extensive configuration possibilities, the universal mill-turn machining centers G350T, G550T and G750T can be ideally matched to your requirements. GROB's mill-turn machining centers achieve complete machining of the part by milling and turning in a single clamping, thereby saving time, space and investment costs in your production facility.

- High productivity and process reliability
- Optimized availability and durability
- Excellent maintainability
- Extensive configuration possibilities
- Designed for automation solutions
- Also available as a pure milling machine in the sizes G350, G550, and G750

OUR PORTFOLIO

#G350T #G550T #G750T

Upside down is easy for us

OUR 5-AXIS MILL-TURN MACHINING CENTERS

No matter whether aerospace, mechanical engineering, energy technology or die and mold industries – our 5-axis universal mill-turn machining centers cover a convincingly broad range of possible applications allowing for efficient milling of a wide variety of materials with just one setup. Moreover, the universal machining centers are designed for automation solutions and, depending on the customer's requirement, are also available as pure milling machines in sizes G350, G550 and G750.

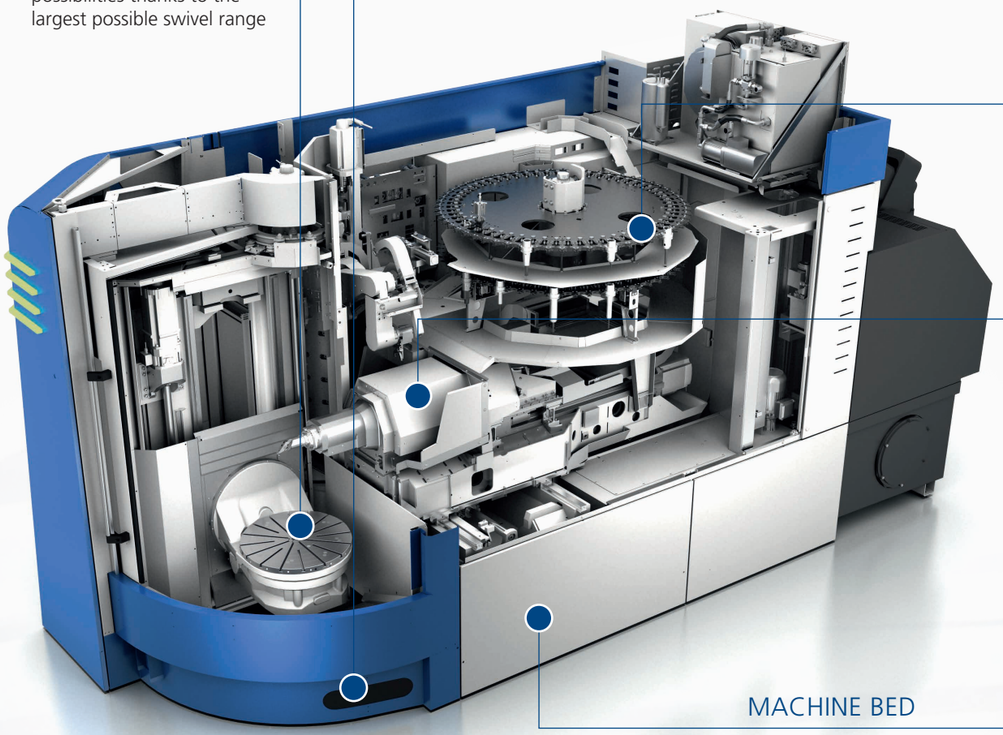
The drive concept is based on two symmetrically arranged ball screw drives and weight compensation for the G550T and G750T in the Y-axis. Torque motors in the A-axis and B-axis ensure dynamic and wear-free parts machining.

MILL-TURN TABLE

- Almost limitless machining possibilities thanks to the largest possible swivel range

CHIP DISPOSAL

- Uninterrupted part machining with chip disposal by a slat band conveyor



DISK-TYPE TOOL MAGAZINE

- Fast chip-to-chip times thanks to the integrated disk-type tool magazine with double gripper technology

HORIZONTAL MOTORIZED SPINDLE

- For meeting the toughest cutting requirements

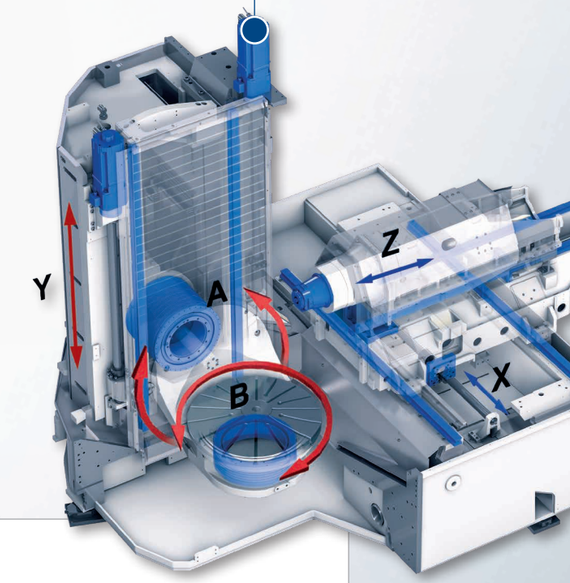
MACHINE BED

- Intrinsically stiff welded design for optimum machine rigidity

Illustration of G350T may contain options

OPTIONAL COOLING CONCEPT

- Ensures exact temperature control of the part, tool, and machine, allowing precise part machining



UNIQUE AXIS CONCEPT

- Optimally designed operating point (TCP) for extreme stability
- Longest Z-travel path of this machine class
- Extremely large swivel range of 230° in the A-axis
- Largest possible part in the work area can be machined with maximum tool length

Optimal chip fall

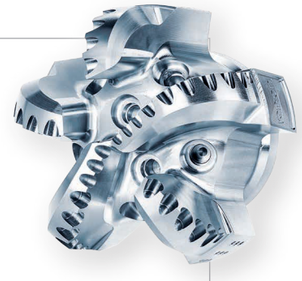
OVERHEAD MACHINING & ADDITIONAL ANGULAR POSITIONS

Due to the slim spindle design and the extremely large swivel range of the A-axis, the table can be positioned in various angular positions. This permits optimum accessibility to the part for the tool.

Thanks to the unique axis arrangement with horizontal spindle bearing, chips fall directly into the chip shaft and the part remains largely free of interfering chip accumulations.

UNIQUE AXIS CONCEPT

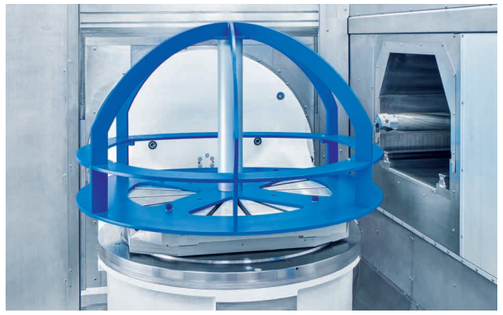
- Best tool life due to perfect chip fall
- Simple cleaning of components ahead of the part/pallet change
- No cutting fluid residue in the part
- No heat input into the machine from chips left on part, clamping equipment, and machining table



Tunnel concept

PART MACHINING WITH MAXIMUM TOOL LENGTH

Thanks to the special axis concept, the full tool length can be employed in any axis position, even with maximum part size. The "tunnel" concept allows the entire work area to be utilized, since the motorized spindle and tool can fully retract from the work area towards the rear.



MAX. TOOL LENGTH ▸ [mm]			
	G350T	G550T	G750T
Single disk-type tool magazine HSK-A/T63	365	465	—
Single disk-type tool magazine HSK-A/T100	—	500	—
Double disk-type tool magazine HSK-A/T63 (disk 1/disk 2/extra-long)	365/180/550*	465/280/700*	400/400 (650)/650*
Double disk-type tool magazine HSK-A/T100 (disk 1/disk 2/extra-long)	—	500/260/750*	450/650*
Three disk-type tool magazine HSK-A/T63 (disk 1/disk 2/disk 3/extra-long)	—	—	400/270/400/650*

*With restrictions in the work area

Subject to technical changes without prior notice

Machine components

GROB MOTORIZED SPINDLES

GROB SPINDLE DIAGNOSTICS (GSD) – OPTION

GROB Spindle Diagnostics is a system that automatically monitors both the condition of the motorized spindle (condition monitoring) and the vibrations that occur during machining.

- System for automatic condition monitoring of the motorized spindle
- Vibrations that occur are monitored during machining and switched off if they exceed limits
- Service life of the motorized spindle extended through identification of critical operating states
- Perfect process optimization is possible
- Machine downtimes avoided through scheduled maintenance

Spindle types – Availability at a glance!

SPINDLE TYPE ◂▸ MACHINE			
Tool interface for hollow taper shanks acc. to ISO 12164-1	**HSK-A/T63**	**HSK-A/T100**	**HSK-A/T100**
Spindle type	27	16	28
Speed n_{max} [rpm]	16,000	10,000	14,500
Max. spindle torque at 100 %/40 % duty cycle [Nm]	159/ 206	258/ 340	225/ 261
Spindle bearing Ø at front bearing [mm]	80	100	100
Max. drive power at 100 %/40 % duty cycle [kW]	25/ 32	50/ 66	50/ 58
Spindle shaft arrest [Nm] (1)	300	1,200	1,200
Spindle bearing lubrication ▸ Lifetime lubrication	—	•	—
▸ Oil/air lubrication	•	—	•
G350T	•	—	—
G550T	•	○	○
G750T	•	○	○

(1) For turning operation

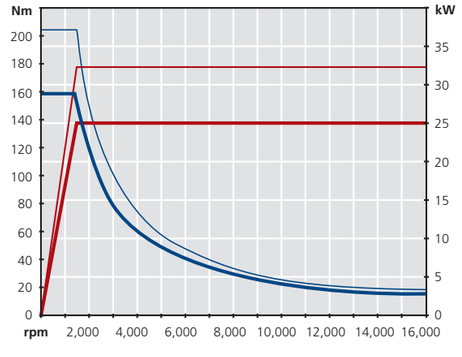
• Standard ○ Option — Not available

Subject to technical changes without prior notice

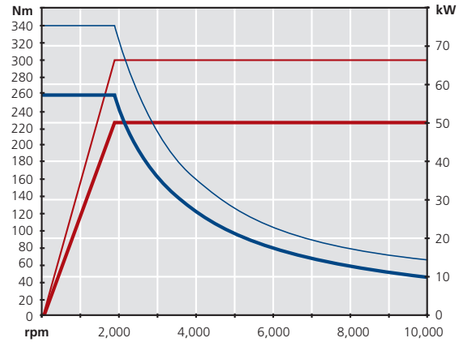
Torque – rotational speed – output

MOTORIZED SPINDLE VERSIONS

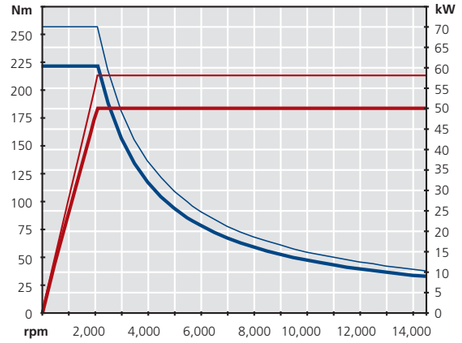
TYPE 27:
HSK-A/T63 ▸ Motorized spindle 206 Nm, 16,000 rpm



TYPE 16:
HSK-A/T100 ▸ Motorized spindle 340 Nm, 10,000 rpm



TYPE 28:
HSK-A/T100 ▸ Motorized spindle 261 Nm, 14,500 rpm



Spindle clamping

CLAMPING DISK

- During turning operations with HSK-A/T63, the spindle shaft is clamped by means of a clamping disk. This disk is permanently connected to the spindle shaft and forms the connection to the spindle housing by means of a hydraulic piston
- This allows the tool to be positioned anywhere

HIRTH GEARING

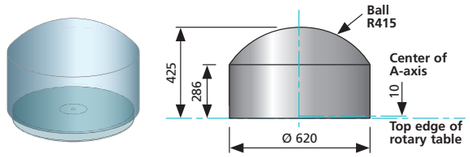
- During turning operations with the HSK-A/T100, the spindle shaft of the motorized spindle is automatically positively locked by an axially acting, frontal gearing (Hirth gearing)
- The positioning of the turning tools is possible in steps of 2°

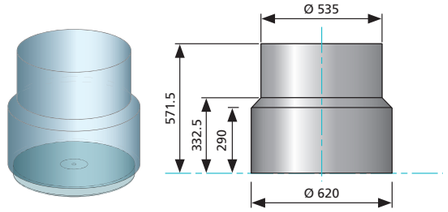
Mill-turn table

TABLE VERSIONS G350T

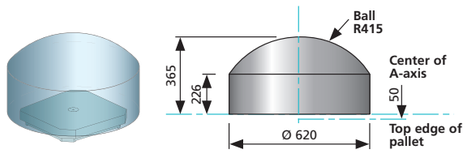
TECHNICAL DATA – ROTARY AXES	
A-axis swiveling angle [°]	-185/+45
Max. A-axis rotational speed [rpm]	35
A-/B-axis drive type	Torque motor
B-axis angle of rotation [°]	n x 360
Max. B-axis rotational speed [rpm]	1,200
Max. B-axis torque at 100 %/40 % duty cycle [Nm]	1,250/1,420
Max. holding torque for B-axis with additional clamping [Nm]	1,500

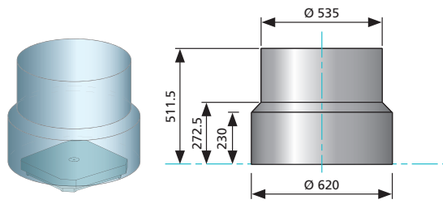
MILL-TURN TABLE WITH T-SLOTS ARRANGED IN A STAR SHAPE (STANDARD)		**A-/B-axis max. [mm]**	**B-axis max. [mm] (for A-axis 0°)**
Basic machine			
Aligning slots (quantity/width/quality)	2 x 14 H7		
Clamping slot (quantity/width/quality)	14 x 14 H12		
Table diameter [mm]	570		
Interference diameter [mm]	620		
Max. permissible loading weight incl. clamping fixture [kg]	350		





MILL-TURN TABLE WITH PALLET (OPTION)		**A-/B-axis max. [mm]**	**B-axis max. [mm] (for A-axis 0°)**
Basic machine with pallet			
Pallet size [mm]	400 x 400		
Max. pallet load [kg]	270		





A-/B-axis arrangement

MAXIMUM PART SIZE

Mill-turn table

TABLE VERSIONS G550T

TECHNICAL DATA – ROTARY AXES	
A-axis swiveling angle [°]	-185/+45
Max. A-axis rotational speed [rpm]	25
A-/B-axis drive type	Torque motor
B-axis angle of rotation [°]	n x 360
Max. B-axis rotational speed [rpm]	800
Max. B-axis torque at 100 %/40 % duty cycle [Nm]	1,200/1,380
Max. holding torque for B-axis with additional clamping [Nm]	2,500

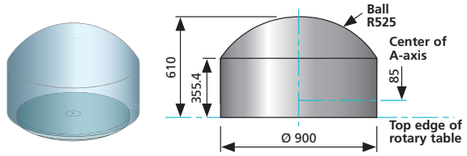
MILL-TURN TABLE WITH T-SLOTS ARRANGED IN A STAR SHAPE (STANDARD)	
Basic machine	
Aligning slots (quantity/width/quality)	4 x 14 H7
Clamping slot (quantity/width/quality)	12 x 14 H12
Table diameter [mm]	770
Interference diameter [mm]	900
Max. permissible loading weight incl. clamping fixture [kg]	750

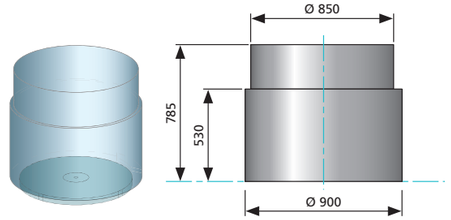
MILL-TURN TABLE WITH PALLET (OPTION)	
Basic machine with pallet	
Pallet size [mm]	630 x 630
Max. pallet load [kg]	600

A-/B-axis arrangement

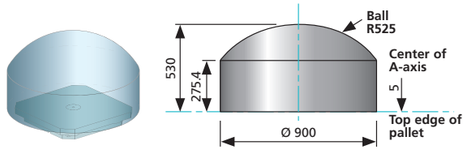
MAXIMUM PART SIZE

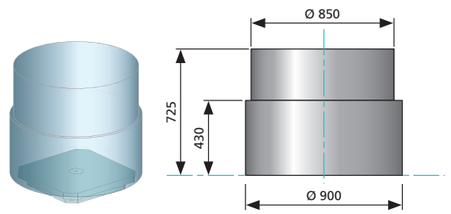
A-/B-axis max. [mm]	B-axis max. [mm] (for A-axis 0°)





A-/B-axis max. [mm]	B-axis max. [mm] (for A-axis 0°)





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Mill-turn table

TABLE VERSIONS G750T

TECHNICAL DATA – ROTARY AXES	
A-axis swiveling angle [°]	-185/+45
Max. A-axis rotational speed [rpm]	20
A-/B-axis drive type	Torque motor
B-axis angle of rotation [°]	n x 360
Max. B-axis rotational speed [rpm]	500
Max. B-axis torque at 100 %/40 % duty cycle [Nm]	3,110/3,740
Max. holding torque for B-axis with additional clamping [Nm]	6,000

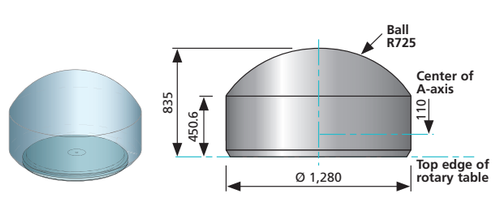
MILL-TURN TABLE WITH T-SLOTS ARRANGED IN A STAR SHAPE (STANDARD)	
Basic machine	
Aligning slots (quantity/width/quality)	4 x 18 H7
Clamping slot (quantity/width/quality)	12 x 18 H12
Table diameter [mm]	950
Interference diameter [mm]*	1,280
Max. permissible loading weight incl. clamping fixture [kg]	1,500

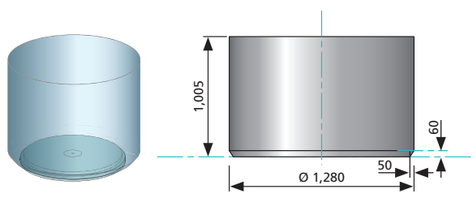
MILL-TURN TABLE WITH PALLET (OPTION)	
Basic machine with pallet	
Pallet size [mm]	800 x 800
Max. pallet load [kg]	1,000

A-/B-axis arrangement

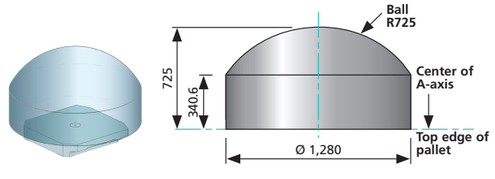
MAXIMUM PART SIZE

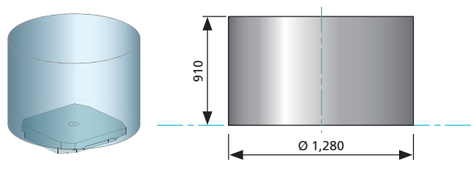
A-/B-axis max. [mm]	**B-axis max. [mm] (for A-axis 0°)**





A-/B-axis max. [mm]	**B-axis max. [mm] (for A-axis 0°)**





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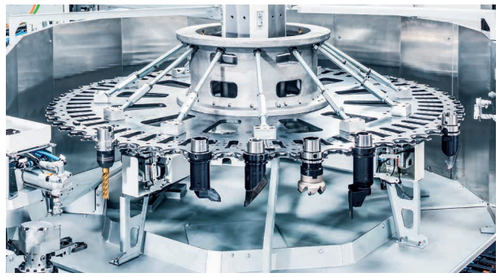
Versatile combinations

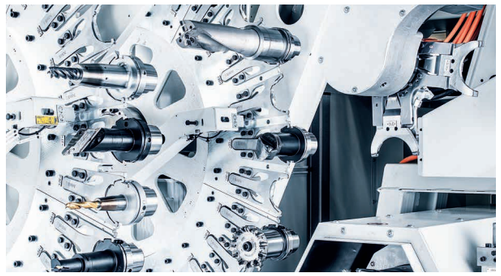
TOOL MAGAZINES BY GROB

GROB tool magazine technology is set apart by fast chip-to-chip times, a small space requirement, and optimized accessibility. You will also profit from fast tool change thanks to a highly dynamic tool changer arm with a swiveling double gripper, loading and unloading in parallel to machining operation, and permanent access to the tool magazine disk.



SINGLE DISK-TYPE TOOL MAGAZINE

- Horizontal magazine disk arrangement on G350T and G550T



DOUBLE DISK-TYPE TOOL MAGAZINE

- Horizontally stacked magazine disks on G350T and G550T
- Vertically adjacent magazine disks with G750T

ADDITIONAL TOOL MAGAZINE TM (OPTION)

- Increases the basic machine's tool capacity with block-wise setup up to:
  - six HSK-A/T63 tools for TM200, TM308 and TM373
  - five HSK-A/T100 tools for TM180 and TM250
- The additional tool magazine can be equipped with tools during the machining operation
- Tool provision in parallel with machining
- Tool and magazine management through the control system of the machine

Number of tool pockets

G350T / G550T / G750T

G350T ▸ BASIC MACHINE ◂▸ ADDITIONAL TOOL MAGAZINE TM

Motorized spindle	Tool interface	Number of tool pockets[1]	Total number of tools of the basic machine and the TM		
Single disk-type tool magazine			**TM200**	**TM308**	**TM373**
For all spindle types	HSK-A/T63	60	251	359	424
Double disk-type tool magazine			**TM200**	**TM308**	**TM373**
For all spindle types	HSK-A/T63	117	311	419	484
	HSK-A/T63	105[2]	293	401	466

G550T ▸ BASIC MACHINE ◂▸ ADDITIONAL TOOL MAGAZINE TM

Single disk-type tool magazine			TM200	TM308	TM373	TM180	TM250
For all spindle types	HSK-A/T63	70	261	369	434	—	—
	HSK-A/T100	40	—	—	—	211	281
Double disk-type tool magazine			**TM200**	**TM308**	**TM373**	**TM180**	**TM250**
For all spindle types	HSK-A/T63	137	331	439	504	—	—
	HSK-A/T63	123[2]	317	425	490	—	—
	HSK-A/T100	77	—	—	—	251	321
	HSK-A/T100	69[2]	—	—	—	243	313

G750T ▸ BASIC MACHINE ◂▸ ADDITIONAL TOOL MAGAZINE TM

Double disk-type tool magazine			TM200	TM308	TM373	TM180	TM250
For all spindle types	HSK-A/T63	117	311	419	484	—	—
	HSK-A/T100	65	—	—	—	241	312
Three disk-type tool magazine			**TM200**	**TM308**	**TM373**	**TM180**	**TM250**
For all spindle types	HSK-A/T63	177	371	479	544	—	—
	HSK-A/T63	167	361	469	534	—	—

[1] Depends on machine configuration
[2] Ability to store oversize tools across both magazine disks with double assignment

Subject to technical changes without prior notice

GROB⁴Pilot

YOUR POWERFUL MACHINE CONTROL PANEL

The innovative GROB⁴Pilot machine control panel offers the machine operator a convenient working environment on the machine through a multi-functional user interface. The entire production process – from the CAD model to the NC simulation – is now digitally mapped on the GROB⁴Pilot control system itself.

- Enhanced user comfort thanks to simplified and intuitive machine operation
- Access to the GROB-NET⁴Industry platform
- Expanded applications for increased efficiency
- Paperless production is possible

FLEXIBLE DISPLAY LAYOUT

- Free division into up to three apps

24" MULTI-TOUCH DISPLAY

- For intuitive operation

2x POWERRIDE

- Convenient operation thanks to multifunctional assignment

OPTIMIZED KEYBOARD

- For easy input

FULLY-AUTOMATED HOMING AT THE PUSH OF A BUTTON

- From any position – our universal machining centers as well as automated systems automatically move to the home position in several steps

3D-SPACEMOUSE® (OPTION)

- For controlling CAD applications

TRACKBALL

- For alternative screen use in addition to the multi-touch function

Example illustration

AVAILABLE CNC CONTROL SYSTEM PROVIDERS FOR GROB⁴PILOT

	SIEMENS SINUMERIK ONE	HEIDENHAIN TNC7
G350T	•	○
G550T	•	○
G750T	•	○

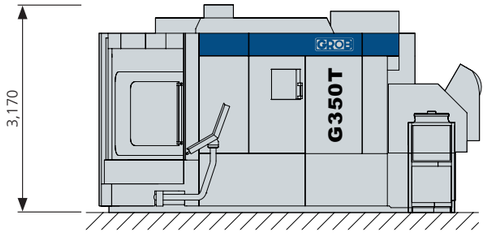
The implementation of GROB⁴Pilot can differ between SIEMENS and HEIDENHAIN

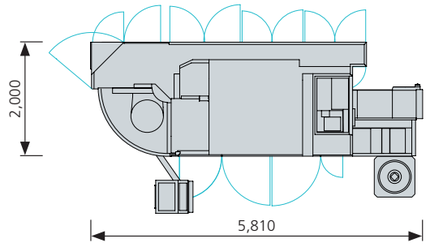
• Standard ○ Option

Footprint
G350T

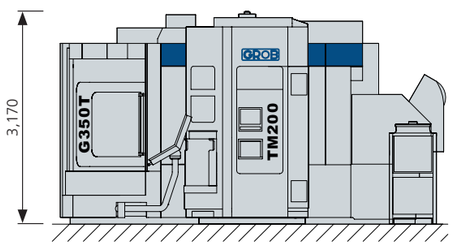
Side view / top view
max. [mm]

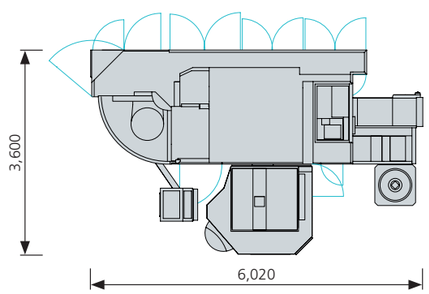
Basic machine





Basic machine with additional tool magazine





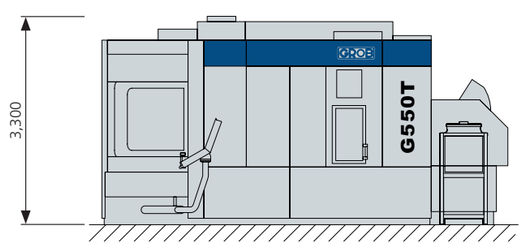
Dimension values [mm], not taking into account preventive maintenance and operating areas or emulsion and chip disposal

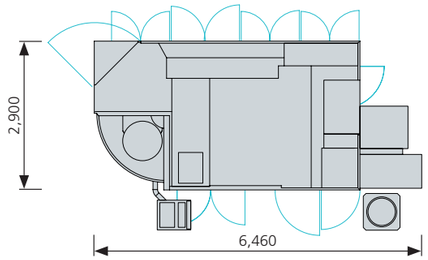
Illustrations may contain options
Subject to technical changes without prior notice

Footprint
G550T

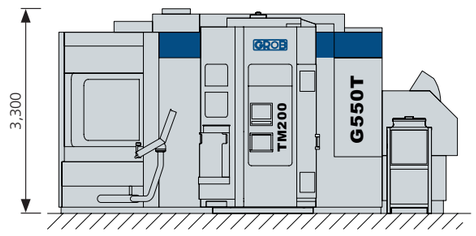
Side view / top view
max. [mm]

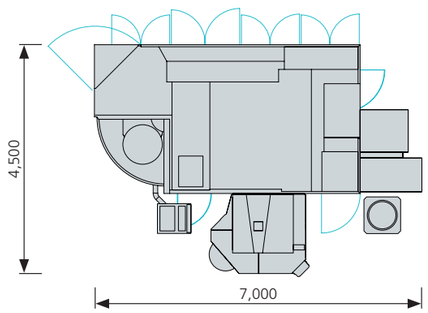
Basic machine





Basic machine with additional tool magazine





Dimension values [mm], not taking into account preventive maintenance and operating areas or emulsion and chip disposal

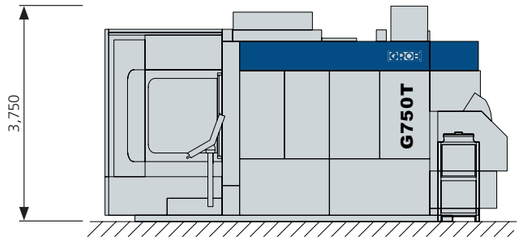
Illustrations may contain options
Subject to technical changes without prior notice

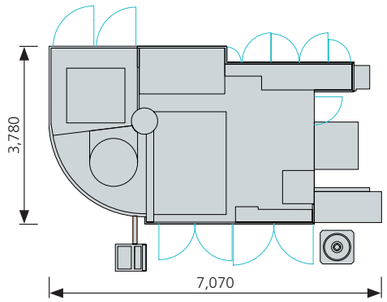
Footprint

G750T

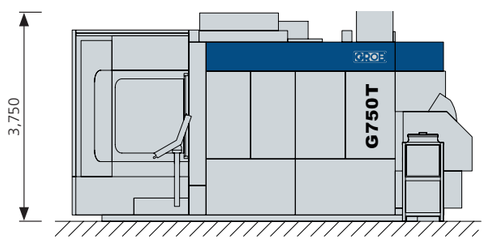
Side view / top view
max. [mm]

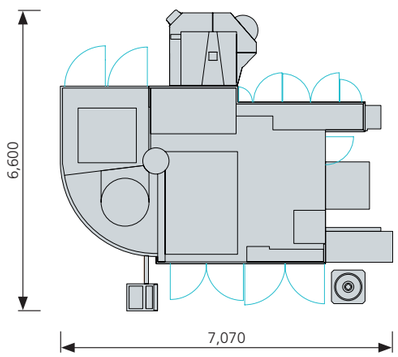
Basic machine





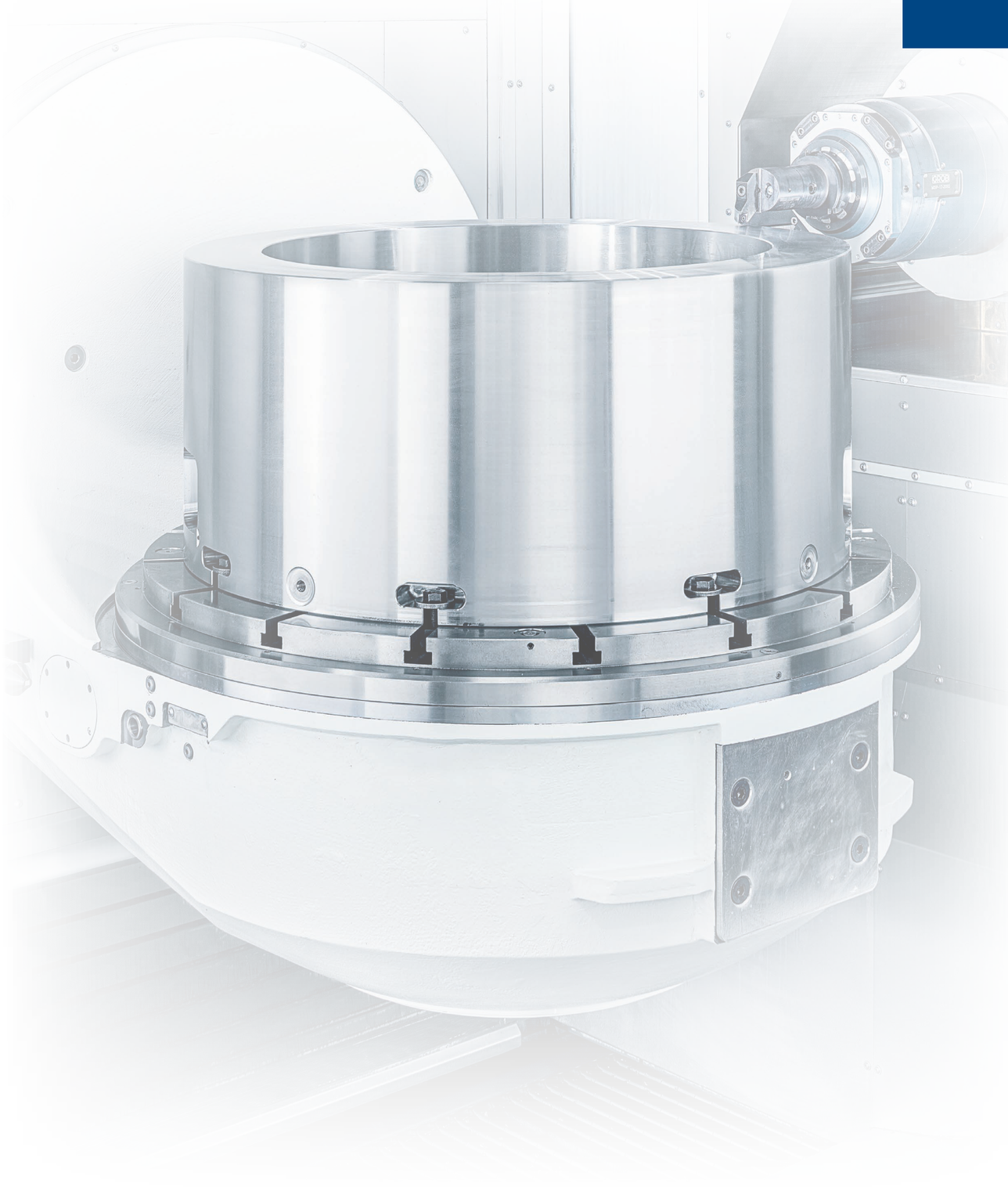
Basic machine with additional tool magazine





Dimension values [mm], not taking into account preventive maintenance and operating areas or emulsion and chip disposal

Illustrations may contain options
Subject to technical changes without prior notice



Technical data – overview

G350T/G550T/G750T

MACHINE TYPE	G350T			G550T						G750T				
SLIDE														
Working travels in X-/Y-/Z-axis [mm]	600/855/750			800/1,020/970						1,000/1,100/1,175				
Max. speeds in X-/Y-/Z-axis [m/min]	70/45/90			65/50/80 (90/50/90)[4]						60/50/75				
Max. accelerations in X-/Y-/Z-axis [m/s²]	4.5/4/6.5			6/4.5/7.5 (8.5/4.5/14)[4]						4.0/3.3/6.5				
Max. feed forces in X-/Y-/Z-axis [kN]	8/8/8			8/8/12[3]						10/10/10[3]				
Positioning accuracy* in X-/Y-/Z-axis [mm]	0.006			0.006						0.006				
Repeat precision of positioning* in X-/Y-/Z-axis [mm]	<0.0025			<0.0025						<0.003				
Positioning accuracy* in A-/B-axis [mm]	0.0017/0.0011			0.0017/0.0011						0.0017/0.0011				
Repeat precision of positioning* inA-/B-axis [°]	0.0008			0.0008						0.0008				
MAIN SPINDLE														
Drive: Standard — Tool interface for hollow taper shanks acc. to ISO 12164-3	HSK-A/T63			HSK-A/T63	HSK-A/T100		HSK-A/T100			HSK-A/T63	HSK-A/T100		HSK-A/T100	
Diameter of front spindle bearing [mm]	80			80	100		100			80	100		100	
Speed n_{max} [rpm]	16,000			16,000	14,500		10,000			16,000	10,000		14,500	
Max. drive power at 100 %/40 % duty cycle [kW]	25/32			25/32	50/58		50/66			25/32	50/66		50/58	
Max. spindle torque at 100 %/40 % duty cycle [Nm]	159/206			159/206	225/261		258/340			159/206	258/340		225/261	
Spindle shaft arrest [Nm][1]	300			300	1,200		1,200			300	1,200		1,200	
Chip-to-chip time t_1 according to VDI 2852 [s] SIEMENS control system and tool changer arm (dynamic package/standard)	2.7			2.9	3.7		3.7			3.8	3.8		3.8	
DISK-TYPE TOOL MAGAZINE	**STM**	**DTM**		**STM**		**DTM**				**DTM**			**TTD**	
TOOL INTERFACE	**HSK-A/T63**	**HSK-A/T63**	**HSK-A/T63**	**HSK-A/T63**	**HSK-A/T100**	**HSK-A/T63**		**HSK-A/T100**		**HSK-A/T63**	**HSK-A/T63**	**HSK-A/T100**	**HSK-A/T63**	**HSK-A/T63**
Number of tool pockets	60	117	105	70	40	137	123	77	69	117	117	65	177	167
Max. tool length [mm] ▸ Horizontal disk arrangement (disk 1/disk 2/disk 3 extra-long)	365	365/180	365/180/550[2]	465	500	465/280	465/280/700[2]	500/260	500/260/750[2]	—	—	—	—	—
▸ Vertical disk arrangement (disk 1/disk 2/disk 3 extra-long)	—	—	—	—	—	—	—	—	—	400/400	400/650[2]	450/650[2]	400/270/400	400/270/400/650[2]
Max. tool diameter [mm] ▸ No diameter restrictions for adjacent pockets	70	70	70	70	118	70	70	118	118	68	68	115	68	68
▸ Diameter restrictions for adjacent pockets	170	170	170	170	260	170	170	260	260	170	170	260	170	170
Max. tool weight [kg]	8	8	8	8	22	8	8	22	22	12	12	35	12	12
Max. tilt moment around gripper groove [Nm]	12	12	12	12	40	12	12	40	40	12	12	40	12	12
MILL-TURN TABLE														
Table diameter [mm]	570			770						950				
Max. table load [kg] (without/with pallet)	350/270			750/600						1,500/1,000				
Interference diameter [mm]	620			900						1,280				
B-axis speed n_{max} [rpm] (with intelligent imbalance detection)	1,200			800						500				
Max. B-axis torque at 100 %/40 % duty cycle [Nm]	1,250/1,420			1,200/1,380						3,110/3,740				
Holding torque with additional clamping [Nm]	1,500			2,500						6,000				
CUTTING FLUID/CHIP DISPOSAL														
Volume of cutting fluid tank [l]	950			1,250						1,070				
Cutting fluid filter flow rate [l]	220			220						220				
CONNECTION RATINGS														
Power requirements at 3 AC 400 V/50 Hz [kVA]	at least 42			at least 42						at least 42				
Compressed air [bar]	5			5						5				
WEIGHT (approx.)														
Max. total weight [kg] (incl. fixture/part/tool/cutting fluid)	15,300			26,000						37,000				
PROCESS STAGES														
Pallet size on basic machine with pallet clamping system [mm]	400×400			630×630						800×800				
Tool magazine expansion	TM200; TM308; TM373 (HSK-A/T63)			TM200; TM308; TM373 (HSK-A/T63)		TM180; TM250 (HSK-A/T100)				TM200; TM308; TM373 (HSK-A/T63)		TM180; TM250 HSK-A/T100		

[1] For turning operation
[2] With restrictions in the work area
[3] Depending on motorized spindle
[4] Available in combination with the dynamic package

STM = single disk-type tool magazine; DTM = double disk-type tool magazine; TTD = three disk-type tool magazine

G350T, G550T and G750T also available as milling machining centers
Subject to technical changes without notice; * According to ISO230-2:2014

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OUR PORTFOLIO
#G350T #G550T #G750T

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OUR AUTOMATION PORTFOLIO

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#TurnkeyManufacturingLines

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- GROB[4]LINE – watch the machine on your smartphone
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- GROB[4]ANALYZE-OFFICECLIENT – flexible data analysis with hall layout function
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- GROB[4]TDX – transfer tool data automatically
- GROB[4]PARTFLOW – process transparency for parts
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