



CHETO[®]

CNC DEEP HOLE DRILLING WITH MILLING

www.cheto.eu

CHETO

DB Series 6 Axes



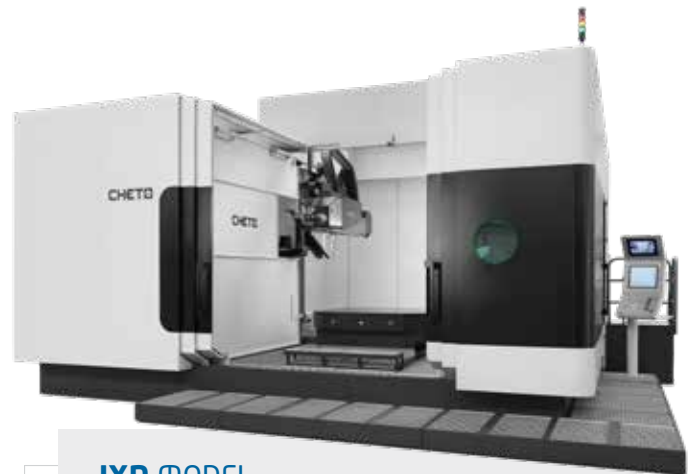
OUR PRODUCTS & DESIGN



INL MODEL

BTA / GUNDRILL

up to **3** Axes



IXN MODEL

1000 / 2000 / 3000 / 4000

6 & 7 Axes



PWN MODEL

1000 / 2000 / 3000

5 Axes



CSHI MODEL

Versions 4.0 / 9.0



SiC MODEL

650 / 1000 / 1000 HD

6 Axes with Gun Drill Arm

- Efficient **Deep Hole Drilling** with **Milling** for **Small Size Parts**
- Working **5 Faces** on a **Single Setup**
- **3+2** milling / **5** axes
- **No Angle Limitation**

Location

CHETO TECHNOLOGICAL CENTER:

Área de Acolhimento Empresarial
UI-Loureiro, Lotes 13-21
3720-070 Loureiro, Oliveira de Azeméis
Portugal
GPS. 40°48'00.5"N | 8°30'35.3"W

CONTACT US

T. +351 256 247 970
E. info@cheto.eu



WORLDWIDE PRESENCE

DEEP SOLUTIONS
INNOVATIVE CONCEPT
TO OPTIMIZE
DEEP HOLE DRILLING,
STANDARD DRILLING
AND MILLING



inovadora'21



CHETO®

CNC DEEP HOLE DRILLING WITH MILLING

INNOVATIVE machine tools

CHETO was officially established in 2009, when the founders started a project to fully develop a deep hole drilling and milling machine-tool up to 7-axis, specialized for the mold making and energy industry.

Since then, a continuous improvement and investigation allowed CHETO to offer the market a versatile product with high levels of accuracy and reliability.

This concept quickly positioned CHETO as a world-renowned brand. With machines sold in four continents, it is our goal to keep improving and innovating, to offer a highly competitive and value-creating product.





Milling Configuration



Deep Hole Drilling Configuration

CNC Axis

W drilling stroke

1500 mm 59.0 in

X longitudinal travel

1250 / 1800 mm 49.2 / 70.9 in

Y vertical travel

900 mm 35.4 in

Z cross travel

800 mm 31.5 in

B table rotation

360,000

A tilting rotation

+25°/-15°

Drilling capacity

Max. drilling stroke W+Z

1500+800 mm 61.0+31.5 in

Drilling capacity

Ø4-30 mm Ø0.16-1.18 mm

Milling capacity

Milling

275 cm³/min 16.8 in³/min

Rigid tapping

M20

Helical threading

Standard

Spindle*

Spindle taper

ISO50 / BT50 / CAT50

Speed

0-6000 rpm

Power

11 kW 14.8 hp

Torque

96/132 Nm 70.8/97.4 ft-lbs

Automatic rotary table

Table size

1000x1000 mm 39.4x39.4 in

Resolution

0,001°

Max. load in rotation

6 Ton 13,228 lbs

Layout dimensions

Total weight

19.5 Ton 42,990 lbs

Foot print (WxL)

5993x6455 mm 235.9x254.1 in

DBB

1500 mm 59.0 in

1250 / 1800 mm 49.2 / 70.9 in

900 mm 35.4 in

800 mm 31.5 in

360,000

1500+800 mm 61.0+31.5 in

Ø4-30 mm Ø0.16-1.18 mm

275 cm³/min 16.8 in³/min

M20

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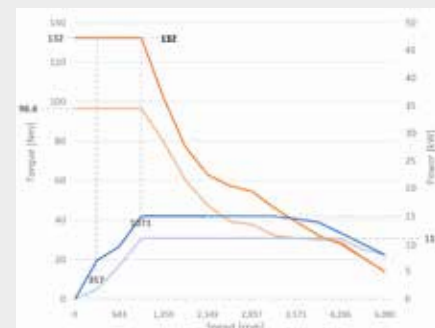
6 Ton 13,228 lbs

19 Ton 41,887 lbs

5993x6455 mm 235.9x254.1 in

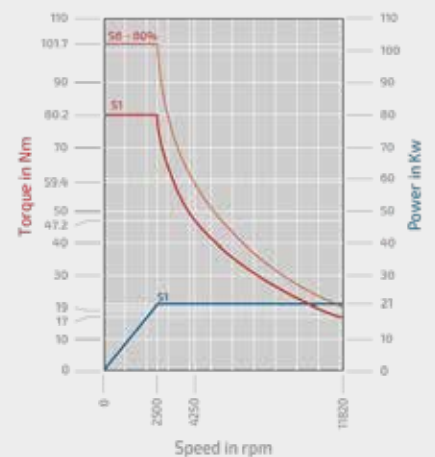
ISO50 / BT50 / CAT50

Spindle Power / Torque Diagram



*HSK63 (optional)

High Speed Spindle
Power / Torque Diagram



DB Series 1250 | 1800

— 6 AXES

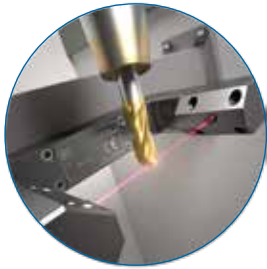


STANDARD EQUIPMENT

- CNC HEIDENHAIN TNC 640
- CNC FAGOR 8065 as optional equipment
- Electronic handwheel
- Digital drives
- Encoders in linear axis X, Y, and Z
- Angular encoders in rotating axis A and B
- Positioning table with continuous movement controlled with servo motor
- 3+2 milling / 5 axes
- External status led indication
- High-pressure pump up to 90 bar, 70 l/min | 1,305 psi, 18.5 gal/min
- Machine prepared to use emulsion or oil
- Coolant tank with automatic filtering
- Pumps for oil recirculation
- Automatic chip conveyor
- Quick change between drilling/milling
- Rigid tapping
- Complete cover with doors
- Spindle HSK63 (11.620rpm) as optional equipment
- ATC 40/80 tools, L=600 mm | 23.6 in for Spindle HSK63 as optional equipment
- ATC 32/50 tools, L=600 mm | 23.6 in for Spindle ISO50/BT50/CAT50 as optional equipment



DB OPTIONAL EQUIPMENT*



*LASER MEASURING SYSTEM
BLUM LC50



*TOOL CABINET



*ELECTRIC PROBE
BLUM TC60



*CHETO RE100
GUNDRILL GRINDER Ø5-32 mm | Ø0.2-1.26 in



WISE SYSTEM



ADAPT MACHINING PARAMETERS ONLINE

- Spindle torque
- Feed
- Coolant pressure
- Coolant flow
- Vibration



TWO CONTROL
OPTIONS



INTERSECTION

The system automatically detects intersections in the process and sets the parameters accordingly to keep the quality of the operation and to protect the tool lifetime.

PROCESS

The system detects variations of the efforts of the process and automatically adjust the drilling parameters online to keep a continuous process.



INTERFACE
REQUIREMENTS

HEIDENHAIN
TNC 640

SIEMENS
SINUMERIK ONE

FAGOR
CNC 8065



WISE
active
control
PATENTED



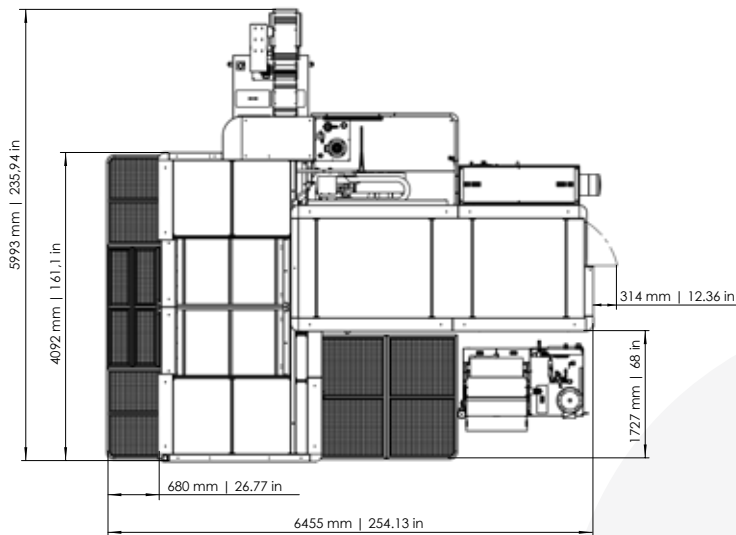
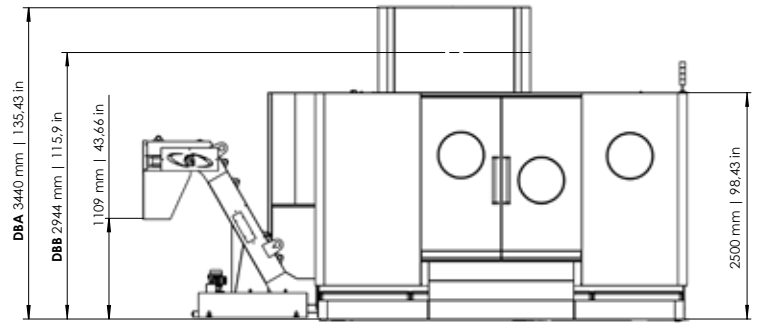
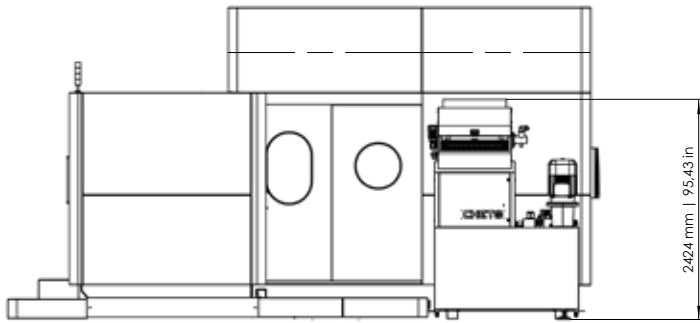
END OF
EXTRAORDINARY COSTS



END OF EXTRAORDINARY COSTS OF NONCONFORMANCE

The diversity of operations, the lack of raw materials homogeneity, the deficient parameter settings, and intersection holes often lead to the reduction of the tool lifetime. As hole intersections are a constant matter on mold making, and considering the difficulty of these operations, it's common to have problems on final results as unexpected hole drifts, premature tool wear or tool break.

FOOT PRINT DB Series



Subject to technical change without notice



CHETOCORPORATION, S.A.

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