

**Offer I CHIRON FZ 12 KW no. 253-14**

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Partly refurbished vertical machining centre CHIRON FZ 12 KW no. 253-14</b>  <b>Year of construction: 2006, weight: 7.500 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Type 12</b> Processing medium cooling lubricant	
400	1,00 ST	<b>Column moving machining centre</b> with machine bed in mineral cast technique and workpiece swivel table Guideways with long-term-grease lubrication	
500	1,00 ST	<b>Machine enclosure</b> 2140 mm high above floor with sliding doors, electrically interlocked, incl. machine lamp service friendly with removable side walls working area with vertical bellows	
600	1,00 ST	<b>Travel:</b> X-axis            550 mm Y-axis            320 mm Z-axis            360 mm	
700	1,00 ST	<b>Main spindle drive with AC-motor</b> 7,5 kW at 100 % 13,0 kW at 25 % Spindle speed range: 20 - 15.000 min <sup>-1</sup> - 70 Nm  Drilling capacity in steel 60                    ø 25 mm (with insert drill) Tapping capacity                                    M 20 Milling capacity in steel 60                    120 cm <sup>3</sup> /min.	
800	1,00 ST	<b>Workpiece swivel table 0/180 degrees</b> with centre divider made of sheet metal clamping surface 2 x 660 mm x 350 mm with thread and locating hole grid M16 x ø 15 H7 x 50 mm workpiece swivel time appr. 2,0 s weight-dependent, self-regulating through self-learning speed-control table loading capacity per side 300 kg, max. 100 kg weight difference between the two table sides	



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900	1,00 ST	<p><b>Automatic tool changer</b> through robust, full enclosed pick up tool changer, with mechanical impact protection an cleaning of the tool taper through air blow</p> <p>No. of tools 48 Tool taper HSK-A 50 DIN 69893 Max. tool dia. max. 60 mm Tool length max. 250 mm Max. tool weight max. 3 kg Tool change time appr. 0,9 s (depends on CNC) Chip-to-chip-time appr. 2,4 s (depends on CNC)</p>	
1000	1,00 ST	<p><b>Mini-operating panel</b> with start and receipt push buttons, for pallet recognition M61/M62</p>	
1100	1,00 ST	<p><b>AC-servo motors for x-, y- and z-axes</b> digital direct drives with indirect absolut path measuring system rapid traverse in all axes 75 m/min. Acceleration: X-axis 1 g, Y-axis 1,5 g, Z-axis 2,0 g</p> <p>Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)</p>	
1200	1,00 ST	<p><b>Fanuc 18i MB – 5 axes continuous path control</b> 10,4“ LCD monochrom screen Memory capacity 256 KB Drilling cycles G81-G89 Absolute path measuring system M- and T-functions Circular interpolation (360 degrees) Re-start into program Makro B subroutines Look ahead Simultaneous programming Automatic corner override 32 tool offsets cutter radius – contour compensation 6 zero shifts G54-G59 metric/inch switch 3D-Interpolation/helical interpolation S-analogue Rigid tapping</p>	



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		Orientated spindle stop Slot for PCMCIA memory card Interface RS 232C on the side at the control panel Software-limitswitch NC-diagnosis / machine diagnosis	
1300	1,00 ST	<b>Oil-free air service unit</b> with automatic condensate separator, pressure control of the air supply and micro filter 0,01 µm for air purge	
1400	1,00 ST	<b>CHIRON Maintenance Management in the screen</b> Display of the pending maintenance: Advance warning = "prepare maintenance" Warning = "carry out maintenance" machine stop = "catch up on maintenance" Abridged instructions for the pending maintenance with graphic illustration on CD-ROM. Password protected confirmation of the performed Maintenance through maintenance staff.	
1500	1,00 ST	<b>Thermodrive</b> at indirect absolut path measuring system	
1600	1,00 ST	<b>Working hours and piece counter</b> in the screen	
1700	1,00 ST	<b>Socket 230 V</b> at control panel	
1800	1,00 ST	<b>Socket for portable mini-hand wheel</b> without emergency stop button, at control panel	
1900	1,00 ST	<b>Wash gun</b> with 1 connection and quick coupling each in loading- and working area	
2000	1,00 ST	<b>Installation elements</b>	
2100	1,00 ST	<b>Chip conveyor (scratch band)</b> instead of standard coolant equipment discharge height 490 mm tank capacity 100 l, pump capacity 110 l/min at 1,3 bar coolant cleaning through slot filter box mesh size W=0,35 mm	



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2200	1,00 ST	<b>Coolant equipment</b> tank capacity 350 l. with low pressure pump 100 l/min. at 2,1 bar, till 200 l/min. at 1,9 bar incl. tub flushing	
2300	1,00 ST	<b>Signal lamp for 3 signals</b> Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running	
2400	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
2500	1,00 ST	<b>4. and 5. NC-axes ready for plug-in</b>	
2600	1,00 ST	<b>Flow control switch</b> for internal coolant	
2700	1,00 ST	<b>Package m-functions</b> m72/m73 2 m-function pairs for m74/m75 simple ON/OFF function m76 m-functions to control a m78 peripheral equipment with external setback (blocking of the machine course)	
2800	1,00 ST	<b>High speed skip and macro common variables</b> (fast measure entrance)	
2900	1,00 ST	<b>Pneumatic connection controlled</b> with A/B connection on each table side for pneumatic clamping device 2 electrically activated pneumatic connections for double acting; one pressure control, either for one or two controlled clamping circuits; at each clamping circuit pressure control switch with automatic pressure regulation. (in case of pressure change automatic pressure sensing)	
3000	1,00 ST	<b>Cutting tools</b> The cutting tools have to be balanced according to DIN 1940, class G 2,5, in two levels, with max. operating speed	



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3100	1,00 ST	<b>- Documentation -</b>	
3200	1,00 ST	<b>Documentation acc. to CE of the first delivery into market</b> 1 x safety regulations in a folder in English 1 x complete documentation on a USB as PDF Language of the operating manuals and safety in English	
3300	1,00 ST	<b>Machine colour</b> Two-components-structure varnish - 3 colours window grey acc. to RAL 7040 grey white acc. to RAL 9002 basalt grey acc. to RAL 7012	
3400		<b>Main circuit</b> total power supply 400 / 230V ± 10 %, 50 cycles N/PE, neutral conductor, load possible, pressure supply 6 bar, ± 1 bar at all procedures, room temperature max 40°	
3500		<b>Information Export</b> We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.	
3600		<b>Information Machine safety</b> The machine is designed and built in accordance with the European machine guideline, according placing the product on the first time onto the market. Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.	
3700		<b>Information Coolant lubrication</b> The machine is designed for standard water soluble coolant and fully enclosed at the standard version. The machine must be equipped with fume extraction.  The machine contents different plastics, varnish, resin and glue, which are selected carefully for using coolant and cutting oil. The use of aggressive coolant and additive could cause major damages and machine stops. Contact in any case your coolant supplier before machine set-up and installation.	



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