

Data sheet I CHIRON FZ 18 KL 2000 no. 167-29

Pos.	Qty.	Description	Price
100	1,00 ST	Partly refurbished vertical machining centre CHIRON FZ 18 KL no. 167-29 Year of construction: 2006, weight: 8.300 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Type 18 Processing medium cooling lubricant	
400	1,00 ST	Column moving machining centre with fixed table Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
500	1,00 ST	Machine enclosure with sliding doors, electrically interlocked, 2400 mm high above floor, incl. machine lamp service friendly with removable side walls vertical bellows	
600	1,00 ST	Travel: X-axis 2000 mm Y-axis 520 mm Z-axis 630 mm (with variable tool change level)	
700	1,00 ST	Main spindle drive with AC-motor 13,0 kW at 100 % 26,0 kW at 25 % Spindle speed range: 20 - 10.500 min ⁻¹ - 300 Nm Drilling capacity in steel 60 \varnothing 50 mm (with insert drill) Tapping capacity M 36 Milling capacity in steel 60 700 cm ³ /min.	
800	1,00 ST	Fixed table with chip pan Clamping surface 2600 x 570 mm ² mit 3 T-Nuten 2 x 18 H12, 1 x 18 H8	
900	1,00 ST	Automatic tool changer No. of tools 40 Tool shaft HSK A 63 DIN 69893 Max. tool max. 78 mm if all magazine pos. are occupied Max. tool max. 160 mm if adjacent places are free Max. tool length max. 280 mm Max. tool weight 5 kg (8 kg) Tool change time appr. 1,0 s (depends on CNC) Chip-to-chip-time appr. 2,9 s (depends on CNC)	

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Pos.	Qty.	Description	Price
1000	1,00 ST	Machining area recognition M61/M62 For shuttle machining 2x 580mm Start- and receipt push buttons, mounted on both sides	
1100	1,00 ST	AC-servo motors for x-, y- and z-axes digital direct drives with indirect absolute path measuring system (no approach reference point) rapid traverse in all axes 40 m/min. acceleration: 0,5 g in X and Y axis 0,7 g in Z axis	
1200	1,00 ST	SIEMENS CNC-control 840D (PCU 50 / NCU 572.4, 6 measuring circuits, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP010S control panel logic Windows XP NC-memory 256 KB (max.200 programmes storage capacity) for DIN 66025 programming hard disk with approx.. 2 GB for free disposal drilling cycles G81-G89 drilling and milling cycles M- and T- functions circular interpolation (360 degrees) re-start into program Subroutines, parameter programming simultaneous programming contour programming with cycle support polar coordinates tool offsets for geometry, wear tool radius correction for intersection computing crossingradius 4 zero offsets G54-G57 30 zero shifts programmable with G-functions 3D and helical interpolation screen switch off mirror function scaling function insert of chamfer and radius Universal interface RS 232C (2 x V24) Ethernet connection RJ45 in control panel orientated spindlestop drip feed function through V24 interface dimension metric or inch	

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Pos.	Qty.	Description	Price
		software limitswitch NC-diagnosis machine-diagnosis absolute indirect path measurement systems powermeter in screen rigid tapping look ahead function	
1300	1,00 ST	CHIRON Powersafe Softwarepaket zum gezielten Abschalten von installierten Verbrauchern wie z.B. Achsmotoren, Antrieben, Spindeln, Sperrluft, Airsensing und Nebenaggregaten in Produktionspausen bzw. zu programmierbaren Zeitpunkten mit Hilfe eines Schichtkalenders. Definierbarer Zeitpunkt an dem die Maschine bedarfsorientiert automatisch mit einem variablen "Warmup"-Programm zur Wiederherstellung der Produktionsbereitschaft beginnt.	
1400	1,00 ST	CHIRON Maintenance Management in the screen 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	Signal lamp on control panel for 3 signals Signal "red" = failure Signal "with" = machine loaded Signal "green" = machine is running	
1600	1,00 ST	Working hours and piece counter in the screen	
1700	1,00 ST	Socket 230 V at control panel	
1800	1,00 ST	Cabinet cooler as a door mounting unit	

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Pos.	Qty.	Description	Price
1900	1,00 ST	<p>Coolant equipment PF50 / KFA 900 (for cast iron slurry, Al with Si \geq 12%) tank capacity 900 l, pump capacity from 100 l/min at 2,1 bar up to 250 l/min at 1,8 bar high pressure pump capacity 20 l/min at 30 bar high pressure circuit with filtration via paper bond filter, filtration 50 μm nominal. twin filter in the high pressure circuit for the protection of the machine. (This filtration method will not eliminate increasing cast iron slurry from the coolant equipment.)</p>	
2000	1,00 ST	<p>Machine preparation for through tool coolant system including: - Sealing system in the DIN 69871 Form A40 or DIN 69893 HSK A63* collet - coolant distributor installed at the main spindle drive - Coolant leakage sensor - Implemented mud flap in the high pressure piping - Solenoid valve, controlled via machine program</p> <p>* At HSK A63 we recommend for tool holders the use of our patented coolant tube with sieve. Advantages: - Decrease of the clogging in the internal coolant channel. - Reduction of the wear at the O-ring seal in the collet.</p> <p>(Subject: required high pressure equipment)</p>	
2100	2,00 ST	Wash gun	
2200	1,00 ST	Installation elements	
2300	1,00 ST	<p>Chip conveyor (scratch band) with side discharge, discharge height 1.050 mm, tank capacity 400 l lift pump capacity max. 300 l/min. at 1,3 bar</p> <p>Precondition: Coolant equipment or connection to central coolant system</p>	
2400	1,00 ST	<p>Socket for portable mini-hand wheel without emergency stop button, at control panel incl. connection cable 900 mm</p>	

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2500	1,00 ST	4. axis ready for plug-in for NC Rotary table (on the right field for ATU 280)	
2600	1,00 ST	Portable mini-hand wheel for conventional travel, without emergency stop button, including connecting cable 900 mm. (This way the emergency stop button at the control panel is within the reach of the operator.)	
2700	1,00 ST	Pneumatic- and Hydraulic Connections	
2800	1,00 ST	Probe for automatic measuring in the machine Renishaw - probe - package OMP 40-2LS for part measuring and automatic machine compensation, - probe with optical contact modul and tool taper suitable for machine spindle - tracing pin 58 mm with ruby ball dia. 4 mm - infrared sensor OMI-2C - process oriented measuring - software for measuring cycles and strategy program	
<p>Remark: For the carrying out of machine compensations with probe a suitable reference surface at the machine or at the fixture or an optional gauge block (VCS12100800) are necessary.</p>			
2900	1,00 ST	- Documentation -	
3000	1,00 ST	Documentation acc. to CE of the first delivery into market 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	
3100	1,00 ST	Machine colour Two-components-structure varnish - 3 colours Window grey acc. to RAL 7040 Greywhite acc. to RAL 9002 Basalt grey acc. to RAL 7012	

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Pos.	Qty.	Description	Price
3200		<p>Main circuit</p> <p>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°</p>	
3300		<p>Information Export</p> <p>We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.</p>	
3400		<p>Information Machine safety</p> <p>The machine is designed and built in accordance with the European machine guideline, according placing the product on the first time onto the market.</p> <p>Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.</p>	
3500		<p>Information Coolant lubrication</p> <p>The machine is designed for standard water soluble coolant and fully enclosed at the standard version. The machine must be equipped with fume extraction.</p> <p>The machine contents different plastics, varnish, resin and glue, which are selected carefully for using coolant and cutting oil.</p> <p>The use of aggressive coolant and additive could cause major damages and machine stops.</p> <p>Contact in any case your coolant supplier before machine set-up and installation.</p>	