

**Data sheet I CHIRON FZ 08 S no. 213-78**

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON FZ 08 S no. 213-78</b>  <b>Year of construction: 2001, weight: 2.000 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre with fixed table</b>	
400	1,00 ST	<b>Machine enclosure</b> bolted on, with loading door, electrically interlocked, 2.000 mm high above floor, incl. machine lamp	
500	1,00 ST	<b>Fixed table with chip pan</b> clamping surface      620 x 270 mm <sup>2</sup> with grid                M16 x Ø 15 H7 x 50 mm table loading capacity   max. 150 kg	
		Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)	
600	1,00 ST	<b>Travel:</b> X-axis                    300 mm Y-axis                    250 mm Z-axis                    250 mm	
700	1,00 ST	<b>High speed spindle</b> 2,2 kW at 100% 7,2 kW at 25% Spindle speed range: 20 – 15.000 rpm –23 Nm  Drilling capacity        Ø 16 mm Tapping capacity        M 12 Milling capacity         30 cm <sup>3</sup> /min	
800	1,00 ST	<b>Automatic tool changer</b> Tool places            12 Tool shaft                HSK-A 32 DIN 69893 Tool-Ø max. 63 mm Tool weight            max. 0,7 kg Tool change time approx.    0,5 s (depends on CNC) Chip-to-chip-time approx.    1,5 s (depends on CNC)	



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Pos.	Qty.	Description	Price
900	1,00 ST	<p><b>AC-servo-motors</b>  feed drives for X-, Y- and Z-axes,  indirect absolut path measuring system  rapid traverse in X- and Y-axes 40 m/min,  acceleration 0,7 g.  rapid traverse in Z-axes 60 m/min,  acceleration 1,0 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>	
1000	1,00 ST	<p><b>SIEMENS CNC-control 840D</b>  (MMC 100.2 / NCU 571.2, 6 measuring circuits, 1 canal)  incl. 10,4" TFT colour LCD screen / full keyboard OP032S  NC-memory 256 MB  (max.200 programmes storage capacity)  for ISO 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  support through cycles  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) at control panel  Ethernet connection RJ45 in control panel  orientated spindlestop  drip feed function through V24 interface  dimension metric or inch  software limitswitch</p>	



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Pos.	Qty.	Description	Price
		NC-diagnosis machine-diagnosis absolute indirect path measurement systems powermeter in screen, rigid tapping	
1100	1,00 ST	<b>CMS Powersafe</b> Software package for selective shutdown of installed consumers such as axis motors, drives, spindles, coolant-pumps and auxiliary equipment during production breaks. Definable point in time at which the machine goes demand-oriented automatically into it's Power Safe mode.	
1200	1,00 ST	<b>Thermocontrol</b>	
1300	1,00 ST	<b>Coolant unit with chip container</b> Tank capacity 100 l, pump capacity 60 l/min. at 1 bar	
1400	1,00 ST	<b>Socket 230 V</b> at control panel	
1500	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
1600	1,00 ST	<b>Automatic central grease lubrication</b>	
1700	1,00 ST	<b>Installation elements</b>	
1800	1,00 ST	<b>Basic package for machining from bar, consisting of:</b>  <b>NC-rotary-table package, complete installed consisting of:</b> - NC-rotary-table, type AWU P 100 suiting to inflexible table raster - 4th NC-axis, complete smallest increment 0,001° - pneumatic supply without control Technical description for NC-rotary-table: repetition accuracy $\pm 30''$ , max. spindle rotation speed 80 min <sup>-1</sup> Spindle with pneumatic clamping, centre height 125 mm, face plate dia. 100 mm, with centre bore dia. 50 +0,012, through hole 35 mm, fixture pin dia.10 h7 4 fixture holes M8 Switch for end of bar mounted outside of the machine enclosure Opening at machine enclosure on left hand side	

### Loading door

as two splitted sliding door to the left „closing“



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Pos.	Qty.	Description	Price
1900	1,00 ST	<b>Wash gun</b>	
2000	1,00 ST	<b>- Documentation -</b>	
2100	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	
2200	1,00 ST	<b>Machine colour</b> Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
2300		<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°  <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.  <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.  <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.	

