

Data sheet I MILL 800 no. 418-25

Pos.	Qty.	Description	Price
100	1,00 ST	<p>Partly refurbished vertical machining centre CHIRON MILL 800 Nr. 418-25</p> <p>Year of construction: 2006, weight: 7.800 kg</p>	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	<p>Machine enclosure bolted on, with loading door, electrically interlocked, 2.500 mm high above floor, incl. machine lamp</p>	
400	1,00 ST	<p>Column moving machining centre with fix table Machine base with integrated chip output to the left Linear-guideways with long-term-grease lubrication</p> <p>Drilling capacity in steel 60 \varnothing 42 mm (with insert drill) Tapping capacity M 30 Milling capacity in steel 60 600 cm³/min.</p>	
500	1,00 ST	<p>Travel: X-axis 800 mm Y-axis 480 mm Z-axis horizontal spindle 715 mm / vertical spindle 630 mm</p>	
600	1,00 ST	<p>NC swivel head package - 12.000 rpm Motor spindle for swivel head, grease lubrication 12,5 kW at 100 % ED 34,0 kW at 10 % ED, watercooled 20 - 12.000 rpm, 140 Nm acceleration and deceleration 0 - 12.000 rpm 0,9 sec. each tool clamping with disk springs, hydraulic knock out, tool shaft for HSK-A 63 DIN 69893 tool magazine prepared for tool holders according to HSK-A 63 DIN 69893 Drilling capacity \varnothing 42 mm (with insert drill), Tapping capacity M 30, Milling capacity 600 cm³/min in steel.</p> <p>NC swivel axis \pm 100 ° - 30 rpm, lowest increment 0,001° - repetition accuracy \pm 10" with direct measuring system - driving torque 280 Nm - with hydraulic clamping system, max. torque through clamping 1400 Nm</p>	



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		<p>Hydraulic unit for continuous duty pressure: 210 bar incl. valves for supply and pressure stage for clamping of swivel head and automatic knock out of tool</p> <p>flood coolant, pump capacity 20 l/min at 4 bar</p> <p>5-axes-machining for the machining of three-dimensional curved or tilted surfaces with 3 linear and 2 additional axes (TRAORI & CYCLE 800). - 5-axes-transformation with tool orientation and tool center point management. The machining task is programmed completely in Cartesian coordinates with Cartesian position and orientation. The movements of all 5 axes resultant from that are computed internally with the 5-axes-transformation. - 5-axes-tool-offset. The length of the tool is automatically Computed and compensated in the movements of the axes. - Oriented tool withdrawal. With the interruption of machining (e. g. tool breakage), the tool can be withdrawn orientated and defined.</p>	
700	1,00 ST	<p>Automatic tool changer, protected against chips</p> <p>No. of tools 60 Tool shaft HSK A 63 DIN 69893 Max. tool dia. 75 mm if all magazine pos. are occupied Max. tool dia. 160 mm if adjacent places are free Max. tool length 320 mm Max. tool weight 4,0 kg Tool change time approx. 1,5 s (depends on CNC) Chip-to-chip-time approx. 5,0 s (depends on CNC)</p>	
800	1,00 ST	<p>AC-servo motors for x-, y- and z-axes</p> <p>digital direct drives with indirect absolute path measuring system rapid traverse in all axes 40 m/min.</p>	
900	1,00 ST	<p>SIEMENS CNC-control 840D</p> <p>(PCU 50 / NCU 572.5, 6 measurement cycles, 1 canal) incl. 15" TFT colour LCD screen full keyboard KB 483 C / machine control panel MCP 483 C control panel logic Windows XP NC-memory 256 KB (max.200 programmes storage capacity) for ISO 66025 programming hard disk with approx. 2 GB for free disposal</p>	



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		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 support through cycles polar coordinates tool offsets for geometry, wear tool radius correction for intersection computing crossing radius 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 spindle stop drip feed function through V24 interface dimension metric or inch software limit switch NC-diagnosis machine-diagnosis absolute indirect path measurement systems power meter in screen rigid tapping look ahead function and dynamic pilot control	
1000	1,00 ST	CHIRON Powersafe Software package for selective shutdown of installed consumers like axis motors, drives, spindles, seal air, airsensing and ancillary equipment in production breaks or during programmable points in time using a shift calendar. Definable point in time at which the machine starts demand-oriented automatically with a variable warmup programm to recovery the production readiness.	



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1100	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 the maintenance staff.	
1200	1,00 ST	Working hours and piece counter in the screen	
1300	1,00 ST	Socket 230 V at control panel	
1400	1,00 ST	Cabinet cooler as a door mounting unit	
1500	1,00 ST	Installation elements	
1600	1,00 ST	Production package with high pressure pump HL 450 / 900 consisting of: - Coolant equipment tank capacity 1000 l, pump capacity from 200 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, inclined bed filter brand. Polo, duplex filter with coolant filtration 50 µm nominal incl. bed flushing system (with Y480 mm or 500 mm) - Chip conveyor (scratch band) with rear discharge, discharge height 1.050 mm, tank capacity 150 l lift pump capacity max. 300 l/min. at 1,3 bar - Flow control switch in TTC line	



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		<p>- Machine preparation for through tool coolant system including: sealing system in the 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>	
1700	1,00 ST	Fixture washing incl. coolant connection	
1800	1,00 ST	Wash gun	
1900	1,00 ST	Automatical central grease lubrication	
2000	1,00 ST	<p>Suction point for customer specific installation Ø 200 mm on top of the machine enclosure and electrical preparation in cabinet</p>	
2100	1,00 ST	<p>Glass scales Overpressured in all axes X, Y, Z = 800 x 500 x 550 mm At NC-swivel head Y,Z = 480 x 715 / 630 mm</p>	
2200	1,00 ST	Pneumatic supply 0,6 bar	
2300	1,00 ST	Increased windows in the front doors, safety glass	
2400	1,00 ST	Technology package for turning from bar	
2500	1,00 ST	<p>Lathe spindle water-cooled motor spindle, installed horizontal, with hollow shaft as opening for bars up to ø 65 mm 14,1 kW at 100 %, 42,5 kW at 5 % spindle speed range 15 - 4.500 rpm - 90 Nm with direct measuring system and hydraulic clamping 800 Nm collet chuck with integrated hydraulic actuation extension hydraulic unit for clamping collet chuck and clamping spindle incl. hydraulic connection</p>	



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2600	1,00 ST	NC-feeding unit as bar feeder rapid traverse 60 m/min, stroke max. 1.100 mm, depending on fixture incl. interface NC axis	
2700	1,00 ST	NC-turning unit with clamping vice for the machining of the 6th side, installed on NC-feeding unit, incl. interface NC axis, incl. rotary table clamping hydraulic incl. pneumatic connection, uncontrolled, for air purge. Technical description for NC-turning unit: indexing accuracy $\pm 15''$, max. spindle rotation speed 45 rpm, with hydraulic clamping, controlled via NC-program	
2800	2,00 ST	Technical description zero point clamping system 2 x clamping modul Inside micrometer 150 +/-0,01 mm Unlocking pressure 6 bar external (it's necessary to dock a pneumatic hose) Media transfer A/B and pneumatic supply	
2900	1,00 ST	Vice with interface for zero point clamping system Stroke per chuck: 8 mm Clamping/unclamping pneumatic Clamping force max. 1.200 dN	
3000	1,00 ST	CHIRON Lasercontrol Single F500 min. tool $\varnothing > 1\text{mm}$, for tool breakage control, for automatic tool measurement, for automatic temperature compensation in 2 axes, including process-orientated measuring, software for measuring cycles and strategy program, and test mandrel with tool holder incl. transmitter and receiver, gland and shutter	
3100	1,00 ST	Switch for end of bar	
3200	1,00 ST	Bar feeding from left side	

Note: After alignment the machine has to be anchored to the floor.
 At bar lengths > 800 mm a hydrostatic bar loader (Option) is necessary.
 additionally necessary: fixture washing, hydraulic unit, unloading of finished parts



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3300	1,00 ST	<p>Bar-leading with hydrodynamic storage for a bar bar-lenght up to 1600 mm from dia. 4 to 65 mm, ideal material leading by changeable leading-channels, manual loading, bar feed and extraction of rest pieces is effected by Chiron CNC-machining-center, rest piece lenght min. 70 mm, best run characteristics by soft vibration construction, oil-aggregate, bar feed is effected by Chiron CNC-machining-center, mechanic loader interface electric loader interface (Harting plug) with adaptation, installation, commissioning, documentation</p>	
3400	1,00 ST	<p>Pneumatic gripper with transport belt included in the working area on the right side.</p> <p>The pneumatic gripper transfers the part to the transport belt. The belt will be timed acc. the width of parts. Executed as follows: - Pneumatic connection controlled - Gripper with form clamping jaws - Transport belt, length approx.. 1 m, incl. coolant return to the machine.</p>	
3500	1,00 ST	<p>CHIRON Tool lifetime control with: tool place organization sister tool organization</p>	
3600	1,00 ST	<p>Ethernet connection RJ45 at the electric cabinet Instead in the control panel</p>	
3700	1,00 ST	<p>CHIRON Variable Clamping Logic For the definition of different clamping and releasing sequences, for a maximum of 10 functions with a maximum of 8 steps. Considering of time delay and monitoring of clamping circuits e.g. through pressure switches or airsensing. The storing of the configuration and reloading, allows fast changeover.</p>	
3800	1,00 ST	<p>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.)</p>	



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3900	1,00 ST	Cutting tools The cutting tools have to be balanced according to DIN ISO 1940, class G 2,5, in two levels, with max. operating speed	
4000	1,00 ST	Socket for portable mini-hand wheel without emergency stop button, at control panel	
4100	1,00 ST	Signal lamp on control panel for 3 signals Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running	
4200	1,00 ST	Machine colour Two-components-structure varnish - 3 colours window grey acc. to RAL 7040 grey white acc. to RAL 5023 basalt grey acc. to RAL 7012	
4300	1,00 ST	- Documentation -	
4400	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	
4500		Main circuit 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°	
4600		Information Export We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.	
4700		Information Machine safety 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.	



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4800		<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>	

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