

Data sheet I FZ 08 KS no. 462-84

Pos.	Qty.	Description	Price
100	1,00 ST	Partly refurbished vertical machining centre CHIRON FZ 08 KS No. 462-84	
		Year of construction: 2001, weight: 2.000 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with fixed table	
400	1,00 ST	Machine enclosure bolted on, with loading door, electrically interlocked, 2.000 mm high above floor, incl. machine lamp	
500	1,00 ST	Fixed table with chip pan clamping surface with grid table loading capacity	620 x 270 mm ² M16 x Ø 15 H7 x 50 mm max. 150 kg
600	1,00 ST	Travel: X-axis Y-axis Z-axis	300 mm 250 mm 250 mm
700	1,00 ST	AC-motor with High speed spindle 2,2 kW 7,2 kW Spindle speed range: Drilling capacity Tapping capacity Milling capacity	at 100% at 25% 20 – 15.000 rpm – 23 Nm Ø 16 mm M 12 20 cm ³ /min
800	1,00 ST	Automatic tool changer Tool places Tool shaft Tool-Ø Tool-Ø if adjacent places are free Tool weight Tool change time approx. Chip-to-chip-time approx.	23 HSK-A 32 DIN 69893 max. 40 mm 50 mm max. 0,7 kg (average 0,5 kg) 0,6 s (depends on CNC) 1,9 s (depends on CNC)

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Pos.	Qty.	Description	Price
900	1,00 ST	AC-servo-motors Feed drives for X-, Y- and Z-axis indirect absolute path measuring system rapid traverse in X- and Y-axis: 40 m/min rapid traverse in Z-axis: 60 m/min	
1000	1,00 ST	Siemens CNC-control 840 D (SIMATIC IPC / NCU 571.5, 6 measuring circuits, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP032S NC-memory 256 KB (max. 200 programmes storage capacity) for ISO 66025 programming 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) orientated spindlestop drip feed function through V24 interface dimension metric or inch software-limitswitch NC-diagnosis machine-diagnosis absolute indirect path measurement systems rigid tapping	

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Pos.	Qty.	Description	Price
1100	1,00 ST	CMS Powersafe Software package for selective shutdown of installed consumers such as axis motors, divers, 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	Socket 230 V on the control console	
1300	1,00 ST	Cabinet cooler as a door mounting unit	
1400	1,00 ST	Installation elements	
1500	1,00 ST	Wash gun	
1600	1,00 ST	Coolant equipment with chip tank Tank capacity: 100 l., pump power 80 l/min. at 1 bar	
1700	1,00 ST	Automatic loading door of total enclosure opening and closing	
1800	1,00 ST	Safety light barrier for automatic door	
1900	1,00 ST	Walk switch	
2000	1,00 ST	Signal light on control console for 3 signals Signal "red" = fault Signal "white" = load machine Signal "green" = machine running	
2100	1,00 ST	Coolant connection device for fixture flushing	
2200	1,00 ST	Measure package Marker HEIDENHAIN, over pressured in all axes X, Y, Z = 300 x 250 x 250 mm note: zero point approach required	
2300	1,00 ST	Machine preparation for inside flushing tools by the spindle, with hollow shaft, sealing in the HSK-A 32 collet, rotary joint to spindle drive, moisture sensor for monitoring of leakage, high pressure supply with built-in dirt collector magnetic valve programmed via NC program	

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Pos.	Qty.	Description	Price
2400	2,00 ST	<p>Rotary table package completely installed consisting of:</p> <ul style="list-style-type: none"> - NC rotary table, type AWU P 100 mounted to the fixed table grid - interface 4th NC-axis lowest increment 0,001° - pneumatic supply, without control <p>Technical description NC rotary table indexing accuracy ± 5 sec. with direct measuring system max. spindle speed 80 rpm Spindle with pneumatic clamping, centre height 125 mm, Faceplate-\varnothing 100 mm, with centre hole $\varnothing 50 + 0,012$, Through bore 35 mm, fixing pin $\varnothing 10H7$, 4 mounting holes M8</p>	
2500	2,00 ST	<p>Chiron standard fixture for rotary table with:</p> <ul style="list-style-type: none"> - base plate for AWU P 100 and counter bearing - counter bearing with pneumatic clamping - centring flange, on side of the rotary table - centring flange, on side of the counter bearing - counter bearing shaft - 4-wire power supply on the counter bearing - 2 x hydraulic - 2 x pneumatic - centre height 180 mm - Bridge size 250 mm 	
2600	1,00 ST	<p>Airsensing with separate valves for 2 clamping stations</p>	
2700	1,00 ST	<p>Electrical main switching off in the pneumatic supply</p>	
2800	1,00 ST	<p>Pneumatic- and Hydraulic Connections</p>	
2900	1,00 ST	<p>Pneumatic supply (A + B) for pneumatic clamping device electrically controlled pneumatic connection, for double acting clamping cylinder; 1 pressure controller; pressure control with automatic pressure regulation. (in case of pressure change automatic pressure sensing)</p>	

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3000	1,00 ST	Machine colour Two-components-structure varnish light grey acc. to NCS S1502-B	
3100	1,00 ST	- Documentation -	
3200	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	
3300		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°	

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