

Pos.	Qty.	Article Description	Price / €
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Complete machine description

- 1 1 **Vertical CNC-machining centre model Mill 800**
Partly refurbished pre-owned machine
Year of construction: 2004, weight: 7.200 kg

Machine-No. 220-61

Scope of delivery:

Column moving machining centre with fixed table

Machine substructure with chip discharge left
 Linear guides with long-term-lubrication

Drilling capacity in steel 60	ø 42 mm (with insert drill)
Tapping capacity	M 30
Milling capacity in steel 60	600 cm ³ /min.

Main spindle drive

7,5 kW at 100 %
 22,5 kW at 10 %, watercooled
 Spindle speed range: 20 - 12.000 rpm - 140 Nm

Travel:

X-axis	800 mm
Y-axis	500 mm
Z-axis	550 mm

Automatic tool changer

No. of tools	40
Tool shaft	SK A-40 DIN 69871 + 72
tool dia.	max. 75 mm
tool dia.	max. 125 mm
if adjacent places are free	max. 280 mm
Max. tool length	4 kg
Max. tool weight	approx. 1,5 s (depends on CNC)
Tool change time	approx. 4,0 s (depends on CNC)
Chip-to-chip-time	

Fixed table with chip pan

clamping surface	1400 x 550 mm ²
with 3 T-slots	2 x 18 H12, 1 x 18 H8
table loading capacity	max. 1200 kg



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AC-servo motors

for x-, y- and z-axes
digital direct drives with indirect absolute path measuring system
(no time-consuming reference)
rapid traverse in all axes 60 m/min.

SIEMENS CNC-control 840D

(PCU 50 / NCU 572.4, 6 measuring circuits, 1 canal)
incl. 10,4" TFT colour LCD screen / full keyboard OP010S
control panel logic Windows NT
NC-memory 256 KB
(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
NC-diagnosis
machine-diagnosis
absolute indirect path measurement systems
powermeter in screen
rigid tapping; look ahead function



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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 program to recovery the production readiness.

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.

Working hours and piece counter
in the screen

Socket 230 V
at control panel

Socket for portable mini-handwheel
without emergency stop button,
at control panel

Cabinet cooler as a door mounting unit

Machine enclosure
with loading door, electrically interlocked,
suitable for loading by crane
2.500 mm high above floor, incl. machine lamp

Installation elements

Signal lamp on control panel for 3 signals

Signal "red" = failure
Signal "white" = machine loaded
Signal "green" = machine is running

Chip conveyor (scratch band)

discharge height 1.050 mm, discharge backwards,
tank capacity 150 l, lift pump with 250 l/min. at 1,5 bar



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Wash gun

Thermodrive at indirect path-measuring system

Shopmill

Incl. tool management

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.)

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

Documentation

Operating manuals, programming and operating manuals 1-fold on a USB-Stick.

Please refer to the manufacturer's instructions for each component.

Machine colour

Two-components-structure varnish - 3 colours

window grey acc. to RAL 7040

distant blue acc. to RAL 5023

basalt grey acc. to RAL 7012

Main circuit

total power supply 400 / 230V \pm 10 %, 50 cycles N/PE,

neutral conductor, load possible, pressure supply

6 bar, \pm 1 bar at all procedures,

room temperature max 40°

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.



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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.

Information Coolant lubrication

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.

