

Pos.	Qty.	Article Description	Price / €
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## Complete machine description | FZ 08 W no. 204-50

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|---|---|---|--|
| 1 | 1 | <b>Completely refurbished<br/>vertical CNC-machining centre model<br/>CHIRON FZ 08 W<br/>Year of construction: 2001, weight: 2.200 kg<br/><br/>Machine-No. 204-50</b> |  |
|---|---|---|--|



Machine image similar.  
The equipment of the sample photo isn't binding.



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Scope of delivery:

100 1 **Column moving machining centre** with workpiece swivel table

200 1 **Main spindle drive with AC-motor**

2,2 kW at 100%  
7,2 kW at 25%  
Spindle speed range: 20 – 15.000 rpm – 23 Nm

Drilling capacity in steel 60 Ø 16 mm  
Tapping capacity M 12  
Milling capacity in steel 60 30 cm<sup>3</sup>/min.

300 1 **Travel:**

X-axis 300 mm  
Y-axis 250 mm  
Z-axis 250 mm

400 1 **Automatic tool changer**

as chain magazine (without basket changer)  
added as Pick-up Version  
integrated in the machine side protected against chips  
No. of tools 23  
Tool shaft HSK 32 DIN 69893  
Max. tool dia. max. 40 mm  
(50mm if free neighbor placers)  
Tool length 160 mm  
Max. tool weight max. 0,7 kg  
Tool change time appr. 0,8 s (depends on CNC)  
Chip-to-chip-time appr. 2,2 s (depends on CNC)

500 1 **Workpiece swivel table 0/180 degrees**

with centre divider made of sheet metal  
clamping surface 2 x 550 mm x 300 mm  
with thread and locating hole grid M16 x ø 15 H7 x 50 mm  
workpiece swivel time appr. 2,0 s weight-dependent, self-regulating  
through self-learning speed-control  
table loading capacity per side 100 kg,  
max. 50 kg weight difference between the two table sides



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600	1	<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>	
700	1	<p><b>SIEMENS CNC-control 840D</b>            (MMC 100.2 / NCU 571.2, 6 measuring cycles, 1 canal)            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</p>	



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		absolute indirect path measurement systems rigid tapping	
800	1	<b>Socket 230 V</b> at control panel	
900	1	<b>Machine enclosure</b> bolted on, with loading door, electrically interlocked, 2.000 mm high above floor, incl. machine lamp	
1000	1	<b>Cabinet cooler</b> as door mounting unit	
1100	1	<b>Wash gun</b>	
1200	1	<b>Machine preparation</b> for through tool coolant system including - Sealing system in the HSK-A 32 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	
1300	1	<b>Chip conveyor (scratch band)</b> discharge height 495 mm with coolant equipment, tank capacity 150 l, pump capacity 100 l/min at 1,3 bar	
1400	1	<b>High pressure pump</b> used together with the standard coolant unit or the chip conveyor as Inline-pump  Pump pressure           max. 150 bar Pump capacity           max. 6 l/min. Vario valve             20, 30, 50, 70, 90, 110, 130, 150 bar Partical coolant cleaning system 60 µ via twin filter Flow monitor	
1500	1	<b>Recooling unit</b> with absolut control of coolant temperature, for single spindle machines.	



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| 1600 | 1 | <p><b>Chiron Lasercontrol Single F295</b><br/>for tool breakage control,<br/>min. tool <math>\varnothing &gt; 1\text{mm}</math>,<br/>incl. test mandrel with tool holder,<br/>transmitter and receiver,<br/>gland and shutter</p> <p>Precondition for Fanuc:<br/>- High speed skip and macro common variables</p>                              |  |
| 1700 | 1 | <p><b>Hydraulic connection for 210 bar</b><br/>with rotation distributor 6-fold and<br/>4 connecting couplings for hydraulic,<br/>2 connecting couplings for pneumatic,<br/>without control, hydraulic installation,<br/>up to the outside machine bed, with electrical control<br/>for clamping ON - OFF via push button at control panel</p> |  |
| 1800 | 1 | <p><b>Hydraulic unit</b><br/>pressure: 210 bar<br/>supply capacity: 1,7 l/min.<br/>with electrical control and external power supply<br/>incl. valves for supply of 2 clamping devices<br/>and 2 pressure switches for clamping control</p>  |  |

### 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 - 2 colours  
light grey acc. to NCS S1502-B  
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°

