

## Data sheet I CHIRON FZ 08 KW no. 204-87

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON FZ 08 KW no. 204-87</b>  <b>Year of construction: 2001, weight: 2.200 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre</b> with workpiece swivel table	
400	1,00 ST	<b>Machine enclosure</b> with sliding doors, electrically interlocked, 2270 mm high above floor, incl. machine lamp	
500	1,00 ST	<b>Workpiece swivel table 0/180 degrees</b> 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	
600	1,00 ST	<b>Travel:</b> X-axis 300 mm Y-axis 250 mm Z-axis 250 mm	
700	1,00 ST	<b>Main spindle drive with AC-motor</b> 2,2 kW at 100% 7,4 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.	
800	1,00 ST	<b>Automatic tool changer</b> 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)	



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Pos.	Qty.	Description	Price
900	1,00 ST	<b>AC-servo-motors feed drives for X-, Y- and Z-axes</b> 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.  Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)	
1000	1,00 ST	<b>FANUC 21 i - 3-axes continuous path control</b> 9.5" LCD monochrom screen memory capacity 32 KB drilling cycles G81-G89 absolute path measuring system M- and T-functions circular interpolation (360 degrees) re-start into program makro B sub-routines look ahead simultaneous programming automatic corner override 32 tool offsets cutter radius - contour compensation 6 zero shifts G54-G59 metric/inch switch 3 D-interpolation/helical interpolation S-analogue rigid tapping orientated spindle stop Interface RS 232C software-limitswitch NC-diagnosis with help function machine diagnosis	
1100	1,00 ST	<b>Thermocontrol</b>	
1200	1,00 ST	<b>Machine enclosure</b> bolted on, with loading door, electrically interlocked, 2.000 mm high above floor, incl. machine lamp	
1300	1,00 ST	<b>Working hours and piece counter</b> in the screen	



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Pos.	Qty.	Description	Price
1400	1,00 ST	<b>Socket 230 V</b> at control panel	
1500	1,00 ST	<b>Wash gun</b>	
1600	1,00 ST	<b>Installation elements</b>	
1700	1,00 ST	<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	
1800	1,00 ST	<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	
1900	2,00 ST	<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	
2000	1,00 ST	<b>Suction point</b> for customer specific installation Ø 150 mm on top of the machine enclosure and electrical preperation in cabinet	
2100	1,00 ST	<b>NC Rotary table package, completely installed consisting of:</b> - NC rotary table, type AWU P 100 mountable to the workpiece swivel table - interface 4th NC-axis lowest increment 0.001° - pneumatic supply, without control Technical description NC rotary table indexing accuracy ± 30" max. spindle speed 80 rpm spindle pneumatic clamped, center height 125 mm face plate dia. 100 mm, center bore dia. 50+0,012, through bore dia 35 mm, location pin dia. 10 h7, 4 bolt holes M8	



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Pos.	Qty.	Description	Price
2200	1,00 ST	<b>Pneumatic- and Hydraulic Connections</b>	
2300	1,00 ST	<b>Hydraulic connection for 210 bar</b> with rotation distributor 6-fold and 4 connecting couplings for hydraulic, 2 connecting couplings for pneumatic, without control, hydraulic installation, up to the outside machine bed, with electrical control for clamping ON - OFF via push button at control panel	
2400	2,00 ST	<b>Hydraulic unit</b> pressure: 210 bar supply capacity: 1,7 l/min. with electrical control and external power supply incl. valves for supply of 2 clamping devices and 2 pressure switches for clamping control	
2500	1,00 ST	<b>Two-hand-push-buttons</b> for clamping ON - OFF, instead of button in operating panel	
2600	1,00 ST	<b>- Documentation -</b>	
2700	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	
2800	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	
2900		<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°	
3000		<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.	



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Pos.	Qty.	Description	Price
3100		<p><b>Information Machine safety</b></p> <p>The machine is designed and built in accordance with the European machine guideline, according placing the product on the first time onto the market.</p> <p>Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.</p>	
3200		<p><b>Information Coolant lubrication</b></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>	

