

Data sheet I CHIRON FZ 15 S FA no. 219-32

Pos.	Qty.	Description	Price
100	1,00 ST	<p>Completely refurbished vertical machining centre CHIRON MILL 800 no. 220-61</p> <p>Year of construction: 2004, weight: 7.200 kg</p>	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	<p>Column moving machining centre with fixed table Machine substructure with chip discharge left Linear guides with long-term-lubrication</p>	
400	1,00 ST	<p>Machine enclosure with loading door, electrically interlocked, suitable for loading by crane 2.500 mm high above floor, incl. machine lamp</p>	
500	1,00 ST	<p>Fixed table with chip pan clamping surface 1400 x 550 mm² with 3 T-slots 2 x 18 H12, 1 x 18 H8 table loading capacity max. 1200 kg</p>	
600	1,00 ST	<p>Travel: X-axis 800 mm Y-axis 500 mm Z-axis 550 mm</p>	
700	1,00 ST	<p>Main spindle drive 7,5 kW at 100 % 22,5 kW at 10 %, watercooled Spindle speed range: 20 - 12.000 rpm - 140 Nm</p> <p>Drilling capacity in steel 60 ø 42 mm (with insert drill) Tapping capacity M 30 Milling capacity in steel 60 600 cm³/min.</p>	
800	1,00 ST	<p>Automatic tool changer No. of tools 40 Tool shaft SK A-40 DIN 69871 + 72 tool dia.max. 75 mm tool dia. if adjacent places are free max. 125 mm Max. tool lengthmax. 280 mm Max. tool weight 4 kg Tool change time approx. 1,5 s (depends on CNC) Chip-to-chip-time approx. 4,0 s (depends on CNC)</p>	



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Pos.	Qty.	Description	Price
900	1,00 ST	<p>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.</p>	
1000	1,00 ST	<p>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</p>	



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Pos.	Qty.	Description	Price
		powermeter in screen rigid tapping, look ahead function	
1100	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.	
1200	1,00 ST	Socket for portable mini-handwheel without emergency stop button, at control panel	
1300	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.	
1400	1,00 ST	Working hours and piece counter in the screen	
1500	1,00 ST	Socket 230 V at control panel	
1600	1,00 ST	Cabinet cooler as a door mounting unit	
1700	1,00 ST	Automatic central grease lubrication	
1800	1,00 ST	Thermodrive at indirect path-measuring system	
1900	1,00 ST	Installation elements	
2000	1,00 ST	Signal lamp on machine enclosure for 3 signals Signal "red" = failure Signal "white" = load machine Signal "green" = machine is running	
2100	1,00 ST	Wash gun	



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2200	1,00 ST	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	
2300	1,00 ST	Shopmill Incl. tool management	
2400	1,00 ST	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.)	
2500	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	
2600	1,00 ST	- Documentation -	
2700	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	
2800	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
2900		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°	
3000		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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3100		<p>Information Machine safety</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>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>	

