

Data sheet I CHIRON FZ 08 KSM no. 225-34

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON FZ 08 KSM no. 225-34 Year of construction: 2003, weight: 3.400 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with fixed table Guideways with long-term-grease lubrication	
400	1,00 ST	Machine enclosure with full enclosed workspace with loading doors, electrically interlocked, 2070 mm high above floor, including machine lamp	
500	1,00 ST	Travel: X-axis 450 mm Y-axis 270 mm Z-axis 280 mm	
600	1,00 ST	Digital maine drive with spindle 7,0 kW at 100 % 9,0 kW at 25 % - watercooled Spindle speed range up to 30.000 rpm – 6,5 Nm Drilling capacity in steel 60 \varnothing 12 mm (with insert drill) Tapping capacity M 8 Milling capacity in steel 60 30 cm ³ /min.	
700	1,00 ST	Automatic tool changer No. of tools 40 Tool shaft HSK-A 40 DIN 69893 Max. tool dia. max. 50 mm Max. tool dia. max. 100 mm if adjacent places are free Tool length max. 160 mm Max. tool weight max. 1,2 kg (max. magazine loading 20 kg) Tool change time appr. 0,8 s (depends on control) Chip-to-chip-time appr. 2,7 s (depends on control) Chip-to-chip-time at 90° appr. 3,0 s (depends on control)	

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Pos.	Qty.	Description	Price
800	1,00 ST	<p>Digital feed drives for X-, Y- and Z-axis with digital direct drives and indirect absolut path measuring system rapid traverse in X- and Y-axes and Z-axis 75 m/min, acceleration: 1,0 g in X-axis 1,5 g in Y-axis 2,0 g in Z-axis</p> <p>Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)</p>	
900	1,00 ST	<p>SIEMENS CNC-control 840D (PCU 50 / NCU 573.4, 6 Messkreise, 1 Kanal) 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 power meter in screen screen switch off look ahead function Bellshape-acceleration ramp software limit switch access authorization over key switch for tool correction, NC-program changes and machine parameters orientated spindle stop rigid tapping re-start into program Subroutines, parameter programming simultaneous programming support through cycles drilling cycles G81-G89 drilling and milling cycles M- and T- functions tool offsets for geometry, wear 4 zero offsets G54-G57 30 zero shifts programmable with G-functions tool radius correction for intersection computing crossing radius contour programming</p>	

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Pos.	Qty.	Description	Price
		dimension metric or inch mirror function polar coordinates circular interpolation (360 degrees) 3D and helical interpolation drip feed function through V24 interface Universal interface RS 232C (2x V24) at control panel Ethernet connection RJ45 in control panel NC-diagnosis machine-diagnosis	
1000	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.	
1100	1,00 ST	Thermodrive with indirect path measuring system	
1200	1,00 ST	Socket for portable mini-handwheel without emergency stop button, at control panel	
1300	1,00 ST	Working hours and piece counter in the screen	
1400	1,00 ST	Socket 230 V at control panel	
1500	1,00 ST	Cabinet cooler as a door mounting unit	
1600	1,00 ST	Installation elements	
1700	1,00 ST	Machine preparation for through tool coolant system including <ul style="list-style-type: none"> - 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	Wash gun	

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Pos.	Qty.	Description	Price
1900	1,00 ST	Chip conveyor (scratch band) discharge height 490 mm tank capacity 110 l, pump capacity 110 l/min at 1,9 bar	
2000	1,00 ST	High pressure pump used together with the standard coolant unit or the chip conveyor as Inline-pump Pump pressure max. 70 bar (till 30.000 min-1) Pump capacity max. 6 l/min. Vario valve 20, 30, 50, 70 bar Partical coolant cleaning system 60 µ via twin filter Flow monitor	
2100	1,00 ST	Coolant equipment tank capacity 500 l, pump capacity 100 l/min at 1,8 bar (only in combination with chip conveyor, the pump in the chip conveyor becomes the lift pump) coolant filtration via paperbondfilter	
2200	1,00 ST	Machine options for bar machining	
2300	1,00 ST	NC-feeding unit as bar feeder Rapid traverse 60 m/min, stroke max. 460 mm, depend on fixture	
2400	1,00 ST	NC-turning unit with clamping vice KSP100 for the machining of the 6th side installed on NC-feeding unit Technical description of NC-turning unit: - indexing accuracy $\pm 30''$ - max. spindle speed 80 rpm with pneumatic clamping feed unit as bar feeder, electrically controlled via NC-program pneumatic connection group	
2500	1,00 ST	Chiron Lasercontrol Single F500 für Werkzeugbruchkontrolle, min. Werkzeugdurchmesser >.1.mm, inkl. Sender und Empfänger, Schmutzblende mit Verschluss	
2600	1,00 ST	Switch for end of bar mounted outside of the machine enclosure	

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Pos.	Qty.	Description	Price
2700	1,00 ST	Opening at machine enclosure on left hand side additionally necessary: fixture washing	
2800	1,00 ST	Part removal handling via pneumatic gripper to transport the work pieces outside of the machine	
2900	1,00 ST	NC Rotary table package, completely installed consisting of: <ul style="list-style-type: none"> - NC rotary table, type AWU P 100 mountable to the workpiece swivel table - interface 4th + 5th NC-axis, ready for plug-in lowest increment 0.001° - pneumatic supply, without control <p>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</p>	
3000	1,00 ST	Automatic collet chuck for collets Ø 28,5 mm maker SCHAUBLIN Type W25, with pneumatic actuation, complete installed. Incl. spanner to the collet chuck change. Control via button OPEN/CLOSED in control panel.	
3100	1,00 ST	Glass scales overpressured in all axes X, Y, Z = 450 x 270 x 280 mm (Thermodrive in Basic machine is cancelled)	
3200	1,00 ST	Signal lamp for 3 signals Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running	
3300	1,00 ST	Suction point for customer specific installation Ø 150 mm on top of the machine enclosure and electrical preperation in cabinet	

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Pos.	Qty.	Description	Price
3400	1,00 ST	Renishaw - probe - package RLP40Q for part measuring and automatic machine compensation, probe with radio module and tool taper suitable for machine spindle tracing pin 58 mm with ruby ball dia. 4 mm receiver RMI-Q with integrated interface bracket for radio receiver process oriented measuring software for measuring cycles and strategy program Remarks: In order to carry out machine compensations with probe a suitable reference surface at the machine or at the fixture or an optional gauge block are necessary.	
3500	1,00 ST	Pressure Amplification to clamp the collet chuck	
3600	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	
3700	1,00 ST	- Documentation -	
3800	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	
3900	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
4000		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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4100		<p>Information Export</p> <p>We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.</p>	
4200		<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>	
4300		<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>	