

Data sheet I CHIRON FZ 08 KWM no. 230-62

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON FZ 08 KWM no. 230-62 Year of construction: 2005, weight: 3.600 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with workpiece swivel table Guideways with long-term lubrication	
400	1,00 ST	Machine enclosure with full enclosed workspace with loading doors, electrically interlocked, including replaceable safety windows, workspace enclosure with stainless steel covers, 2070 mm high above floor, including machine lamp	
500	1,00 ST	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 200 kg, max. 50 kg weight difference between the two table sides	
600	1,00 ST	Travel: X-axis 450 mm Y-axis 270 mm Z-axis 310 mm	
700	1,00 ST	Main Spindle drive with AC-motor with air purge and monitoring of the tool clamping 2,2 KW at 100 % 7,4 KW at 25 % Spindle speed range: 20 - 15.000 rpm - max.23 Nm Drilling capacity in 60 pc. Ø 16 mm Tapping capacity M 12 Milling capacity in steel in 60 pc. 60 cm ³ /min	

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Pos.	Qty.	Description	Price
800	1,00 ST	Automatic tool changer through robust, full enclosed pick up tool changer, with mechanical impact protection an cleaning of the tool taper through air blow Tool places 24 Tool shaft HSK-A 40 DIN 69893 Max Tool-Ø max. 47 mm Max Tool-Ø if next places are free 100 mm Tool length 160 mm Max. tool weight max. 1,2 kg Tool change time approx. 0,8 s (depends on CNC) Chip-to-chip-time approx. 1,9 s (depends on CNC)	
900	1,00 ST	AC-servo-motors feed drives for X-, Y- and Z-axes, indirect absolute path measuring system rapid traverse in X-, Y-, and Z-axes 75 m/min acceleration: 1,0 g in X-axis 1,5 g in Y-axis 2,0 g in Z-axis	
1000	1,00 ST	SIEMENS CNC-control 840D (PCU 50 / NCU 572.3, 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	

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Pos.	Qty.	Description	Price
		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 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	
1100	1,00 ST	CMS Powersafe Software package for selective shutdown of installed consumers such as axis motors, drives, spindles, coolant-pumps and auxiliary equipment during production breaks. Definable point in time at which the machine goes demand-oriented automatically into it's Power Safe mode.	
1200	1,00 ST	Thermodrive	
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.	

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Pos.	Qty.	Description	Price
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	Socket for portable mini-hand wheel without emergency stop button, at control panel	
1700	1,00 ST	Cabinet cooler as a dour mounting unit	
1800	1,00 ST	Oil-free air service unit with automatic condensate separator, pressure control of the air supply and micro filter 0,01 µm for air purge	
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	Chip conveyor (scratch band) discharge height 490 mm instead of standard-coolant equipment, tank capacity 110 l, at 1,8 bar Coolant cleaning by slot screen case	
2200	1,00 ST	Additional coolant tank tank capacity 500 l, pump capacity 100 l/min at 1,8 bar coolant filtration via paperbondfilter 50 µm with automatic filter transport (only in combination with chip conveyor, the pump in the chip conveyor becomes the lift pump)	
2300	1,00 ST	Wash gun With 1 connection and fast coupling per loading- and working area	
2400	2,00 ST	Rotary table package completely installed consisting of: - NC rotary table, type TG 100 FT axis fit on the workpiece table grid - interface 4 th and 5 th NC-axes lowest increment 0,001° - pneumatic supply, without control	

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Pos.	Qty.	Description	Price
		<p>Technical description NC rotary table Spindle with pneumatic clamping, centre height 125 mm, indexing accuracy $\pm 30''$ max. spindle speed 80 rpm Faceplate-\varnothing 100 mm, with centre hole $\varnothing 50 + 0,012$, Through bore 35 mm, fixing pin $\varnothing 10H7$, 4 mounting holes M8</p>	
2500	2,00 ST	<p>Chiron standard fixture for rotary table Bridge size 410 mm in X, 105 mm in Y Consisting of: - base plate for AWU P 100 and counter bearing - counter bearing with pneumatic clamping - centring flange, on side of the rotary table - centring flange, on side of the counter bearing - counter bearing shaft - 2 x 2-wired power supply (pneumatic) - centre height 125 mm</p>	
2600	1,00 ST	<p>Automatic loading door of total enclosure opening and closing, actuating via push button at mini-operating panel</p>	
2700	1,00 ST	<p>CHIRON Tool lifetime control with: - tool place organization - sister tool organization - Working field organisation by 4 digit program number in the screen Geometrie monitoring at tool call</p>	
2800	1,00 ST	<p>Electrical suction preparation</p>	
2900	1,00 ST	<p>Machine preparation for through tool coolant system including - Sealing system in the HSK collet - coolant distributor installed at the main spindle drive - Coolant leakage sensor - Implemented mud flap in the high pressure piping and flow control switch - Solenoid valve, controlled via machine program</p>	

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Pos.	Qty.	Description	Price
3000	1,00 ST	<p>Electric interface for loader with Harting plug on W-machines for loading through manual or automatic loading door for automatic loading system, with DP/DP-coupler (slave) in the electrical cabinet, according to documentation of CHIRON loader interface, consisting of: circuit diagram, signal description and functional diagram, interface tested according to Chiron-description, incl. key-operated switch and indicator lamp in the control panel "with loader", incl. direct door switch in position "door open"</p> <p>Deviation from the standard interface and set up will be charged according to effort. Waiting periods during set up will also be charged. Recommended options:</p> <ul style="list-style-type: none"> ▪ automatic doors, if necessary ▪ tool life control ▪ tool breakage control ▪ fixture washing ▪ chip conveyor, if not included in basic machine ▪ Parts location air sensing ▪ automatic central lubrication <p>Note: The machine has to be anchored with robot loading or linkage. Anchoring the machine to the ground can be made by Chiron if wanted. This outlay will be charged according to effort.</p>	
3100	1,00 ST	<p>Additional button for indexing in the loading station indexing 4 x 90° or 2 x 180° for NC rotary tables, 4th or 4th and 5th axis</p>	
3200	1,00 ST	<p>Chiron Lasercontrol Single F500 for tool breakage control, min. tool Ø > 1mm, incl. test mandrel with tool holder, transmitter and receiver, gland and shutter</p>	

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Pos.	Qty.	Description	Price
3300	1,00 ST	- Documentation -	
3400	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	
3500	1,00 ST	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 ± 10 %, 50 cycles N/PE, neutral conductor, load possible, pressure supply 6 bar, ± 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. 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.	