

## Data sheet I CHIRON FZ 12 KW no. 253-13

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON FZ 12 KW no. 253-13</b>  <b>Year of construction: 2005, weight: 7.500 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Type 12</b> Processing medium cooling lubricant	
400	1,00 ST	<b>Column moving machining centre</b> with machine bed in mineral cast technique and workpiece swivel table Guideways with long-term-grease lubrication	
500	1,00 ST	<b>Machine enclosure</b> 2140 mm high above floor with sliding doors, electrically interlocked, incl. machine lamp service friendly with removable side walls working area with vertical bellows	
600	1,00 ST	<b>Travel:</b> X-axis            550 mm Y-axis            320 mm Z-axis            360 mm	
700	1,00 ST	<b>Main spindle drive with AC-motor</b> 7,5 kW at 100 % 13,0 kW at 25 % Spindle speed range: 20 - 15.000 min <sup>-1</sup> - 70 Nm  Drilling capacity in steel 60                    ø 25 mm (with insert drill) Tapping capacity                                    M 20 Milling capacity in steel 60                    120 cm <sup>3</sup> /min.	
800	1,00 ST	<b>Workpiece swivel table 0/180 degrees</b> with centre divider made of sheet metal clamping surface 2 x 660 mm x 350 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 300 kg, max. 100 kg weight difference between the two table sides	



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Pos.	Qty.	Description	Price
900	1,00 ST	<p><b>Automatic tool changer</b> through robust, full enclosed pick up tool changer, with mechanical impact protection an cleaning of the tool taper through air blow</p> <p>No. of tools 24 Tool taper HSK-A 50 DIN 69893 Max. tool dia. max. 60 mm Tool length max. 250 mm Max. tool weight max. 3 kg Tool change time appr. 0,9 s (depends on CNC) Chip-to-chip-time appr. 2,4 s (depends on CNC)</p>	
1000	1,00 ST	<p><b>Mini-operating panel</b> with start and receipt push buttons, for pallet recognition M61/M62</p>	
1100	1,00 ST	<p><b>AC-servo motors for x-, y- and z-axes</b> digital direct drives with indirect absolut path measuring system rapid traverse in all axes 75 m/min. Acceleration: X-axis 1 g, Y-axis 1,5 g, Z-axis 2,0 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>	
1200	1,00 ST	<p><b>Fanuc 18i MB – 5 axes continuous path control</b> 10,4“ LCD monochrom screen Memory capacity 256 KB Drilling cycles G81-G89 Absolute path measuring system M- and T-functions Circular interpolation (360 degrees) Re-start into program Makro B subroutines Look ahead Simultaneous programming Automatic corner override 32 tool offsets cutter radius – contour compensation 6 zero shifts G54-G59 metric/inch switch 3D-Interpolation/helical interpolation S-analogue Rigid tapping</p>	



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Pos.	Qty.	Description	Price
		<p>Orientated spindle stop            Slot for PCMCIA memory card            Interface RS 232C on the side at the control panel            Software-limitswitch            NC-diagnosis / machine diagnosis</p>	
1300	1,00 ST	<p><b>Oil-free air service unit</b>            with automatic condensate separator,            pressure control of the air supply            and micro filter 0,01 µm for air purge</p>	
1400	1,00 ST	<p><b>CHIRON Maintenance Management in the screen</b>            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 maintenance staff.</p>	
1500	1,00 ST	<p><b>Thermodrive</b>            at indirect absolut path measuring system</p>	
1600	1,00 ST	<p><b>Working hours and piece counter</b>            in the screen</p>	
1700	1,00 ST	<p><b>Socket 230 V</b>            at control panel</p>	
1800	1,00 ST	<p><b>Socket for portable mini-hand wheel</b>            without emergency stop button,            at control panel</p>	
1900	1,00 ST	<p><b>Coolant equipment</b>            tank capacity 350 l.            with low pressure pump 100 l/min. at 2,1 bar,            till 200 l/min. at 1,9 bar            incl. tub flushing</p>	
2000	1,00 ST	<p><b>Machine preparation</b>            for through tool coolant system including:</p> <ul style="list-style-type: none"> <li>- Sealing system in the DIN 69871 Form A40              or DIN 69893 HSK A63* collet</li> <li>- coolant distributor installed at the main spindle drive</li> <li>- Coolant leakage sensor</li> <li>- Implemented mud flap in the high pressure piping</li> </ul>	



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		- Solenoid valve, controlled via machine program	
		* At HSK A63 we recommend for tool holders the use of our patented coolant tube with sieve. Advantages: - Decrease of the clogging in the internal coolant channel. - Reduction of the wear at the O-ring seal in the collet.	
		(Subject: required high pressure equipment)	
2100	1,00 ST	<b>Wash gun</b> with 1 connection and quick coupling each in loading- and working area	
2200	1,00 ST	<b>Installation elements</b>	
2300	1,00 ST	<b>Chip conveyor (scratch band)</b> instead of standard coolant equipment discharge height 490 mm tank capacity 100 l, pump capacity 110 l/min at 1,3 bar coolant cleaning through slot filter box mesh size W=0,35 mm	
2400	1,00 ST	<b>Coolant equipment</b> tank capacity 350 l. with low pressure pump 100 l/min. at 2,1 bar, till 200 l/min. at 1,9 bar incl. tub flushing	
2500	1,00 ST	<b>Signal lamp for 3 signals</b> Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running	
2600	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
2700	1,00 ST	<b>Electric cabinet – Indoor light</b> Connected in front of the main switch	
2800	1,00 ST	<b>Flow control switch</b> for internal coolant	



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2900	1,00 ST	<b>Package m-functions</b> m72/m73 2 m-function pairs for m74/m75 simple ON/OFF function m76 m-functions to control a m78 peripheral equipment with external setback (blocking of the machine course)	
3000	1,00 ST	<b>Electric interface for loader with "Profibus" - Fanuc</b> for automatic loading system, with DP/DP-coupler (Slave) in the cabinet, for shuttle machining, according to documentation of CHIRON loader interface, consisting of: circuit diagram, signal description and functional diagram, Interface tested according to Chiron-description V03.01, incl. key-operated switch and indicator lamp in the control panel "with loader".  Deviation from the standard interface and set up will be charged according to effort. Waiting periods during set up will also be charged.	
3100	1,00 ST	<b>Pneumatic- and Hydraulic Connections</b>	
3200	1,00 ST	<b>Hydraulic connection for 200 bar</b> with 2 connecting couplings "A + B" and hydraulic installation up to outside of machine bed, electrical control for clamping ON - OFF via push button at control panel	
3300	1,00 ST	<b>Pneumatic connection</b> for pneumatic clamping device electrically controlled pneumatic connection, for double acting; pressure control; pressure control switch with automatic pressure regulation. (in case of pressure change automatic pressure sensing)	
3400	1,00 ST	<b>Pneumatic shut off valve</b> maker Ross	
3500	1,00 ST	<b>- Documentation -</b>	
3600	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	



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Pos.	Qty.	Description	Price
3700	1,00 ST	<p><b>Machine colour</b></p> <p>Two-components-structure varnish - 2 colours  light grey acc. to NCS S1502-B  basalt grey acc. to RAL 7012</p>	
3800		<p><b>Main circuit</b></p> <p>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°</p>	
3900		<p><b>Information Export</b></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>	
4000		<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.  Other safety features due to special company rules and  specifications can be considered. The actual cost will be  invoiced.</p>	
4100		<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>	

