

Data sheet I CHIRON FZ 12 KS no. 251-13

Pos.	Qty.	Description	Price
100	1,00 ST	<p>Completely refurbished vertical machining centre CHIRON FZ 12 KS no. 251-13</p> <p>Year of construction: 2005, weight: 6.900 kg</p>	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	<p>Column moving machining centre with machine bed in mineral cast technique and workpiece swivel table Guideways with long-term-grease lubrication</p>	
400	1,00 ST	<p>Machine enclosure 2140 mm high above floor with sliding doors, electrically interlocked, incl. machine lamp service friendly with removable side walls working area with vertical bellows</p>	
500	1,00 ST	<p>2-spindle 2-axes rotary table type AWU 160-2 / AWU 200</p> <p>Peiseler twin pot rotary (B-axis) type AWU 160 face plate \varnothing 180 mm, centre face \varnothing 40 H6 spindle distance 250 mm prepared for hydraulic face plate clamping repetition accuracy out of worm gear drive \pm 15 sec. of arc max. tangential torque transmitted through worm gear drive for rotary milling 220 Nm when the face plate is clamped (60 bar) 800 Nm max. tilting moment 1200 Nm including pneumatic cylinder for chuck clamping</p> <p>Tilting unit AWU 160 (A-axis) tilting \pm 90 degree + 5 degree overload to one side prepared to assemble AWU 160 twin repetition accuracy out of worm gear drive \pm 10 sec. of arc prepared for hydraulic clamping and 5-fold distributor</p> <p>Counter bearing with hydraulic clamping bush</p> <p>2 axis motor covered, complete installed</p> <p>4th and 5th axis overpressure connection</p>	



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600	1,00 ST	Travel: X-axis 550 mm Y-axis 320 mm Z-axis 360 mm	
700	1,00 ST	Digital main drive with spindle with air purge and monitoring of the tool clamping 7,5 kW at 100 % 13,0 kW at 25 % spindle speed range up to 15.000 rpm; 70 Nm Drilling capacity \varnothing 25 mm (with insert drill) Tapping capacity M 20 Milling capacity 120 cm ³ /min Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)	
800	1,00 ST	Automatic tool changer through robust, full enclosed pick up tool changer, with mechanical impact protection and cleaning of the tool taper through air blow 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)	
900	1,00 ST	Fanuc 18i MB – 5 axes continuous path control 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	



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		cutter radius – contour compensation 6 zero shifts G54-G59 metric/inch switch 3D-Interpolation/helical interpolation S-analogue Rigid tapping Orientated spindle stop Slot for PCMCIA memory card Interface RS 232C on the side at the control panel Software-limitswitch NC-diagnosis / machine diagnosis	
1000	1,00 ST	AC-servo motors for x-, y- and z-axes 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	
1100	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. Confirmation of the performed maintenance through the maintenance staff by password.	
1200	1,00 ST	Thermodrive at indirect absolute path measuring system	
1300	1,00 ST	Socket for portable mini-hand wheel without emergency stop button, at control panel	
1400	1,00 ST	Cabinet cooler as a door mounting unit	
1500	1,00 ST	Socket 240 V at control panel	



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1600	1,00 ST	<p>Coolant equipment KF 150 / FKA 500 (also for sludge generating materials, e.g. grey cast iron, GGG, Al with Si \geq 12%) tank capacity 500 l</p> <p>low pressure pump capacity from 40 l/min. at 3.2 bar up to 120 l/min at 3.2 bar high pressure pump capacity 28 l/min at 30bar</p> <p>full stream purification via compact paper bond filter KF 150, with coolant purification 50 μm nominal twin filter in the high pressure circuit for the protection of the machine</p>	
1700	1,00 ST	<p>Signal lamp for 3 signals Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running</p>	
1800	1,00 ST	<p>Wash gun with 1 connection and quick coupling each in loading- and working area</p>	
1900	1,00 ST	<p>Oil-free air service unit with automatic condensate separator, pressure control of the air supply and micro filter 0,01 μm for air purge</p>	
2000	1,00 ST	<p>Fixture washing incl. coolant connection</p>	
2100	1,00 ST	<p>Chip conveyor (scratch band) Typ 340 K-1/100 discharge height 490 mm tank capacity 100 l, pump capacity 20 l/min at 0,8 bar lifting pump 110 l/min coolant cleaning through slot filter box wear-resistant guideways and wear ground</p>	
2200	1,00 ST	<p>Walk switch</p>	
2300	1,00 ST	<p>Automatic central grease lubrication</p>	



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2400	1,00 ST	Machine preparation for through tool coolant system including: <ul style="list-style-type: none"> - sealing system in the DIN 69893 HSK A50* collet or DIN 69871 Form A40 - 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 * 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	
2500	1,00 ST	Electric cabinet Indoor light of the electrical cabinet including additional transformer ON/ OFF switch at the light.	
2600	1,00 ST	Indoor lighting of the cabinet connected before main switch (only for power supply with loadable neutral)	
2700	1,00 ST	Flow control switch for coolant through tool	
2800	1,00 ST	Pneumatic and hydraulic connections	
2900	1,00 ST	Hydraulic connection for 210 bar With connection coupling for clamping the 2-spindle 2-axes rotary table	
3000	1,00 ST	Hydraulic connection for 210 bar 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	
3100	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	



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3200	1,00 ST	- Documentation -	
3300	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	
3400	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
3500		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°	
3600		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.	
3700		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.	
3800		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.	

