

**Data sheet I STAMA MC 326 TWIN no. 2041**

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON MC 326 TWIN no. 2041</b>  <b>Year of construction: 2001, weight: 5.600 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Traverse Ranges</b> Spindle distance A: 266 mm X axis 520 mm Y axis 300 mm Z axis 360 mm Feed Thrust: X-Y axis 4000 N Z axis 8000 N	
400	1,00 ST	<b>Traverse Rates - Axes Dynamic</b> Rapid traverse in X- Y- and Z- axes 60 m/min Feed rate X- Y- and Z- axes 1-10000 mm/min Axis dynamics: a max. (m/sec <sup>2</sup> ) X=5.0; Y=8.0; Z=12.0	
500	1,00 ST	<b>Swivel Table</b> Swivel drive pneumatically controlled. Pneumatically pull down in crown gear Clamping area 2 x 700 x 350 mm Distance table-spindle nose min./max. 200/560 mm Number and size of T-slots per clamping area: 2 x 14 H12 Number and diameter of location holes per clamping area: 4 x ø16 F7 Acceptable table load 2 x 450 kg Indexing time approx. 1,9 sec.	



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600	1,00 ST	<p><b>Spindle Units</b></p> <p>Tool holder HSK A 63            Draw bar pulling force 8000 N            Spindle diameter 65 mm            Spindle speed:            Standard 12.000 rpm            Incl. automatic blowing facility for process safety            taper cleaning during tool change.            retention force 18000 N            Special spindle bearing configuration.            Electronically balanced spindle.            Balancing after fitting to spindle head.</p>	
700	1,00 ST	<p><b>Performance Data 37 kW</b></p> <p>Torque constant up to 2500 rpm:            At 100% cont. duty 65 Nm; at 20% cont. duty 142 Nm            Driving power over 2500 rpm:            At 100% cont. duty 17 Kw; at 20% cont. duty 37 Kw</p>	
800	1,00 ST	<p><b>Tool Magazine</b></p> <p>Tool places standard 2 x 21            Tool diameter maximum:            all places used <math>\varnothing</math> 88 mm            with empty adjacent tool place <math>\varnothing</math> 125 mm (at 100 mm length)            Tool length max. 250 mm            Tool register HSK A63 DIN 69893            Tool weight max. 5 kg            Chip-to-chip time approx. 2,4 sec.</p>	
900	1,00 ST	<p><b>Tool data management OP 08T</b></p> <p>Menu guided tool data management.            To each tool are assigned direct:            8-digit tool ident. no.            For length and radius offsets            service life guideline            Data input:            At inserting station with input panel or            menu guided direct at the display of the control or            via interface of the tool presetting</p>	
1000	1,00 ST	<p><b>Measuring System</b></p> <p>X-Y-Z axis, digital pulse coder (Siemens absolut)            Absolute measuring value processing resolution 0.001 mm</p>	



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1100	1,00 ST	<b>Installation Data</b> Space required for machine approx. 7 m <sup>2</sup> Weight approx. 5.600 kg Control voltage 24 V DC Valve voltage 24 V DC Customers side requirement: Working voltage 3x400 V ±10%; 50Hz; N/PE. Connected rating machine 40 KVA Fuse before master switch 3 x 80 A Connected cross section 4 x 25 mm <sup>2</sup> Required air pressure min. 6 bar ISO 8573-1 Klasse 4 Necessary connection inner diameter Ø13mm	
1200	1,00 ST	<b>Guarding Equipment</b> Enclosure of working area	
1300	1,00 ST	<b>Axis movement with open safety door</b> If the safety door is open, axis movement and spindle rotation are just possible during setting mode. Speed of axis max. 2 m/min. Spindle RPM max. 800 1/min. Actuated by press-button and confirmation key.	
1400	1,00 ST	<b>Lamp in Working Area</b>	
1500	1,00 ST	<b>Coolant equipment with swarf Conveyor</b> Ejection height 850 mm on left side of MC. Integrated wedge wire sieve box, changeable, gap width: 350 µm. Tank for 300 l. External coolant supply integrated in spindle head with adjustable nozzles. If mainly cast iron or light metal has to be machined, additional coolant concentration units are necessary.	
1600	1,00 ST	<b>Wash gun</b> For manual cleaning of the loading area.	
1700	1,00 ST	<b>Additional Rinsing in 1 Loading Area</b> Additional coolant pipes for cleaning of clamping fixture and workpiece in 1 loading/unloading area. When actuated rinsing is done after each pallet change. Rinsing time is adjustable from 0-10 sec.	



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1800	1,00 ST	<p><b>Additional rinsing of Work area</b>            Additional rinsing pipe for rough cleaning of clamping-            fixture and workpiece .            Installed at working area with adjustable nozzles.            Controllable by M-function.</p>	
1900	1,00 ST	<p><b>Machine Supports without Coolant Tray</b>            for levelling and fixing the machine on the ground.            Including all mounting elements.</p>	
2000	1,00 ST	<p><b>Control Siemens 840D (POWER LINE)</b>            TFT Colour display 10,4", NCU 572.5, PCU 50            NCK user memory 768KB (approx.. 256 KB freely available)            Universal interface RS-232C (V24)            4 x USB, 2.0            2 x Ethernet °10/100 Mbit/s interface</p> <p>Max. 24-digit alphanumeric programmed names            Forming of sub-routines according to DIN or standard            Language and parameter max. nesting 7 times            3D-lin. interpolation G1 (max. 4 axes simultaneously)            Circular interpolation G2/G3, helical interpolation            Polar or Cartesian coordinates measuring system            49 zero point shifts direct by G-function            Inclusive of additive zero point shift            Turning of coordinates; Mirror; Scaling factor            Insertion of chamfer or radius            Siemens standard drilling and milling cycles            (additional G81 - G86 same as Siemens 840C)            Rigid tapping            32-digit alphanumeric tool identification            Tool data input by program or direct with input panel            at inserting station            Tool life monitoring wear or number of parts            Cutter radius compensation G41/G42 by calculation of            intersection points or transition radius            Restart of program            Prompt facility            Editing and programming during machining            Conversational programming according to DIN 66025            including graphical generating of contour            up to 3 axis.            Diagnostic displ. and operating feed back in clear text</p>	



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Pos.	Qty.	Description	Price
		Oriented spindle stop Measuring system: digital absolut incremental encoders Screen saver	
2100	1,00 ST	<b>Direct Measuring System X-Y-Z-Axis</b> Measurement to VDI/DGQ 3441	
2200	1,00 ST	<b>Coolant Filtration Paper</b> Inner rim filter, installed on additional 600 l coolant tank Compact construction, filter paper width 720 mm Middle filter mesh nominal < 50 microns. Filter performance 200 l/min - emulsion. With feed-back facility in the event of paper shortage. Paper transport actuated by level switch.	
2300	1,00 ST	<b>Internal Coolant through Spindles 70 bar</b> Internal coolant supply through work spindles for tool adaptors to DIN 69871 (ISO) form AD or B, or for tool adaptors to DIN 69893 (hollow taper shank) form A > 70 bar high-pressure pump for coolant (22 l/min.) > Incl. Vario valve, pressure is programmable in 7 steps by M-functions. (Applicable only in combination with coolant filtration system filter mesh 50 microns).	
2400	1,00 ST	<b>Hydraulic Basic Equipment</b> Necessary in case of hydraulically actuated clamping fixtures. Consisting of: > High pressure aggregate system pressure 250 bar. > 1 hydr. block for 1 circuit double action (2 controlled lines). The clamping line is equipped with a manual pressure adjustment 30-200 bar incl. pressure control (unclamping line 250 bar) Lines are installed up to machine table. > Electrical soft- and hardware. > Additional control panel added to main control panel with funct. clamping, control lamp clamping pressure reached and unclamp fixtures.	



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Pos.	Qty.	Description	Price
2500	2,00	<p><b>ST</b></p> <p><b>Hydraulic connection for 200 bar</b> with 2 connecting couplings A+B and hydraulic installation up to outside of machine bed, incl. valve to control 1 double acting clamping circuit with pressure switch for electrical clamping control and electrical control for clamping OPEN-CLOSED</p> <p>Remark: 2 x A + B Standard, 2 x A+B additional and x 2 A + B per table side Total: 4 x A + B</p>	
2600	1,00	<p><b>ST</b></p> <p><b>Additional Hydr. Circuit Double Action</b> Extension of hydraulic basic equipment by 1 circuit (2 controlled lines) with throttle check valve. Workmanship is the same as in the basic equipment.</p>	
2700	1,00	<p><b>ST</b></p> <p><b>STAMA Variable Clamping Logic</b> For the definition of different clamping and releasing sequences, for a maximum of 10 functions with a maximum of 8 steps. Considering of time delay and monitoring of clamping circuits e.g. through pressure switches or airsensing. The storing of the configuration and reloading, allows fast changeover.</p>	
2800	1,00	<p><b>ST</b></p> <p><b>Parts location air sensing</b> for rough sensing with energy-efficient pressure control by using 1 pressure switch, incl. pneumatic and electric installation Remarks: Maximum 3 nozzles per switch. Additional rotary feedthroughs may be necessary at rotary table and at standard fixture for rotary table Remark: 1 per table side</p>	
2900	1,00	<p><b>ST</b></p> <p><b>Distributor Swivel Table 10-fold</b> distributor for oil supply to clamping fixtures mounted on one or two sides of swivel table. Central space-saving installation in the middle of the swivel table. Supply through middle of swivel table. The oil-distributor is prepared for the additional supply to electrical units on the swivel table.</p>	
3000	1,00	<p><b>ST</b></p> <p><b>Automatic Loading Door</b> Automatic opening and closing of loading door/s. According to valid german safety regulations (UVV) and</p>	



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		electrically safeguarded.	
3100	1,00 ST	<b>Mini operating panel on the loading side</b>	
3200	1,00 ST	<b>Full Enclosure of Working Area</b> As protection against swarf and fumes the working area of the machine is completely closed. The drive units are placed outside of the capsule. A suction unit is recommended.	
3300	1,00 ST	<b>Preparation for suction unit</b> Preparation of machine for connection to customer's suction unit. 1 connection nozzle Ø 200 for 1 working area Incl. deflector in the working area	
3400	1,00 ST	<b>Signal Lamp 3 Colours</b> mounted on machine guard. red = machine stop yellow = advance warning green = Automatic cycle	
3500	1,00 ST	<b>Adapter for hand-wheel</b>	
3600	1,00 ST	<b>4. axis, ready for plug-in</b>	
3700	1,00 ST	<b>Interface automatic loading system (Profi-Bus)</b> The data transfer takes place over the profi bus system The interface includes a DP/DP coupler and two pcs. hardware connectors for potential free emergency stop and safety door signals	
3800	1,00 ST	<b>- Documentation -</b>	
3900	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	
4000	1,00 ST	<b>Machine colour</b> Standard painting: 3-coloured light grey/basalt grey RAL 7035/7012/4010 with telemagenta stripes	
4100		<b>Main circuit</b> 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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4200		<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>	
4300		<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.</p> <p>Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.</p>	
4400		<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>	

