

**Data sheet I STAMA MC 726 no. 1530**

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Partly refurbished vertical machining centre CHIRON MC 726 no. 1530</b>  <b>Year of construction: 2005, weight: 5.300 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Traverse Ranges</b> X-Axis 500 mm Y-Axis 380 mm Z-Axis 360 mm  Feed Thrust X-Y-Axis 4000 N Z-Axis 8000 N Incl. safety package with kevlar expansion bellow	
400	1,00 ST	<b>Traverse Rates</b> Rapid traverse X-Y- and Z-axis 60 m/min. Feed rate in X-Y- and Z-axis 1-10000 mm/min Axis dynamics: (m/sek <sup>2</sup> ) max. X=5; Y=8; Z=12	
500	1,00 ST	<b>Machine Base Frame</b> The welded base frame has an incorporated rotating and swivelling device which has been designed for the machining of components from bars up to a length of 800 mm in both the horizontal and vertical planes. Mounting area with hole patterns for additional fitting of tailstock or 6th side equipment	
600	1,00 ST	<b>Tilting table for main turn. spind.</b> Tilting table for main turning spindle. For turning and random machining of parts with highly sophisticated shapes and angles in 1 set up. With integrated spring clamped, hydraulically opened collet chuck. Hainbuch size 65. (collets and changing device for collet are not incl.) Inclusive required NC-axes in the control and direct measuring systems for the tilting and turning axes. Technical data: tilting equipment / rotary table tilting angle 120 degree / 360 degree accuracy tilting $\pm 8''$ , rotary $\pm 15''$ torque (tables locked) 2380 / 1400 Nm Length of bar max. 800 mm.	

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700	1,00 ST	<p><b>Main turning spindle 120Nm</b>            Speed range 1 - 4000 rpm.            Torque constant up to 4000 rpm:            At 100% continuous duty 48Nm; at 20% cont. duty 120Nm            Driving power at 4000 rpm:            At 100% cont. duty 20KW; at 20% cont. duty 50KW</p>	
800	1,00 ST	<p><b>Automatic Loading Magazine</b>            For automatically loading of bright round- and profile material in quality 11, straightness 0,4mm for 800mm length, clearance guide tube: 1mm on diameter.            Stock of material on incline plane at dia. 20mm            32 bars, at dia. 65mm 9 bars.            Unit is installed outside the machine.            Consisting of: - welded base frame            - loading device at adjustable incline plane, with control and decollate device.            - central adjusting of bar-diameter.</p>	
900	1,00 ST	<p><b>Workpiece Data/Workpiece Carrying-off</b>            Workpiece dia. max. 65 mm            Workpiece dia. min. 15 mm            Workpiece length max. 120 mm            Residue length max. 120 mm            Workpiece carrying-off of work area with integrated belt conveyor.            A cover is protecting the belt conveyor against swarf and emulsion.            Takeover of the workpiece at the end of the belt conveyor through the customer.</p>	
1000	1,00 ST	<p><b>Hydraulic Basic Equipment</b>            Including:            Hydraulic unit (100 bar) including hydraulic hardware for controlled actuation of component clamping in the rotating-/swivelling device and axes clamping.            Electrical software and equipment including pressure control.</p>	

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1100	1,00 ST	<b>Spindle Unit</b> Tool register HSK A63 DIN 69893 Retention force 20.000 N Spindle diameter 65 mm Spindle speed: Standard 15000 rpm Incl. safety window brand SEGE	
1200	1,00 ST	<b>Mainspindle Drive 37 KW - SIEMENS</b> Driving power over 2500 rpm: At 100% cont. duty 17 KW; at 20% cont. duty 37 KW Torque constant up to 2500 rpm: At 100% cont. duty 65 Nm; at 20% cont. duty 142Nm	
1300	1,00 ST	<b>Tool Magazine</b> Tool places 42 Tool diameter maximum: all places used $\varnothing$ 88 mm with empty adjacent tool place $\varnothing$ 125 mm (length 100 mm) Tool length max. 250 mm Tool register DIN 69893 HSK A63 Tool weight max. 5 kg Chip-to-chip time approx. 2,4 sec.	
1400	1,00 ST	<b>Inserting Station and Input Panel – OP10</b> Menu guided tool data management for loading of the magazine with turning and milling tools. To each tool are assigned direct: 32-digit tool ident. no. in numerical or alphanumerical format. Length and radius offsets, cutting edge directions Data input : At inserting station with guided control menue identical to the nc-control menue.	
1500	1,00 ST	<b>Direct Measuring System X-Y-Z-Axis</b> For all linear axes Measurement to VDI/DGQ 3441	

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1600	1,00 ST	<b>Installation Data</b> Space required for machine/equipment approx. 12 m2 Weight approx. 6800 kg Control voltage 24 V DC Valve voltage 24 V DC Installation conditions: Working voltage 3x400 V ±10%; 50Hz; N/PE. Connected rating machine 46 KVA Fuse before master switch 3 x 80 A Connected cross section 4 x 25 mm2 Required air pressure min. 6 bar Clean air conditions acc. to ISO 8573-1 class 4 Supply pipe inside dia. min. 13 mm.	
1700	1,00 ST	<b>Guarding Equipment</b> Enclosure of working area	
1800	1,00 ST	<b>Full Enclosure of Working Area</b> As protection against swarf and fumes A suction is recommended.	
1900	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.	
2000	1,00 ST	<b>Lamp in Working Area</b>	
2100	1,00 ST	<b>Permanent Lubrication low-Maintenance</b> All linear guides and ball screws are equipped with long-time lubrication systems. 3 years but max. 5000 working hours maintenance-free. After 5000 working hours the linear guides and ball screws must be lubricated.	
2200	2,00 ST	<b>Air-Conditioning of the Electrical-Cabinet</b>	
2300	1,00 ST	<b>Swarf Conveyor and Paperband Filtration</b> Link conveyor suitable for all kinds of material and swarf shapes. Ejection height 1200 mm on right side of MC. Tank for 200 l. External coolant supply integrated in spindle head with adjustable nozzles. Inner rack filter, build on additional coolant tank 600 l,	

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		compact design. filter paper, width 390 mm Filter performance 200 l/min - emulsion. Middle filter mesh nominal < 50 microns. With feed-back facility in the event of paper shortage. Suitable for all current materials.	
2400	1,00 ST	<b>Rinsing Pistol</b> for manual cleaning of the working area.	
2500	1,00 ST	<b>Machine Supports without Coolant Tray</b> for levelling and fixing the machine on the ground without coolant tray. Including all mounting elements.	
2600	1,00 ST	<b>Labeling of the Machine</b> The labels on the machine are in German.	
2700	1,00 ST	<b>Operating Menues of Control</b> The display of the menus as well as the error and operating messages are in German. The operating panel of the magazine loading station is in German.	
2800	1,00 ST	<b>Control Siemens 840D (POWER LINE)</b> > NCU 572.5 (at 2-C, NCU 573.5) NCK user memory 3MB > (1 MB free available; depending on the used options) > PCU 50.3, Operating system windows > Harddisk, free memory for programs, 10GB > USB 2.0 - interface and USB-Stick 1GB > Analysis tools for Service, Ethernet-card is included > USB 2.0 - connection for: mouse, keyboard > MPI > Additional free slots: 2x PCI, 1x CF-Card Screen size: Colour display 10,4" - System x26, x31, 332, x33, x34, x36 Colour display 12" - System MT 726 2-C Colour display 15" - System x32 (exclude 332), 533, x37, x38 , and MT 724 2C Max. 24-digit alphanumeric programme 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) Machines with tilting and swivel tables max. 5 axis simultaneously. Circular interpolation G2/G3, helical interpolation Polar or Cartesian coordinates measuring system	

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		<p>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 programme 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 programme            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            Oriented spindle stop            Measuring system: digital absolut incremental encoders            Screen saver</p>	
2900	1,00 ST	<p><b>STAMA warm-up</b>            Definable point in time at which the machine starts demand-oriented            automatically with a variable warmup programm to recovery the production            readiness.</p>	

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3000	1,00 ST	<p><b>External Set-Up Magazine</b>            ESUM for 90 tools in taper ISO 40, hollow taper shank A63 at 2 levels. Tool length 300mm.            Tool dia. 70 mm - in case of free places 155mm. Tool weight 12 kg. Tool change set up magazine to machine magazine. Level 1 approx. 15sec, level 2 approx. 17sec. The magazine is a rotary magazine with 2 plates (each 45tool places).The loading resp.tool change is made by a linear gripper with Z-stroke.The MC is getting a fixed position and is taking the tools from the additional magazine into the tool magazine of the MC during the workpart change over is happening in the working area. For storage in the external magazine in there must be empty place. Z-/Y-Axis incl. easy lub. Remark: Tool-diam &amp; -length must be considered in the Basic-MC. Includes in combination with NC-Control 840D, 210 tools can be save in the tool list.</p>	
3100	1,00 ST	<p><b>Pressure Air at Spindle 6 bar</b>            Optional pressure air 6 bar or through internal coolant line/s of spindle head.            Programmable by M- function.  <b>For the external coolant line (ball nozzles)</b></p>	
3200	1,00 ST	<p><b>Immersible recooling system</b>            Compressor-recooling system for coolant emulsion or cutting oil. Air-cooled. Cooling power 34 MJ (8200 Kcal, 9.5 KW*h). Refrigerant FCKW-free.            Installed in 900 l. coolant tank.            Incl. control system.</p>	
3300	1,00 ST	<p><b>Internal Coolant through Spindle 70 bar</b>            Internal coolant supply through work spindle for tool adaptors to DIN 69871 (SK), Form AD or Form B, for tool adaptors to DIN 69893 (hollow taper shank) form A.            Consisting of:            &gt; 70 bar Bosch-high-pressure pump for coolant (17 l/min)            &gt; Incl. Vario valve, pressure is programmable in 7 steps by M-functions.            (Applicable only in combination with coolant filtration system filter mesh 50 microns).</p>	

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3400	1,00 ST	<p><b>Counter-Spindle for 6<sup>th</sup> side 100 Nm</b>            3 NC axis, turning spindle            Linear and swivel unit 120 degrees NC-controlled for machining in the angle range minus 30 up to plus 90. Swivel axis. for inclusion by means of a stretched spring and hydraulic solved special clamping system through centring mount - similar to DIN 6353 ZA140.            For clamping / workpiece transfer after the 5th side machining.            Stroke linear device = 190 mm.            Workpiece specified clamping equipment's are not incl.            Integrated NC controlled turning spindle            Spindle data: 4500 RPM; max 37,5 KW; max. 100 Nm.            Draw bar pull: min. 10,4 kN (12 Bar); max. 40 kN (50 bar)</p>	
3500	1,00 ST	<p><b>2-Jaw Chuck for turning spindle 100Nm</b>            Chuck diameter 165 mm            Power chucks operated by tow bar of the turning spindle 100 Nm            6<sup>th</sup> side clamping system adjustable.            Mounting diameter of the turning spindle 140h5.            Tow bar: connection thread M54x1,5. Stroke per jaw 3,7mm            Thread adapter tow bar incl.</p>	
3600	1,00 ST	<p><b>Measuring device TS27R for MT-Series</b>            Probesystem Renishaw TS27R with adaptor plate, mounted in the working room without cover hood.            Build on the machining range of the spindle.            Measuring cycles for breakage control as well as for measuring of tool length and radius,            incl. turning tools at the MT-series.            Not possible is to measure diverent lenght-offsets at stepped tools or special cutting tools.</p>	
3700	1,00 ST	<p><b>Software Thermal Compensation 3-D Probe</b>            For linear axis X-Y-Z a correction value is determined by the stat.3D probe. After measurement the zero point offsets corrected by this value. Measurement is realized at machine start and after longer standstill (adjustable). During production measuring will be executed by intervalls, which are adjustable.            Precondition is the Probesystem VS_2700.0040 or VS_3000.0523.</p>	



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3800	1,00 ST	<b>Rotating Window</b> Permits viewing into the working area during machining with coolant.	
3900	1,00 ST	<b>Signal lamp 3-colour</b> mounted on the machine cover red = Stopped yellow = Warning green = Automatic cycle green blinking = automatic mode, program doesn't run	
4000	1,00 ST	- <b>Documentation</b> -	
4100	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	
4200	1,00 ST	<b>Machine colour</b> Standard painting: 3-coloured light grey/basalt grey RAL 7035/7012/4010 with telemagenta stripes  <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°	