

Pos.	Qty.	Article Description	Price / €
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## Data sheet | FZ 08 W no. 204-02

1	1	<b>Completely refurbished vertical CNC-machining centre model CHIRON FZ 08 W Year of construction: 2001, weight: 2.200 kg  Machine-No. 204-02</b>	
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Machine image similar.  
The equipment of the sample photo isn't binding.

GB | Data sheet | ref 204-02.docx

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Geschäftsführer:  
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<b>Data sheet   FZ 08 W no. 204-02</b>			
Scope of delivery:			
100	1	<b>Column moving machining centre</b> with workpiece swivel table	
200	1	<b>Main spindle drive with AC-motor</b> 2,2 kW at 100% 7,4 kW at 25% Spindle speed range: 20 – 15.000 rpm – 23 Nm  Drilling capacity Ø 16 mm Tapping capacity M 12 Milling capacity 20 cm <sup>3</sup> /min	
300	1	<b>Travel:</b> X-axis 300 mm Y-axis 250 mm Z-axis 250 mm	
400	1	<b>Automatic tool changer</b> as chain magazine (without basket changer) full enclosed pick up tool changer Tool places 23 Tool shaft HSK 32 DIN 69893 Tool-Ø max. 40 mm ( 50 mm at free neighbour places) Tool length 160 mm Tool weight max. 0,7 kg Tool change time approx. 0,6 s (depends on CNC) Chip-to-chip-time approx. 1,9 s (depends on CNC)	
500	1	<b>Work piece changer 0/180 degrees</b> With centre divider made from stainless steel Clamping surface 2 x 550 x 300 mm <sup>2</sup> with thread and locating hole grids M 16 x Ø 15 H7 x 50 mm Table loading capacity per side max. 100 kg	
600	1	<b>AC-servo-motors Feed drives for X-, Y- and Z-axis</b> Indirect absolute path measuring system Rapid traverse in X- and Y-axis: 40 m/min, acceleration 0,7g Rapid traverse in Z-axis: 60 m/min, acceleration 1,0g	



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<b>Data sheet   FZ 08 W no. 204-02</b>			
700	1	<b>Fanuc 18 i – 3 axes continuous path control</b> 9,5" LCD monochrom screen Memory capacity 64 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 64 tool offsets cutter radius – contour compensation 6 zero shifts G54-G59 metric/inch switch 3D-Interpolation/helical interpolation Direct spindle speed programming Rigid tapping Orientated spindle stop Tape puncher / reader connection RS 232 C Software-limitswitch NC-diagnosis / machine diagnosis	
800	1	<b>Portable handwheel</b>	
900	1	<b>Working hours and piece counter</b> in the screen	
1000	1	<b>Socket 230 V</b> at control panel	
1100	1	<b>Machine enclosure</b> bolted on, with loading door, electrically interlocked, 2.000 mm high above floor, incl. machine lamp	
1200	1	<b>Installation elements</b>	
1300	1	<b>Wash gun</b>	
1400	1	<b>Machine preparation</b> for through tool coolant system including - Sealing system in the HSK-A32 collet - 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	



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1300	1	<b>Chip conveyor (scratch band)</b> discharge height with coolant equipment 495 mm tank capacity 150 ltr. pump capacity 100 ltr./min. at 1,3 bar	
1400	1	<b>High pressure pump</b> used together with the standard coolant unit or the chip conveyor as an inline pump incl. Flow switch  Pressure max. 150 bar Pump capacity max. 6 l/min. Vario valve 20, 30, 50, 70, 90, 110, 130, 150 bar Partical coolant cleaning system 60µ via twin filter Flow controller	
1500	2	<b>NC Rotary table, completely installed consisting of:</b> - NC rotary tables, type AWU P 100 mountable to the workpiece swivel table - 4th and 5th NC-axes, complete - lowest increment 0,001° - pneumatic supply, without control  Technical description NC rotary table indexing accuracy ± 30", max. spindle speed 80 rpm spindle pneumatic clamped, center height 125 mm face plate dia. 100 mm, center bore dia. 50+0,012, through bore dia. 35 mm, location pin dia. 10h7, 4 bolt holes M8	
1600	2	<b>CHIRON standard fixture for rotary table</b> existing of: - base plate for AWU P 100 and counter bearing - counter bearing with pneumatic clamping - flange plate incl. connecting coupling, on side of the rotary table - flange plate incl. connecting coupling, on side of the counter bearing - 2 x 1-core energy supply pneumatic - center height 125 mm	
1700	1	<b>Loading door of total enclosure</b> opening and closing automatically incl. two-hand-push-buttons	
1800	1	<b>Cabinet cooler as door mounting unit</b>	
1900	1	<b>Thermocontrol</b>	



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2000	1	<b>Exhaust fan with air cleaner</b> exhaust capacity 500 m <sup>3</sup> /h fitted and integrated in the chassis	
2100	1	<b>Glass scales</b> Heidenhain, overpressured in all axes X, Y, Z = 300 x 250 x 250 mm	
2200	1	<b>Pneumatic connection</b> without control and 2 connections couplings	

### Documentation

Operating manuals, programming and operating manuals 1-fold on a USB-Stick.  
Please refer to the manufacturer's instructions for each component.

### 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°

