

**Data sheet I CHIRON FZ 18 W no. 158-52**

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON FZ 18 W no. 158-52</b>  <b>Year of construction: 2001, weight: 9.100 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre with workpiece swivel table</b> Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
400	1,00 ST	<b>Machine enclosure</b> with sliding doors, electrically interlocked, 2400 mm high above floor, incl. machine lamp service friendly with removable side walls vertical bellows	
500	1,00 ST	<b>Integrated Workpiece swivel table IWW 0/180 degrees</b> With gaps underneath the trunnion fixture for optimal chip drop, with center divider workpiece swivel time appr. 2,4 s weight-dependent, self-regulating through self-learning speed-control table loading capacity per side 0 - max. 300 kg, Per table side integrates: <ul style="list-style-type: none"> <li>- NC-rotary-table, type AWU 160 P with pneumatic clamping                accuracy <math>\pm 15''</math>, face plate dia. 160 mm,                with center bore dia. 50 +0.012 mm, fixture pin dia. 16 h7,                4 fixture bores M10,</li> <li>- <b>CHIRON standard fixture for rotary table</b>                bridge size 620 mm                counter bearing with pneumatic clamping                flange plate incl. connecting couplings and quick-locator,                on side of the rotary table                flange plate incl. connecting couplings and quick-locator,                on side of the counter bearing                2 x 1-core energy supply</li> <li>- centre height 165 mm over base plate</li> <li>- total height of the basic device                "top edge till the middle of the rotary axis" 197 mm <math>\pm 0,02</math> mm</li> <li>- set zero point to the middle of the rotary table in Y-axis to 220 mm</li> <li>- pneumatic supply without control</li> <li>- 4.or 5. NC-axis, ready for plug-in</li> </ul>	





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		<p>re-start into program  Subroutines, parameter programming  simultaneous programming  contour programming with cycle support  support through cycles  polar coordinates  tool offsets for geometry, wear  tool radius correction for  intersection computing  crossing radius  4 zero offsets G54-G57  30 zero shifts programmable with G-functions  3D and helical interpolation  screen switch off  mirror function  scaling function  insert of chamfer and radius  USB-Interface at the control panel  orientated spindle stop  dimension metric or inch  software limits witch  NC-diagnosis  machine-diagnosis  absolute indirect path measurement systems  power meter in screen, rigid tapping, look ahead function</p>	
1200	1,00 ST	<p><b>CHIRON Powersafe</b>  Software package for selective shutdown of installed consumers like axis motors, drives, spindles, seal air, airsensing and ancillary equipment in production breaks or during programmable points in time using a shift calendar.  Definable point in time at which the machine starts demand-oriented automatically with a variable warmup programm to recovery the production readiness.</p>	
1300	1,00 ST	<p><b>Working hours and piece counter</b>  in the screen</p>	
1400	1,00 ST	<p><b>Socket 230 V</b>  <b>at control panel</b></p>	
1500	1,00 ST	<p><b>Cabinet cooler as a door mounting unit</b></p>	
1600	1,00 ST	<p><b>Installation elements</b></p>	



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1700	1,00 ST	<b>Screw conveyor</b> implemented in machine base for swarf extraction	
1800	1,00 ST	<b>Chip conveyor (scratch belt)</b> discharge height 1050 mm, discharge behind, tank capacity 400 l, lifting pump max. 150 l/min at 2,0 bar incl. tube flushing	
1900	1,00 ST	<b>Fully enclosed working area</b>	
2000	1,00 ST	<b>Coolant equipment</b> (also for sludge generating materials, i.e. grey cast iron, GGG, Al with Si $\geq$ 12%) tank capacity 1000 l low pressure pump capacity from 100 l/min at 2 bar high pressure pump capacity 20 l/min at 30 bar partly stream purification with turbo filter with coolant purification 50 $\mu$ m nominal twin filter in the high pressure circuit for the protection of the machine with sludge remover	
2100	1,00 ST	<b>Machine preparation</b> for through tool coolant system including: - Sealing system in the DIN 69893 HSK A63 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	
2200	1,00 ST	- <b>Documentation</b> -	
2300	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	
2400	1,00 ST	<b>Machine colour</b> Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
2500		<b>Main circuit</b> total power supply 400 / 230V $\pm$ 10 %, 50 cycles N/PE, neutral conductor, load possible, pressure supply 6 bar, $\pm$ 1 bar at all procedures, room temperature max 40°	



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2600		<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>	
2700		<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>	
2800		<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>	

