

Data sheet I CHIRON FZ 18 KW no. 196-58

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON FZ 18 KW no. 196-58 Year of construction: 2001, weight: 8.000 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with workpiece swivel table Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
400	1,00 ST	Machine enclosure 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	Workpiece swivel table 0/180 degrees with centre divider made of sheet metal clamping surface 2 x 940 mm x 470 mm with thread and locating hole grid M16 x ø 15 H7 x 50 mm workpiece swivel time appr. 4,0 s weight-dependent, self-regulating through self-learning speed-control table loading capacity per side 0 - max. 400 kg	
600	1,00 ST	Mini-operating panel with start and receipt push buttons, for pallet recognition M61/M62	
700	1,00 ST	Travel: X-axis 630 mm Y-axis 400 mm Z-axis 630 mm (with variable tool change level)	
800	1,00 ST	Main spindle drive with AC-motor 10,0 kW at 100 % 18,0 kW at 25 % Spindle speed range: 20 - 10.500 min ⁻¹ - 140 Nm Drilling capacity in steel 60 ø 42 mm (with insert drill) Tapping capacity M 30 Milling capacity in steel 60 500 cm ³ /min.	



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900	1,00 ST	Automatic Pick up tool changer Tool places 40 Tool shaft SK 40 DIN 69871+72 Tool-Ø max. 78 mm Tool-Ø if adjacent places are free max. 160 mm Max. tool length 280 mm Max. tool weight max. 5 kg (8 kg) Tool change time approx. 1,0 s (depends on CNC) Chip-to-chip-time approx. 2,9 s (depends on CNC)	
1000	1,00 ST	AC-servo motors for x-, y- and z-axes digital direct drives with indirect absolute path measuring system rapid traverse in all axes 40 m/min. acceleration: 0,5 g in X and Yaxis 0,7 g in Z axis	
1100	1,00 ST	SIEMENS CNC-control 840D (MMC 100.2 / NCU 572.2, 6 measuring circuits, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP032S NC-memory 256 KB (max.200 programmes storage capacity) for ISO 66025 programming drilling cycles G81-G89 drilling and milling cycles M- and T- functions circular interpolation (360 degrees) re-start into program Subroutines, parameter programming simultaneous programming contour programming with cycle support polar coordinates tool offsets for geometry, wear tool radius correction for intersection computing crossingradius 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 Universal interface RS 232C (2 x V24) orientated spindlestop	



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Pos.	Qty.	Description	Price
		drip feed function through V24 interface dimension metric or inch software limitswitch NC-diagnosis machine-diagnosis absolute indirect path measurement systems powermeter in screen rigid tapping look ahead function	
1200	1,00 ST	CMS Powersafe Software package for selective shutdown of installed consumers such as axis motors, drives, spindles, coolant-pumps and auxiliary equipment during production breaks. Definable point in time at which the machine goes demand-oriented automatically into it's Power Safe mode.	
1300	1,00 ST	Working hours and piece counter in the screen	
1400	1,00 ST	Socket 230 V at control panel	
1500	1,00 ST	Cabinet cooler as a door mounting unit	
1600	1,00 ST	Installation elements	
1700	1,00 ST	Chip conveyor (scratch band) discharge height 1050 mm with coolant equipment, tank capacity 400 ltr., pump capacity 150 ltr/min at 2,0 bar incl. tub flushing	
1800	1,00 ST	Wash gun	
1900	1,00 ST	Automatic loading door of total enclosure opening and closing, actuating to closing via two-hand push buttons	
2000	1,00 ST	Fully enclosed working area	
2100	1,00 ST	Coolant equipment tank capacity 800 l, pump capacity from 200 l/min at 2,5 bar (the pump in the chip conveyor will becomes a lifting pump) high pressure pump capacity 20 l/min at 30 bar high pressure circuit with coolant filtration 60 µm incl. tub flushing	



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2200	2,00 ST	<p>Machine preparation for through tool coolant system including:</p> <ul style="list-style-type: none"> - Sealing system in the DIN 69871 Form A40 or 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 	
2300	2,00 ST	<p>Rotary table package, completely installed consisting of:</p> <ul style="list-style-type: none"> - NC rotary tables, type RT 160, CHIRON-PEISELER - 4th and 5th NC-axis, ready for plug-in - Central pneumatic-connection, uncontrolled <p>Technical description NC rotary table Center height 165 mm, indexing accuracy $\pm 15''$ face plate dia. 160 mm, with center hole $\varnothing 50 +0,012$ fixture pin dia. 16 h7, 4 fixture bores M10 incl. pneumatic clamping</p>	
2400	1,00 ST	<p>Exhaust fan with air cleaner exhaust capacity 1.000 m³/h</p>	
2500	1,00 ST	<p>Automatic central grease lubrication</p>	
2600	1,00 ST	<p>Thermocontrol</p>	
2700	1,00 ST	<p>Glass scales maker HEIDENHAIN, overpressured in all axes X, Y, Z = 630 x 400 x 630 mm</p>	
2800	1,00 ST	<p>Coolant supply for fixture washing in the work-piece-swivel area, with 1 magnetic valve and one coupling in the working area</p>	
2900	1,00 ST	<p>Pneumatic- and Hydraulic Connections</p>	
3000	1,00 ST	<p>Central hydraulic and pneumatic supply with 10-core turning supply including connecting couplings, thereof 8 connections for hydraulic, max. 210 bar and 2 connections for uncontrolled pneumatic</p>	



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3100	1,00 ST	Hydraulic unit HEILMEIER & WEINLEIN pressure: 210 bar supply capacity: 6 l/min. incl. valves for supply of 2 clamping devices and 2 pressure switches for clamping control 2 x A/B per tableside	
3200	1,00 ST	CMS variable clamping logic To define of various clamping and releasing consequences per tableside max. 5 clamping circuits and max. 5 clamping or unclamping steps, taking account of delay times and clamping circuit monitoring such as pressure switches.	
3300	1,00 ST	- Documentation -	
3400	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	
3500	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
3600		Transport insurance to be covered by customer	
3700		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°	
3800		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.	



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3900		<p>Information Machine safety</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>	
4000		<p>Information Coolant lubrication</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>	

