

Data sheet I CHIRON FZ 12 WM no. 260-66

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON DZ 12 WM no. 260-66 Year of construction: 2005, weight: 4.000 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Type 12 Processing medium cooling lubricant	
400	1,00 ST	Column moving machining centre with workpiece changing table	
500	1,00 ST	Machine enclosure 1800 mm high above floor, with sliding doors, electrically interlocked, with transponder-coded safety switch. Suitable for loading by crane, incl. machine lamp	
600	1,00 ST	Travel: X-axis 550 mm Y-axis 300 mm Z-axis 425 mm mit variable Werkzeugwechselebene	
700	1,00 ST	Main Spindle drive with AC-motor 5,0 KW at 100 % 9,5 KW at 25 % Spindle speed range: 20 – 10.500 rpm - max. 60 Nm Drilling capacity in St 60 Ø 25 mm Tapping capacity M 20 Milling capacity in St 60 150 cm ³ /min	
800	1,00 ST	Workpiece swivel table 0/180 degrees clamping surface 2 x 660 mm x 350 mm ² with thread and locating hole grids M 16 x Ø 15 H7 x 50 mm workpiece swivel time approx. 2,9 s table loading capacity per side max. 100 kg (150 kg) max. 100 kg weight difference between both tables	
900	1,00 ST	Automatic tool changer Tool places 20 Tool shaft SK 40 DIN 69871+72 Tool-Ø max. 65 mm Tool-Ø if adjacent places are free max. 150 mm Tool weight max. 2,5 kg (5,0 kg on 4 places) Tool change time approx. 0,9 s (depends on CNC) Chip-to-chip-time approx. 2,4 s (depends on CNC)	



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1000	1,00 ST	AC-servo motors for X-, Y- and Z-axes with indirect absolute path measuring system rapid traverse in all axes 40 m/min.	
1100	1,00 ST	Sinamics drives	
1200	1,00 ST	SIEMENS CNC-control 840D Solution Line (TCU / NCU 710.3, 6 measuring circuits, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP010S operator panel logic NC-memory 3 MB Standard (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 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 Universal interface RS 232C (2 x V24) orientated spindle stop drip feed function through V24 interface dimension metric or inch software limits witch NC-diagnosis machine-diagnosis absolute indirect path measurement systems power meter in screen	



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		rigid tapping look ahead function	
1300	1,00 ST	CHIRON Powersafe 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.	
1400	1,00 ST	Operating hours and piece counter on the screen	
1500	1,00 ST	Full enclosure with suction point, with supplementary machine lamp, servicedoors, drop channel at loading area An exhaust fan is required by using a full enclosure!	
1600	1,00 ST	Socket 230 V at control panel	
1700	1,00 ST	Socket for portable mini-hand wheel without emergency stop button, at control panel	
1800	1,00 ST	Wash gun	
1900	1,00 ST	Installation elements	
2000	1,00 ST	Chip conveyor (scratch band) 340 K-1/150 discharge height 850 mm, tank capacity 150 l	
2100	1,00 ST	Kühlmittelanlage KF 150 / FKA 500 (auch für schlammbildende Werkstoffe z.B. Grauguss, GGG, Al mit Si \geq 12%) Behälterinhalt 500 l ND-Pumpe 80 l/min. bei 3,0 bar bis 100 l/min bei 1,8 bar HD-Pumpe 20 l/min bei 30 bar Vollstromreinigung über Kompaktpapierbandfilter KF 150 mit Kühlmittelreinigung 50 μ m nominal Doppelschaltfilter im HD-Kreis zum Schutz der Maschine	



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2200	1,00 ST	70 bar high pressure pump Flow rate 20 l/min at 30 bar – 11 l/min at 70 bar Vario pressure relief valve for 8 programmable pressure stages pre-defined pressure stages (20, 30, 40, 50, 55, 60, 65, 70 bar) Instead of standard high pressure pompe	
2300	1,00 ST	Automatically central grease lubrication	
2400	1,00 ST	Machine preparation for inside tool cooling through spindle, acc. to DIN 69871 Form A incl. elevation of the machine enclosure from 1800 mm to 2200 mm	
2500	1,00 ST	- Pneumatic and hydraulic connections-	
2600	1,00 ST	Hydraulic connection for 210 bar with rotation distributor 6-fold and 4 connecting couplings for hydraulic, 2 connecting couplings for pneumatic, without control, installation up to the outside of machine bed, with electrical control for clamping ON - OFF via push button at control panel	
2700	1,00 ST	Hydraulic unit continuous duty at switch cycles less than 30 seconds pressure: 210 bar, flow rate: 4,3 l/min. incl. valves for supply of 2 clamping circuits and 2 pressure switches for electric clamping control	
2800	1,00 ST	- Documentation -	
2900	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	
3000	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	



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3100		<p>Main circuit</p> <p>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°</p>	
3200		<p>Information Export</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>	
3300		<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>	
3400		<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>	

