

Data sheet I CHIRON MILL 2000 no. 245-24

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON MILL 2000 no. 245-24 Year of construction: 2002, weight: 10.000 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with fixed table Machine substructure with chip discharge left Guideways with long-term lubrication Drilling capacity in steel 60 \varnothing 42 mm (with insert drill) Tapping capacity M 30 Milling capacity in steel 60 600 cm ³ /min.	
400	1,00 ST	Machine enclosure with loading door, electrically interlocked, suitable for loading by crane 2.500 mm high above floor, incl. machine lamp	
500	1,00 ST	NC swivel head Motor spindle for swivel head 12,5 kW at 100 % ED 34,0 kW at 10 % ED, watercooled Spindle speed 20 - 12.000 rpm, 140 Nm acceleration and deceleration 0 - 12.000 rpm – each 0,9 seconds tool clamping with disk springs, hydraulic knock out, tool shaft for HSK-A 63 DIN 69893 NC swivel axis \pm 100 ° - 30 rpm, lowest increment 0,001° - repetition accuracy \pm 10" with direct measuring system - driving torque 280 Nm - with hydraulic clamping system - max. torque through clamping 1400 Nm Hydraulic unit for continuous duty at switch cycles less than 30 seconds pressure: 170 bar, flow rate: 11,3 l/min. incl. valves for supply and pressure stage for clamping of swivel head and automatic knock out of tool	

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		flood coolant, pump capacity 20 l/min at 11 bar	
		notice: 5-axes-transformation with tool orientation and tool center point management	
600	1,00 ST	Travel: X-axis 2000 mm Y-axis 610 mm Z-axis horizontal spindle 715 mm / vertical spindle 630 mm	
700	1,00 ST	Automatic tool changer, protected against chips No. of tools 40 Tool shaft HSK A-63 DIN 69893 tool dia.max. 75 mm tool dia. if adjacent places are free max. 125 mm Max. tool lengthmax. 280 mm Max. tool weight 3 kg (max. 8 kg) Tool change time approx. 1,5 s (depends on CNC) Chip-to-chip-time approx. 5,0 s (depends on CNC)	
800	1,00 ST	Fixed table with chip pan clamping surface 2600 x 710 mm ² with 5 T-slots 4 x 18 H12, 1 x 18 H8	
900	1,00 ST	AC-servo motors for x-, y- and z-axes digital direct drives with indirect absolute path measuring system (no time-consuming reference) rapid traverse in all axes 40 m/min.	
1000	1,00 ST	SIEMENS CNC-control 840D (PCU 50 / NCU 572.3, 6 measuring circuits, 1 canal) incl. 10,4" TFT colour LCD screen / full keyboard OP010S incl. network card, control panel logic Windows NT hard disk. Approx. 2 GB programs storage for free disposal NC-memory 1,5 MB (max.200 programs storage capacity) for ISO 66025 programming hard disk with approx. 2 GB for free disposal drilling cycles G81-G89 drilling and milling cycles M- and T- functions circular interpolation (360 degrees) re-start into program	

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		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 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) at control panel Ethernet connection RJ45 in control panel orientated spindlestop 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	
1100	1,00 ST	Preparation for portable mini-handwheel without emergency stop button, for conventional travel	
1200	1,00 ST	Working hours and piece counter in the screen	
1300	1,00 ST	Socket 230 V at control panel	
1400	1,00 ST	Cabinet cooler as a door mounting unit	
1500	1,00 ST	Installation elements	

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1600	1,00 ST	<p>Production package with HP pump (HSK A63) consisting of:</p> <ul style="list-style-type: none"> - Chip conveyor (scratch band) instead of coolant equipment with chip container discharge height 1.050 mm, discharge to the left, tank capacity 200 ltr., lift pump with 200 ltr./min. at 1,5 bar, incl. bed flushing system - Coolant equipment (for cast iron slurry, Al with Si \geq 12%) tank capacity 900 ltr., pump capacity 200 ltr./min. at 2,0 bar (the pump in the coolant tank from the basic machine becomes the lift pump) high pressure pump, pump capacity 20 ltr./min at 30 bar, coolant filtration for high pressure cycles via paper bond filter PF 50 and double acting filter incl. tube flushing - 70 bar high pressure pump flow rate 20 l/min at 30 bar - 11 l/min at 70 bar with vario pressure control valve for 8 programmable pressure stages pre-defined pressure steps 20, 30, 40, 50, 55, 60, 65, 70 bar instead of standard high pressure pump 	
1700	1,00 ST	Automatic grease lubrication	
1800	1,00 ST	<p>Machine preparation for through tool coolant system including:</p> <ul style="list-style-type: none"> - 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 <p>We recommend for tool holders the use of our patented coolant tube with sieve.</p> <p>Advantages:</p> <ul style="list-style-type: none"> - Decrease of the clogging in the internal coolant channel. - Reduction of the wear at the O-ring seal in the collet. <p>(This filtration method will not eliminate increasing cast iron slurry from the coolant equipment.)</p>	
1900	2,00 ST	Wash gun	

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2000	1,00 ST	Centre divider with mechanically activated door. Position closed, checked electrically. Shuttle machining Standard 2 x 750. Shuttle machining swivel head 2 x 765 (swivel head only in 0° - position) incl. machining area recognition M61/M62 and start and receipt push buttons, mounted on both sides. Quick removable because of pluggable connections and screwed bolts.	
2100	1,00 ST	4. Axis ready for plug-in	
2200	2,00 ST	Suction points for customer specific installation with 1 connection Ø 200 mm each on left and right hand side and top of the machine enclosure and electrical preparation in cabinet	
2300	1,00 ST	Portable mini-hand wheel for conventional travel, without emergency stop button, including connecting cable 900 mm. (This way the emergency stop button at the control panel is within the reach of the operator.)	
2400	1,00 ST	Cutting tools The cutting tools have to be balanced according to DIN ISO 1940, class G 2,5, in two levels, with max. operating speed	
2500	1,00 ST	- Documentation -	
2600	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	
2700	1,00 ST	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°	