

Data sheet I CHIRON FZ 08 KSM no. 415-15

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON FZ 08 KSM no. 414-15 Year of construction: 2004, weight: 3.400 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with fixed table Guideways with long-term-grease lubrication	
400	1,00 ST	Machine enclosure with full enclosed workspace with loading doors, electrically interlocked, including replaceable safety windows, workspace enclosure with stainless steel covers, 2070 mm high above floor, including machine lamp	
500	1,00 ST	Digital main drive with water-cooled motor spindle with air purge and monitoring of the tool clamping 7 kW at 100 % 9 kW at 25 % spindle speed range up to 30.000 rpm; 11 Nm acceleration from 0 to 30.000 rpm or deceleration in 1,9 seconds Drilling capacity in steel Ø 12 mm Tapping capacity M 8 Milling capacity in steel 30 cm ³	
600	1,00 ST	NC swivel head swivel range -20° / +115° rapid traverse 60 rpm lowest increment 0,0001° with direct measuring system ± 5"	
700	1,00 ST	Travel: X-axis 450 mm Y-axis 270 mm Z-axis 310 mm (plus distance from spindle nose to table surface, according to data sheet)	



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800	1,00 ST	<p>Automatic tool changer trough robust, fully enclosed Pick-up magazine chain with mechanical tailgate protection and cone cleaning.</p> <p>No. of tools 40 Tool shaft HSK-A 40 DIN 69893 Max. tool dia. 50 mm Max. tool dia. 100 mm if adjacent places are free Tool length 160 mm Max. tool weight max. 1,2 kg (max. magazine loading 20 kg) Tool change time appr. 0,8 s Chip-to-chip-time appr. 1,9 s Chip-to-chip-time with 90° appr. 2,3 s</p>	
900	1,00 ST	<p>AC-servo-motors feed drives for X-, Y- and Z-axes with glass scale package, digital direct drives with direct absolute path measuring system overpressured in all axes rapid traverse in X-, Y- and Z-axes 75 m/min, acceleration X-axis 1 g, Y-axis 1,5 g, Z-axis 2 g</p> <p>Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)</p>	
1000	1,00 ST	<p>SIEMENS CNC-control 840D (PCU 70 / NCU 573.5, 6 measuring cycles, 1 canal) incl. 10,4" TFT colour LCD screen / full keyboard OP010S control panel logic Windows XP NC-memory 2,0 MB (max.200 programmes storage capacity) for ISO 66025 programming hard disk with approx. 2 GB for free disposal power meter in screen screen switch off look ahead function with dynamic pilot control bellshape acceleration ramp software limit switch access authorization via key switch for tool corrections, CNC-program modification, and machine parameter orientated spindle stop rigid tapping re-start into program Subroutines, parameter programming</p>	



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		<p>simultaneous programming support through cycles drilling cycles G81-G89 drilling and milling cycles M- and T- functions tool offsets for geometry, wear 4 zero offsets G54-G57 30 zero shifts programmable with G-functions tool radius correction for intersection computing insert of chamfer and radius crossing radius contour programming dimension metric or inch scaling function mirror function polar coordinates circular interpolation (360 degrees) 3D and helical interpolation drip feed function through V24 interface Universal interface RS 232C (1x V24) at control panel Ethernet connection RJ45 in control panel NC-diagnosis with help function machine-diagnosis</p> <p>Spline Interpolation</p> <p>SINDNC Option to send and receive NC-programs in a network. The client-software (e. g. UNIX, Novell, Windows NT) and the wiring to the network is not included.</p>	
1100	1,00 ST	<p>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.</p>	



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1200	1,00 ST	5-axes-machining for the machining of three-dimensional curved or tilted surfaces with 3 linear and 2 additional axes (TRAORI & CYCLE 800), incl. compressor CompCAD. - 5-axes-transformation with tool orientation and tool center point management. The machining task is programmed completely in Cartesian coordinates with Cartesian position and orientation. The movements of all 5 axes resultant from that are computed internally with the 5-axes-transformation. - 5-axes-tool-offset. The length of the tool is automatically computed and compensated in the movements of the axes. - Oriented tool withdrawal. With the interruption of machining (e. g. tool breakage), the tool can be withdrawn orientated and defined.	
1300	1,00 ST	CHIRON Maintenance Management in the screen display of the pending maintenance: - advance warning = "prepare maintenance" - warning = "carry out maintenance" - machine stop = "catch up on maintenance" Abridged instructions for the pending maintenance with graphic illustration on CD-ROM. Password protected confirmation of the performed maintenance through the maintenance staff.	
1400	1,00 ST	Wash gun mounted outside	
1500	1,00 ST	Working hours and piece counter in the screen	
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	Cabinet cooler as a door mounting unit	



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1900	1,00 ST	Signal lamp on machine enclosure for 3 signals Signal "red" = failure Signal "white" = load machine Signal "green" = machine is running	
2000	1,00 ST	Chip conveyor (scratch band) Instead of standard-coolant equipment, discharge height 495 mm, tank capacity 150 l, pump capacity 100 l/min at 1,3 bar coolant cleaning through slot filter box	
2100	1,00 ST	Coolant equipment FKA/500 with filtration via PF100 filter performance 100 l/min filter unit (nominal) 50 µm Scratchband-chip conveyor with discharge height 1200 mm, surge water pump 100 l/min at 2,6 bar, high pressure system 7 l/min at 70 bar and coolant container with container content 500 liter and machine preparation for through flushing DIN 69893 HSK-A-40. High pressure pump manufacture Knoll	
2200	1,00 ST	Oil-free air service unit with automatic condensate separator, pressure control of the air supply and micro filter 0,01 µm for air purge	
2300	1,00 ST	Installation elements	
2400	1,00 ST	Technology package for turning from bar dia. 32 Lathe spindle water-cooled motor spindle, installed horizontal, with hollow shaft as opening for bars up to ø 32 mm 4 kW at 100 %, 8,5 kW at 15% spindle speed range 15 - 8.000 rpm - 14,3 Nm with direct measuring system and pneumatic clamping 100 Nm collet chuck 22 kN adjustable to 100 %, 50 % and 25 % with integrated pneumatic actuation NC-feeding unit as bar feeder rapid traverse 60 m/min, stroke max. 460 mm, depending on fixture	



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		<p>NC-turning unit with clamping vice KSP100 for the machining of the 6th side installed on NC-feeding unit Technical description of NC-turning unit: repetition accuracy $\pm 30''$, max. spindle speed 80 rpm with pneumatic clamping, electrically controlled via NC-program, incl. pneumatic connection group</p> <p>Switch for end of bar via light barrier mounted outside of the machine enclosure</p> <p>Bar feeding from left side Remark: After alignment the machine has to be anchored to the floor. additionally necessary: fixture washing, removal of the finished part</p> <p>Part slide out of the machine on the left side</p> <p>Collecting vessel at the left side of the machine with drip pan and backflow of the coolant into this machine</p>	
2500	1,00 ST	<p>Socket 230 V in electrical cabinet, connected before main switch (only for power supply with loadable neutral)</p>	
2600	1,00 ST	<p>Automatic central grease lubrication</p>	
2700	1,00 ST	<p>Exhaust fan with air cleaner exhaust capacity 500 m³/h Smoke and gases that arise during the processing are not filtered by this unit. In this case we recommend the connection to a central exhaust fan.</p>	
2800	1,00 ST	<p>Opening at machine enclosure on left hand side additionally necessary: fixture washing</p>	
2900	1,00 ST	<p>Preparation probe for automatic measurement in the machine</p>	
3000	1,00 ST	<p>Renishaw probe package OMP 40</p>	
3100	1,00 ST	<p>Machine preparation for coolant flowing through spindle With rotary feedthrough at the hollow shaft and high pressure piping with flow control switch.</p>	



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3200	1,00 ST	Fixture washing with nozzles controlled with m-functions (Subject: Additional coolant tank)	
3300	1,00 ST	Cutting tools The cutting tools have to be balanced according to DIN ISO 1940, class G 6,3, in two levels, with max. operating speed	
3400	1,00 ST	- Documentation -	
3500	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	
3600	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
3700		Informations	
3800		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°	
3900		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.	
4000		Information Machine safety The machine is designed and built in accordance with the European machine guideline, according placing the product on the first time onto the market. Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.	



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4100		<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>	

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