

Data sheet I MILL 1250 no. 454-01

Pos.	Qty.	Description	Price
100	1,00 ST	<p>Completely refurbished vertical machining centre CHIRON MILL 1250 Nr. 454-01</p> <p>Year of construction: 2007, weight: 9.000 kg</p>	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	<p>Machine enclosure with loading door, electrically interlocked, suitable for loading by crane 2.500 mm high above floor, incl. machine lamp</p>	
400	1,00 ST	<p>Travel: X-axis 1250 mm Y-axis 820 mm Z-axis horizontal spindle 715 mm / vertical spindle 630 mm</p>	
500	1,00 ST	<p>Column moving machining centre Machine substructure with optimal chip drop Linear guides with long-term-lubrication</p> <p>Drilling capacity in steel 60 \varnothing 30 mm (with insert drill) Tapping capacity M 20 Milling capacity in steel 60 150 cm³/min.</p>	
600	1,00 ST	<p>NC swivel head – 20.000 min-1 TORQUE Motor spindle for swivel head, grease lubrication 60,0 kW at 100 % ED 75,0 kW at 40 % ED, watercooled Spindle speed 20 - 20.000 rpm, 75 Nm acceleration and deceleration 0 - 20.000 rpm – each 1,8 seconds tool clamping with disk springs, hydraulic knock out, tool shaft for HSK-A 63 DIN 69893</p> <p>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 2350 Nm</p>	

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700	1,00 ST	Machine table divided for the setting up a numerical control top plate and a back support with free splinter openings between the table halves directly into the cooling agent plant	
800	1,00 ST	Automatic tool changer, protected against chips No. of tools 24 Tool shaft SK A-40 DIN 69871 + 72 tool dia. max. 75 mm tool dia. max. 160 mm if adjacent places are free max. 160 mm Max. tool length max. 320 mm Max. tool weight 4 kg Tool change time approx. 1,5 s (depends on CNC) Chip-to-chip-time approx. 2,9 s (depends on CNC)	
900	1,00 ST	AC-servo motors for x-, y- and z-axes digital direct drives with direct absolute path measuring system (no time-consuming reference) rapid traverse in all axes 60 m/min.	
1000	1,00 ST	SIEMENS CNC-control 840D (PCU 50 / NCU 573.5, 12 measuring circuits for free form milling, 1 canal) incl. 10,4" TFT colour LCD screen / full keyboard OP010S NC-memory 3 MB (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 crossingradius 4 zero offsets G54-G57 30 zero shifts programmable with G-functions 3D and helical interpolation screen switch off mirror function	

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Pos.	Qty.	Description	Price
		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	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.	
1200	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.	
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	Wash gun	

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Pos.	Qty.	Description	Price
1800	1,00 ST	Thermodrive with indirect path measuring system	
1900	1,00 ST	Chip conveyor (scratch band) discharge height 1.050 mm, discharge to the left, tank capacity 200 ltr., lift pump with 300 ltr./min. at 1,3 bar	
2000	1,00 ST	Production package with HP pump PF 50 / FKA 900 consisting of: <ul style="list-style-type: none"> - Coolant equipment PF 50 / 900 (for cast iron slurry, Al with Si \geq 12%) tank capacity 900 l, LP-pump capacity from 100 l/min at 2,1 bar up to 250 l/min at 1,8 bar and HP-pump 20 l/min. at 30 bar coolant filtration with hydrostatic paper bond filter PF 50, filtration 50 μm nominal and double act filter for protection of the machine - Machine preparation for through tool coolant system including: <ul style="list-style-type: none"> - sealing system in the DIN 69871 Form A40 - 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 We recommend for tool holders the use of our patented coolant tube with sieve. Advantages: <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. 	
2100	1,00 ST	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	
2200	1,00 ST	Workspace washing With nozzles installed on the Left hand and right hand side of the machine enclosure	

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Pos.	Qty.	Description	Price
2300	1,00 ST	Socket for portable mini-handwheel without emergency stop button, at control panel	
2400	1,00 ST	Automatic loading door of total enclosure opening and closing, actuating to closing via two-hand push buttons	
2500	1,00 ST	Signal lamp for 3 signals Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running	
2600	1,00 ST	Glass scales overpressured in all axes X, Y, Z = 1250 x 840 x 550 mm	
2700	1,00 ST	5-axes-machining for the machining of three-dimensional curved surfaces with 3 linear and 2 additional axes. - 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.	
2800	2,00 ST	NC-rotary table package, completely installed consisting of: - NC rotary table, type AWU 355 interface 4th axis including adapter plate prepared for hydraulic clamping - NC-rotary table, type G AWU 355 as counter bearing including adapter plate prepared for hydraulic clamping	

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2900	1,00 ST	Direct path measuring system for NC rotary table AWU 100, -160, -200 and -280, repetition accuracy $\pm 8''$	
3000	1,00 ST	Exhaust fan with air cleaner exhaust capacity 800 m ³ /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.	
3100	1,00 ST	Visiport with pneumatic drive mounted to the side door (for Five Axis and W-machines)	
3200	1,00 ST	Undervoltage relay with inadvertently variation of the power supply the machine will be stopped	
3300	1,00 ST	Pneumatic- and Hydraulic Connections	
3400	1,00 ST	Pneumatic connection (A + B) for pneumatic clamping device electrically controlled pneumatic connection, for double acting; pressure control; pressure control switch with automatic pressure regulation. (in case of pressure change automatic pressure sensing)	
3500	1,00 ST	Hydraulic connection for 210 bar with 2 connecting couplings "A + B" and hydraulic installation up to outside of machine bed, electrical control for clamping ON - OFF via push button at control panel per connection	
3600	1,00 ST	Rotary distributor on counter bearing side 4-core 2 x hydraulic – 2 x pneumatic	
3700	1,00 ST	Extension hydraulic unit for clamping of rotary table or counter bearing with 1 second pressure stage, 1 additional clamping circuit and 1 connecting coupling with hydraulic installation up to outside of machine bed for one table side (4th axis)	

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3800	1,00 ST	Extension hydraulic unit of Hydraulic unit from the NC-Tilting head package pressure: 210 bar incl. valves for supply of 1 clamping device and 1 pressure switch for clamping control	
3900	1,00 ST	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	
4000	1,00 ST	CHIRON Tool lifetime control with: - tool place organization - sister tool organization - work field organization via 4-digit program no. in the screen (just for machines with more than one work field) - tool data check for geometric values	
4100	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	
4200	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
4300	1,00 ST	- Documentation -	
4400	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	
4500		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°	