

## Offer I STAMA MC 526/Compact no. 1533

Pos.	Qty.	Description	Price
100	1,00 ST	<p><b>Completely refurbished vertical machining centre CHIRON MC 526/Compact/ no. 1533</b></p> <p><b>Year of construction: 2007, weight: 9.000 kg</b></p>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<p><b>Traverse Ranges</b></p> <p>X-Axis 1000 mm Y-Axis 400 mm Z-Axis 360 mm Feed Thrust X-Y-Axis 4000 N Z-Axis 8000 N</p>	
400	1,00 ST	<p><b>Traverse Rates</b></p> <p>Rapid traverse X-Y- and Z-axis 60 m/min. Feed rate in X-Y- and Z-axis 1-10000 mm/min Axis dynamics: (m/sek<sup>2</sup>) max. X=5; Y=8; Z=12</p>	
500	1,00 ST	<p><b>Machine Bed with Screw-down Surface</b></p> <p>Preparation of machine for installation of:</p> <ul style="list-style-type: none"> <li>&gt; Machine table with T-slots and location holes.</li> <li>&gt; NC-Rotary table with counter support.</li> </ul> <p>Steep walls in the work area guarantee free swarf fall into the swarf conveyor.</p> <p>The welded base is provided with 2 milled areas for assembly of fixtures or units.</p> <p>Max. dimension 1400 x 600 mm Acceptable table loading 1500 Kg Distance table-spindle nose min./max. 350/710 mm</p>	
600	1,00 ST	<p><b>Spindle Units</b></p> <p>Tool register HSK A63 DIN 69893 Retention force 7.000 N Spindle diameter 65 mm Main spindle speed: 12000 rpm</p>	
700	1,00 ST	<p><b>Main spindle drive 15 kW</b></p> <p>Torque constant up to 1500 rpm: At 100% continuous duty 60 Nm; at 20% cont. duty 96 Nm Driving power at 1500 rpm: At 100% cont. duty 9,5 kW; at 20% cont. duty 15 kW</p>	



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800	1,00 ST	<p><b>Tool Magazine</b>            Tool places 42            Tool diameter maximum:            all places used <math>\varnothing</math> 88 mm            with empty adjacent tool place <math>\varnothing</math> 125 mm (length 100 mm)            Tool length max. 250 mm            Tool register DIN 69871 A/B SK 40            Bolt acc. DIN 69872-19            Tool weight max. 5 kg            Chip-to-chip time approx. 2,6 sec.</p>	
900	1,00 ST	<p><b>Measuring System</b>            X-Y axis, digital pulse coder            (Fanuc cyclic absolut)            Absolute measuring value processing resolution 0.001 mm            pitch error compensation is executed            Z-axis linear scale</p>	
1000	1,00 ST	<p><b>Installation Data</b>            Space required for machine/equipment approx. 9 m<sup>2</sup>            Weight approx. 5.000 kg            Working voltage 3x400 V <math>\pm</math>10%; 50Hz; N/PE.            Control voltage 24 V DC            Valve voltage 24 V DC            Installation conditions:            Connected rating machine 28 KVA            Fuse before master switch 3 x 50 A            Connected cross section 5 x 16 mm<sup>2</sup>            Required air pressure min. 6 bar            Clean air conditions acc. to ISO 8573-1 class 4            Supply pipe inside dia. min. 13 mm.</p>	
1100	1,00 ST	<p><b>Guarding Equipment</b>            Enclosure of working area</p>	
1200	1,00 ST	<p><b>Axis movement with open safety door</b>            If the safety door is open, axis movement and spindle rotation are just possible during setting mode.            Speed of axis max. 2 m/min. Spindle RPM max. 800 1/min.            Actuated by press-button and confirmation key.</p>	
1300	1,00 ST	<p><b>Lamp in Working Area</b></p>	



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1400	1,00 ST	<p><b>Permanent Lubrication low-Maintenance</b>            All linear guides and ball screws are equipped with long-time lubrication systems.            6000 working hours maintenance-free.            After 6000 working hours or 1 x per year the linear guides and ball screws must be lubricated.</p>	
1500	1,00 ST	<p><b>Air-Conditioning of the Electrical-Cabinet</b></p>	
1600	1,00 ST	<p><b>Swarf Conveyor</b>            Scaper conveyor suitable for all kinds of material and swarf shapes.            Ejection height 850 mm on left side of MC.            Integrated wedge wire sieve box, changeable.            Tank: 300 l            External coolant supply integrated in spindle head with adjustable nozzles.            If mainly cast iron or light metal has to be machined, additional coolant concentration units are necessary.</p>	
1700	1,00 ST	<p><b>Rinsing Pistol</b>            for manual cleaning of the working area.</p>	
1800	1,00 ST	<p><b>Machine Supports without Coolant Tray</b>            for levelling and fixing the machine on the ground without coolant tray.            Including all mounting elements.</p>	
1900	1,00 ST	<p><b>Coolant equipment KF 150 / FKA 500</b>            (also for sludge generating materials, e.g. grey cast iron, GGG, Al with Si &gt;= 12%)            tank capacity 500 l             low pressure pump capacity from 40 l/min. at 3.2 bar            up to 120 l/min at 3.2 bar            high pressure pump capacity 28 l/min at 30bar             full stream purification via compact paper bond filter KF 150,            with coolant purification 50 µm nominal            twin filter in the high pressure circuit for            the protection of the machine</p>	



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2000	1,00 ST	<p><b>Full Enclosure of Working Area</b> As protection against swarf and fumes the working area of the machine is completely enclosed, with the drive units outside of the capsule. A suction unit with is recommended.</p>	
2100	1,00 ST	<p><b>Internal Coolant through Spindle 20 bar</b> Internal coolant supply through the work spindle. High-pressure pump 20 bar for coolant. (Applicable only in combination with coolant filtration system.) For SK AD Form A acc. to DIN 69871</p>	
2200	1,00 ST	<p><b>Preparation Central Extraction Plant</b> Preparation of machine for connection to central extraction plant provided to the customer, consisting of 1 connector <math>\varnothing</math> 200 for each working area. Incl. impact plate/s in the work area.</p>	
2300	1,00 ST	<p><b>FANUC 18i M</b> FANUC 3-Axis-CNC further Axis possible as option memory capacity 128 KB 63 programs with program name stored Program number 4 digits, record number 5 digits Formation of Subroutine (Nesting max. 4 mark ) Decimal point Resolution 0,001 mm 10,4" colour screen Ladder diagram of the SPS on control screen Interface RS 232-C / V 24 according DIN 66020 3 D- linear interpolation G1 (max. 4 Axis at the same time) Circular interpolation G2/G3, line interpolation screws Full circle programming and circular interpolation with Radius specification Exact Stop and railway system G09, G61, G63, G64 Automatic Reference point approach G28, G29 Programmable zero point shift G53-G59/G92 Local zero point shift G52 drilling cycles G73. G74. G76. G80-G89. with G98 and G99 variable, programmable dwell time G04 Thread without compensation chuck Tool length compensation G43, G44, G49 For each Tool 3 corrections for length and radius</p>	



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		Cutter radius compensation G40-G42 Tool life monitoring Tool call over 8-digit T address Correction memory max. $\pm 999.999$ mm Feed 0-120% in 10% steps Rapid traverse 0-100% in 10% steps Spindle speed override 50-120% in 10% steps Diagnostic display. Operating messages in plain text Parallel programming, to avoid stand still times. Highly accurate, digital, absolute path measurement preparation.	
2400	1,00 ST	<b>Add. Rinsing Pipes for Clamping Fixture</b> Additional coolant pipes for cleaning of clamping fixture and workpiece with connection in working area. The pipes are adapted to the clamping fixture. Moment and frequency of the rinsing process are controllable by M-funktion in the NC-programme. This option is required twice for longbed machines.	
2500	1,00 ST	<b>NC-Rotary Table Diameter 240 mm</b> Horizontal NC-rotary axis, worm pinion drive by transistor-controlled AC motor. Position measurement by digital pulse coder. Ready for connection including CNC axis, intermediate plate to fit rotary table on machine table and hydraulic locking of table. Rotary table with centre hole $\varnothing 30$ H7 and T-slots Center height 230 mm Permissible tilting torque 2000 Nm Permissible torque 1200 Nm at hydraulic locking Permissible torque during rotary milling 380 Nm Permissible table load 250 kg Speed of rotation 42 rpm Resolution 1/1000 degree Indexing accuracy $\pm 15''$ .	
2600	1,00 ST	<b>Counter Support with Hydraulic Locking</b> Support for rotary table dia. 180 mm or dia. 240 mm. Sturdy design for reception of high cutting forces. Hydraulical locking of flange. Cylindrical locating flange for positioning and mounting of manually or hydraulically actuated fixtures in bridge design. Mounted on console for leveling to rotary table.	



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2700	1,00 ST	<p><b>Hydraulic Basic Equipment</b> Necessary in case of hydraulically actuated clamping fixtures. Consisting of: &gt; High pressure aggregate system pressure 230 bar. &gt; Hydr. clamping block for 1 double acting clamping cycle (2 controlled lines). The clamping line is with one manual adjustable pressure control from 30-200 bar and one pressure monitoring (dissolve line 230 bar). The lines are installed until the machine table. &gt; Electrical soft- and hardware. &gt; Transmitter on loading station with followed functions: “clamping”, control lamp “clamping reached” and “unclamping”.</p>	
2800	1,00 ST	<p><b>Additional Hydr. Circuit Double Action</b> Extension of hydraulic basic equipment by 1 circuit (2 controlled lines). Release pressure: max. system pressure.</p>	
2900	1,00 ST	<p><b>Oil-Distributor for NC-Rotary Table</b> Oil-Distributor 7-fold for oil supply to clamping fixtures mounted on rotary table diameter 240mm. The oil-distributor is flanged on NC-rotary table.</p>	
3000	1,00 ST	<p><b>Oil-Distributor 2-fold Counter Support</b> Oil-Distributor 2-fold for oil supply to clamping fixtures mounted on tilting bridge. The oil-distributor is flanged on the counter support. Oil supply up to the mounting flange of the tilting bridge.</p>	
3100	1,00 ST	<p><b>Pneumatic Basic Equipment</b> Necessary in case of pneumatically actuated clamping fixtures. Consisting of: Pneumatic hardware for 1 circuit (2 controlled lines). Lines are installed up to machine table. &gt; Electrical soft- and hardware. &gt; Operators panel installed in control unit with: clamping, control lamp clamping pressure reached and unclamp fixtures.</p>	
3200	1,00 ST	<p><b>Additional Pneumatic circuit</b> Extension of pneumatic basic equipment by 1 circuit (2 controlled lines)</p>	



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3300	1,00 ST	<p><b>Automatic Loading Door</b> Automatic opening and closing of loading door/s. According to valid german safety regulations (UVV) and electrically safeguarded.</p>	
3400	1,00 ST	<p><b>Connection to Central Coolant System</b> Preparation of machine for connection to customer's central coolant system. Incl. flow control for the supply line and shut off valve to disconnect the system. Dirt particle size 50 microns max. Required volume: 350l/min Required supply pressure: 6 bar (Emulsion) Incl. connection up to the backside of the machine. For final configuration the coolant layout from the customer must be available !</p>	
3500	1,00 ST	<p><b>Illumination Control Cabinet and Socket</b> Illumination of control cabinet automatically activated when opening the door and 230 Volt socket before main switch.</p>	
3600	1,00 ST	<p><b>Interface for automatic loading system</b> The Interface includes 5 inputs and 6 outputs for correspondence with the loading system. Following signals are provided: STAMA to loading system &gt; Emergency stop &gt; Clamping fixture clamped &gt; Clamping fixture unclamped &gt; Automatic &gt; Permission for part exchange &gt; Tool broken further are required: From loading system to STAMA &gt; Closing of clamping fixture &gt; Opening of clamping fixture &gt; Loading system out of disturbance area &gt; Part exchange finished <b>Remarks</b> The supplier of the loading system is responsible for the security regulations of the system. In case of emergency stop of the loading system or the STAMA machine the whole production cell stops. The restart</p>	



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		has to be done manually step by step. Emergency stop signal is provided from STAMA potential free. Included 1 day installation at the customer. Each additional day will be calculated separately according to the actual STAMA service regulations.	
3700	1,00 ST	<b>- Documentation -</b>	
3800	1,00 ST	<b>Documentation acc. to CE of the first delivery into market</b> 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	
3900	1,00 ST	<b>Machine colour</b> Standard painting: 3-coloured light grey/basalt grey RAL 7035/7012/4010 with telemagenta stripes	
4000		<b>Main circuit</b> 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°	
4100		<b>Information Export</b> We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.	
4200		<b>Information Machine safety</b> 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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4300		<p><b>Information Coolant lubrication</b></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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