

## Data sheet I STAMA MC 334 TWIN no. 2024

Pos.	Qty.	Description	Price
100	1,00 ST	<p><b>Completely refurbished vertical machining centre CHIRON MC 334 TWIN no. 2024</b></p> <p><b>Year of construction: 2003, weight: 13.000 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>Spindle distance A: 320 mm</p> <p>Traverse Ranges</p> <p>X axis 700 mm</p> <p>Y axis 520 mm</p> <p>Z axis 400 mm</p> <p>Feed Thrust:</p> <p>X-Y axis 7000 N</p> <p>Z axis 12000 N</p>	
400	1,00 ST	<p><b>Traverse Rates - Axes Dynamic</b></p> <p>Rapid traverse in X- Y- and Z- axes 60 m/min</p> <p>Feed rate X- Y- and Z- axes 1-10000 mm/min</p> <p>Axis Dynamics: a max. (m/sec<sup>2</sup>) X=5.0; Y=7.0; Z=10.0</p>	
500	1,00 ST	<p><b>Swivel Table with direct drives</b></p> <p>Torque constant up to 2200 rpm:</p> <p>At 100% cont. duty 77 Nm; at 20% cont. duty 170 Nm</p> <p>Driving power over 2200 rpm:</p> <p>At 100% cont. duty 17,8 Kw; at 20% cont. duty 39,2 Kw</p> <p>Tool holder SK 40</p> <p>Draw bar pulling force 8000 N</p> <p>Spindle diameter 70 mm</p> <p>Spindle speed: 10.000 1/min.</p>	
600	1,00 ST	<p><b>Tool Magazine</b></p> <p>Tool places standard 2 x 24</p> <p>Tool diameter maximum:</p> <p>all places used <math>\varnothing</math> 105 mm</p> <p>with empty adjacent tool place <math>\varnothing</math> 160 mm</p> <p>Tool length max. 300 mm</p> <p>Tool register SK 40 DIN 69871</p> <p>Tool weight max. 12 kg</p> <p>Chip-to-chip time approx. 3,7 sec.</p>	



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700	1,00 ST	<b>Measuring System</b> X-Y axis, digital pulse coder (Fanuc, cyclic absolute, siemens absolute) Absolute measuring value processing resolution 0.001 mm	
800	1,00 ST	<b>Installation Data</b> Space required for machine approx. 20m <sup>2</sup> Weight approx. 13.000 kg Working voltage 3x400 V ±10%; 50Hz; N/PE. Control voltage 24 V DC Valve voltage 24 V DC Customers side requirement: Connected rating machine 80 KVA Fuse before master switch 3 x 150 A Connected cross section 3 x 70 mm <sup>2</sup> + 1 x 35 mm <sup>2</sup> Required air pressure min. 6 bar ISO 8573-1 Klasse 4 Necessary connection inner diameter Ø13mm	
900	1,00 ST	<b>Guarding Equipment</b> Enclosure of working area	
1000	1,00 ST	<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.	
1100	1,00 ST	<b>Lamp in Working Area</b>	
1200	1,00 ST	<b>Permanent Lubrication low-Maintenance</b> All linear guides and ball screws are equipped with long-time lubrication systems, 3 years max. 5000 working hours maintenance-free. After 5000 working hours linear guides and ball screws must be lubricated.	



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1300	1,00 ST	<p><b>Air-Conditioning of the Electrical-Cabinet Scaper conveyor suitable for all kinds of material and swarf shapes.</b>  Ejection height 1050 mm on left side of MC.  Integrated wedge wire sieve box, changeable.  Tank for 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>	
1400	1,00 ST	<p><b>Wash gun</b>  For manual cleaning of the loading area.</p>	
1500	1,00 ST	<p><b>FANUC 18i M</b>  <b>FANUC 3-Axis-CNC</b>  further Axis possible as option</p> <p>memory capacity 128 KB</p> <p>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</p> <p>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  Cutter radius compensation G40-G42</p>	



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		<p>Tool life monitoring            Tool call over 8-digit T address            Correction memory max. <math>\pm 999.999</math> 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.</p>	
1600	1,00 ST	<p><b>Coolant Filtration Paper (200 l/min)</b>            Paper tape through-shaped filter, installed on coolant tank 600 l.            A good utilization of the filter paper is guaranteed due the high level of fluid.            Compact design, Filter paper width 710 mm.            Filter performance 200 l/min - emulsion.            Installed 1 roll of filter paper, width 200 mm, 710 mm.            Middle filter mesh 50 microns.            With feed-back facility in the event of paper shortage.            Paper transport controlled by level switch</p>	
1700	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 closed. The drive units are placed outside of the capsule.</p>	
1800	1,00 ST	<p><b>Internal Coolant through Spindle 20 bar</b>            Internal coolant supply through the work spindle. for tool holder acc. 69871 (SK) Form AD or Form B, for tool holder acc. DIN 69893 (HSK) Form A, coolant-high pressure pump (just possible in connection with coolant cleaning unit)</p>	
1900	2,00 ST	<p><b>Distributor for Swivel Table 20-fold</b>            Distributor for oil supply to clamping fixtures mounted on one or two sides of swivel table. Central space-saving installation in the middle of the swivel table. Supply through middle of swivel table. The oil-distributor is prepared for the additional supply to electrical units on the swivel table.</p>	
2000	1,00 ST	<p><b>2 x 4. Axis ready for plug-in</b></p>	



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2100	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 200 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 200 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>	
2200	1,00 ST	- <b>Documentation</b> -	
2300	1,00 ST	<p><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</p>	
2400	1,00 ST	<p><b>Machine colour</b> Standard painting: 3-coloured light grey/basalt grey RAL 7035/7012/4010 with telemagenta stripes</p>	
2500		<p><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°</p>	
2600		<p><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.</p>	
2700		<p><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.</p>	



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2800		<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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