

Pos.	Qty.	Article Description	Price / €
------	------	---------------------	-----------

Offer

1 1

**Vertical
CNC-machining centre
FZ 18 WM
Complete refurbished
pre-owned machine
Modernize in 2008
Delivered 1990**

Machine-No. 430-27

**Column moving machining
centre
with workpiece swivel table**



Original picture

AC-motor

10,0 kW at 100%
18,0 kW at 25%
Spindle speed: 20 – 10.500 min⁻¹ – 140 Nm

Travel:

X-axis 630 mm
Y-axis 400 mm
Z-axis 350 mm

Automatic tool changer

Tool places 20
Tool shaft SK 40 DIN 69871+72
Tool-Ø max. 65 mm
Tool-Ø max. 120 mm
if adjacent places are free max. 120 mm
Tool weight max. 5 kg
Tool change time approx. 1,9 s (depends on CNC)
Chip-to-chip-time approx. 3,9 s (depends on CNC)

Workpiece swivel table 0/180 degrees

Clamping surface 1250 x 850 mm²
with thread and locating hole grids
M 16 x Ø 15 H7 x 50 mm
Tool change time approx. 4,0 s
Table loading capacity per side max. 150 kg

Pos.	Qty.	Article Description	Price / €
------	------	---------------------	-----------

AC-servo-motors

Feed drives for X-, Y- and Z-axis
 Indirect path measuring system
 Rapid traverse 20 m/min

Steel covers in all axes

Pallet recognition M61 / M62

SIEMENS 840D iSL

(PCU 50)

incl. 10,4" TFT colour LCD screen / full keyboard OP010S

NC-memory 256 KB

(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

scaling function

insert of chamfer and radius

orientated spindlestop

Discharge great CNC-programs over USB Stick

dimension metric or inch

software limitswitch

NC-diagnosis

machine-diagnosis

rigid tapping

Pos.	Qty.	Article Description	Price / €
------	------	---------------------	-----------

Machine enclosure

bolted on, with loading door, electrically interlocked,
2000 mm high above floor, incl. machine lamp

2

Optional extra equipment

Coolant equipment with chip conveyor (scratch band)

Discharge height 1350 mm,
tank capacity 550 ltr.,
N-pump capacity 200 ltr/min at 1,5 bar
and HD-pump 40 ltr/min at 20 bar
high pressure circuit with coolant filtration
paper band filter PF50 and double switch filter
instead of Standard chip conveyor

Machine preparation

through tool coolant form DIN 69871 form A40

Rotary table package, consisting of:

- 2 NC rotary table, type RT 160
- 4th and 5th axis, complete
- Central pneumatic connection, uncontrolled

Technical description for NC-rotary-table

centre height 165 mm, indexing accuracy $\pm 15''$,
load moment of inertia (without turnable distributor) 1,9 kgm²
face plate dia. 160 mm, with centre bore dia. 50 +0,012,
fixture pin dia. 16 F7, 4 fixture bores M10
incl. pneumatic clamping

CHIRON standard fixture for rotary table

with pneumatic counter bearing clamping

Bridge size 650 mm

existing of:

- base plate (instead of the adaptor plate from the rotary table package)
Screwed and detachable to workpiece changer
- counter bearing with pneumatic clamping
- flange, on side of the rotary table
- flange, on side of the counter bearing
- 2 x 1-core energy supply
- Centre height 165 mm over base plate

Wash gun

Pos.	Qty.	Article Description	Price / €
------	------	---------------------	-----------

Installation elements

Central pneumatic connection

with 2 uncontrolled lines with connecting coupling

Central hydraulic and pneumatic supply

prepared for max. 20 connections,
6 connections are installed including connecting couplings,
4 for hydraulic, max. 210 bar and
2 for pneumatic without control.

Installation up to the outside of machine bed, with electrical control
for clamping ON - OFF via push button at control panel

Hydraulic unit

continuous duty
pressure: 210 bar
supply capacity: 4,30 ltr./min.
incl. valves for supply of 2 clamping device
and 2 pressure switch for clamping control

Total machine price, as described above

on inquiry

Commissioning and Instruction

on inquiry

CHIRON Range

- final alignment according to CHIRON geometric data sheet
- complete check of the machine functions
- basic instruction of the operating staff

Before commissioning the customer has to provide for:

- unload and transport of the machine to the installation place
- installation and prealignment of the machine
- electric and pneumatic connecting of the machine

During start up through CHIRON personnel, the customer
assistance together with auxiliary equipment must be available free of
charge.

Following additional work will be invoiced on expense:

- try out and production of customer workpieces
- try out of customer fixtures
- additional training exceeding basic instruction
- any effort caused by customer failing to meet provisions listed above

Packing and loading

on inquiry

(One-way packing for transport by truck)

Pos.	Qty.	Article Description	Price / €
------	------	---------------------	-----------

Documentation

Operating manuals, programming and operating manuals 1-fold in German

Delivery

ex works, packing excluded

Delivery time: after arrangement, intermediate sale reserve

Payment

30% by order
30% by pre-acceptance by CMS
40% before delivery each net

Warranty

6 months on parts
excluding wear parts

Machine colour

two-components-structure-varnish – 3 colours
grey beige acc. to RAL 1019
light ivory acc. to RAL 1015
basalt grey acc. to RAL 7012

Transport insurance

to be covered by customer