

Data sheet No. 20385497 / 15.08.2024

Item	Qty	Description
1000	1	Vertical CNC-machining center FZ 08 W 204-12
1040	1	Condition: completely refurbished Year of construction: 2001
According to the scope described below		
1060	1	Column moving machining centre with workpiece swivel table
1080	1	Splash guard paneling bolted, electrically fused, Height 2000 mm above floor, incl. machine light
1100	1	Work piece changer 0/180 degrees With centre divider made Clamping surface 2 x 550 x 300 mm ² with thread and locating hole grids M 16 x Ø 15 H7 x 50 mm Work piece swivel time approx.. 2,0 s, with self-learning speed-control Weight difference max. 100 kg between both table sides
1120	1	Travel X-axis 300 mm Y-axis 250 mm Z-axis 250 mm
1140	1	Main spindle drive with AC-motor 2,2 kW at 100% 7,2 kW at 25% Spindle speed range: 20 – 15.000 rpm – 23 Nm Drilling capacity Ø 16 mm Tapping capacity M 12 Milling capacity 30 cm ³ /min
1160	1	Automatic tool changer Tool places 12 Tool shaft HSK 32 DIN 69893 Tool-Ø max. 63 mm (50 mm at free neighbour places) Tool weight max. 0,7 kg Tool change time approx. 0,5 s (depends on CNC) Chip-to-chip-time approx. 1,5 s (depends on CNC)
1180	1	Digital feed drives for X-, Y- and Z-axis with digital direct drives and indirect absolut path measuring system rapid traverse in X- and Y-axes 40 m/min, Z-axis 60 m/min, acceleration X- and Y-axes 0,7 g, Z-axis 1 g
<p>Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)</p>		

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| 1200 | 1 | <p>SIEMENS CNC-control 840D
 (MMC 100.2 / NCU 571.2, 6 measuring circuits, 1 channel)
 incl. 10,4" TFT colour LCD screen / full keyboard OP010S
 operator panel logic
 NC-memory 256 KB Standard
 (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
 crossing radius
 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
 Universal interface RS 232C (2x V24)
 orientated spindle stop
 drip feed function through V24 interface
 dimension metric or inch
 software limits witch
 NC-diagnosis
 machine-diagnosis
 absolute indirect path measurement systems
 power meter in screen, rigid tapping, look ahead function</p> |
| 1210 | 1 | <p>CMS Powersafe
 Software package for selective shutdown of installed consumers
 such as axis motors, drives, spindles, coolant-pumps and auxiliary
 equipment during production breaks.
 Definable point in time at which the machine goes demand-oriented
 automatically into it's Power Safe mode.</p> |
| 1220 | 1 | <p>Working hours and piece counter
 in the screen</p> |
| 1240 | 1 | <p>230 V socket
 in the screen</p> |

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- 1260 1 **Cabinet cooler as a door mounting unit**
- 1280 1 **Installation elements**
- 1300 1 **Wash gun**
- 1320 2 **NC Rotary table, completely installed consisting of:**
 - 2 NC rotary tables, type AWU P 100 mountable to the workpiece swivel table
 - interface 4th + 5th nc-axis lowest increment 0,001°
 - pneumatic supply, without control

Technical description NC rotary table
repetition accuracy $\pm 30''$
max. spindle speed 80 rpm
spindle pneumatic clamped, center height 125 mm
face plate dia. 100 mm, center bore dia. 50+0,012,
through bore dia 35 mm, location pin dia. 10 h7,
4 bolt holes M8
- 1340 2 **Hydraulic or pneumatic turning supply 2-core**
for rotary table
- 1360 2 **CHIRON standard fixture for rotary table**
with:
 - common base plate for AWU P 100 and counter bearing
 - counter bearing with pneumatic clamping
 - centering flange, on side of the rotary table
 - centering flange, on side of the counter bearing
 - chuck on side of the rotary table with connection coupling
 - chuck on side of the counter bearing with connection coupling
 - counter bearing shaft
 - 1-core supply (pneumatic) through counter bearing
 - center height 125 mm
- 1380 1 **Automatic loading door of total enclosure**
opening and closing
- 1400 1 **Coolant equipment with chip container**
Tank capacity 100 l., pump power 60 l/min. at 1 bar
- 1420 1 **Walk Switch**
- 1440 1 **Pneumatic connection controlled**
with A/B connection on each side of the table
for pneum. clamping device
Two electrically controlled pneumatic connections
for double-acting clamping cylinders; one pressure regulator,
optionally one or both clamping circuits controlled together;
One clamping pressure control per clamping circuit by means of a
differential pressure switch
(no pressure switch tracking required in the event of a pressure change)

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| 1460 | 1 | Hydraulic connection for 210 bar
with rotation distributor 6-fold and
4 connecting couplings for hydraulic,
2 connecting couplings for pneumatic,
without control, hydraulic installation,
up to the outside machine bed, with electrical control
for clamping ON - OFF via push button at control panel |
| 1480 | 1 | Hydraulic unit
pressure: 210 bar
supply capacity: 1,7 l/min.
with electrical control and external power supply
incl. valves for supply of 2 clamping devices
and 2 pressure switches for clamping control |
| 1500 | 1 | Milling of cylinder path |
| 1520 | 1 | Machine colour
Two-components-structure varnish - 2 colours
light grey acc. to NCS S1502-B
basalt grey acc. to RAL 7012 |
| 1540 | 1 | 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 |