

Data sheet No. 20385302 / 15.10.2024

CHIRON Group SE

Item	Qty	Description
1000	1	Vertical CNC-machining center CHIRON MILL 800
1040	1	Condition: partly refurbished Year of construction: 2004 According to described below scope of delivery
1060	1	Column moving machining centre with fixed table Machine substructure with chip discharge left Linear guides with long-term-lubrication
1080	1	AC-motor 7,5 kW at 100 % 22,5 kW at 10 % for main spindle Spindle speed range: 20 - 12.000 rpm - 140 Nm Drilling capacity in steel 60 ø 42 mm (with insert drill) Tapping capacity M 30 Milling capacity in steel 60 600 cm ³ /min.
1100	1	Machine enclosure bolted on, with loading door, electrically interlocked, 2.500 mm high above floor, incl. machine lamp
1120	1	Fixed table with chip pan clamping surface 1400 mm x 550 mm with 3 T-slots 2 x 18 H12, 1 x 18 H 8 table loading capacity max. 1200 kg
1140	1	Travel: X-axis 800 mm Y-axis 500 mm Z-axis 550 mm (plus distance from spindle nose to table surface, according to data sheet)
1160	1	Automatic tool changer, protected against chips No. of tools 24 Tool shaft SK 40 DIN 69871 + 72 Max. tool dia. 75 mm - if all magazine pos. are occupied Max. tool dia. 125 mm - if adjacent places are free Max. tool length 280 mm Max. tool weight 4,0 kg
1180	1	AC-servo motors for x-, y- and z-axes digital direct drives with indirect absolute path measuring system rapid traverse in all axes 60 m/min.

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- 1200 1 **SIEMENS CNC-control 840D**
(PCU 50 / NCU 572.4, 6 measuring circuits, 1 canal)
incl. 10,4" TFT colour LCD screen / full keyboard OP010S
control panel logic Windows NT
NC-memory 256 KB
(max.200 programs storage capacity)
for ISO 66025 programming
hard disk with approx. 2 GB for free disposal
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 (1 x V24) at control panel
USB-interface at control panel
Ethernet connection RJ45 in control panel
orientated spindle stop
drip feed function through V24 interface
dimension metric or inch
software limit switch
NC-diagnosis
machine-diagnosis
absolute indirect path measurement systems
power meter in screen
rigid tapping
look ahead function
- 1220 1 **CHIRON Powersave**
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 points in time at which the machine starts demand-oriented
automatically with a variable warmup program
to recovery the production readiness.

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| 1240 | 1 | <p>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.</p> |
| 1260 | 1 | <p>Automatic central grease lubrication</p> |
| 1280 | 1 | <p>Working hours and piece counter
 in the screen</p> |
| 1300 | 1 | <p>Socket 230 V
 at control panel</p> |
| 1320 | 1 | <p>Cabinet cooler as a door mounting unit</p> |
| 1340 | 1 | <p>Socket for portable mini-hand wheel
 without emergency stop button,
 at control panel</p> |
| 1360 | 1 | <p>Installation elements
 For installation in an oil pan the installation directly on the sheet metal is not allowed. For out of it resulting problems there is no warranty. The machine documents for approval contain a proposal for the appropriate execution of the oil pan.</p> |
| 1380 | 1 | <p>Signal lamp on machine enclosure for 3 signals
 Signal "red" = failure
 Signal "white" = load machine
 Signal "green" = machine is running</p> |
| 1400 | 1 | <p>Chip conveyor (scratch band)
 discharge height 1.050 mm, discharge backwards,
 tank capacity 150 l, lift pump with 250 l/min. at 1,5 bar</p> |
| 1420 | 1 | <p>Thermodrive at indirect path-measuring system</p> |
| 1440 | 1 | <p>Wash gun</p> |
| 1480 | 1 | <p>Portable mini-hand wheel
 for conventional travel, without emergency stop button, including connecting cable 900 mm.
 (This way the emergency stop button at the control panel is within the reach of the operator.)</p> |
| 1500 | 1 | <p>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</p> |

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| 1520 | 1 | Machine colour
two-components-structure varnish - 3 colours
window grey acc. to RAL 7040
blue acc. to NCS S2050-R80B
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 |