

Pos.	Qty.	Article Description	Price / €
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Complete machine description | DZ 15 W no. 258-60

- | | | | |
|---|---|---|--|
| 1 | 1 | Complete refurbished vertical CNC-machining centre model CHIRON DZ 15 W
Year of construction: 2007, weight: 7.820 kg | |
|---|---|---|--|

Machine-No. 258-60



Machine image similar.
The equipment of the sample photo isn't binding.

GB | Data sheet | ref 258-60.docx

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26.05.2020

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BLZ 653 700 75, Kto.-Nr.: 2208 148
Steuer-Nr. 21101/01726, Ust.-Id.-Nr. DE 812948040
IBAN : DE42653700750220814800
SWIFT : DEUTDESS653



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Scope of delivery:

- | | | | | | | | | | | | | | | | | | | |
|-----------------------------|--|---|----------------------------|---|------------------|--------------------|---------------------------|--|------------------|--------|-----------------------------|-------------|-------------|----------------------------------|------------------------|------------------------|---------------------------|------------------------|
| 100 | 1 | <p>Column moving machining centre in steel- concrete- composite design with workpiece changing device
Suitable for dry-machining with optimized chip drop
Guideways with long-term-grease lubrication</p> | | | | | | | | | | | | | | | | |
| 200 | 1 | <p>Main Spindle drive with 2 AC-motors
9,5 KW at 100 %
14,0 KW at 15 %
Spindle speed range: 20 – 12.000 rpm - max. 90 Nm</p> <table border="0" style="margin-left: 20px;"> <tr> <td>Drilling capacity in St 60</td> <td>2 x Ø 36 mm with reversible plate drill</td> </tr> <tr> <td>Tapping capacity</td> <td>2 x M 24</td> </tr> <tr> <td>Milling capacity in St 60</td> <td>2 x 150 cm³/min</td> </tr> </table> | Drilling capacity in St 60 | 2 x Ø 36 mm with reversible plate drill | Tapping capacity | 2 x M 24 | Milling capacity in St 60 | 2 x 150 cm ³ /min | | | | | | | | | | |
| Drilling capacity in St 60 | 2 x Ø 36 mm with reversible plate drill | | | | | | | | | | | | | | | | | |
| Tapping capacity | 2 x M 24 | | | | | | | | | | | | | | | | | |
| Milling capacity in St 60 | 2 x 150 cm ³ /min | | | | | | | | | | | | | | | | | |
| 300 | 1 | <p>Travel:</p> <table border="0" style="margin-left: 20px;"> <tr> <td>X-axis</td> <td>300 mm</td> </tr> <tr> <td>Y-axis</td> <td>400 mm</td> </tr> <tr> <td>Z-axis</td> <td>425 mm with adjustable tool change level</td> </tr> <tr> <td>Spindle distance</td> <td>250 mm</td> </tr> </table> | X-axis | 300 mm | Y-axis | 400 mm | Z-axis | 425 mm with adjustable tool change level | Spindle distance | 250 mm | | | | | | | | |
| X-axis | 300 mm | | | | | | | | | | | | | | | | | |
| Y-axis | 400 mm | | | | | | | | | | | | | | | | | |
| Z-axis | 425 mm with adjustable tool change level | | | | | | | | | | | | | | | | | |
| Spindle distance | 250 mm | | | | | | | | | | | | | | | | | |
| 400 | 1 | <p>Automatic tool changer, protected against chips</p> <table border="0" style="margin-left: 20px;"> <tr> <td>Tool places</td> <td>2 x 12</td> </tr> <tr> <td>Tool shaft</td> <td>HSK-A 63 DIN 69893</td> </tr> <tr> <td>Tool-Ø</td> <td>max. 65 mm</td> </tr> <tr> <td>Tool-Ø</td> <td></td> </tr> <tr> <td>if adjacent places are free</td> <td>max. 150 mm</td> </tr> <tr> <td>Tool weight</td> <td>max. 2,5 kg (5,0 kg at 2 places)</td> </tr> <tr> <td>Tool change time appr.</td> <td>0,9 s (depends on CNC)</td> </tr> <tr> <td>Chip-to-chip-time approx.</td> <td>2,1 s (depends on CNC)</td> </tr> </table> | Tool places | 2 x 12 | Tool shaft | HSK-A 63 DIN 69893 | Tool-Ø | max. 65 mm | Tool-Ø | | if adjacent places are free | max. 150 mm | Tool weight | max. 2,5 kg (5,0 kg at 2 places) | Tool change time appr. | 0,9 s (depends on CNC) | Chip-to-chip-time approx. | 2,1 s (depends on CNC) |
| Tool places | 2 x 12 | | | | | | | | | | | | | | | | | |
| Tool shaft | HSK-A 63 DIN 69893 | | | | | | | | | | | | | | | | | |
| Tool-Ø | max. 65 mm | | | | | | | | | | | | | | | | | |
| Tool-Ø | | | | | | | | | | | | | | | | | | |
| if adjacent places are free | max. 150 mm | | | | | | | | | | | | | | | | | |
| Tool weight | max. 2,5 kg (5,0 kg at 2 places) | | | | | | | | | | | | | | | | | |
| Tool change time appr. | 0,9 s (depends on CNC) | | | | | | | | | | | | | | | | | |
| Chip-to-chip-time approx. | 2,1 s (depends on CNC) | | | | | | | | | | | | | | | | | |
| 500 | 1 | <p>Workpiece swivel table 0/180 degrees
with centre divider made of stainless steel
clamping surface 2 x 660 mm x 400 mm
with thread and locating hole grid M16 x ø 15 H7 x 50 mm
workpiece swivel time appr. 2,4 s weight-dependent, self-regulating through self-learning speed-control
table loading capacity per side 0 - max. 300 kg
max. 100 kg weight difference between both table sides</p> | | | | | | | | | | | | | | | | |



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|-----|---|--|--|
| 600 | 1 | <p>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. With 1,0 g acceleration.</p> | |
|-----|---|--|--|

Remark:

With normal conditions the machine does not have to be anchored to the floor.

(For slippery floors we recommend anchoring.)

- | | | | |
|-----|---|--|--|
| 700 | 1 | <p>SIEMENS CNC-control 840D
(PCU 50 / NCU 572.5, 6 measuring circuit, 1 channel)
incl. 10,4" TFT colour LCD screen / full keyboard OP010S
Windows NT/XP
NC-memory 256 KB
(max. 200 programmes storage capacity)
for ISO 66025 programming
hard disk with approx.. 20 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)
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</p> | |
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CHIRON Powersafe

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 point in time at which the machine starts demand-oriented automatically with a variable warmup program to recovery the production readiness.

800	1	CHIRON maintenance management on the screen	
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display of the pending maintenance:
 advance warning = "prepare maintenance"
 warning = "carry out maintenance"
 machine stop = "catch up on maintenance"

Brief instructions for the pending maintenance with graphic illustration on USB data-carrier.

Password protected confirmation of the maintenance work carried out by the maintenance staff.

900	1	Operating hours and piece counter on the screen	
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1000	1	Socket 230 V at control panel	
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1100	1	Socket for portable mini-hand wheel without EMERGENCY-STOP button, at control panel	
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1200	1	Electrical cabinet cooler mounted to the door	
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1300	1	Signal lamp on control panel for 3 signals	
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Signal "red" = failure
 Signal "white" = machine loading
 Signal "green" = machine is running

1400	1	Machine enclosure with full enclosed workspace	
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with sliding doors, electrically interlocked, 2200 mm high above floor, incl. machine lamp service friendly with removable side walls workspace enclosure with stainless steel covers



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|------|---|--|--|
| 1500 | 1 | <p>Chip conveyor (scratch band) small version
with discharge backwards, discharge height 1.050 mm,
tank capacity 150 l, lift pump capacity max. 300 l/min. at 1,3 bar</p> <p>(In case of steel machining and other materials with long chips
we recommend the use of a screw conveyor)</p> | |
| 1600 | 1 | <p>Mini-operating panel
with start and receipt push buttons, for pallet recognition M61/M62</p> | |
| 1700 | 1 | <p>Installation elements</p> | |
| 1800 | 1 | <p>Wash gun
with 1 connection and quick coupling each
in loading- and working area</p> | |
| 1900 | 1 | <p>Central pneumatic-connection
Uncontrolled with 2 connection couplings</p> | |
| 2000 | 1 | <p>Coolant equipment HL 450 / 900
(for cast iron slurry, Al with Si \geq 12%)
tank capacity 900 l,
pump capacity from 100 l/min at 2,1 bar
up to 250 l/min at 1,8 bar
high pressure pump capacity 35 l/min at 30 bar
coolant filtration for high pressure and flood coolant
with hydrostatic paper bond filter HL 450, filtration 50 μm nominal
twin filter in the high pressure circuit for the protection of the
machine.
incl. bed flushing system and
Fixture washing
with nozzles installed at the centre divider
controlled with m-functions for washing the working area.</p> | |



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- 2100 1 **2 x Machine preparation**
 for through tool coolant system including:
 - sealing system in the DIN 69871 Form A40
 or DIN 69893 HSK A63* collet
 - coolant distributor installed at the main spindle drive
 coolant leakage sensor
 - implemented mud flap in the high pressure piping
 - solenoid valve, controlled via machine program

* HSK A63 tool holders for through tool coolant require the use of our patented coolant tube with sieve.
 Advantages: - Decrease of the clogging in the internal coolant channel.
 - Reduction of the wear at the O-ring seal in the collet.

(Subject: requires high pressure equipment)

Fully enclosed workspace

CHIRON Tool lifetime control with:

tool place organization
 sister tool organization
 working area organization by 4-figure program no. in the display
 (only at machines with several working areas)

- 2200 1 **Automatic loading door of total enclosure**
 opening and closing, via two-hand-push-button

- 2300 1 **Electric interface for loader with "Profibus" - Siemens on W-machines for loading through manual or automatic loading door for automatic loading system**
 with DP/DP-coupler (slave) in the electrical cabinet, according to documentation of CHIRON loader interface, consisting of: circuit diagram, signal description and functional diagram,
 interface tested according to Chiron-description,
 incl. key-operated switch and indicator lamp in the control panel "with loader",
 incl. direct door switch in position "door open"

Deviation from the standard interface and set up will be charged according to effort.
 Waiting periods during set up will also be charged.



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Recommended options:

- automatic doors, if necessary
- tool life control
- tool breakage control
- fixture washing
- chip conveyor, if not included in basic machine
- Parts location air sensing
- automatic central lubrication

Note:

The machine has to be anchored with robot loading or linkage. Anchoring the machine to the ground can be made by Chiron if wanted. This outlay will be charged according to effort.

- | | | |
|------|---|---|
| 2200 | 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> |
| 2300 | 1 | <p>Machine shoes</p> |
| 2400 | 1 | <p>Plug connections
for all additional units and pumps</p> |
| 2500 | 1 | <p>Pneumatic and hydraulic connections</p> |
| 2600 | 1 | <p>Central hydraulic and pneumatic supply
prepared for max. 20 connections,
6 connections are installed including connecting couplings,
4 for hydraulic, max. 200 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</p> |
| 2700 | 1 | <p>Hydraulic unit
continuous duty
pressure: 210 bar, flow rate: 4,3 l/min.
incl. valves for supply of 2 clamping circuits
and 2 pressure switches for electric clamping control
1 x A/B per table side</p> |
| 2800 | 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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Machine colour

Two-components-structure varnish - 2 colours

light grey acc. to NCS S1502-B

basalt grey acc. to RAL 7012

Main circuit

total power supply 400 / 230V \pm 10 %, 50 cycles N/PE,

neutral conductor, load possible, pressure supply

6 bar, \pm 1 bar at all procedures,

room temperature max 40°

CMS-GmbH

