

Data sheet I FZ 15 KW no. 132-08

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON FZ 15 KW Nr. 132-08 Year of construction: 2000, weight: 8.800 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with machine bed in mineral cast technique and workpiece swivel table Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
400	1,00 ST	Machine enclosure with loading door, electrically interlocked, 2200 mm high above floor, incl. machine lamp service friendly with removable side walls vertical bellows	
500	1,00 ST	Mini-operating panel with start and receipt push buttons, for pallet recognition M61/M62	
600	1,00 ST	Workpiece swivel table 0/180° degrees with middle partition of sheet steel clamping surface 2 x 660 mm x 400 mm ² with thread and locating hole grid M16 x ø 15 H7 x 50 mm workpiece swivel time approx. 2,0 s depends on the weight, by self-learning speed control table loading capacity per side 0 – max. 300 kg	
700	1,00 ST	Construction of the center divider for a fixture height of 360 mm	
800	1,00 ST	Travel: X-axis 550 mm Y-axis 400 mm Z-axis 360 mm with variable tool changing level	
900	1,00 ST	Main Spindle drive with AC-motor 9,5 KW at 100 % 14,0 KW at 10 % Spindle speed range: 20 - 12.000 rpm - max. 90 Nm Drilling capacity in 60 pc Ø 36 mm Tapping capacity M 24 Milling capacity in steel 150 cm ³ /min	



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Pos.	Qty.	Description	Price
1000	1,00 ST	Automatic tool changer Tool places 48 Tool shaft HSK A63 DIN 69893 Tool- \varnothing max. 82 mm Tool- \varnothing if adjacent places are free max. 125 mm Tool length max. 250 mm Tool weight max. 10,0 kg Chip-to-chip-time approx. 2,4 s (depends on CNC)	
1100	1,00 ST	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. acceleration: 0,5 g in X-axis 1,0 g in Y-axis 1,2 g in Z-axis Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)	
1200	1,00 ST	SIEMENS CNC-control 840D (PCU 50 / NCU 572.5 6 measuring circuit, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP032S 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	



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		3D and helical interpolation screen switch off, mirror function scaling function, insert of chamfer and radius Universal interface RS 232C (2 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 rigid taping, Look ahead	
1300	1,00 ST	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 programm to recovery the production readiness.	
1400	1,00 ST	Working hours and piece counter in the screen	
1500	1,00 ST	Socket 230 V at control panel	
1600	1,00 ST	Socket for portable mini-hand wheel without EMERGENCY-STOP button, at control panel	
1700	1,00 ST	Fully enclosed working area	
1800	1,00 ST	Cabinet cooler as a door mounting unit	
1900	1,00 ST	Installation elements	
2000	1,00 ST	Glass scales HEIDENHAIN, overpressured in all axes X, Y, Z = 550 x 400 x 360 mm	
2100	1,00 ST	Chip conveyer (scratch band) discharge height 1.050 mm with coolant equipment, tank capacity 400 l, pump capacity max. 150 l/min. at 2,0 bar	



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2200	1,00 ST	<p>Coolant tank (also for sludge generating materials, i.e. grey cast iron, GGG, Al with Si \geq 12%) tank capacity 800 l low pressure pump capacity 200 l/min at 2.5 bar high pressure pump capacity 20 l/min at 30 bar Full stream purification via drum paper bond filter PF 50 and twin filter incl. tube flushing</p>	
2300	1,00 ST	<p>Machine preparation for through tool coolant system including: - Sealing system in the DIN 69893 HSK A63* collet - coolant distributor installed at the main spindle drive - Coolant leakage sensor - Implemented mud flap in the high pressure piping and flow control switch - Solenoid valve, controlled via machine program * At HSK A63 we recommend for tool holders the use of our patented coolant tube with sieve. Advantages: Decrease of the clogging in the internal coolant channel.</p>	
2400	2,00 ST	<p>NC-rotary-table package complete installed consisting of: - NC-rotary-table, type AWU 160 P, Fabr. Chiron-Peiseler - 4th and 5th NC-axes, complete - 2 adapter-plates for center height 200 mm - central pneumatic supply without control Technical description for NC-rotary-table: center height 165 mm, repetition accuracy $\pm 15''$, face plate dia. 160 mm, with center bore dia. 50 +0.012, fixture pin dia. 16 h7, 4 fixture bores M10, incl. pneumatic clamping</p>	
2500	2,00 ST	<p>CHIRON standard fixture for rotary table with hydraulic actuated counter bearing bridge size 580 mm, existing of: - adaptor plate (instead of the adapter plate on the rotary package) mountable and demountable on the work piece changing device - counter bearing with pneumatic clamping - cheek with "Quick-Locator" - cheek with "Fluid-Team hydr. clamping" - cheek incl. 2 connecting couplings, on side of the rotary table - cheek incl. 2 connecting couplings, on side of the counter bearing - 2 x 2-core energy supply - centre height 165 mm over base plate</p>	



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2600	1,00 ST	Pneumatic- and Hydraulic Connections	
2700	1,00 ST	Pneumatic connection controlled with A/B connection on each tableside for pneumatic clamping device 2 electrically activated pneumatic connections for double acting; one pressure control, either for one or two controlled clamping circuits; at each clamping circuit pressure control switch with automatic pressure regulation. (in case of pressure change automatic pressure sensing)	
2800	1,00 ST	Cutting tools The cutting tools have to be balanced according to VDI 2060, class G 2,0	
2900	1,00 ST	Central pneumatic connection uncontrolled with 2 connection couplings	
3000	1,00 ST	- Documentation -	
3100	1,00 ST	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	
3200	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
3300		Main circuit 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°	
3400		Information Export We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.	



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3500		<p>Information Machine safety</p> <p>The machine is designed and built in accordance with the European machine guideline, according placing the product on the first time onto the market.</p> <p>Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.</p>	
3600		<p>Information Coolant lubrication</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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