

**Data sheet I FZ 15 W no. 147-37**

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON FZ 15 W Nr. 147-37</b>  <b>Year of construction: 2003, weight: 7.820 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre in steel- concrete- composite design</b> with workpiece changing device Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
400	1,00 ST	<b>Machine enclosure</b> 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	<b>Workpiece swivel table 0/180 degrees</b> 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	
600	1,00 ST	<b>Mini-operating panel</b> with start and receipt push buttons, for pallet recognition M61/M62	
700	1,00 ST	<b>Travel:</b> X-axis            550 mm Y-axis            400 mm Z-axis            425 mm with adjustable tool change level	
800	1,00 ST	<b>Main Spindle drive with 2 AC-motors</b> 9,5 KW at 100 % 14,0 KW at 15 % Spindle speed range: 20 – 12.000 rpm - max. 90 Nm  Drilling capacity in St 60            Ø 36 mm with reversible plate drill Tapping capacity                        M 24 Milling capacity in St 60                300 cm <sup>3</sup> /min	



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900	1,00 ST	<p><b>Automatic tool changer, protected against chips</b></p> <p>Tool places 20            Tool shaft SK 40 DIN 69871 + 72            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 4 places)            Tool change time appr. 0,9 s (depends on CNC)            Chip-to-chip-time approx. 2,1 s (depends on CNC)</p>	
1000	1,00 ST	<p><b>AC-servo motors for x-, y- and z-axes</b></p> <p>digital direct drives with indirect absolute path measuring system            rapid traverse in all axes 60 m/min.            acceleration 1,0 g</p> <p>Remark:            With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)</p>	
1100	1,00 ST	<p><b>SIEMENS CNC-control 840D</b>            (PCU 50.3 / NCU 572.5)            incl. 10,4" TFT colour LCD screen / full keyboard OP032S            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            crossing radius            4 zero offsets G54-G57            30 zero shifts programmable with G-functions            3D and helical interpolation            screen switch off            mirror function</p>	



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Pos.	Qty.	Description	Price
		scaling function insert of chamfer and radius Universal interface RS 232C (2 x V24) 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 powermeter in screen	
1200	1,00 ST	<b>CMS Powersafe</b> 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	
1300	1,00 ST	<b>Working hours and piece counter</b> in the screen	
1400	1,00 ST	<b>Socket 230 V</b> at control panel	
1500	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
1600	1,00 ST	<b>Socket for portable mini-hand wheel</b> without emergency stop button, at control panel	
1700	1,00 ST	<b>Installation elements</b>	
1800	1,00 ST	<b>Wash gun</b> with each 1 connection and quick coupling in loading- and working area	
1900	1,00 ST	<b>Automatic grease lubrication</b>	
2000	1,00 ST	<b>Fully enclosed working area</b>	
2100	1,00 ST	<b>Chip conveyor (scratch band)</b> with lateral discharge, discharge height 1050 mm, tank capacity 400 ltr., with pump capacity 150 l/min. at 2,0 bar incl. bed flush	



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2200	1,00 ST	<p><b>Coolant tank TPF 350 / FKA 900 (new)</b>            (also for sludge generating materials, i.e. grey cast iron, GGG, Al with Si <math>\geq</math> 12%)            tank capacity 900 l            low pressure pump capacity from 100 l/min at 2.4 bar up to 250 l/min at 2.3 bar            high pressure pump capacity 30 l/min at 30 bar            Full stream purification via drum paper bond filter TPF 350 S, with coolant purification 50 <math>\mu</math>m nominal            twin filter in the high pressure circuit for the protection of the machine</p>	
2300	1,00 ST	<p><b>Machine preparation</b>            for through tool coolant system including:            - Sealing system in the DIN 69871 Form A40 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            (Subject: required high pressure equipment)</p>	
2400	1,00 ST	<b>Thermocontrol</b>	
2500	1,00 ST	<b>Pneumatic- and Hydraulic Connections</b>	
2600	1,00 ST	<p><b>Central hydraulic and pneumatic supply</b>            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</p>	
2700	1,00 ST	<p><b>Central pneumatic connection</b>            uncontrolled with 2 connection couplings</p>	
2800	1,00 ST	<p><b>Hydraulic unit</b>            for continues duty            pressure: 210 bar less than 30 seconds            supply capacity: 4,3 l/min.            incl. valves for supply of 2 clamping devices            and 2 pressure switches for clamping control</p>	



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2900	1,00 ST	<p><b>Cutting tools</b></p> <p>The cutting tools have to be balanced according to DIN ISO 1940, class G 2,5, in two levels, with max. operating speed</p>	
3000	1,00 ST	- <b>Documentation</b> -	
3100	1,00 ST	<p><b>Documentation acc. to CE of the first delivery into market</b></p> <p>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</p>	
3200	1,00 ST	<p><b>Machine colour</b></p> <p>Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012</p>	
3300		<p><b>Main circuit</b></p> <p>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°</p>	
3400		<p><b>Information Export</b></p> <p>We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.</p>	
3500		<p><b>Information Machine safety</b></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>	



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3600		<p><b>Information Coolant lubrication</b></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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