

Data sheet I FZ 15 W no. 147-73

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON FZ 15 W Nr. 147-73 Year of construction: 2003, weight: 7.820 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	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	
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	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	
600	1,00 ST	Mini-operating panel with start and receipt push buttons, for pallet recognition M61/M62	
700	1,00 ST	Travel: X-axis 550 mm Y-axis 400 mm Z-axis 425 mm with adjustable tool change level	
800	1,00 ST	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	
		Drilling capacity in St 60 Ø 36 mm with reversible plate drill	
		Tapping capacity M 24	
		Milling capacity in St 60 300 cm ³ /min	



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900	1,00 ST	<p>Automatic tool changer, protected against chips</p> <p>Tool places 20</p> <p>Tool shaft SK 40 DIN 69871 + 72</p> <p>Tool-\varnothing max. 65 mm</p> <p>Tool-\varnothing</p> <p>if adjacent places are free max. 150 mm</p> <p>Tool weight max. 2,5 kg (5,0 kg at 4 places)</p> <p>Tool change time appr. 0,9 s (depends on CNC)</p> <p>Chip-to-chip-time approx. 2,1 s (depends on CNC)</p>	
1000	1,00 ST	<p>AC-servo motors</p> <p>for x-, y- and z-axes</p> <p>digital direct drives with indirect absolute path measuring system</p> <p>rapid traverse in all axes 60 m/min. With 1,0 g acceleration.</p>	
1100	1,00 ST	<p>SIEMENS CNC-control 840D</p> <p>(PCU 20 / NCU 572.3, 6 measuring cycles, 1 channel)</p> <p>incl. 10,4" TFT colour LCD screen / full keyboard OP010S</p> <p>NC-memory 256 KB</p> <p>(max.200 programmes storage capacity)</p> <p>for ISO 66025 programming</p> <p>drilling cycles G81-G89</p> <p>drilling and milling cycles</p> <p>M- and T- functions</p> <p>circular interpolation (360 degrees)</p> <p>re-start into program</p> <p>Subroutines, parameter programming</p> <p>simultaneous programming</p> <p>contour programming with cycle support</p> <p>support through cycles</p> <p>polar coordinates</p> <p>tool offsets for geometry, wear</p> <p>tool radius correction for</p> <p>intersection computing</p> <p>crossing radius</p> <p>4 zero offsets G54-G57</p> <p>30 zero shifts programmable with G-functions</p> <p>3D and helical interpolation</p> <p>screen switch off</p> <p>mirror function</p> <p>scaling function</p> <p>insert of chamfer and radius</p> <p>Universal interface RS 232C (2 x V24)</p> <p>orientated spindle stop</p>	



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		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	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	
1300	1,00 ST	Working hours and piece counter in the screen	
1400	1,00 ST	Socket 230 V at control panel	
1500	1,00 ST	Cabinet cooler as a door mounting unit	
1600	1,00 ST	Socket for portable mini-hand wheel without emergency stop button, at control panel	
1700	1,00 ST	Installation elements	
1800	1,00 ST	Wash gun with each 1 connection and quick coupling in loading- and working area	
1900	1,00 ST	Automatic grease lubrication	
2000	1,00 ST	Fully enclosed working area	
2100	1,00 ST	Chip conveyor (scratch band) with lateral discharge, discharge height 1050 mm, tank capacity 300 ltr., with pump capacity 150 l/min. at 1,5 bar incl. bed flush	
2200	1,00 ST	For machining with high chip volume or additional flushing options and the resultant big coolant flow we recommend, to calm down the coolant and to decrease the cleaning cycles at the chip conveyor and the coolant pipes, coolant equipment with a tank capacity of 900 l.	



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2300	1,00 ST	Coolant equipment tank capacity 900 l, pump capacity 200 l/min. at 2,0 bar (the pump in the chip conveyor becomes the lift pump) incl. bed flushing system	
2400	1,00 ST	Package m-functions m72/m73 2 m-function pairs for m74/m75 simple ON/OFF function m76 m-functions to control a m78 peripheral equipment with external setback (blocking of the machine course)	
2500	1,00 ST	Slot sieve type W = 0,35	
2600	1,00 ST	Suction point for customer specific installation Ø 200 mm on top of the machine enclosure	
2700	1,00 ST	Pneumatic- and Hydraulic Connections	
2800	1,00 ST	Central pneumatic connection uncontrolled with 2 connection couplings	
2900	1,00 ST	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	
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°	



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3400		<p>Information Export</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>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>	

