

**Data sheet I CHIRON DZ 15 W no. 157-88**

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON DZ 15 W no. 157-88</b>  <b>Year of construction: 2002, weight: 7.220 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre</b> 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	<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 middle partition of sheet steel clamping surface 2 x 660 mm x 400 mm <sup>2</sup> with thread and locating hole grid M16 x Ø 15 H7 x 50 mm workpiece swivel time appr. 2,4 s depends on the weight, self-regulating by 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 300 mm Y-axis 400 mm Z-axis 425 mm with variable tool changing level Spindle distance 250 mm	
800	1,00 ST	<b>Main Spindle drive with 2 AC-motor</b> 9,5 KW at 100 % 14,0 KW at 15 % Spindle speed range: 20 - 12.000 rpm - max.90 Nm  Drilling capacity in 60 pc 2 x Ø 36 mm Tapping capacity 2 x M 24 Milling capacity in steel 2 x 150 cm <sup>3</sup> /min	



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900	1,00 ST	<b>Automatic tool changer</b> Tool places 2 x 12 Tool shaft HSK A63 DIN 69893 Tool- $\varnothing$ max. 65 mm Tool- $\varnothing$ if adjacent places are free max. 150 mm Tool weight max. 2,5 kg (5,0 kg on 2 places) Tool changing time approx. 0,9 s (depends on CNC) Chip-to-chip-time approx. 2,1 s (depends on CNC)	
1000	1,00 ST	<b>AC-servo motors for x-, y- and z-axes</b> digital direct drives with indirect absolute path measuring system rapid traverse in all axes 60 m/min. acceleration: 1,0 g  Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)	
1100	1,00 ST	<b>SIEMENS CNC-control 840D</b> (PCU 20 / NCU 572.3, 6 measuring circuit, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP010S 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	



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Pos.	Qty.	Description	Price
		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	
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 at control panel</b>	
1500	1,00 ST	<b>Socket for portable mini-hand wheel</b> without EMERGENCY-STOP button, at control panel	
1600	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
1700	1,00 ST	<b>Installation elements</b>	
1800	1,00 ST	<b>Chip conveyor (scratch band)</b> discharge height 1050 mm, lateral discharge tank capacity 400 ltr, pump capacity 150 ltr/min at 2,0 bar	
1900	1,00 ST	<b>Wash gun</b>	
2000	1,00 ST	<b>Central pneumatic-connection</b> Uncontrolled with 2 connection couplings	



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2100	1,00 ST	<b>Signal lamp for 3 signals</b> Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running	
2200	1,00 ST	<b>Automatic loading door of total enclosure</b> opening and closing, actuating to closing via two-hand push buttons	
2300	1,00 ST	<b>Fully enclosed working area</b>	
2400	1,00 ST	<b>Coolant equipment</b> tank capacity 900 ltr., pump capacity 200 ltr/min at 2,0 bar (the pump in the chip conveyor becomes the lift pump) pump capacity 35 ltr/min at 30 bar full flow cleaning via vacuum rotation filter VRF 300, filtration 50 µm nominal incl. tub flushing	
2500	2,00 ST	<b>Machine preparation</b> for through tool coolant system including: <ul style="list-style-type: none"> <li>- Sealing system in the DIN 69893 HSK A63* collet</li> <li>- coolant distributor installed at the main spindle drive</li> <li>- Coolant leakage sensor</li> <li>- Implemented mud flap in the high pressure piping and flow control switch</li> <li>- Solenoid valve, controlled via machine program</li> </ul> * 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.	
2600	1,00 ST	<b>Automatic central grease lubrication</b>	
2700	1,00 ST	<b>Pneumatic- and Hydraulic Connections</b>	
2800	1,00 ST	<b>Central hydraulic and pneumatic supply</b> 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	



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2900	1,00 ST	<b>Hydraulic unit</b> continuous duty at switch cycles less than 30 seconds pressure: 210 bar, output: 4,3 ltr/min incl. valves for supply of 2 clamping circuits and 2 pressure switches for electric clamping control	
3000	1,00 ST	<b>- Documentation -</b>	
3100	1,00 ST	<b>Documentation acc. to CE of the first delivery into market</b> 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	<b>Machine colour</b> Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
3300		<b>Main circuit</b> 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		<b>Information Export</b> We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.	
3500		<b>Information Machine safety</b> The machine is designed and built in accordance with the European machine guideline, according placing the product on the first time onto the market. Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.	



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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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