

Complete machine description

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| 1 | 1 | <p>Completely refurbished vertical CNC-machining centre model FZ 08 W
 Year of construction: 2001, weight: 2.200 kg</p> | |
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Machine-No. 204-17

Scope of delivery:

Column moving machining centre with workpiece swivel table

Main spindle drive with AC-motor

2,2 kW	at 100%
7,4 kW	at 25%
Spindle speed range:	20 – 15.000 rpm – 23 Nm

Drilling capacity	Ø 16 mm
Tapping capacity	M 12
Milling capacity	30 cm ³ /min

Travel:

X-axis	300 mm
Y-axis	250 mm
Z-axis	250 mm

Automatic tool changer

as chain magazine (without basket changer)	
full enclosed pick up tool changer	
Tool places	23
Tool shaft	HSK 32 DIN 69893
Tool-Ø	max. 40 mm (50 mm at free neighbour places)
Tool length	160 mm
Tool weight	max. 0,7 kg
Tool change time approx.	0,8 s (depends on CNC)
Chip-to-chip-time approx.	2,2 s (depends on CNC)



Pos.	Qty.	Article Description	Price / €
		<p>Work piece changer 0/180 degrees With centre divider made from stainless steel Clamping surface 2 x 550 x 300 mm² with thread and locating hole grids M 16 x Ø 15 H7 x 50 mm Work piece changing time approx. 2,0s weight dependent Self-controlled by self-learning speed control Table loading capacity per side max. 100 kg Maximum 50 kg weight difference between both table sides</p> <p>AC-servo-motors Feed drives for X-, Y- and Z-axis Indirect absolute path measuring system Rapid traverse in X- and Y-axis: 40 m/min, acceleration 0,7g Rapid traverse in Z-axis: 60 m/min, acceleration 1,0g Please note: anchoring recommended on slippery floor</p> <p>SIEMENS CNC-control 840D (MMC 103 / NCU 571.2, 6 measuring circuits, 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 1,5 GB program memory for free disposal dialog programming, mill simulation loading block by block from the hard disk 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 polar coordinates tool offsets for geometry, wear tool radius correction for intersection computing crossingradius 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 (2 x V24)</p>	



Pos.	Qty.	Article Description	Price / €
		orientated spindlestop drip feed function through V24 interface dimension metric or inch software limitswitch NC-diagnosis machine-diagnosis absolute indirect path measurement systems powermeter in screen rigid tapping look ahead function	
		Shopmill incl. tool management, keyboard	
		PCI / ISA Adapter with 2 slots (for example for connection to the network)	
		Network card incl. installation, with 3 connections (AUI; RJ45; RG58) The wiring to the network isn't included	
		Socket 230 V at control panel	
		Machine enclosure bolted on, with loading door, electrically interlocked, 2.000 mm high above floor, incl. machine lamp	
		Cabinet cooler as door mounting unit	
		Installation elements	
		Wash gun	
		Machine preparation for through tool coolant system including - Sealing system in the HSK-A 32 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	



Pos.	Qty.	Article Description	Price / €
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Chip conveyor (scratch band)

discharge height 495 mm with coolant equipment,
tank capacity 150 l, pump capacity 100 l/min at 1,3 bar

High pressure pump

used together with the standard coolant unit or
the chip conveyor as Inline-pump

Pump pressure max. 150 bar
Pump capacity max. 6 l/min.
Vario valve 20, 30, 50, 55, 60, 65, 70 bar
Partical coolant cleaning system 60 µ via twin filter
Flow monitor

2 NC Rotary table package, completely installed consisting of:

- NC rotary table, type AWU P 100
mountable to the workpiece swivel table
- interface 4th + 5th NC-axis, ready for plug-in
lowest increment 0.001°
- pneumatic supply, without control

Technical description NC rotary table
indexing accuracy ± 30"
max. spindle speed 80 rpm
spindle pneumatic clamped, center height 125 mm
face plate dia. 100 mm, center bore dia. 50+0,012,
through bore dia 35 mm, location pin dia. 10 h7,
4 bolt holes M8

2 CHIRON standard fixture for rotary table

- with hydraulic actuated counter bearing
consisting of:
- base plate for AWU P 100 and counter bearing
 - counter bearing with pneumatic clamping
 - Centering flange, rotary table side
 - Centering flange, counter bearing side
 - Counter bearing bolts
 - 2 x 1-core energy supply (pneumatic)
 - Center height 125 mm

Suction point

Suction power 500 m³/h
Mounted and integrated in the machine frame



Machine colour

Two-components-structure varnish - 3 colours

light grey acc. to NCS S1502-B

blue acc. to NCS S2050-R80B

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°

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.

Information Machine safety

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.

Information Coolant lubrication

The machine is designed for standard water soluble coolant and fully enclosed at the standard version.

The machine must be equipped with fume extraction.

The machine contents different plastics, varnish, resin and glue, which are selected carefully for using coolant and cutting oil.

The use of aggressive coolant and additive could cause major damages and machine stops.

Contact in any case your coolant supplier before machine set-up and installation.

