

Data sheet I DZ 18 WM no. 442-03

Pos.	Qty.	Description	Price
100	1,00 ST	<p>Function tested vertical machining centre CHIRON DZ 17 WM Nr. 442-03</p> <p>Completely refurbished and modernised in 2017, weight: 6.000 kg</p>	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with workpiece swivel table	
400	1,00 ST	<p>Machine enclosure bolted on, with loading door, electrically interlocked, 2.600 mm high above floor, incl. machine lamp.</p>	
500	1,00 ST	<p>Mini-operating panel with start and receipt push buttons, for pallet recognition M61/M62</p>	
600	1,00 ST	<p>Workpiece swivel table 0/180 degrees with centre divider Clamping surface 2 x 850 x 470 mm² with thread and locating hole grids M 16 x Ø 15 H7 x 50 mm Tool change time approx. 4,0 s Table loading capacity per side max. 250 kg (400 kg)</p>	
700		<p>Travel:</p> <p>X-axis 400 mm Y-axis 400 mm Z-axis 630 mm with adjustable tool change level Spindle dist. X-Axis 320 mm</p>	
800	1,00 ST	<p>Main spindle drive with 2 AC-motors</p> <p>5,0 kW at 100% 9,5 kW at 25% Spindle speed 20 – 10.500 rpm – 60 Nm</p> <p>Drilling capacity in steel 60 2 x ø 35 mm Tapping capacity 2 x M 22 Milling capacity in steel 60 2 x 150 cm³/min.</p>	

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900	1,00 ST	Automatic tool changer Tool places 2 x 12 Tool shaft HSK A 63 DIN 69893 Tool- \varnothing max. 65 mm Tool- \varnothing if adjacent places are free max. 180 mm Tool weight max. 4,0 kg (8,0 kg on 2 places per spindle) Tool change time approx. 0,9 s (depends on CNC) Chip-to-chip-time approx. 2,4 s (depends on CNC)	
1000	1,00 ST	AC-servo-motors, Feed drives for X-, Y- and Z-axis Indirect absolute path measuring system Rapid traverse 30 m/min	
1100	1,00 ST	ADI 4 Analogue drive and motors remain	
1200	1,00 ST	SIEMENS CNC-control 840D Solution Line (PCU 50 / NCU 720.3, 10 measuring circuits, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP010S operator panel logic, Windows XP NC-memory 3 MB Standard (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 scaling function	

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Pos.	Qty.	Description	Price
		<p>insert of chamfer and radius</p> <p>Universal interface RS 232C (2 x V24) sideways at control panel</p> <p>USB-interface at the control panel</p> <p>Ethernet connection RJ45 in the control panel</p> <p>orientated spindle stop</p> <p>drip feed function through V24 interface</p> <p>dimension metric or inch</p> <p>software limits witch</p> <p>NC-diagnosis</p> <p>machine-diagnosis</p> <p>absolute indirect path measurement systems</p> <p>power meter in screen</p> <p>rigid tapping, look ahead function with dynamic feedforward</p>	
1300	1,00 ST	<p>CHIRON Powersafe</p> <p>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.</p> <p>Definable point in time at which the machine starts demand-oriented automatically with a variable warmup program to recovery the production readiness.</p>	
1400	1,00 ST	<p>Working hours and piece counter</p> <p>in screen</p>	
1500	1,00 ST	<p>Cabinet cooler as a door mounting unit</p>	
1600	1,00 ST	<p>Installation elements</p>	
1700	1,00 ST	<p>Wash gun</p>	
1800	1,00 ST	<p>Chip conveyer (scratch band)</p> <p>(for cast iron slurry)</p> <p>discharge height 1050 mm with coolant equipment</p> <p>tank capacity 500 ltr.,</p> <p>pump capacity 200 ltr/min at 1,3 bar</p> <p>pump capacity 20 ltr/min at 20 bar</p> <p>high pressure circuit with coolant filtration via paperbondfilter PF50 and twinfilter incl. bed flushing system</p> <p>(This filtration method will not eliminate increasing cast iron slurry from the coolant equipment.)</p>	
1900	2,00 ST	<p>Machine preparation</p> <p>for through tool coolant system including acc. DIN 69871 Form A40</p>	

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2000	1,00 ST	Automatic loading door of total enclosure opening and closing, actuating to closing via two-hand push buttons	
2100	1,00 ST	4th NC-axes ready for plug in	
2200	1,00 ST	Pneumatic- and Hydraulic Connections	
2300	1,00 ST	Hydraulic connection for 210 bar with rotation distributor 10-fold and 6 connecting couplings for hydraulic, 2 connecting couplings 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	
2400	2,00 ST	Hydraulic connection for 200 bar with 1 connecting coupling A and hydraulic installation up to outside of machine bed, incl. valve to control 1 single acting clamping circuit with pressure switch for electrical clamping control and electrical control for clamping OPEN-CLOSED	
2500	1,00 ST	Hydraulic connection for 200 bar with 2 connecting couplings A+B on each table side and hydraulic installation up to outside of machine bed, incl. valve to control 2 double acting clamping circuit with pressure switch for electrical clamping control and electrical control for clamping OPEN-CLOSED	
2600	1,00 ST	Hydraulic unit continuous duty pressure: 200 bar	
2700	1,00 ST	Hydraulic clamping for rotary table- and/or counterbearing	
2800	1,00 ST	CHIRON Variable Clamping Logic For the definition of different clamping and releasing sequences, for a maximum of 10 functions with a maximum of 8 steps. Considering of time delay and monitoring of clamping circuits e.g. through pressure switches or airsensing. The storing of the configuration and reloading, allows fast changeover.	

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2900	1,00 ST	Two-hand-push-buttons for clamping ON - OFF, instead of button in operating panel	
3000	1.00 ST	Rigid tapping	
3100	1,00 ST	Chiron Lasercontrol Single F500 for tool breakage control, distance from transmitter to receiver ≤ 1000 mm, min. tool $\varnothing > 1$ mm, incl. test mandrel with tool holder, transmitter and receiver, gland and shutter	
3200	1,00 ST	Parts location air sensing with 1 switch, completely installed, including energy-efficient shutdown during machining. Remark: Maximum 3 nozzles per switch. Precondition: Processed faces or aluminium die casting (not on partition or ejector flags), no grey cast iron. At rotary table and standard fixture for rotary table are additional turning supplies necessary. Remark: Lines will be fed through pendulum connection	
3300	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
3400	1,00 ST	- Documentation -	
3500	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	
3600		Main circuit total power supply $400 / 230V \pm 10 \%$, 50 cycles N/PE, neutral conductor, load possible, pressure supply $6 \text{ bar}, \pm 1 \text{ bar}$ at all procedures, room temperature max 40°	

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3700		<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>	
3800		<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>	
3900		<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>	