

Complete description

- | | | | |
|---|---|--|--|
| 1 | 1 | Partly refurbished
vertical CNC-machining centre model FZ 08 KWM
Year of construction: 2006, weight: 3.600 kg | |
|---|---|--|--|

Machine-No. 230-52

Scope of delivery:

Column moving machining centre with workpiece swivel table
 Guideways with long-term lubrication

Main Spindle drive with AC-motor

with air purge and monitoring of the tool clamping

2,2 KW at 100 %

7,4 KW at 25 %

Spindle speed range: 20 - 15.000 rpm - max.23 Nm

Drilling capacity in 60 pc.	Ø 16 mm
Tapping capacity	M 12
Milling capacity in steel in 60 pc.	60 cm ³ /min

Travel:

X-axis	450 mm
Y-axis	270 mm
Z-axis	310 mm

Automatic tool changer

through robust, full enclosed pick up tool changer,
 with mechanical impact protection and cleaning
 of the tool taper through air blow

Tool places	24
Tool shaft	HSK-A 40 DIN 69893
Max Tool-Ø	max. 47 mm
Max Tool-Ø	
if next places are free	100 mm
Tool length	160 mm
Max. tool weight	max. 1,2 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 / €
------	------	---------------------	-----------

Workpiece swivel table 0/180 degrees

with centre divider made of sheet metal
clamping surface 2 x 550 mm x 300 mm
with thread and locating hole grid M16 x ø 15 H7 x 50 mm
workpiece swivel time appr. 2,0 s weight-dependent, self-regulating
through self-learning speed-control
table loading capacity per side 200 kg,
max. 50 kg weight difference between the two table sides

AC-servo-motors

feed drives for X-, Y- and Z-axes,
indirect absolute path measuring system
rapid traverse in X- and Y-axes 40 m/min
rapid traverse in Z-axes 60 m/min
acceleration X- and Y-axes 0,7 g, Z-axis 1,0 g

SIEMENS CNC-control 840D

(PCU 50 / NCU 573.4, 6 Messkreise, 1 Kanal)
incl. 10,4" TFT colour LCD screen / full keyboard OP010S
control panel logic Windows NT
NC-memory 256 KB
(max.200 programmes storage capacity)
for ISO 66025 programming
hard disk with approx. 2 GB for free disposal
power meter in screen
screen switch off
look ahead function
Bellshape-acceleration ramp
software limit switch
access authorization over key switch
for tool correction, NC-program changes
and machine parameters
orientated spindle stop
rigid tapping
re-start into program
Subroutines, parameter programming
simultaneous programming
support through cycles

drilling cycles G81-G89
drilling and milling cycles
M- and T- functions
tool offsets for geometry, wear
4 zero offsets G54-G57
30 zero shifts programmable with G-functions



Pos.	Qty.	Article Description	Price / €
------	------	---------------------	-----------

tool radius correction for
intersection computing
crossing radius
contour programming
dimension metric or inch
mirror function
polar coordinates
circular interpolation (360 degrees)
3D and helical interpolation

drip feed function through V24 interface
Universal interface RS 232C (2x V24) at control panel
Ethernet connection RJ45 in control panel

NC-diagnosis
machine-diagnosis

CHIRON Powersafe

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. Definable point in time at which the machine starts demand-oriented automatically with a variable warmup program to recovery the production readiness.

CHIRON Maintenance Management in the screen

display of the pending maintenance:
advance warning = "prepare maintenance",
warning = "carry out maintenance",
machine stop = "catch up on maintenance".
Abridged instructions for the pending maintenance with graphic illustration on CD-ROM.
Confirmation of the performed maintenance through the maintenance staff by password.

Thermocontrol

Thermodrive

Working hours and piece counter
in the screen

Socket 230 V
at control panel



Pos.	Qty.	Article Description	Price / €
------	------	---------------------	-----------

Socket for portable mini-hand wheel

without emergency stop button,
at control panel

Machine enclosure with full enclosed workspace

with loading doors, electrically interlocked,
including replaceable safety windows,
workspace enclosure with stainless steel covers,
2070 mm high above floor, including machine lamp

Signal lamp for 3 signals

Signal "red" = failure
Signal "white" = machine loaded
Signal "green" = machine is running

Chip conveyor (scratch band)

discharge height 490 mm instead of standard-coolant equipment,
tank capacity 110 l,
Coolant cleaning by slot screen case

Cabinet cooler as a door mounting unit

Cabinet cooler doors as bipartite model

Oil-free air service unit

with automatic condensate separator,
pressure control of the air supply
and micro filter 0,01 µm for air purge

Installation elements

Wash gun

With 1 connection and fast coupling per loading- and working area.

Fixture flushing

Incl. coolant connection
At the loading side (instead at the working side)



Pos.	Qty.	Article Description	Price / €
------	------	---------------------	-----------

Pneumatic connection controlled

with A/B connection on each tableside
for pneumatic clamping device
2 electrically activated pneumatic connections
for double acting; one pressure control,
either for one or two controlled clamping circuits;
at each clamping circuit pressure control
switch with automatic pressure regulation.
(in case of pressure change automatic pressure sensing)

Machine colour

RAL 9010

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.

