

## Data sheet I CHIRON DZ 15 W no. 258-36

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON DZ 15 W no. 258-36</b>  <b>Year of construction: 2006, weight: 7.820 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Type 15</b> Processing medium cooling lubricant	
400	1,00 ST	<b>Column moving machining centre in steel- concrete- composite design</b> with workpiece changing device Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
500	1,00 ST	<b>Machine enclosure with full enclosed workspace</b> with sliding doors, electrically interlocked, 2200 mm high above floor, incl. machine lamp service friendly with removable side walls workspace enclosure with stainless steel covers	
600	1,00 ST	<b>Travel:</b> X-axis 300 mm Y-axis 400 mm Z-axis 425 mm with adjustable tool change level Spindle distance 250 mm	
700	1,00 ST	<b>Main Spindle drive with 2 AC-motors</b> 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 2 x Ø 36 mm with reversible plate drill Tapping capacity 2 x M 24 Milling capacity in St 60 2 x 150 cm <sup>3</sup> /min	
800	1,00 ST	<b>Workpiece swivel table 0/180 degrees</b> 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 max. 100 kg weight difference between both table sides	



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900	1,00 ST	<b>Automatic tool changer, protected against chips</b> Tool places 2 x 12 Tool shaft SK 40 DIN 69871 + 72 Tool-Ø max. 65 mm Tool-Ø if adjacent places are free max. 150 mm Tool weight max. 2,5 kg (5,0 kg at 2 places) Tool change time appr. 0,9 s (depends on CNC) Chip-to-chip-time approx. 2,1 s (depends on CNC)	
1000	1,00 ST	<b>Mini-operating panel</b> with start and receipt push buttons, for pallet recognition M61/M62	
1100	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. With 1,0 g acceleration.  Remark: With normal conditions the machine does not have to be anchored to the floor. (For slippery floors we recommend anchoring.)	
1200	1,00 ST	<b>SIEMENS CNC-control 840D</b> (PCU 50 / NCU 572.5, 6 measuring circuit, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP010S Windows XP 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	



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		3D and helical interpolation screen switch off mirror function scaling function insert of chamfer and radius Universal interface RS 232C (1 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  <b>Pressure regulator in the unclamping line (B-cycles)</b>  <b>Rigid taping</b>  <b>USB-interface</b>	
1300	1,00 ST	<b>CHIRON Powersafe</b> 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 programm to recovery the production readiness.	



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Pos.	Qty.	Description	Price
1400	1,00 ST	<b>CHIRON maintenance management on the screen</b> display of the pending maintenance: advance warning = "prepare maintenance" warning = "carry out maintenance" machine stop = "catch up on maintenance" Brief instructions for the pending maintenance with graphic illustration on USB data-carrier. Password protected confirmation of the maintenance work carried out by the maintenance staff.	
1500	1,00 ST	<b>Operating hours and piece counter</b> on the screen	
1600	1,00 ST	<b>Fully enclosed working area</b>	
1700	1,00 ST	<b>Socket 230 V</b> at control panel	
1800	1,00 ST	<b>Socket for portable mini-hand wheel</b> without emergency stop button, at control panel	
1900	1,00 ST	<b>Wash gun</b> with 1 connection and quick coupling each in loading- and working area	
2000	1,00 ST	<b>Installation elements</b>	
2100	1,00 ST	<b>Chip conveyor (scratch band) small version</b> with discharge backwards, discharge height 1.050 mm, tank capacity 150 l lift pump capacity max. 300 l/min. at 1,3 bar (In case of steel machining and other materials with long chips we recommend the use of a screw conveyor)	
2200	1,00 ST	<b>Coolant equipment FKA 900</b> (for cast iron slurry, Al with Si $\geq$ 12%) tank capacity 900 l, pump capacity from 100 l/min at 2,1 bar up to 250 l/min at 1,8 bar incl. bed flushing system and <b>Device flushing</b> with nozzles controlled with m-functions for washing the working area	



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2300	1,00 ST	<b>Device flushing</b> incl. coolant connection in the loading station	
2400	1,00 ST	<b>Working area flushing</b> with flushing nozzles at both sides in the machine enclosure	
2500	1,00 ST	<b>Signal lamp for 3 signals</b> Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running	
2600	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
2700	1,00 ST	<b>Automatic loading door of total enclosure</b> opening and closing	
2800	1,00 ST	<b>Automatically central grease lubrication</b>	
2900	1,00 ST	<b>Package m-functions</b> 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)	
3000	1,00 ST	<b>Suction point</b> for customer specific installation Ø 200 mm on top of the machine enclosure	
3100	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	
3200	1,00 ST	<b>Hydraulic unit – extension</b> Incl. connection couplings, max. 210 bar, for central hydraulic- and pneumatic connection (in sum are max. 20 lines for hydraulic/pneumatic possible)	



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3300	1,00 ST	<b>Hydraulic unit</b> continuous duty at switch cycles less than 30 seconds pressure: 210 bar, flow rate: 4,3 l/min. incl. valves for supply of 2 clamping circuits and 2 pressure switches for electric clamping control	
3400	1,00 ST	<b>Hydraulic unit – extension</b> second pressure stage with additional pressure valve	
3500	1,00 ST	<b>CHIRON Variable Clamping Logic</b> 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:	
3600	1,00 ST	<b>Cutting tools</b> The cutting tools have to be balanced according to DIN 1940, class G 2,5, in two levels, with max. operating speed	
3700	1,00 ST	- Documentation -	
3800	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	
3900	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	
4000		<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°	
4100		<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.	



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4200		<p><b>Information Machine safety</b></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>	
4300		<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>	

