

**Data sheet I FZ 15 KS no. 129-19**

Pos.	Qty.	Description	Price
100	1,00 ST	<p><b>Completely refurbished vertical machining centre CHIRON FZ 15 KS FX Nr. 129-19</b></p> <p><b>Year of construction: 2001, weight: 8.700 kg</b></p>	
200	1,00 ST	<p><b>According to described below scope of delivery</b></p>	
300	1,00 ST	<p><b>Column moving machining centre in steel- concrete- composite design with swing setup</b></p> <p>Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication</p> <p><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</p> <p><b>2 axis rotary table type ZAS 280 consisting of:</b> 4th and 5th axis smallest increment 0,001°</p> <p>Tilting axis Tilting angle: <math>\pm 100^\circ</math> Tilting accuracy <math>\pm 8''</math> with absolute, direct path measuring system RCN 220 via worm drive system incl. hydraulic clamping system max. transmittable torque 1.100 Nm max. torque if the table is clamped 2.000 Nm max spindle rev. 16 rpm</p> <p>rotary table faceplate dia 280 mm with thread and pin hole grid M16 x <math>\varnothing</math> 15 H7 x 50 mm incl hydraulic clamping system Tilting accuracy <math>\pm 8''</math> with absolute, direct path measuring system RCN 220 max. transport weight (workpiece weight): 300 kg via worm drive system max. transmittable torque 700 Nm max. torque if the table is clamped 1.500 Nm Max spindle rev. 25 rpm</p>	



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		Counter bearing incl. hydraulic clamping system without drive max. torque via clamping system 2.000 Nm	
		<b>Hydraulic unit for clamping of faceplate and counter bearing</b> Central Pneumatic or Hydraulic Turning Supply 4-fold, integrated in A- and B-axis, with 4 O-ring connections in the center of the face plate Remark: power-actuated clamping fixtures on the faceplate require additional connections and clamping circuits.	
		<b>Travel:</b> X-axis 550 mm Y-axis 400 mm Z-axis 360 mm	
400	1,00 ST	<b>Main Spindle drive with 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 steel Ø 36 mm (with insert drill) Tapping capacity M 24 Milling capacity in steel 250 cm <sup>3</sup> /min	
500	1,00 ST	<b>Automatic tool changer</b> Tool places 48 Tool shaft HSK A63 DIN 69893 Tool-Ø max. 82 mm Tool-Ø if adjacent places are free max. 125 mm Tool length max. 250 mm Tool weight max. 5,0 kg (optional max. 10,0 kg) Chip-to-chip-time approx. 2,4 s (depends on CNC)	



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Pos.	Qty.	Description	Price
600	1,00 ST	<p><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: 0,5 g in X-axis  1,0 g in Y-axis  1,2 g in Z-axis</p> <p>Remark:  With normal conditions the machine does not have to be anchored to the floor.  (For slippery floors we recommend anchoring.)</p>	
700	1,00 ST	<p><b>SIEMENS CNC-control 840D</b>  (MMC 103./ NCU 573.2, 6 measuring cycles, 1 canal)  incl. 10,4" TFT colour LCD screen / full keyboard OP032S  Hard disk, NC-memory 1,5 GB programmes storage capacity  Dialog programing, milling simulation  reloading block by block from the hard disk  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  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)  orientated spindlestop  drip feed function through V24 interface  dimension metric or inch</p>	



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Pos.	Qty.	Description	Price
		software limitswitch NC-diagnosis machine-diagnosis absolute indirect path measurement systems, rigid tapping	
		<b>PCI / ISA adapter</b> with 2 plug-ins	
		<b>Network card</b> Inkl. Installation With 3 connections (AUI, RJ45, RG58) The cabling to the network isn't included.	
800	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.	
900	1,00 ST	<b>Working hours and piece counter</b> in the screen	
1000	1,00 ST	<b>Socket 230 V</b> at control panel	
1100	1,00 ST	<b>Installation elements</b>	
1200	1,00 ST	<b>Fully enclosed working area</b>	
1300	1,00 ST	<b>Wash gun</b>	
1400	1,00 ST	<b>Control panel on the front</b>	
1500	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
1600	1,00 ST	<b>Chip screw</b> Mounted in the machine food	
1700	1,00 ST	<b>Chip conveyor (scratch band)</b> discharge height 1050 mm, tank capacity 300 ltr, pump capacity 150 ltr/min at 1,3 bar, incl. bed flushing system	
1800	1,00 ST	<b>Coolant equipment PF 50 / 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	



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		<p>high pressure pump capacity 20 l/min at 30 bar            high pressure circuit with filtration via paper bond filter PF50,            filtration 50 µm nominal.            twin filter in the high pressure circuit for the protection of the machine.            incl. bed flushing system</p>	
1900	1,00 ST	<p><b>Machine preparation</b>            for through tool coolant system including:            - Sealing system in the DIN 69893 HSK A63 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            We recommend for tool holders the use of our patented coolant tube with sieve.            Advantages:- Decrease of the clogging in the internal coolant channel.            - Reduction of the wear at the O-ring seal in the collet.            (Subject: required high pressure equipment)</p>	
2000	1,00 ST	<p><b>Electric interface for loader with Harting-plug</b>            for automatic loading system mounted to the side of the cabinet,            key-operated switch and indicator lamp in the control panel "with loader".            Without commissioning</p>	
2100	1,00 ST	<p><b>Pneumatic- and Hydraulic Connections</b></p>	
2200	1,00 ST	<p><b>Pneumatic connection</b>            for pneumatic clamping device            electrically controlled pneumatic connection,            for double acting; pressure control;            pressure control switch with automatic pressure regulation.            (in case of pressure change automatic pressure sensing)</p>	
2300	1,00 ST	<p><b>Central Pneumatic or Hydraulic Turning Supply</b>            4-fold, integrated in A- and B-axis,            with 2 connecting couplings in the center of the face plate            Precondition: hydraulic connection with hydraulic unit or controlled pneumatic supply</p>	
2400	1,00 ST	<p><b>Prepared for Schunk-clamping system</b>            with uncontrolled line and 1 connection coupling</p>	



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2500	1,00 ST	<b>Pneumatic supply</b> without control and 1 outlet coupling	
2600	1,00 ST	<b>- Documentation -</b>	
2700	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	
2800	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	
2900		<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°	
3000		<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.	
3100		<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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3200		<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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