

Data sheet I CHIRON DZ 18.2 KW no. 200-76

Pos.	Qty.	Description	Price
100	1,00 ST	<p>Completely refurbished vertical machining centre CHIRON DZ 18.2 KW no. 200-76</p> <p>Year of construction: 2012, weight: 10.500 kg</p>	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	<p>Column moving machining centre workpiece swivel table Suitable for dry-machining with optimized chip drop</p>	
400	1,00 ST	<p>Machine enclosure with full enclosed workspace with sliding doors, electrically interlocked, 2270 mm high above floor, incl. machine lamp service friendly with removable side walls vertical bellows</p>	
500	1,00 ST	<p>Integrated Workpiece swivel table IWW 0/180 degrees for optimal chip drop, with center divider workpiece swivel time appr. 3,5 s weight-dependent, self-regulating through self-learning speed-control table loading capacity per side 0 - max. 250 kg, max. 120 kg weight difference between the two table sides. Per table side integrates:</p> <ul style="list-style-type: none"> - NC-rotary-table, type ATU 200 with hydraulic clamping repetition accuracy $\pm 15''$, load moment of inertia (without turning supply) 5,76 kgm² face plate dia. 225 mm, with center bore dia.50h7, fixture pin dia. $\varnothing 16h7$, 4 fixture bores M10, - CHIRON standard fixture for rotary table bridge size 720 mm counter bearing with hydraulic clamping flange plate incl. connecting couplings and quick-locator, on side of the rotary table flange plate incl. connecting couplings and quick-locator, on side of the counter bearing 2 x 2-core energy supply pneumatic or hydraulic swing radius 200 mm - 4th or 5th NC-axes, complete - pneumatic supply without control <p>additionally necessary: hydraulic connection and extension for clamping of rotary table</p>	

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		<p>hard disk with approx.. 2 GB for free disposal</p> <p>drilling cycles G81-G89</p> <p>drilling and milling cycles</p> <p>M- and T- functions</p> <p>circular interpolation (360 degrees)</p> <p>re-start into program</p> <p>subroutines, parameter programming</p> <p>simultaneous programming</p> <p>contour programming with cycle support</p> <p>support through cycles</p> <p>polar coordinates</p> <p>tool offsets for geometry, wear</p> <p>tool radius correction for intersection computing</p> <p>crossing radius</p> <p>4 zero offsets G54-G57</p> <p>30 zero shifts programmable with G-functions</p> <p>3D and helical interpolation</p> <p>screen switch off</p> <p>mirror function</p> <p>scaling function</p> <p>insert of chamfer and radius</p> <p>Universal interface RS 232C (2 x V24)</p> <p>USB-interface at control panel</p> <p>Ethernet connection RJ45 in control panel</p> <p>orientated spindle stop</p> <p>drip feed function through V24 interface</p> <p>dimension metric or inch</p> <p>software limit switch, NC-diagnosis</p> <p>machine-diagnosis</p> <p>absolute indirect path measurement systems</p> <p>power meter in screen</p> <p>rigid tapping</p>	
1200	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>	

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1300	1,00 ST	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. Password protected confirmation of the performed maintenance through the maintenance staff.	
1400	1,00 ST	Working hours and piece counter in the screen	
1500	1,00 ST	Socket 230 V at control panel	
1600	1,00 ST	Socket for portable mini-hand wheel without EMERGENCY-STOP button, at control panel	
1700	1,00 ST	Cabinet cooler as a door mounting unit	
1800	1,00 ST	Installation elements For installation in an oil pan the installation directly on the sheet metal is not allowed. For out of it resulting problems there is no warranty. The machine documents for approval contain a proposal for the appropriate execution of the oil pan.	
1900	1,00 ST	Chip conveyor (scratch band) small version with lateral discharge, discharge height 1.050 mm, tank capacity 150 l, 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) Precondition: Coolant equipment or connection to central coolant system	
2000	1,00 ST	Signal lamp for 3 signals Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running	
2100	1,00 ST	Fully enclosed working area	

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2200	1,00 ST	<p>Coolant equipment HL 450 / 900 (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 high pressure pump capacity 35 l/min at 30 bar coolant filtration for high pressure and flood coolant with hydrostatic paper bond filter HL 450, filtration 50 μm nominal twin filter in the high pressure circuit for the protection of the machine. incl. bed flushing system and Fixture washing with nozzles installed at the centre divider controlled with m-functions for washing the working area.</p>	
2300	2,00 ST	<p>Machine preparation 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 and 2 flow control switches - Solenoid valve, controlled via machine program * At HSK A63 we recommend for tool holders the use of our patented coolant tube with sieve. Advantages: Decrease of the clogging in the internal coolant channel. (Subject: required high pressure equipment)</p>	
2400	1,00 ST	<p>Automatic central grease lubrication</p>	
2500	1,00 ST	<p>Suction point for customer specific installation Ø 200 mm on top of the machine enclosure and electrical preparation in cabinet</p>	
2600	1,00 ST	<p>Undervoltage relay with inadvertently variation of the power supply the machine will be stopped</p>	

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2700	1,00 ST	Wash gun with 1 connection and quick coupling each in loading- and working area	
2800	1,00 ST	Pneumatic- and Hydraulic Connections	
2900	1,00 ST	Central hydraulic and pneumatic supply prepared for max. 20 connections, 6 connections are installed including connecting couplings, 4 for hydraulic, max. 210 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	
3000	2,00 ST	Further hydraulic connection(s) including 1 connecting coupling, max. 200 bar, addition to central hydraulic and pneumatic supply (a total of max. 20 connections is possible) 1 x A/B per table side	
3100	2,00 ST	Further pneumatic connection(s) including 1 connecting coupling, addition to central hydraulic and pneumatic supply (a total of max. 20 connections is possible)	
3200	1,00 ST	Hydraulic unit for continues duty pressure: 200 bar supply capacity: 4,3 l/min. incl. valves for supply of 2 clamping devices and 2 pressure switches for clamping control	
3300	1,00 ST	Hydraulic unit – extension For rotary table or counter bearing clamping with: 1 second pressure stage 2 additional clamping cycles 2 connections at central hydraulic- and pneumatic connection (a total of max. 20 connections is possible)	
3400	1,00 ST	Cutting tools The cutting tools have to be balanced according to DIN 69 888, class G 2,5, in two levels, with max. operating speed	

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3500	1,00 ST	- Documentation -	
3600	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	
3700	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	
3800		Main circuit 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°	