

## Data sheet I CHIRON DZ 18 W no. 212-77

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON DZ 18 W no. 212-77</b>  <b>Year of construction: 2006, weight: 8.000 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre workpiece swivel table</b> Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
400	1,00 ST	<b>Machine enclosure with full enclosed workspace</b> with sliding doors, electrically interlocked, 2270 mm high above floor, incl. machine lamp service friendly with removable side walls vertical bellows	
500	1,00 ST	<b>Workpiece swivel table 0/180 degrees</b> with centre divider made of stainless steel clamping surface 2 x 940 mm x 470 mm with thread and locating hole grid M16 x ø 15 H7 x 50 mm workpiece swivel time appr. 3,7 s weight-dependent, self-regulating through self-learning speed-control table loading capacity per side 0 - max. 400 kg max. 120 kg difference in weight between both table sides	
600	1,00 ST	<b>Mini-operating panel</b> with start and receipt push buttons, for pallet recognition M61/M62	
700	1,00 ST	<b>Travel:</b> X-axis 400 mm Y-axis 400 mm Z-axis 630 mm with variable tool change level Spindle distance in X-axis 320 mm	
800	1,00 ST	<b>Main spindle drive with 2 AC-motors</b> 12,0 kW at 100 % 28,0 kW at 15 % Spindle speed range: 20 - 12.000 min <sup>-1</sup> - 180 Nm  Drilling capacity in steel 2 x Ø 36 mm (with insert drill) Tapping capacity 2 x M 24 Milling capacity in steel 2 x 150 cm <sup>3</sup> /min	

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Pos.	Qty.	Description	Price
900	1,00 ST	<p><b>Automatic tool changer, protected against chips</b></p> <p>No. of tools 2 x 12            Tool shaft HSK A 63 DIN 69893            Max. tool dia. 65 mm            Max. tool dia. 180 mm if adjacent places are free            Max. tool weight 4,0 kg (8 kg on 2 places per spindle)            Tool changing time approx. 0,9 s (depends on CNC)            Chip-to-chip-time approx. 2,1 s (depends on CNC)</p>	
1000	1,00 ST	<p><b>AC-servo motors for x-, y- and z-axes</b></p> <p>digital direct drives with indirect absolut path measuring system            rapid traverse in all axes 60 m/min.            acceleration: 0,5 g in X and Yaxis                              0,7 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>	
1100	1,00 ST	<p><b>SIEMENS CNC-control 840D</b></p> <p>(PCU 50 / NCU 572.4, 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            3D and helical interpolation            screen switch off            mirror function</p>	

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Pos.	Qty.	Description	Price
		scaling function insert of chamfer and radius Universal interface RS 232C (2 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	
1200	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.	
1300	1,00 ST	<b>Wash gun</b> with 1 connection and quick coupling each in loading- and working area	
1400	1,00 ST	<b>Working hours and piece counter</b> in the screen	
1500	1,00 ST	<b>Socket 230 V</b> at control panel	
1600	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
1700	1,00 ST	<b>Signal lamp on machine enclosure for 3 signals</b> Signal "red" = failure Signal "white" = load machine Signal "green" = machine is running	
1800	1,00 ST	<b>Chip conveyor (scratch band) small version</b> with lateral discharge, discharge height 1.050 mm, tank capacity 150 l, pump capacity max. 300 l/min. at 1,3 bar	
1900	1,00 ST	<b>Screw conveyor</b>	

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Pos.	Qty.	Description	Price
2000	1,00 ST	<p><b>Coolant equipment PF 50 / KFA 900</b>            (for cast iron slurry, Al with Si <math>\geq</math> 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            high pressure circuit with filtration via paper bond filter,            filtration 50 <math>\mu</math>m 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            (This filtration method will not eliminate increasing cast iron slurry from the            coolant equipment.)</p>	
2100	1,00 ST	<p><b>Through tool coolant package with suction point</b>            consisting of:</p> <p><b>2 x Machine preparation</b>            for through tool coolant system including:</p> <ul style="list-style-type: none"> <li>- sealing system in the DIN 69871 Form A40              or DIN 69893 HSK A63* collet</li> <li>- coolant distributor installed at the main spindle drive</li> <li>- coolant leakage sensor</li> <li>- implemented mud flap in the high pressure piping              and 2 flow control switches</li> <li>- solenoid valve, controlled via machine program</li> </ul> <p>* HSK A63 tool holders for through tool coolant require            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: requires high pressure equipment)</p>	
2200	1,00 ST	<b>Automatic central grease lubrication</b>	
2300	1,00 ST	<b>Fully enclosed workspace</b>	
2400	1,00 ST	<p><b>Suction point</b>            for customer specific installation            Ø 200 mm on top of the machine enclosure</p>	

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2500	1,00 ST	<b>Tool lifetime control with:</b> - tool place organization - sister tool organization - field of work organization via 4-digit program no. in the screen (just at machines with more work fields) - Geometrie monitoring at tool call	
2600	1,00 ST	<b>Automatic loading door of total enclosure</b> opening and closing, incl. walk switch	
2700	1,00 ST	<b>Pneumatic- and Hydraulic Connections</b>	
2800	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. 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	
2900	1,00 ST	<b>Hydraulic unit</b> continuous duty at switch cycles less than 30 seconds pressure: 210 bar supply capacity: 4,3 l/min. incl. valves for supply of 2 clamping devices and 2 pressure switches for clamping control	
3000	1,00 ST	<b>- Documentation -</b>	
3100	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	
3200	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	
3300		<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°	