

Data sheet I DZ 15 KW no. 132-10

Pos.	Qty.	Description	Price
100	1,00 ST	Completely refurbished vertical machining centre CHIRON DZ 15 KW Nr. 132-10 Year of construction: 2002, weight: 9.600 kg	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	Column moving machining centre with machine bed in mineral cast technique and workpiece swivel table Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
400	1,00 ST	Machine enclosure with loading door, electrically interlocked, 2200 mm high above floor, incl. machine lamp service friendly with removable side walls vertical bellows	
500	1,00 ST	Mini-operating panel with start and receipt push buttons, for pallet recognition M61/M62	
600	1,00 ST	Workpiece swivel table 0/180° degrees with middle partition of sheet steel clamping surface 2 x 660 mm x 400 mm ² with thread and locating hole grid M16 x Ø 15 H7 x 50 mm workpiece swivel time appr. 2,4 s depends on the weight, self-regulating by self-learning speed control table loading capacity per side 0 – max. 300 kg max. 100 kg weight difference between both table sides	
700		Travel: X-axis 300 mm Y-axis 400 mm Z-axis 360 mm with variable tool changing level Spindle distance 250 mm	
800	2,00 ST	Main Spindle drive with AC-motor 7,5 KW at 100 % 15,0 KW at 10 % Spindle speed range: 20 - 12.000 rpm - max.95 Nm Drilling capacity in 60 pc 2 x Ø 36 mm Tapping capacity 2 x M 24 Milling capacity in steel 2 x 150 cm ³ /min	



Data sheet I DZ 15 KW no. 132-10

Pos.	Qty.	Description	Price
900	1,00 ST	<p>Automatic tool changer</p> <p>Tool places 2 x 24</p> <p>Tool shaft HSK A63 DIN 69893</p> <p>Tool-Ø max. 82 mm</p> <p>Tool-Ø</p> <p>if adjacent places are free max. 125 mm</p> <p>Tool length max. 250 mm</p> <p>Tool weight max. 5,0 kg (10,0 kg at reduced chain speed)</p> <p>Tool changing time approx. 0,9 s (depends on CNC)</p> <p>Chip-to-chip-time approx. 2,4 s (depends on CNC)</p>	
1000	1,00 ST	<p>AC-servo motors for x-, y- and z-axes</p> <p>digital direct drives with indirect absolute path measuring system</p> <p>rapid traverse in all axes 60 m/min.</p> <p>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>	
1100	1,00 ST	<p>FANUC 18 i - 3-axes continuous path control</p> <p>9.5" LCD monochrom screen</p> <p>memory capacity 512 KB (max. expansion to 1,5 MB)</p> <p>drilling cycles G81-G89</p> <p>absolute path measuring system</p> <p>M- and T-functions</p> <p>circular interpolation (360 degrees)</p> <p>re-start into program</p> <p>makro B sub-routines</p> <p>look ahead</p> <p>simultaneous programming</p> <p>automatic corner override</p> <p>99 tool offsets</p> <p>cutter radius - contour compensation</p> <p>6 zero shifts G54-G59</p> <p>metric/inch switch</p> <p>3 D-interpolation/helical interpolation</p> <p>S-analogue</p> <p>rigid tapping</p> <p>orientated spindle stop</p> <p>Slot for PCMCIA memory card</p>	



Data sheet I DZ 15 KW no. 132-10

Pos.	Qty.	Description	Price
		Interface RS 232C on the side at the control panel software-limitswitch NC-diagnosis, Machine diagnosis	
		FANUC Tool lifetime control with: tool place organization sister tool organization	
1200	1,00 ST	Working hours and piece counter in the screen	
1300	1,00 ST	Socket 230 V at control panel	
1400	1,00 ST	Fully enclosed working area	
1500	1,00 ST	Cabinet cooler as a door mounting unit	
1600	1,00 ST	Installation elements	
1700	1,00 ST	Wash gun	
1800	1,00 ST	Thermocontrol	
1900	1,00 ST	Coolant equipment tank capacity 900 ltr., pump capacity 200 ltr/min at 2,0 bar (the pump in the chip conveyor becomes the lift pump) pump capacity 20 ltr/min at 30 bar coolant filtration for high pressure and flood coolant with vacuum rotation filter VRF 300, filtration 50 µm nominal	
2000	1,00 ST	70 bar high pressure pump flow rate 20 l/min at 30 bar - 11 l/min at 70 bar with vario pressure control valve for 8 programmable pressure stages pre-defined pressure steps (20, 30, 40, 50, 55, 60, 65, 70 bar) instead of standard high pressure pump	
2100	1,00 ST	Coolant Unit with Chip conveyor (scratch band) discharge height 1050 mm, lateral discharge tank capacity 100 ltr, pump capacity 150 ltr/min at 2,0 bar	
2200	1,00 ST	Work space washing with nozzles installed inside the Machine enclosure and washing of centre divider	



Data sheet I DZ 15 KW no. 132-10

Pos.	Qty.	Description	Price
2300	1,00 ST	Fixture washing with nozzles installed an the swivel centre divider separate controlled with m-functions for washing the working area and the loading station (Subject: Coolant equipment with tank capacity 900 l)	
2400	1,00 ST	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 flow control switch - 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 canal.	
2500	1,00 ST	Automatic loading door of total enclosure opening and closing, actuating to closing via two-hand push buttons	
2600	2,00 ST	NC-rotary-table package complete installed consisting of: - NC-rotary-table, type AWU 160 P, Fabr. Chiron-Peiseler - 4th and 5th NC-axes, complete - 2 adapter-plates for center height 200 mm - central pneumatic supply without control Technical description for NC-rotary-table: center height 165 mm, repetition accuracy $\pm 15''$, load moment of inertia (without turning supply) 1,9 kgm ² face plate dia. 160 mm, with center bore dia. 50 +0.012, fixture pin dia. 16 h7, 4 fixture bores M10, incl. pneumatic clamping	



Data sheet I DZ 15 KW no. 132-10

Pos.	Qty.	Description	Price
2700	2,00 ST	CHIRON standard fixture for rotary table with hydraulic actuated counter bearing bridge size 580 mm existing of: - adaptor plate (instead of the adapter plate on the rotary package) mountable and demountable on the work piece changing device - counter bearing with pneumatic clamping - flange plate incl. connecting coupling, on side of the rotary table - flange plate incl. connecting coupling, on side of the counter bearing - 2 x 2-core energy supply - centre height 165 mm over base plate	
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	1,00 ST	Hydraulic unit continuous duty at switch cycles less than 30 seconds pressure: 210 bar, output: 4,3 ltr/min incl. valves for supply of 2 clamping circuits and 2 pressure switches for electric clamping control	
3100	1,00 ST	Cutting tools The cutting tools have to be balanced according to DIN ISO 1940, class G 2,5, in two levels, with max. operating speed	
3200	1,00 ST	- Documentation -	
3300	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	
3400	1,00 ST	Machine colour Two-components-structure varnish - 2 colours light grey acc. to NCS S1502-B basalt grey acc. to RAL 7012	



Data sheet I DZ 15 KW no. 132-10

Pos.	Qty.	Description	Price
3500		<p>Main circuit</p> <p>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°</p>	
3600		<p>Information Export</p> <p>We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.</p>	
3700		<p>Information Machine safety</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>	
3800		<p>Information Coolant lubrication</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>	

