

Data sheet I FZ 15 KS no. 129-38

Pos.	Qty.	Description	Price
100	1,00 ST	<p>Completely refurbished vertical machining centre CHIRON FZ 15 KS Nr. 129-38</p> <p>Year of construction: 2001, weight: 8.700 kg</p>	
200	1,00 ST	According to described below scope of delivery	
300	1,00 ST	<p>Column moving machining centre in steel- concrete- composite design with swing setup Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication</p>	
400	1,00 ST	<p>Machine enclosure with loading door, electrically interlocked, 2200 mm high above floor, incl. machine lamp service friendly with removable side walls vertical bellows</p>	
500	1,00 ST	<p>2 axis rotary table type ZAS 280 consisting of: 4th and 5th axis smallest increment 0,001°</p> <p>Tilting axis Tilting angle: $\pm 100^\circ$ Tilting accuracy $\pm 8''$ 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 3.600 Nm max spindle rev. 20 rpm</p> <p>rotary table faceplate dia 280 mm with thread and pin hole grid M16 x \varnothing 15 H7 x 50 mm incl hydraulic clamping system Tilting accuracy $\pm 8''$ 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 2.800 Nm Max spindle rev. 33 rpm</p>	



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		Counter bearing incl. hydraulic clamping system without drive max. torque via clamping system 3.600 Nm	
		Hydraulic unit for clamping of faceplate and counter bearing	
		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.	
600	1,00 ST	Travel: X-axis 550 mm Y-axis 400 mm Z-axis 360 mm	
700	1,00 ST	Main Spindle drive with AC-motor 9,5 KW at 100 % 14,0 KW at 10 % 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 ³ /min	
800	1,00 ST	Automatic tool changer 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
900	1,00 ST	<p>AC-servo motors for x-, y- and z-axes 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>	
1000	1,00 ST	<p>HEIDENHAIN CNC-control TNC 430M with SIEMENS servo- and main spindle motors (9 axes plus spindle) incl. 10,4" TFT flat colour LCD screen / full keyboard hard disk with 1,5 GB for ISO 66025 programming and Heidenhain plain language 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 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 (V24) and RS 422 orientated spindle stop drip feed function from hard disk or through V24 interface dimension metric or inch software limit switch NC-diagnosis/machine-diagnosis</p>	



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		absolute indirect path measurement systems rigid tapping tool magazine with firm place coding	
1100	1,00 ST	Working hours and piece counter in the screen	
1200	1,00 ST	Socket 230 V at control panel	
1300	1,00 ST	Fully enclosed working area	
1400	1,00 ST	Cabinet cooler as a door mounting unit	
1500	1,00 ST	Installation elements	
1600	1,00 ST	Wash gun	
1700	1,00 ST	Central grease lubrication	
1800	1,00 ST	Glass scales HEIDENHAIN, overpressured in all axes X, Y, Z = 550 x 400 x 360 mm	
1900	1,00 ST	Chip conveyor (scratch band) discharge height 1050 mm, tank capacity 400 ltr, pump capacity 150 ltr/min at 2,0 bar, incl. bed flushing system	
2000	1,00 ST	Coolant equipment (for cast iron slurry) tank capacity 800 ltr., pump capacity 200 ltr/min at 2,5 bar (the pump in the chip conveyor becomes the lift pump) pump capacity 20 ltr/min at 30 bar high pressure circuit with coolant filtration via paperbondfilter PF50 and twinfilter incl. bed flushing system (This filtration method will not eliminate increasing cast iron slurry from the coolant equipment.)	
2100	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 - Solenoid valve, controlled via machine program We recommend for tool holders the use of our patented coolant tube with sieve.	



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		<p>Advantages:- Decrease of the clogging in the internal coolant channel.</p> <p>- Reduction of the wear at the O-ring seal in the collet.</p> <p>(Subject: required high pressure equipment)</p>	
2200	1,00	<p>Suction point</p> <p>for customer specific installation with socket 400V 15A</p>	
2300	1,00	<p>Pneumatic- and Hydraulic Connections</p>	
2400	1,00	<p>Pneumatic connection</p> <p>electrically controlled pneumatic connection, control via ON/OFF button at the control panel for double acting clamping cylinder; incl. clamping pressure control; conduct up to the connection outside of the machine base for clamping and loosen or rather for control of the powerful-clamping system. (pressure transducer) not on the rotary transmission)</p>	
2500	1,00	<p>Hydraulic connection, not controlled</p> <p>incl. bulkhead union and quick change couplings from the connectors outside the machine base to the rotary coupling on the ZASP 280</p>	
2600	1,00	<p>Ethernet-card</p> <p>incl. software for TNC 430M</p>	
2700	1,00	<p>Portable handwheel</p> <p>Brand: Heidenhain</p>	
2800	1,00	<p>Parameterization of the cycles 19</p>	
2900	1,00	<p>Cutting tools</p> <p>The cutting tools have to be balanced according to DIN ISO 1940, class G 2,5, in two levels, with max. operating speed</p>	
3000	1,00	<p>- Documentation -</p>	
3100	1,00	<p>Documentation acc. to CE of the first delivery into market</p> <p>1 x safety regulations in a folder in English</p> <p>1 x complete documentation on a USB as PDF</p> <p>Language of the operating manuals and safety in English</p>	
3200	1,00	<p>Machine colour</p> <p>Two-components-structure varnish - 2 colours</p> <p>light grey acc. to NCS S1502-B</p> <p>basalt grey acc. to RAL 7012</p>	



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3300		<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>	
3400		<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>	
3500		<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>	
3600		<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>	

