

**Data sheet I FZ 15 W no. 148-27**

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON FZ 15 W Nr. 148-27</b>  <b>Year of construction: 2004, weight: 7.820 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre in steel- concrete-</b> composite design with workpiece changing device Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
400	1,00 ST	<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	
500	1,00 ST	<b>Workpiece swivel table 0/180 degrees</b> with centre divider made of stainless steel clamping surface 2 x 660 mm x 400 mm with thread and locating hole grid M16 x Ø 15 H7 x 50 mm workpiece swivel time appr. 2,4 s weight-dependent, self-regulating through self-learning speed-control table loading capacity per side 0 - max. 300 kg	
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            550 mm Y-axis            400 mm Z-axis            425 mm with adjustable tool change level	
800	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 St 60            Ø 36 mm with reversible plate drill Tapping capacity                      M 24 Milling capacity in St 60            300 cm <sup>3</sup> /min	



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900	1,00 ST	<b>Automatic tool changer, protected against chips</b> Tool places 20 Tool shaft SK 40 DIN 69871 + 72 Tool- $\varnothing$ max. 65 mm Tool- $\varnothing$ if adjacent places are free max. 150 mm Tool weight max. 2,5 kg (5,0 kg at 4 places) Tool change time appr. 0,9 s (depends on CNC) Chip-to-chip-time approx. 2,1 s (depends on CNC)	
1000	1,00 ST	<b>AC-servo motors</b> for x-, y- and z-axes digital direct drives with indirect absolute path measuring system rapid traverse in all axes 60 m/min. With 1,0 g acceleration	
1100	1,00 ST	<b>SIEMENS CNC-control 840D</b> (PCU 50 / NCU 572.4, 6 measuring cycles, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP010S NC-memory 256 KB (max.200 programmes storage capacity) 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 crossing radius 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 spindle stop	



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Pos.	Qty.	Description	Price
		drip feed function through V24 interface dimension metric or inch software limit switch NC-diagnosis machine-diagnosis absolute indirect path measurement systems powermeter in screen rigid taping Look ahead	
1200	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	
1300	1,00 ST	<b>Working hours and piece counter</b> in the screen	
1400	1,00 ST	<b>Socket 230 V</b> at control panel	
1500	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
1600	1,00 ST	<b>Socket for portable mini-hand wheel</b> without emergency stop button, at control panel	
1700	1,00 ST	<b>Installation elements</b>	
1800		<b>Signal lamp on the machine enclosure – 3 signals</b> Signal "red" = error Signal "white" = machine is loaded Signal "green" = machine is running	
1900	1,00 ST	<b>Wash gun</b> with each 1 connection and quick coupling in loading- and working area	
2000	1,00 ST	<b>Automatic grease lubrication</b>	
2100	1,00 ST	<b>Fully enclosed working area</b>	
2200	1,00 ST	<b>Chip conveyor (scratch band)</b> with lateral discharge, discharge height 1050 mm, tank capacity 300 ltr., with pump capacity 300 l/min. at 1,3 bar incl. bed flush	



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Pos.	Qty.	Description	Price
2300	1,00 ST	<p><b>Machine preparation</b> for through tool coolant system including:</p> <ul style="list-style-type: none"> <li>- Sealing system in the 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</li> <li>- Solenoid valve, controlled via machine program</li> </ul>	
2400	1,00 ST	<p><b>Coolant equipment</b> tank capacity 900 l, pump capacity 200 l/min. at 2,0 bar (the pump in the chip conveyor becomes the lift pump) and HP-pump 20 l/min at 30 bar HP-cycles with coolant cleaning via PF 50 and DSF incl. bed flushing system and middle center divider</p>	
2500	2,00 ST	<p><b>NC-rotary-table package complete installed consisting of:</b></p> <ul style="list-style-type: none"> <li>- NC-rotary-table, type RT 160 (no. 13414 and 10947)</li> <li>- 4th and 5th NC-axes, complete</li> <li>- 2 adapter-plates for center height 200 mm</li> <li>- central pneumatic supply without control</li> </ul> <p>Peiseler conversion in z-drive Motors digital</p> <p>Technical description for NC-rotary-table: center height 165 mm, repetition accuracy <math>\pm 15''</math>, face plate dia. 160 mm, with center bore dia. 50 <math>+0.012</math>, fixture pin dia. 16 h7, 4 fixture bores M10, incl. pneumatic clamping</p>	
2600	2,00 ST	<p><b>CHIRON standard fixture for rotary table</b> with pneumatic actuated counter bearing bridge size 580 mm existing of:</p> <ul style="list-style-type: none"> <li>- adaptor plate (instead of the adapter plate on the rotary package) mountable and demountable on the work piece changing device</li> <li>- counter bearing with pneumatic clamping</li> <li>- cheek with "Quick-Locator"</li> <li>- 2 x 1-core energy supply</li> <li>- centre height 165 mm over base plate</li> </ul>	
2700	1,00 ST	<p><b>Suction point</b> for customer specific installation <math>\varnothing</math> 200 mm on top of the machine enclosure</p>	



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2800	1,00 ST	<b>Pneumatic- and Hydraulic Connections</b>	
2900	1,00 ST	<b>Central pneumatic connection</b> uncontrolled with 2 connection couplings	
3000		<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	
3100		<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	
3200	1,00 ST	<b>Cutting tools</b> The cutting tools have to be balanced according to DIN ISO 1940, class G 2,5, in two levels, with max. operating speed	
3300	1,00 ST	<b>- Documentation -</b>	
3400	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	
3500	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	
3600		<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°	



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3700		<p><b>Information Export</b></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>	
3800		<p><b>Information Machine safety</b></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>	
3900		<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>	

