

Pos.	Qty.	Article Description	Price / €
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Complete machine description | FZ 15 KS FX no. 129-19

1	1	Completely refurbished vertical CNC-machining centre model CHIRON FZ 15 KS FX Year of construction: 2001, weight: 8.700 kg Machine-No. 129-19	
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Machine image similar.
The equipment of the sample photo isn't binding.



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Scope of delivery:

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

Drilling capacity in steel Ø	36 mm (with insert drill)
Tapping capacity	M 24
Milling capacity in steel	250 cm ³ /min

Main Spindle drive with AC-motor

9,5 KW at 100 %
14,0 KW at 15 %
Spindle speed range: 20 - 12.000 rpm - max.90 Nm

Travel:

X-axis	550 mm
Y-axis	400 mm
Z-axis	360 mm

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)

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

Remark:

With normal conditions the machine does not have to be anchored to the floor.
(For slippery floors we recommend anchoring.)



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2 axis rotary table type ZAS 280

consisting of:
4th and 5th axis
smallest increment 0,001°

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 2.000 Nm
max spindle rev. 16 rpm

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 1.500 Nm
Max spindle rev. 25 rpm

Counter bearing incl. hydraulic clamping system
without drive
max. torque via clamping system 2.000 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.

SIEMENS CNC-control 840D

(MMC 103./ NCU 573.2, 6 measuring cycles, 1 canal)
incl. 10,4" TFT colour LCD screen / full keyboard OP032S
Hard disk, NC-memory 1,5 GB programmes storage capacity
Dialog programming, milling simulation
reloading block by block from the hard disk
for ISO 66025 programming
drilling cycles G81-G89
drilling and milling cycles



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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
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 spindlestop
drip feed function through V24 interface
dimension metric or inch
software limitswitch
NC-diagnosis
machine-diagnosis
absolute indirect path measurement systems, rigid tapping

PCI / ISA adapter

with 2 plug-ins

Network card

Inkl. Installation
With 3 connections (AUI, RJ45, RG58)
The cabling to the network isn't included.

CMS Powersafe

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.

Working hours and piece counter

in the screen



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Socket 230 V
at control panel

Cabinet cooler as a door mounting unit

Machine enclosure
with loading door, electrically interlocked,
2200 mm high above floor, incl. machine lamp
service friendly with removable side walls
vertical bellows

Chip conveyor (scratch band)
discharge height 1050 mm, tank capacity 300 ltr,
pump capacity 150 ltr/min at 1,3 bar, incl. bed flushing system

Installation elements

Wash gun

Control panel on the front

Fully enclosed working area

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.

Advantages:- Decrease of the clogging
in the internal coolant channel.
- Reduction of the wear at the
O-ring seal in the collet.

(Subject: required high pressure equipment)

Chip screw
Mounted in the machine food



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Main circuit

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°

Information Export

We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.

Information Machine safety

The machine is designed and built in accordance with the European machine guideline, according placing the product on the first time onto the market.

Other safety features due to special company rules and specifications can be considered. The actual cost will be invoiced.

Information Coolant lubrication

The machine is designed for standard water soluble coolant and fully enclosed at the standard version. The machine must be equipped with fume extraction.

The machine contents different plastics, varnish, resin and glue, which are selected carefully for using coolant and cutting oil.

The use of aggressive coolant and additive could cause major damages and machine stops.

Contact in any case your coolant supplier before machine set-up and installation.

