

## Data sheet I FZ 15 KW no. 132-10

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON FZ 15 KW Nr. 132-10</b>  <b>Year of construction: 2002, weight: 9.600 kg</b>	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre</b> 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	<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>Mini-operating panel</b> with start and receipt push buttons, for pallet recognition M61/M62	
600	1,00 ST	<b>Workpiece swivel table 0/180° degrees</b> with middle partition of sheet steel clamping surface 2 x 660 mm x 400 mm <sup>2</sup> 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	1,00 ST	<b>Travel:</b> X-axis 550 mm Y-axis 400 mm Z-axis 360 mm with variable tool changing level	
800	1,00 ST	<b>Main Spindle drive with AC-motor</b> 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 Ø 36 mm Tapping capacity M 24 Milling capacity in steel 250 cm <sup>3</sup> /min	



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Pos.	Qty.	Description	Price
900	1,00 ST	<b>Automatic tool changer</b> Tool places 48 Tool shaft HSK A63 DIN 69893 Tool- $\varnothing$ max. 82 mm Tool- $\varnothing$ if adjacent places are free max. 125 mm Tool length max. 250 mm Tool weight max. 5,0 kg (10,0 kg at reduced chain speed) Tool changing time approx. 0,9 s (depends on CNC) Chip-to-chip-time approx. 2,4 s (depends on CNC)	
1000	1,00 ST	<b>AC-servo motors for x-, y- and z-axes</b> 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.)	
1100	1,00 ST	<b>FANUC 18 i - 3-axes continuous path control</b> 9.5" LCD monochrom screen memory capacity 512 KB (max. expansion to 1,5 MB) drilling cycles G81-G89 absolute path measuring system M- and T-functions circular interpolation (360 degrees) re-start into program makro B sub-routines look ahead simultaneous programming automatic corner override 99 tool offsets cutter radius - contour compensation 6 zero shifts G54-G59 metric/inch switch 3 D-interpolation/helical interpolation S-analogue rigid tapping orientated spindle stop Slot for PCMCIA memory card Interface RS 232C on the side at the control panel	



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Pos.	Qty.	Description	Price
		software-limitswitch NC-diagnosis, Machine diagnosis FANUC Tool lifetime control with: tool place organization sister tool organization	
1200	1,00 ST	<b>Working hours and piece counter</b> in the screen	
1300	1,00 ST	<b>Socket 230 V</b> at control panel	
1400	1,00 ST	<b>Automatic loading door of total enclosure</b> opening and closing, actuating to closing via two-hand push buttons	
1500	1,00 ST	<b>Fully enclosed working area</b>	
1600	1,00 ST	<b>Cabinet cooler as a door mounting unit</b>	
1700	1,00 ST	<b>Installation elements</b>	
1800	1,00 ST	<b>Thermocontrol</b>	
1900	1,00 ST	<b>Fixture washing</b> 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)	
2000	1,00 ST	<b>Coolant equipment</b> 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	
2100	1,00 ST	<b>70 bar high pressure pump</b> 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	
2200	1,00 ST	<b>Work space washing</b> with nozzles installed inside the Machine enclosure and washing of centre divider	



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Pos.	Qty.	Description	Price
2300	1,00 ST	<b>Coolant Unit with Chip conveyor (scratch band)</b> discharge height 1050 mm, lateral discharge tank capacity 100 ltr, pump capacity 150 ltr/min at 2,0 bar	
2400	1,00 ST	<b>Machine preparation</b> for through tool coolant system including: <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 and flow control switch</li> <li>- Solenoid valve, controlled via machine program</li> </ul> <p>* 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 channel.</p>	
2500	2,00 ST	<b>NC-rotary-table package complete installed consisting of:</b> <ul style="list-style-type: none"> <li>- NC-rotary-table, type AWU 160 P, Fabr. Chiron-Peiseler</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> Technical description for NC-rotary-table: center height 165 mm, repetition accuracy $\pm 15''$ , load moment of inertia (without turning supply) 1,9 kgm <sup>2</sup> face plate dia. 160 mm, with center bore dia. 50 +0.012, fixture pin dia. 16 h7, 4 fixture bores M10, incl. pneumatic clamping	
2600	2,00 ST	<b>CHIRON standard fixture for rotary table</b> with hydraulic actuated counter bearing bridge size 580 mm existing of: <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>- flange plate incl. connecting coupling, on side of the rotary table</li> <li>- flange plate incl. connecting coupling, on side of the counter bearing</li> <li>- 2 x 2-core energy supply</li> <li>- centre height 165 mm over base plate</li> </ul>	



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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, output: 4,3 ltr/min incl. valves for supply of 2 clamping circuits and 2 pressure switches for electric clamping control	
3000	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	
3100	1,00 ST	<b>- Documentation -</b>	
3200	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	
3300	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	
3400		<b>Main circuit</b> 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°	
3500		<b>Information Export</b> We point out that the CNC-machining centres are subject to controls. For the export from the European Union an export license is necessary.	
3600		<b>Information Machine safety</b> The machine is designed and built in accordance with the	



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3700		<p>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> <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>	

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