

## Data sheet I CHIRON DZ 18 W no. 212-11

Pos.	Qty.	Description	Price
100	1,00 ST	<b>Completely refurbished vertical machining centre CHIRON DZ 18 W no. 212-11</b>  Year of construction: 2001, weight: 8.000 kg	
200	1,00 ST	<b>According to described below scope of delivery</b>	
300	1,00 ST	<b>Column moving machining centre workpiece swivel table</b> Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication	
400	1,00 ST	<b>Machine enclosure with full enclosed workspace</b> with sliding doors, electrically interlocked, 2400 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 940 mm x 470 mm with thread and locating hole grid M16 x ø 15 H7 x 50 mm workpiece swivel time appr. 3,7 s weight-dependent, self-regulating through self-learning speed-control table loading capacity per side 0 - max. 400 kg max. 120 kg difference in weight between both table sides	
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 400 mm Y-axis 400 mm Z-axis 630 mm with variable tool change level Spindle distance in X-axis 320 mm	
800	1,00 ST	<b>Main spindle drive with 2 AC-motors</b> 9,5 kW at 100 % 14,0 kW at 15 % Spindle speed range: 20 - 12.000 min <sup>-1</sup> - 90 Nm	
		Drilling capacity in steel 2 x Ø 36 mm (with insert drill)	
		Tapping capacity 2 x M 24	
		Milling capacity in steel 2 x 150 cm <sup>3</sup> /min	



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Pos.	Qty.	Description	Price
900	1,00 ST	<b>Automatic tool changer, protected against chips</b> No. of tools 2 x 12 Tool shaft HSK A 63 DIN 69893 Max. tool dia. 65 mm Max. tool dia. 180 mm if adjacent places are free Max. tool weight 4,0 kg (8 kg on 2 places per spindle) Tool changing time approx. 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 for x-, y- and z-axes</b> digital direct drives with indirect absolut path measuring system rapid traverse in all axes 60 m/min. acceleration: 0,5 g in X and Yaxis 0,7 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>SIEMENS CNC-control 840D</b> (PCU 50.3 / NCU 572.5, 6 measuring circuit, 1 channel) incl. 10,4" TFT colour LCD screen / full keyboard OP32S Windows XP NC-memory 256 KB (max. 200 programmes storage capacity) for ISO 66025 programming hard disk with approx.. 20 GB for free disposal 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	



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Pos.	Qty.	Description	Price
		insert of chamfer and radius Universal interface RS 232C (2 x V24) USB-interface at control panel Ethernet connection RJ45 in control panel orientated spindle stop drip feed function through V24 interface dimension metric or inch software limit switch, NC-diagnosis machine-diagnosis absolute indirect path measurement systems power meter in screen	
1200	1,00 ST	<b>CHIRON Powersafe</b> Software package for selective shutdown of installed consumers like axis motors, drives, spindles, seal air, airsensing and ancillary equipment in production breaks or during programmable points in time using a shift calendar. Definable point in time at which the machine starts demand-oriented automatically with a variable warmup programm to recovery the production readiness.	
1300	1,00 ST	<b>Wash gun</b> with 1 connection and quick coupling each in loading- and working area	
1400	1,00 ST	<b>Working hours and piece counter</b> in the screen	
1500	1,00 ST	<b>Socket 230 V</b> <b>at control panel</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>Chip conveyor (scratch band) small version</b> with lateral discharge, discharge height 1.050 mm, tank capacity 400 l, pump capacity max. 150 l/min. at 2,0 bar tank capacity	
1900	1,00 ST	<b>Fully enclosed working area</b>	



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Pos.	Qty.	Description	Price
2000	1,00 ST	<b>Coolant tank TPF 350 / FKA 900 (new)</b> (also for sludge generating materials, i.e. grey cast iron, GGG, Al with Si $\geq$ 12%) tank capacity 900 l low pressure pump capacity from 100 l/min at 2.4 bar up to 250 l/min at 2.3 bar high pressure pump capacity 30 l/min at 30 bar Full stream purification via drum paper bond filter TPF 350 S, with coolant purification 50 $\mu$ m nominal twin filter in the high pressure circuit for the protection of the machine	
2100	2,00 ST	<b>Machine preparation</b> for through tool coolant system including: - sealing system in the DIN 69871 Form A40 or 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 2 flow control switches - solenoid valve, controlled via machine program * HSK A63 tool holders for through tool coolant require 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: requires high pressure equipment)	
2200	1,00 ST	<b>Automatic central grease lubrication</b>	
2300	1,00 ST	<b>Suction point</b> for customer specific installation Ø 200 mm on top of the machine enclosure	
2400	1,00 ST	<b>Fixture washing</b> with nozzles installed at the centre divider controlled with m-functions for washing the working area (This filtration method will not eliminate increasing cast iron slurry from the coolant equipment.)	
2500	1,00 ST	<b>Screw conveyor</b> implemented in machine base for swarf extraction	



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Pos.	Qty.	Description	Price
2600	1,00 ST	<b>Pneumatic- and Hydraulic Connections</b>	
2700	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	
2800	1,00 ST	<b>Hydraulic unit</b> pressure: 210 bar supply capacity: 6 l/min. incl. valves for supply of 2 clamping devices and 2 pressure switches for clamping control	
2900	1,00 ST	<b>CHIRON Tool lifetime control with:</b> - tool place organization - sister tool organization - work field organization to control of 2 clamping cycles - tool data check for geometric values	
3000	1,00 ST	- <b>Documentation</b> -	
3100	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	
3200	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	
3300		<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°	
3400		<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.	



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Pos.	Qty.	Description	Price
3500		<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>	
3600		<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>	

