

Data sheet No. 20407835 / 13.08.2024

Item	Qty	Description
1000	1	<p>Vertical CNC-machining center FZ 15 W no. 149-04</p> <p>Year of construction: 2006 Condition: will be completely refurbished</p>
1040	1	<p>Vertical CNC-machining centre model FZ 15 W</p> <p>Drilling capacity in steel Ø 36 mm (with insert drill) Tapping capacity M 24 Milling capacity in steel 300 cm³/min</p> <p>COLUMN MOVING MACHINING CENTRE in steel- concrete- composite design with workpiece swivel table Suitable for dry machining with optimized chip drop Guideways with long-term-grease lubrication</p>
1060	1	<p>Main Spindle drive with AC-motor</p> <p>9,5 KW at 100 % 14,0 KW at 15 % for mainspindle Spindle speed range: 20 - 12.000 rpm - max.90 Nm</p>
1080	1	<p>Travel:</p> <p>X-axis 550 mm Y-axis 400 mm Z-axis 425 mm</p> <p style="margin-left: 200px;">with adjustable tool change level (plus distance from spindle nose to table surface, according to data sheet)</p>
1100	1	<p>Automatic tool changer, protected against chips</p> <p>No. of tools 20 Tool shaft SK 40 DIN 69871 + 72 Max. tool dia. 65 mm if all magazine pos. are occupied Max. tool dia. 175 mm if adjacent places are free Max. tool weight 2,5 kg (5,0 kg at 4 places) Tool change time appr. 0,9 s (depends on CNC) Chip-to-chip-time appr. 2,1 s (depends on CNC)</p>
1120	1	<p>Integrated Workpiece swivel table IWW 0/180 degrees</p> <p>With gaps underneath the trunnion fixture for optimal chip drop, with center divider workpiece swivel time appr. 2,4 s weight-dependent, self-regulating through self-learning speed-control table loading capacity per side 0 - max. 160 kg, max. 100 kg weight difference between the two table sides. Per table side integrated:</p> <ul style="list-style-type: none"> - NC-rotary-table, type AWU 160 P with pneumatic clamping repetition accuracy ± 15", face plate dia. 160 mm, with center bore dia. 50 +0.012 mm, fixture pin dia.16 h7, 4 fixture bores M10, - CHIRON standard fixture for rotary table bridge size 580 mm counter bearing with pneumatic clamping

Data sheet No. 20407835 / 13.08.2024

- flange plate incl. connecting couplings and quick-locator,
on side of the rotary table
- flange plate incl. connecting couplings and quick-locator,
on side of the counter bearing
- 2 x 2-core energy supply pneumatic or hydraulic
- swing radius 200 mm
- 4th or 5th NC-axes, complete
- pneumatic supply without control

1140 1 **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.
with 1 g acceleration

1160 1 **SIEMENS CNC-control 840D**
(PCU 50 / NCU 572.5)
incl. 10,4" TFT colour LCD screen / full keyboard OP10S
control panel logic 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
insert of chamfer and radius
Universal interface RS 232C (1 x V24) at control panel
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

Data sheet No. 20407835 / 13.08.2024

rigid tapping
look ahead function

- 1180 1 **CHIRON Maintenance Management in the screen**
display of the pending maintenance:
- advance warning = "prepare maintenance"
- warning = "carry out maintenance"
- machine stop = "catch up on maintenance"
Abridged instructions for the pending maintenance with graphic illustration on CD-ROM.
Password protected confirmation of the performed maintenance through the maintenance staff.
- 1200 1 **Working hours and piece counter**
in the screen
- 1220 1 **Socket 230 V**
at control panel
- 1240 1 **Socket for portable mini-hand wheel**
without emergency stop button,
at control panel
- 1260 1 **Cabinet cooler as a door mounting unit**
- 1280 1 **Signal lamp on machine enclosure for 3 signals**
Signal "red" = failure
Signal "white" = load machine
Signal "green" = machine is running
- 1300 1 **Machine enclosure**
with sliding doors, electrically interlocked,
2200 mm high above floor, incl. machine lamp
service friendly with removable side walls
vertical bellows
- 1320 1 **Chip conveyor (scratch band)**
with side discharge, discharge height 1.050 mm,
tank capacity 150 l
lift pump capacity max. 300 l/min. at 1,3 bar

(In case of steel machining and other materials with long chips
we recommend the use of a screw conveyor)

Precondition:
Coolant equipment or connection to central coolant system
- 1340 1 **Mini-operating panel**
with start and receipt push buttons, for pallet recognition M61/M62
- 1360 1 **Installation elements**

Data sheet No. 20407835 / 13.08.2024

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|------|---|--|
| 1380 | 1 | <p>Wash gun
with 1 connection and quick coupling each in loading- and working area</p> |
| 1400 | 1 | <p>Central pneumatic supply
with 2 outlet couplings, without control</p> |
| 1420 | 1 | <p>Stationary 3D Probe System
type TS 27 R, maker RENISHAW,
with adapter plate and
air blow for the measuring stylus,
for tool breakage control (in one working area),
for automatic tool length measurement,
for automatic temperature compensation,
including process-orientated measuring,
software for measuring cycles,
strategy program and tool holder with ball dia. 12 mm.</p> |
| 1440 | 1 | <p>Coolant equipment FKA 350
tank capacity 350 l,
pump capacity from 100 l/min. at 2,1 bar
up to 200 l/min. at 1,9 bar
incl. bed flushing system
Fixture washing
with nozzles installed at the centre divider
controlled with m-functions for washing the working area.</p> |
| 1460 | 1 | <p>Work space washing
with nozzles installed inside the Machine enclosure
and washing of centre divider
(Subject: Coolant equipment)</p> |
| 1480 | 1 | <p>Pneumatic connection controlled
with A/B connection on each tableside
for pneumatic clamping device
2 electrically activated pneumatic connections
for double acting; one pressure control,
either for one or two controlled clamping circuits;
at each clamping circuit pressure control
switch with automatic pressure regulation.
(in case of pressure change automatic pressure sensing)</p> |
| 1500 | 1 | <p>Central hydraulic and pneumatic supply
prepared for max. 20 connections,
6 connections are installed including connecting couplings,
4 for hydraulic, max. 200 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</p> |

Data sheet No. 20407835 / 13.08.2024

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| 1520 | 1 | Hydraulic unit
continuous duty
pressure: 200 bar
incl. valves for supply of 2 clamping devices
and 2 pressure switches for clamping control |
| 1540 | 1 | Cutting tools
The cutting tools have to be balanced
according to DIN 69 888, class G 6, 3,
in two levels, with max. operating speed |
| 1560 | 1 | Machine color
two-component structured paint - 2 colors
light grey acc. to NCS S1502-B
grey basalt acc. to RAL 7012 |