

Data sheet. 20385357 / 13.08.2024

Item	Qty	Description
1000	1	CNC-machining centre DZ 15 W 157-88 Year of construction: 2002
1040	1	Condition: Completely refurbished in 2022 Year of construction: 2002

According to described below scope of delivery

**Series 15
Machining medium Coolant**

1060	1	Column moving machining centre 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
1080	1	Machine enclosure with loading door, electrically interlocked, 2200 mm high above floor, incl. machine lamp service friendly with removable side walls vertical bellows
1100	1	Mini-operating panel with start and receipt push buttons, for pallet recognition M61/M62
1120	1	Workpiece swivel table 0/180° degrees with middle partition of sheet steel clamping surface 2 x 660 mm x 400 mm ² 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
1140	1	Travel: X-axis 300 mm Y-axis 400 mm Z-axis 425 mm with variable tool changing level Spindle distance 250 mm
1160	1	Main Spindle drive with 2 AC-motor 9,5 KW at 100 % 14,0 KW at 15 % Spindle speed range: 20 - 12.000 rpm - max.90 Nm Drilling capacity in 60 pc 2 x Ø 36 mm Tapping capacity 2 x M 24 Milling capacity in steel 60 pc 2 x 150 cm ³ /min

Data sheet. 20385357 / 13.08.2024

- 1180 1 **Automatic tool changer**
 Tool places 2 x 12
 Tool shaft HSK A63 DIN 69893
 Tool- max. 65 mm
 Tool-
 if adjacent places are free max. 150 mm
 Tool weight max. 2,5 kg (5,0 kg on 2 places)
 Tool changing time approx. 0,9 s (depends on CNC)
 Chip-to-chip-time approx. 2,1 s (depends on CNC)
- 1200 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.
 acceleration: 1,0 g
- Remark:
 With normal conditions the machine does not have to be anchored to the floor.
 (For slippery floors we recommend anchoring.)
- 1220 1 **SIEMENS CNC-control 840D**
 (PCU 20 / NCU 572.3, 6 measuring circuit, 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
 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 (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

Data sheet. 20385357 / 13.08.2024

		NC-diagnosis machine-diagnosis absolute indirect path measurement systems power meter in screen Rigid Taping
1240	1	CMS Powersafe Software package for the selective shutdown of installed loads loads such as axle motors, drives, spindles, KM pumps and auxiliary units during production breaks. Definable point in time at which the machine automatically switches to the automatically switches to Powersafe mode.
1260	1	Working hours and piece counter in the screen
1280	1	Socket 230 V at control panel
1300	1	Socket for portable mini-hand wheel without EMERGENCY-STOP button, at control panel
1320	1	Cabinet cooler as a door mounting unit
1340	1	Automatic loading door of total enclosure opening and closing, actuating to closing via two-hand push buttons
1360	1	Installation elements
1380	1	Signal lamp for 3 signals Signal "red" = failure Signal "white" = machine loaded Signal "green" = machine is running Mounted on splash guard panelling
1400	1	Wash gun
1420	1	Automatic centralised grease lubrication
1440	1	Fully enclosed working area
1460	2	Machine preparation for internal flushing tools through the spindle: - Sealing system in the DIN 69893 HSK A63* collet The following functions are deactivated, but remain in the machine: (- coolant distributor installed at the main spindle drive - Coolant leakage sensor - Implemented mud flap in the high pressure piping and flow control switch - Solenoid valve, controlled via machine program * At HSK A63 we recommend for tool holders the use of our patented coolant tube with sieve. Advantages: Decrease of the clogging

Data sheet. 20385357 / 13.08.2024

- in the internal coolant cannell.)
(Requirement for coolant system with HP pump)
- 1480 1 **Chip conveyor (scratch band)**
discharge height 1050 mm, lateral discharge
tank capacity 400 ltr, pump capacity 150 ltr/min at 2,0 bar
- 1500 1 **Coolant equipment**
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 35 ltr/min at 30 bar
full flow cleaning via vacuum rotation filter VRF 300, filtration 50 µm nominal
incl. tub flushing
- 1520 1 **Pneumatic- and Hydraulic Connections**
- 1540 1 **Central pneumatic connection**
uncontrolled with 2 connection couplings
- 1560 1 **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
- 1580 1 **Hydraulic unit**
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
- 1600 1 **Machine colour**
Two-components-structure varnish - 2 colours
light grey acc. to NCS S1502-B
basalt grey acc. to RAL 7012
- 1620 1 **Documentation acc. to CE of the first delivery into market**
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