

Datasheet No. 20505765 / 25.06.2026

Item	Qty	Description
1000	1	Vertical CNC-machining center DZ 18.2 KW 200-16
1040	1	Year of construction: 2005 Condition: completely refurbished
		According to described below scope of delivery
1060	1	COLUMN MOVING MACHINING CENTRE with workpiece swivel table Suitable for dry-machining with optimized chip drop Drilling capacity in steel 60 2 x ø 42 mm (with insert drill) Tapping capacity 2 x M 30 Milling capacity in steel 60 2 x 350 cm ³ /min.
1080	1	Machine enclosure with sliding doors, electrically interlocked, 2270 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 center divider made of sheet steel clamping surface 2 x 940 mm x 520 mm with thread and locating hole grid M16 x dia. 15 H7 x 50 mm workpiece change time approx. 3.7 s weight-dependent, self-regulating by means of self-teaching speed-control table loading capacity per side 0 - max. 400 kg max. 120 kg weight difference between the two table sides
1140	1	Travel X-axis 630 mm Y-axis 520 mm Z-axis 400 mm Spindle distance in X-axis 320 mm
1160	1	Main Spindle drive with 2 AC-motors 11,0 kW at 100 % 18,0 kW at 25 % Spindle speed range: 20 - 12.000 min ⁻¹ - 140 Nm
1180	1	Automatic tool changer No. of tools 2 x 32 Tool shaft HSK 63 DIN 69893 Max. tool dia. 78 mm if all magazine pos. are occupied Max. tool dia. 160 mm if adjacent places are free Max. tool length 300 mm Max. tool weight 5,0 kg (10 kg at reinforced tool places) Chip-to-chip-time appr. 2,7 s (depends on CNC)

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| 1200 | 1 | <p>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
 0,7 g in Y axis
 1,0 g in Z axis</p> |
| 1220 | 1 | <p>SIEMENS CNC-control 840D
 (PCU 50 / NCU 573.5, 6 measuring circuit, 1 channel)
 incl. 10,4" TFT colour LCD screen / full keyboard OP10S
 Windows NT
 NC-memory 256 KB
 (max. 200 programmes storage capacity)
 for ISO 66025 programming
 hard disk with approx.. 2 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, NC-diagnosis
 machine-diagnosis
 absolute indirect path measurement systems
 power meter in screen
 rigid taping</p> |
| 1240 | 1 | <p>CHIRON Powersave
 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.</p> |

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| 1260 | 1 | <p>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 USB flash drive.
 Password protected confirmation of the performed maintenance through the maintenance staff.</p> |
| 1280 | 1 | <p>Working hours and piece counter
 in the screen</p> |
| 1300 | 1 | <p>Socket 230 V
 at control panel</p> |
| 1320 | 1 | <p>Socket for portable mini-hand wheel
 without emergency stop button,
 at control panel</p> |
| 1340 | 1 | <p>Cabinet cooler as a door mounting unit</p> |
| 1360 | 1 | <p>Share button in the loading station
 for NC rotary table: 4 x 90° or 2 x 180° indexing,
 4th axis or 4th and 5th axes</p> |
| 1380 | 1 | <p>Installation elements
 For installation in an oil pan the installation directly on the sheet metal is not allowed. For out of it resulting problems there is no warranty. The machine documents for approval contain a proposal for the appropriate execution of the oil pan.</p> |
| 1400 | 1 | <p>Signal lamp on machine enclosure for 3 signals
 Signal "red" = failure
 Signal "white" = load machine
 Signal "green" = machine is running</p> |
| 1420 | 1 | <p>CHIRON Lasercontrol Single F500
 for tool breakage control,
 distance from transmitter to receiver <= 1000 mm,
 min. tool Ø > 1mm,
 incl. test mandrel with tool holder,
 transmitter and receiver,
 gland and shutter</p> |
| 1440 | 1 | <p>Fully enclosed work space</p> |
| 1460 | 1 | <p>Undervoltage relay
 with inadvertently variation of the power supply
 the machine will be stopped</p> |

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- 1480 1 **Electric interface for loader with "Profibus" - Siemens**
 on W-machines for loading through manual or automatic loading door
 for automatic loading system,
 with DP/DP-coupler (slave) in the electrical cabinet,
 according to documentation of CHIRON loader interface,
 consisting of: circuit diagram, signal description and functional diagram,
 interface tested according to Chiron-description,
 incl. key-operated switch and indicator lamp in the control panel "with
 loader",
 incl. direct door switch in position "door open"
- Deviation from the standard interface and set up will be
 charged according to effort.
 Waiting periods during set up will also be charged.
- Recommended options:
 - automatic doors, if necessary
 - tool life control
 - tool breakage control
 - fixture washing
 - chip conveyor, if not included in basic machine
 - Parts location air sensing
 - automatic central lubrication
- 1500 1 **Suction point**
 for customer specific installation
 Ø 200 mm on top of the machine enclosure
 and electrical preparation in cabinet
- 1520 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
- 1540 1 **Coolant equipment PF 50 / KFA 900**
 (for cast iron slurry, Al with Si \geq 12%)
 tank capacity 900 l,
 pump capacity from 100 l/min at 2,1 bar
 up to 250 l/min at 1,8 bar
 high pressure pump capacity 35 l/min at 30 bar
 high pressure circuit with filtration via paper bond filter,
 filtration 50 μ m nominal.
 twin filter in the high pressure circuit for the protection of the machine.
 incl. bed flushing system and
Fixture washing
 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.)

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- 1560 1 **2 x 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 and 2 flow control switches
 - 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 in the internal coolant channel.
- (Subject: required high pressure equipment)
- 1580 1 **NC-rotary-table package completely installed**
 consisting of:
 - 2 x NC-rotary-table, type AWU 160 P
 - 4th and 5th NC-axes, complete
 - 2 adapter-plates for center height 200 mm
 - central pneumatic supply without control
- Technical description for NC-rotary-table:
 center height 165 mm, repetition accuracy $\pm 15''$,
 load moment of inertia (without turning supply) 1,9 kgm²
 face plate dia. 160 mm, with center bore dia. 50 +0.012,
 fixture pin dia. 16 h7, 4 fixture bores M10,
 incl. pneumatic clamping
- 1590 2 **CHIRON standard fixture for rotary table**
 with pneumatic actuated counter bearing
 bridge size 800 mm
 existing of:
 - base plate (instead of the adaptor plate from the rotary table package) detachable to workpiece changer
 - counter bearing with pneumatic clamping
 - flange plate incl. connecting coupling and quick-locator, on side of the rotary table
 - flange plate incl. connecting coupling and quick-locator, on side of the counter bearing
 - 1 x 4-core energy supply pneumatic or hydraulic
 - 1 x 5 core energy supply 4 x pneumatic or hydraulic and 1 pneumatic
 - center height 230 mm about the base plate
- 1597 1 **Tool lifetime control with:**
 - tool place organization
 - sister tool organization

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| 1620 | 4 | <p>Hydraulic connection for 200 bar
 with 2 connecting couplings A+B and
 hydraulic installation up to outside of machine bed,
 incl. valve to control 1 double acting clamping circuit
 with pressure switch for electrical clamping control and
 electrical control for clamping OPEN-CLOSED
 2 x A/B per table side</p> |
| 1640 | 1 | <p>Hydraulic unit
 continuous duty, switch cycles less than 30 seconds
 pressure: 210 bar</p> |
| 1660 | 8 | <p>Parts location air sensing
 for fine sensing
 with energy-efficient pressure control by using 1 pressure switch
 including pneumatic and electric installation,
 Remarks: Maximum 3 nozzles per switch.
 Pre-requisite:
 Processed faces or aluminum die casting (not on partition
 or ejector flags), no grey cast iron.
 Additional rotary feedthroughs may be necessary at rotary table and at
 standard fixture for rotary table</p> |
| 1665 | 1 | <p>Treading feed without compensating chuck</p> |
| 1670 | 1 | <p>Direct switch
 in position 'door open'</p> |
| 1675 | 1 | <p>Automatic loading door of splash guard cover
 opening and closing, actuation via push button
 at control panel with photoelectric barrier</p> |
| 1680 | 1 | <p>Machine colour
 Two-components-structure varnish - 2 colours
 light grey acc. to NCS S1502-B
 basalt grey acc. to RAL 7012</p> |
| 1700 | 1 | <p>Cutting tools
 The cutting tools have to be balanced
 according to VDI 2060 quality,
 in two levels</p> |
| 1720 | 1 | <p>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</p> |