

Data sheet No. 20510990 / 25.06.2026

Item	Qty	Description
1000	1	Vertical CNC-machining center FZ 18 W 218-12 Condition: completely refurbished Year of manufacture: 2006
1040	1	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 Guideways with long-term-grease lubrication Drilling capacity in steel 60 \varnothing 42 mm (with insert drill) Tapping capacity M 30 Milling capacity in steel 60 500 cm ³ /min.
1080	1	AC-motor 11 kW at 100 % 18 kW at 25 % for main spindle Spindle speed range: 20 - 12.000 rpm - 140 Nm
1100	1	Travel X-axis 630 mm Y-axis 520 mm Z-axis 400 mm (plus distance from spindle nose to table surface, according to data sheet)
1120	1	Automatic tool changer with magazine cover against chips No. of tools 56 Tool shaft HSK A 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 Chip-to-chip-time appr. 2,7 s (depends on CNC)
1140	1	Workpiece swivel table 0/180 degrees with centre divider made of sheet metal clamping surface 2 x 940 mm x 520 mm with thread and locating hole grid M16 x \varnothing 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 weight difference between the two table sides
1160	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: 0,5 g in X axis 0,7 g in Y axis 1,0 g in Z axis

Data sheet No. 20510990 / 25.06.2026

1180 1 **SIEMENS CNC-control 840D**
 (PCU 50 / NCU 572.5)
 incl. 10,4" TFT colour LCD screen / full keyboard OP010S
 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
 rigid tapping
 look ahead function

1200 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 USB flash drive.
 Password protected confirmation of the performed
 maintenance through the maintenance staff.

Data sheet No. 20510990 / 25.06.2026

- | | | |
|------|---|--|
| 1240 | 1 | <p>Working hours and piece counter
in the screen</p> |
| 1260 | 1 | <p>Socket 230 V
at control panel</p> |
| 1280 | 1 | <p>Socket for portable mini-hand wheel
without emergency stop button,
at control panel</p> |
| 1300 | 1 | <p>Cabinet cooler as a door mounting unit</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> |
| 1500 | 1 | <p>Machine enclosure
Machine enclosure
with sliding doors, electrically interlocked,
2270 mm high above floor, incl. machine lamp
service friendly with removable side walls
vertical bellows</p> |
| 1600 | 1 | <p>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</p> <p>(In case of steel machining and other materials with long chips
we recommend the use of a screw conveyor)</p> <p>Precondition:
Coolant equipment or connection to central coolant system</p> |
| 1700 | 1 | <p>Mini-operating panel
with start and receipt push buttons, for pallet recognition M61/M62</p> |
| 1800 | 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> |
| 2500 | 1 | <p>Coolant equipment VRF 250 / 1200
tank capacity 1200 l,
pump capacity from 100 l/min at 2,1 bar
up to 250 l/min at 1,8 bar
high pressure pump capacity 20 l/min at 30 bar
coolant filtration for high pressure and flood coolant
with vacuum rotation filter VRF 250, filtration 50 µm nominal
and mud remover in clean water tank.
incl. bed flushing system and</p> |

Data sheet No. 20510990 / 25.06.2026

Fixture washing

with nozzles installed at the centre divider
controlled with m-functions for washing the working area.

2700 1 **70 bar high pressure pump**
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

2800 1 **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 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
in the internal coolant channel.
(Subject: required high pressure equipment)

3100 1 **Wash gun**
with 1 connection and quick coupling each
in loading- and working area

3600 1 **NC-rotary-table package, complete installed consisting of:**
- NC-rotary-table, type AWU 160 P
- 4th NC-axis, complete
- adapter-plate for centre height 200 mm
- central pneumatic supply without control

Technical description for NC-rotary-table:
centre height 165 mm, repetition accuracy $\pm 15''$,
load moment of inertia (without turning supply) 1,9 kgm²
face plate dia. 160 mm, with centre bore dia.
50 +0.012, fixture pin dia. 16 h7, 4 fixture bores
M10, incl. pneumatic clamping

Data sheet No. 20510990 / 25.06.2026

- | | | |
|------|---|--|
| 3900 | 1 | <p>CHIRON standard fixture for rotary table
 with pneumatic actuated counter bearing
 bridge size 720 mm
 existing of:</p> <ul style="list-style-type: none"> - 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 - 2 x 2-core energy supply pneumatic or hydraulic - center height 165 mm below the base plate |
| 4100 | 1 | <p>Fully enclosed work space</p> |
| 4200 | 1 | <p>Suction point
 for customer specific installation
 Ø 200 mm on top of the machine enclosure
 and electrical preparation in cabinet</p> |
| 4300 | 1 | <p>Software
 After the program has ended - Switch off the chip conveyor and tub rinsing pump
 - "Manual intervention" on the chip conveyor
 must be possible for cleaning.</p> |
| 4750 | 1 | <p>Additional button for indexing in the loading station
 indexing 4 x 90° or 2 x 180° for NC rotary tables,
 4th or 4th and 5th axis</p> |
| 5000 | 1 | <p>Machine colour
 two-components-structure varnish - 2 colours
 light grey acc. to NCS S1502-B
 basalt grey acc. to RAL 7012</p> |
| 7800 | 1 | <p>Documentation
 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> |