CHIRON Group

Data sheet No. 20385320 / 16.09.2022   CHIRON Group SE

Item	Qty	Description
1000	1	**Vertical CNC-machining center FZ 15 W**

1040	1	**Year of construction:** 2003
		Condition: completely refurbished
		Machine no.: 147-73

1060   1   **Vertical CNC-machining centre model FZ 15 W**

Drilling capacity in steel Ø 36 mm (with insert drill)
Tapping capacity   M 24
Milling capacity in steel   250 cm³/min

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

1080   1   **Machine enclosure**
with sliding doors, 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 centre divider made of sheet metal
clamping surface 2 x 660 mm x 400 mm
with thread and locating hole grid M16 x ø 15 H7 x 50 mm
workpiece swivel time appr. 2,4 s weight-dependent, self-regulating
through self-learning speed-control
table loading capacity per side 0 - max. 300 kg,
max. 100 kg weight difference between the two table sides

1140   1   **Travel:**
X-axis   550 mm
Y-axis   400 mm
Z-axis   425 mm   with adjustable tool change level

1160   1   **Main Spindle drive with AC-motor**
  9,5 KW at 100 %
14,0 KW at 15 % for mainspindle
Spindle speed range: 20 - 12.000 rpm - max.90 Nm

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1180   1   **Automatic tool changer, protected against chips**
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.   150 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)

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.
with 1, 0 g acceleration

1220   1   **SIEMENS CNC-control 840D**
(PCU 20 / NCU 572.3)
incl. 10,4" TFT colour LCD screen / full keyboard OP010S
NC-memory 256 KB
(max.200 programmes storage capacity)
for ISO 66025 programming
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) 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

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1240	1	**CMS Powersafe**

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.

1260	1	**Working hours and piece counter**

in the screen

1280	1	**Socket 230 V**

at control panel

1300	1	**Cabinet cooler as a door mounting unit**

1320	1	**Installation elements**

1340	1	**Wash gun**

with 1 connection and quick coupling each
in loading- and working area

1360	1	**Automatic central grease lubrication**

1380	1	**Fully enclosed work space**

(Standard at high speed plus package)

1400	1	**Chip conveyor (scratch band)**

with lateral discharge, discharge height 1.050 mm
tank capacity 300 l with pump capacity 150 l/min. at1, 5 bar

1420	1	**For machining with high chip volume or additional flushing options**

and the resultant big coolant flow
we recommend, to calm down the coolant and to
decrease the cleaning cycles at the chip conveyor and
the coolant pipes, coolant equipment with a tank capacity of 900 l.

1440	1	**Coolant equipment**

tank capacity 900 l,
pump capacity 200 l/min. at 2,0 bar
(the pump in the chip conveyor becomes the lift pump)
incl. bed flushing system

1460	1	**Package m-functions**

m72/m73   2 m-function pairs for
m74/m75   simple ON/OFF function
m76   m-functions to control a
m78   peripheral equipment with external setback
    (blocking of the machine course)

1480	1	**Slot sieve type W = 0,35**

1500	1	**Suction point**

for customer specific installation
Ø 200 mm on top of the machine enclosure

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1510	1	**Warranty**

CMS-full-service-Warranty
6 months after commissioning
for NC-control and machine
excluded wear parts.

1520	1	**Two-components-structure varnish - 2 colours**

light grey   acc. to NCS S1502-B
basalt grey   acc. to RAL 7012

1540	1	**Cutting tools**

The cutting tools have to be balanced
according to DIN ISO 1940, class G 2, 5,
in two levels, with max. operating speed

1560	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