

Data sheet No. 20385504 / 16.09.2022

Item	Qty	Description
1000	1	Vertical CNC-machining center CHIRON FZ 15 L no. 167-29
1040	1	Condition: partly refurbished Year of construction: 2006 According to described below scope of delivery
1060	1	Column moving machining centre with fixed table Suitable for dry-machining with optimized chip drop Guideways with long-term-grease lubrication
1080	1	Main spindle drive with AC-motor 13,0 kW at 100 % 26,0 kW at 25 % Spindle speed range: 20 - 10.500 min ⁻¹ - 300 Nm Drilling capacity in steel 60 ø 50 mm (with insert drill) Tapping capacity M 36 Milling capacity in steel 60 700 cm ³ /min.
1100	1	Travel: X-axis 2000 mm Y-axis 520 mm Z-axis 630 mm with adjustable tool change level
1120	1	Automatic tool changer with magazine cover against chips No. of tools 40 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 280 mm Max. tool weight 5,0 kg (8,0 kg) Tool change time appr. 1,0 s (depends on CNC) Chip-to-chip-time appr. 2,9 s (depends on CNC)
1140	1	Fixed table with chip pan clamping surface 2600 mm x 570 mm with 3 T-slots 2 x 18 H12, 1 x 18 H 8
1160	1	Machining area recognition M61/M62 for shuttle machining 2 x 580 mm, start- and receipt push buttons, mounted on both sides
1180	1	AC-servo motors for x-, y- and z-axes digital direct drives with indirect absolute path measuring system rapid traverse in all axes 40 m/min. acceleration: 0,5 g in X and Y axis 0,7 g in Z axis

Data sheet No. 20385504 / 16.09.2022

- 1200 1 **SIEMENS CNC-control 840D**
(PCU 50 / NCU 572.4, 6 measuring circuits, 1 channel)
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 DIN 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
polar coordinates
tool offsets for geometry, wear
tool radius correction for intersection computing
crossingradius
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)
Ethernet connection RJ45 in control panel
orientated spindlestop
drip feed function through V24 interface
dimension metric or inch
software limitswitch
NC-diagnosis
machine-diagnosis
absolute indirect path measurement systems
powermeter in screen
rigid tapping
look ahead function
- 1210 1 **CHIRON Powersave**
software package for selective shutdown of installed
consumers like axis motors, drives, spindles,
seal air, airsensing and ancillary equipment in production
breaks or during programmable points in time using a shift calendar.
- Definable points in time at which the machine starts demand-oriented
automatically with a variable warmup program
to recovery the production readiness.

Data sheet No. 20385504 / 16.09.2022

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| 1220 | 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 CD-ROM.
 Password protected confirmation of the performed maintenance through the maintenance staff.</p> |
| 1260 | 1 | <p>Working hours and piece counter
 in the screen</p> |
| 1280 | 1 | <p>Socket 230 V
 at control panel</p> |
| 1300 | 1 | <p>Socket for portable mini-hand wheel
 without emergency stop button,
 at control panel</p> |
| 2020 | 1 | <p>Cabinet cooler as a door mounting unit</p> |
| 2040 | 1 | <p>Signal lamp on control panel for 3 signals
 Signal "red" = failure
 Signal "white" = machine loaded
 Signal "green" = machine is running</p> |
| 2060 | 1 | <p>Machine enclosure
 with sliding doors, electrically interlocked,
 2400 mm high above floor, incl. machine lamp
 service friendly with removable back walls
 vertical bellows</p> |
| 2080 | 1 | <p>Chip conveyor (scratch band)
 with side discharge, discharge height 1.050 mm,
 tank capacity 400 l
 lift pump capacity max. 300 l/min. at 1,3 bar</p> <p>Precondition:
 Coolant equipment or connection to central coolant system</p> |
| 2100 | 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> |

Data sheet No. 20385504 / 16.09.2022

- 2180 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 20 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.
 (This filtration method will not eliminate increasing
 cast iron slurry from the coolant equipment.)
- 2200 1 **Machine preparation**
 for through tool coolant system including:
 - Sealing system in the DIN 69871 Form A40
 or DIN 69893 HSK A63* collet
 - coolant distributor installed at the main spindle drive
 - Coolant leakage sensor
 - Implemented mud flap in the high pressure piping
 - 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.
 - Reduction of the wear at the
 O-ring seal in the collet.
- (Subject: required high pressure equipment)
- 2220 2 **2 x Wash gun**
- 2240 1 **4. Achse steckerfertig**
 für NC Rundtisch
 (auf dem rechten Pendelfeld
 für ATU 280)
- 2260 1 **Machine colour**
 two-components-structure varnish - 3 colours
 window grey acc. to RAL 7040
 grey white acc. to RAL 9002
 basalt grey acc. to RAL 7012
- 2280 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
- 2285 1 **Warranty**
 3 months after commissioning
 on parts, excluded wear parts