

Offer

- 1 1 **Vertical CNC-machining centre model DZ 18 W Magnum
Refurbished used machine-delivered 2001
Weight 7000 kg**

Machine-No. 442-89

Column moving machining centre with workpiece swivel table

Main spindle drive with 2 AC-motors

2x 5,0 kW at 100% ED

9,5 kW at 25% ED

range of speed: 20 – 10.500 min⁻¹ – 60 Nm

Travel:

X-axis 400 mm

Y-axis 400 mm

Z-axis 630 mm with adjustable tool change level

Spindle distance in X-axis 320 mm

Automatic tool changer

Tool places 2 x 12

Tool shaft SK 40 DIN 69871 +72

Tool-Ø max. 78 mm

Tool-Ø for adjacent places are free max. 160 mm

Tool length max. 280 mm

Tool weight max. 5,0 kg (8,0 kg)

Tool change time approx. ca. 1,0 s (depends on CNC)

Chip-to-chip-time approx. ca. 2,9 s (depends on CNC)

Workpiece swivel table 0/180 degrees with mid separating wall
clamping surface 2 x 850 x 470 mm²

with thread and locating hole grids

M 16 x Ø 15 H7 x 50 mm

Tool change time approx. 4,0 s

Table loading capacity per side max. 250 kg (400 kg)

(at major table loading till max. 2 x 400 kg

the tool changer time will be to ca. 7 s elongated)

AC-Servo-Motor

feed drives for X-, Y- and Z- axis

indirect path measuring system

rapid traverse 30 m/min

SIEMENS CNC-control 840D

(MMC 100.2 / NCU 571.2, 6 measuring circuits, 1 channel)
 incl. 10,4" TFT LCD monochrom screen / complete keyboard 0O032S
 NC-memory 256 KB
 (200 KB dispisable)
 for ISO 66025 programming
 drilling cycles G81-G89
 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
 crossingradius
 4 zero offsets G54-G57
 30 zero shifts programmable with G-functions
 3D and helical interpolation
 screen switch off
 mirror function
 scale factor
 insert of chamfer and radius
 universal interface RS 232C (2x V24)
 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

Working hours and piece counter
 in the screen

Socket 230 V
 at control panel

Machine enclosure
 screwed, with loading door, electrically interlocked
 2600 mm high above floor, incl. machine lamp,

Mini-operating panel
 with start and receipt push buttons, for pallet recognition M61/M62

Pos.	Menge	Artikel Beschreibung	Preis / €
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Cabinet cooler as a door mounting unit

Installation elements

2 **Optional extra equipment**

Chip conveyer (scratch band)

discharge height 1050 mm
 (for cast iron slurry)
 tank capacity 500 ltr.,
 pump capacity 200 ltr/min at 1,3 bar
 pump capacity 20 ltr/min at 20 bar
 high pressure circuit with coolant filtration via
 paperbondfilter and twinfilter incl. bed flushing system
 (This filtration method will not eliminate increasing cast
 iron slurry from the coolant equipment.)

70 bar high pressure pump

flow rate 34 l/min at 30 bar - 22 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

2 x Machine preparation

for through tool coolant system including for DIN 69871 Form A 40

Wash gun

Loading door of total enclosure

opening and closing automatically,
 incl. two-hand push buttons

NC Rotary table, completely installed consisting of:

- 2 NC rotary tables, type RT 160, maker CHIRON-PEISELER
- 4th and 5th NC-axes, complete
- 2 adapter plates for centre height 200 mm
- pneumatic supply, without control

Technical description NC rotary table
 centre height 165 mm, indexing accuracy $\pm 15''$
 face plate dia. 160 mm, center bore dia. 50+0,012,
 location pin dia. 16h7, 4 bolt holes M10
 with pneum. clamping

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CHIRON standard fixture for rotary table

with pneumatic counter bearing clamping

existing of:

- base plate (instead of the adaptor plate from the rotary plate)
screw and setting on at the workpiece changing device
- counter bearing with pneumatic clamping
- cheek incl. connecting coupling, on side of the rotary table
- cheek incl. connecting coupling, on side of the counter bearing
- 2 x 1-core energy supply pneumatic
- centre height 165 mm over base plate

Bridge size 620 mm

Central greasing

Coolant lubrication:

The machine is designed for standard water soluble emulsion and without top enclosure as described in our brochure. If the coolant mixture is higher than 15 % oil or cutting oil is used the machine has to be totally enclosed, an exhaust system and the cutting oil package has to be installed.

The machine contains different plastics, varnish, resin and glue, which are selected carefully for using coolant and cutting oil. The use of aggressive coolant and additive could cause or damages and machine stoppages.

3 Pneumatic- and Hydraulic Connections

Hydraulic connection

with 9-connecting turnable lead-in and connecting coupling therefrom 8 connections for hydraulic max. 350 bar and 1 connection for uncontrolled pneumatic
2 connecting couplings

Hydraulic unit Heilmeyer & Weinlein

pressure: 210 bar
supply capacity: 6,0 ltr./min.
incl. valves for supply of 2 clamping circles
including 2 pressure switches for electric clamping control

4 Options of Sinumerik 840D

Rigid tapping

Pos.	Menge	Artikel Beschreibung	Preis / €
		Total machine price as describe above	on inquiry
		Packing and loading (One-way packing for transport by truck)	on inquiry
		Documentation and machine marks Operating manuals, programming and operating manuals 1-fold	
		Main circuit total power supply 400 / 230V \pm 10 %, 50 cycles N/PE neutral conductor, load possible pressure supply 6 bar, \pm 1 bar room temperature max 40 degrees celsius	
		Delivery time: after arrangement, intermediate resale reserve	
		Delivery ex works, packing excluded	
		Payment 100% strictly net after delivery	
		Warranty 6 months on parts excluding wear parts	
		Machine colour RAL 7040 – RAL 9002 - RAL 7012	
		Transport insurance to be covered by customer	