

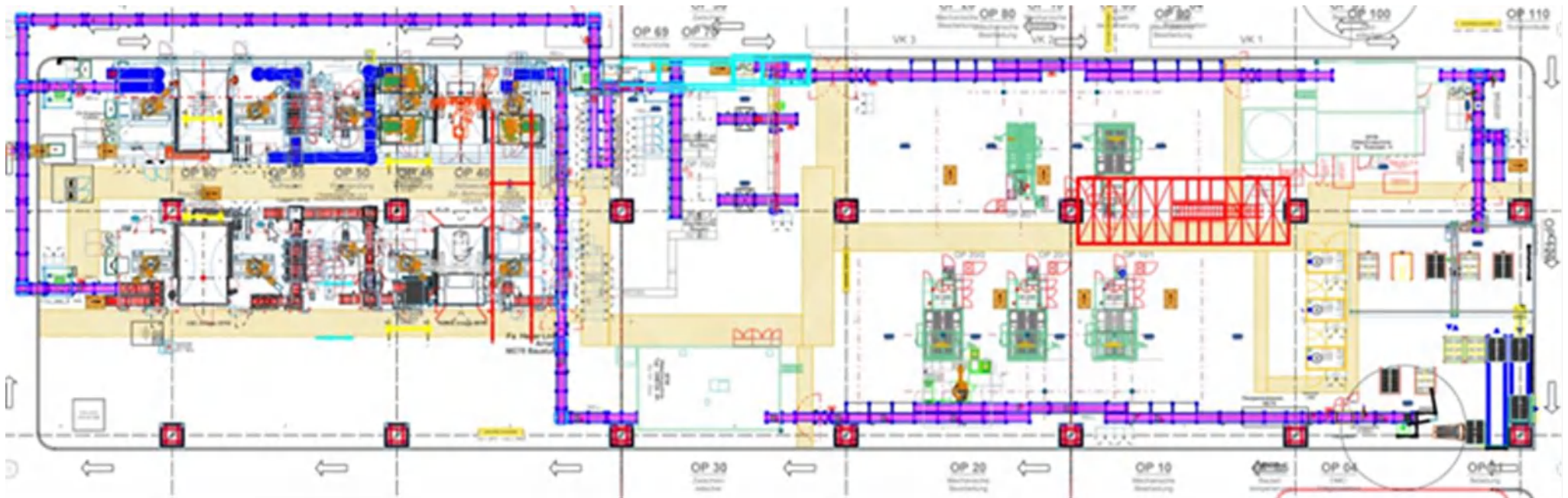
Subject to prior Sale we offer for Sale

Machining Line for Cylinder-Blocks of Aluminium Cylinder Blocks

formerly used for pre-machining of the 3 Liter V6 petrol engine block M 276

YoM 2012, Capacity: 200.000 Pieces per Year in 3 Shifts on ca. 1.500 sqm

The production line has been dismantled and temporarily stored in the warehouse, Danzhou City, Hainan Province, China.



Operation – Stations (OP) of the Line:

- OP 04 TRUMPF marking – laser
- OP 05 BLEICHERT tempering unit
- OP 10 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor
- OP 20.1 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor
- OP 20.2 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor
- OP 30 MTM 4-chamber rotary transfer washing unit
- OP 40.1 cylinder bore coating unit -NOT PART OF SALE- (patented)
- OP 40.1 2x KUKA robots, BLEICHERT conveyor, URACA high-pressure pumps
- OP 40.2 high pressure beam-ray unit -NOT PART OF SALE- (patented)
- OP 40.2 2x KUKA robots, BLEICHERT conveyor, URACA high-pressure pumps
- OP 45.1 cleaning station -NOT PART OF SALE- (patented)
- OP 45.2 cleaning station -NOT PART OF SALE- (patented)
- OP 50.1 HOMMEL pore-checking, KUKA robot
- OP 52.1 BLEICHERT conveyor
- OP 55.1 BSN through feed furnace
- OP 55.2 BSN through feed furnace
- OP 60.1 2x KUKA robots
- OP 60.1 cylinder bore coating unit -NOT PART OF SALE- (patented)
- OP 60.2 2x KUKA robots
- OP 60.2 cylinder bore coating unit -NOT PART OF SALE- (patented)
- OP 65 BLEICHERT tempering unit

- OP 70.1 GEHRING PT 4-1000-125 cylinder-bore honing machine
- OP 70.2 GEHRING PT 4-1000-125 cylinder-bore honing machine
- OP 80 MAG SPECHT 500 hmc, KUKA robot, BLEICHERT conveyor
- OP 90 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor
- OP 100 MTM high-pressure washing unit with KUKA robot
- OP 110 SIEMENS final checking
- OP 120 BLEICHERT end of line + unloading


Fotos of Operation – Stations (OP):

a) OP 04 TRUMPF marking – laser and OP 05 BLEICHERT tempering unit



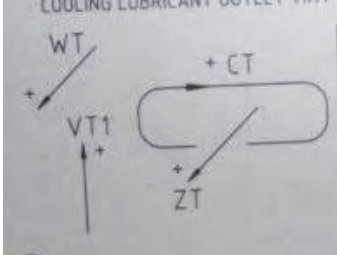
b) OP 10 MAG SPECHT 500 DUO hmc, KUKA KR 210-2-2000 robot, BLEICHERT conveyor



 MAG IAS GmbH <small>Selcher Straße 93 73054 Eisingen</small>	
MASCHINEN_TYP TYPE OF MACHINE	Specht 500 DUO
DAIMLER EQUIPMENT-NUMMER	910100015519
MASCHINENNUMMER MACHINE NO.	X.0112.2785
AUFTRAGSNUMMER ORDER NO.	7012656
SCHALTPLAN-NR. WIRING DIAGRAM NO.:	XD.8056.9311
BAUJAHR YEAR OF PRODUCTION	2011
BETRIEBSSPANNUNG OPERATION VOLTAGE	400V 3~ / 50 Hz
STEUERSPANNUNG CONTROL VOLTAGE	24 V~
VENTILSPANNUNG VALVE VOLTAGE	24 V~
KURZSCHLUSSAUSSCHALTVERMÖGEN SHORT CIRCUIT RATING	100 kA
BEDAMTENNISTROM NOMINAL FULL-LOAD CURRENT	80 A
SICHERUNG IN DER ZULEITUNG MAIN SUPPLY FUSE	max 105 A
<small>MADE IN GERMANY</small>	


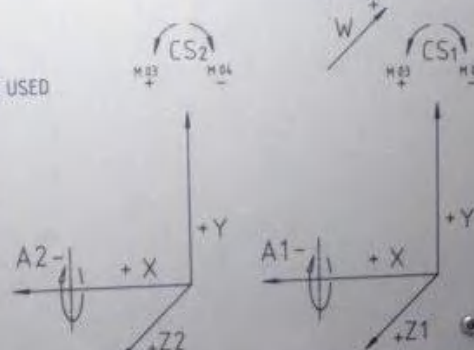
NUR WERKZEUGE MIT MONTIERTEM KUEHLSCHMIERMITTELROHR UND KUEHLSCHMIERMITTELAUSTRITTS-OEFFNUNG VERWENDEN

ONLY TOOLS HAVING INSTALLED COOLING LUBRICANT LINES AND COOLING LUBRICANT OUTLET MAY BE USED



KEINE PRESSLUFT ZUM REINIGEN DER MASCHINE VERWENDEN

DO NOT USE COMPRESSED AIR FOR CLEANING MACHINE



c) OP 20.1 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor



MAG
MAG IAS GmbH
Salacher Straße 93 73054 Eisingen

MASCHINEN TYP TYPE OF MACHINE	Specht 500 DUO
DAIMLER EQUIPMENT-NUMMER	910100015516
MASCHINENNUMMER MACHINE NO.	X.0112.2786
AUFTRAGSNUMMER ORDER NO.	7012657
SCHALTPLAN-NR. WIRING DIAGRAM NO.	XD.1056.7754
BAUJAHR YEAR OF PRODUCTION	2011
BETRIEBSSPANNUNG OPERATION VOLTAGE	400V 3- / 50 Hz
STEUERSPANNUNG CONTROL VOLTAGE	24 V=
VENTILSPANNUNG VALVE VOLTAGE	24 V=
KURZSCHLUSSAUSSCHALTVERMÖGEN SHORT CIRCUIT RATING	100 kA
GESAMTNENNSTROM NOMINAL FULL-LOAD CURRENT	80 A
SICHERUNG IN DER ZULEITUNG MAIN SUPPLY FUSE	max. 125 A

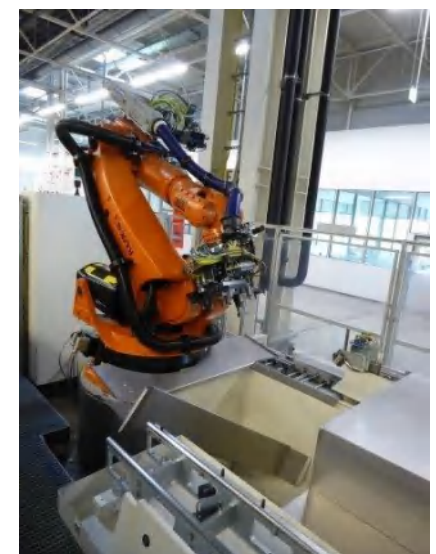
MADE IN GERMANY

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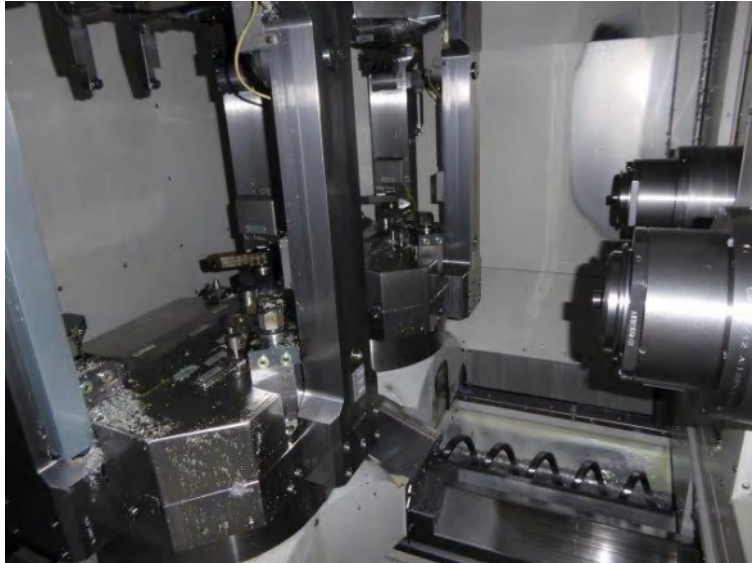
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d) OP 20.2 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor



MAG
MAG IAS GmbH
Salscher Straße 93 73054 Eisingen

MASCHINEN TYP TYPE OF MACHINE	Specht 500 DUO
DAIMLER EQUIPMENT-NUMMER MACHINE NO.	910100016297
MASCHINENNUMMER MACHINE NO.	X.0112.3656
AUFTRAGSNUMMER ORDER NO.	7013570
SCHALTPLAN-NR. WIRING DIAGRAM NO.	XD 1056.7754
BALJAHR YEAR OF PRODUCTION	2013
BETRIEBSSPANNUNG OPERATION VOLTAGE	400V 3~ / 50 Hz
STEUERSPANNUNG CONTROL VOLTAGE	24 V~
VENTILSPANNUNG VALVE VOLTAGE	24 V~
KURZSCHLUSSAUSSCHALTVERMÖGEN SHORT CIRCUIT RATING	100 kA
GESAMTNENNSTROM NOMINAL FULL-LOAD CURRENT	80 A
SICHERUNG IN DER ZULIEFERUNG MAIN SUPPLY FUSE	125 A

MADE IN GERMANY

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e) OP 30 MTM OMEGA 4-H, 4-chamber rotary transfer washing unit



f) OP 40.1 cylinder bore coating unit -NOT PART OF LINE- (patented)

g) OP 40.2 high pressure beam-ray unit -NOT PART OF LINE- (patented)

h) handling of OP 40.1 and OP 40.2

2x KUKA KR 360-2 F robots, BLEICHERT conveyor, URACA high-pressure 3.000 bar pump



2x KUKA KR 360-2 F robots, BLEICHERT conveyor, URACA high-pressure 3.000 bar pump



- i) OP 45.1 and OP 45.2 cleaning stations -NOT PART OF LINE- (patented)
- j) OP 50.1 HOMMEL pore-checking, KUKA KR 30-3 F robot



k) OP 52.1 BLEICHERT conveyor

OP 55.1 BSN through feed furnace

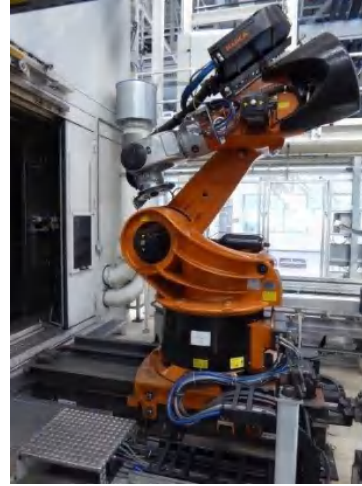
OP 55.2 BSN through feed furnace



l) OP 60.1 and OP 60.2 cylinder bore coating unit -NOT PART OF LINE- (patented)

m) OP 60.1 and OP 60.2

2x KUKA KR 360-2 F robots

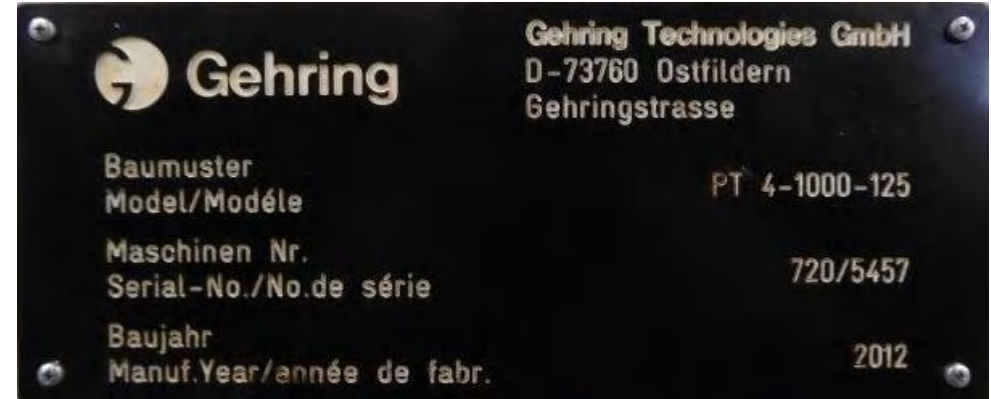
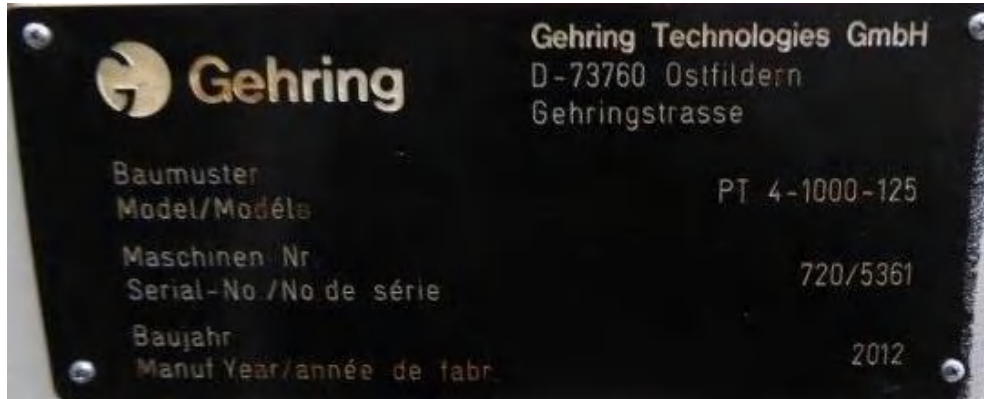


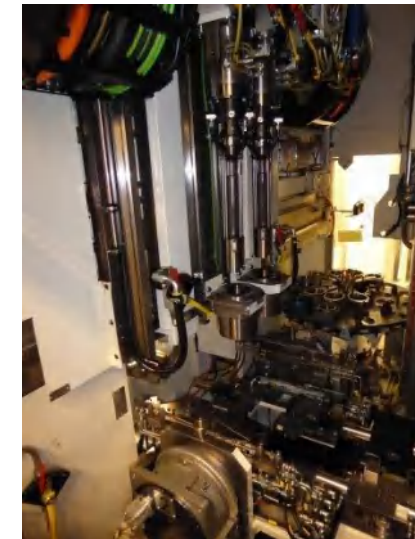
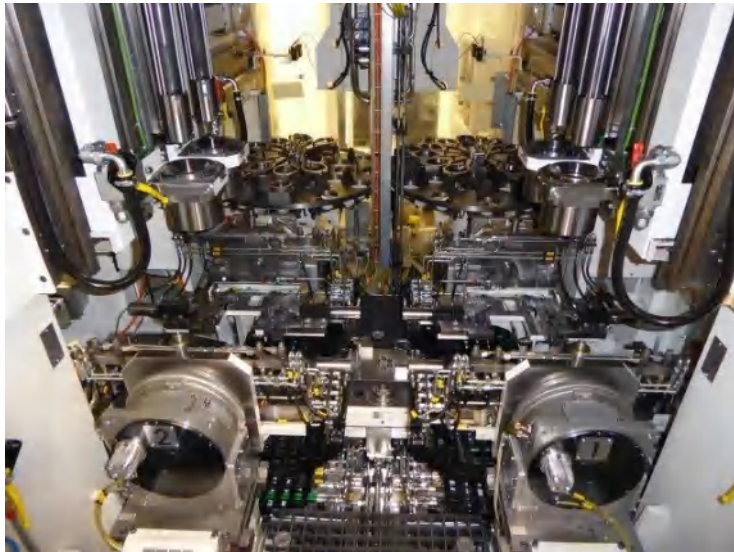
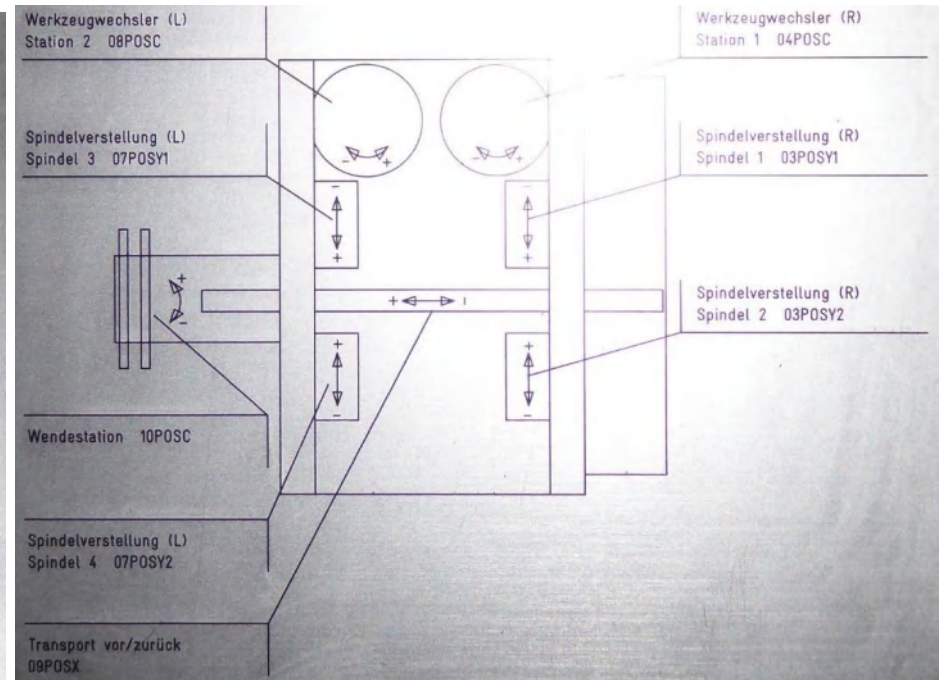
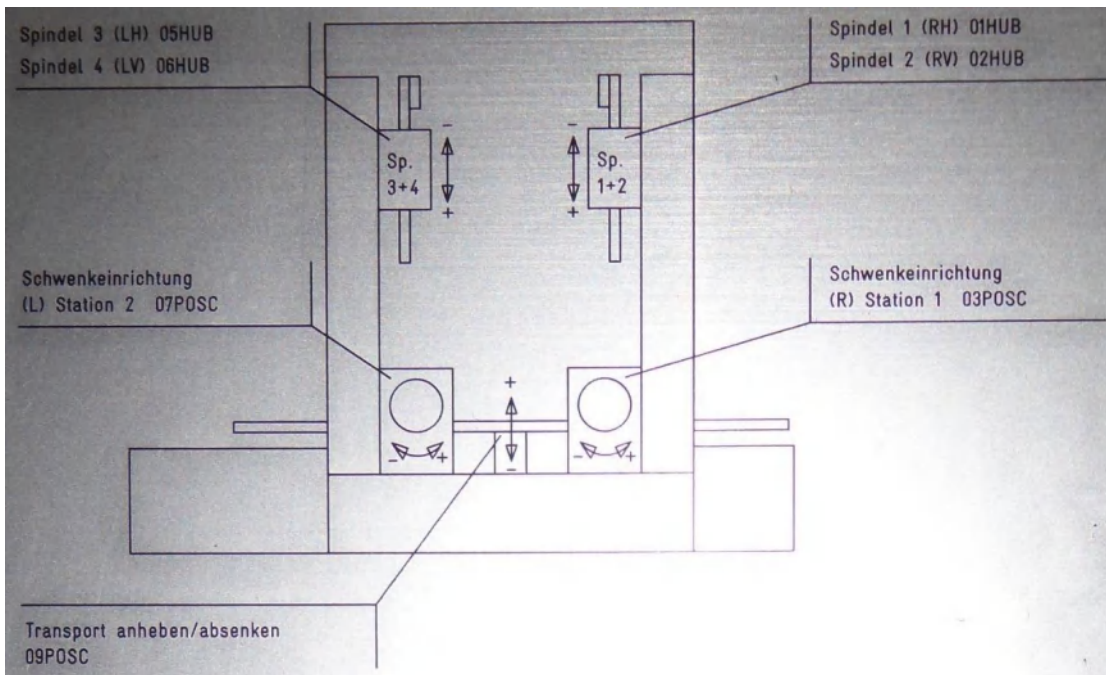
2x KUKA KR 360-2 F robots



n) OP 65 BLEICHERT tempering unit

o) OP 70.1 and OP 70.2 GEHRING PT 4-1000-125 cylinder-bore honing machines



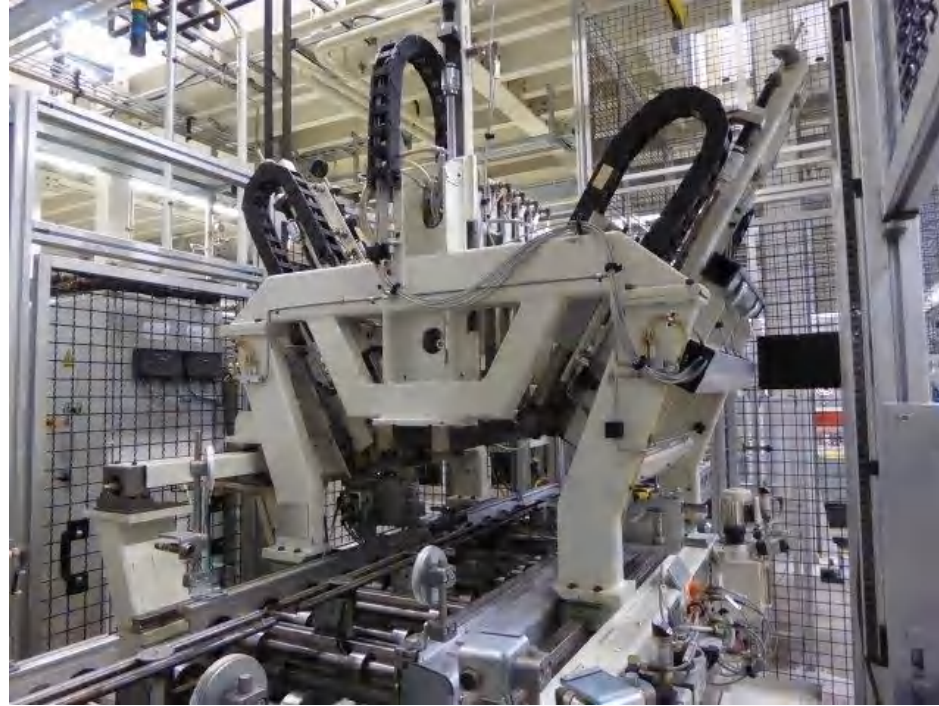




min/mx honing dia 40 – 105 mm
 min/max honing stroke 5 – 500 mm
 honing length 300 mm
 L x W x H, ca. 8,5 x 6 x 4 m / 8,5 x 9 x 4 m


no. of honing spindles 4
 tool changer, 2 pieces
 spindle speeds
 weight, ca.

4
 2 x 12 positions
 100 – 2.000 rpm
 28 tons



p) OP 80 MAG SPECHT 500 hmc, KUKA KR 210-2 2000 robot, BLEICHERT conveyor




 MAG IAS GmbH <small>Sälcher Straße 92 73054 Ebingen</small>	
MASCHINEN_TYP TYPE OF MACHINE	Specht 500
DAIMLER EQUIPMENT-NUMMER	910100015317
MASCHINENNUMMER MACHINE NO.	X.0112.3282
AUFTRAGSNUMMER ORDER NO.	7013176
SCHALTPLAN-NR. WIRING DIAGRAM NO.	XD.1058.0140
BAUJAHR YEAR OF PRODUCTION	2012
BETRIESSPANNUNG OPERATION VOLTAGE	400V/3~ (50 Hz)
STEUERSPANNUNG CONTROL VOLTAGE	24 V _{DC}
VENTILSPANNUNG VALVE VOLTAGE	24 V _{DC}
KURZSCHLUSSAUSCHALTVERMÖGEN SHORT CIRCUIT RATING	100 kA
GESAMTHEINSTROM NOMINAL FULL-LOAD CURRENT	80 A
SICHERUNG IN DER ZULEITUNG MAIN SUPPLY FUSE	80 A
MADE IN GERMANY	



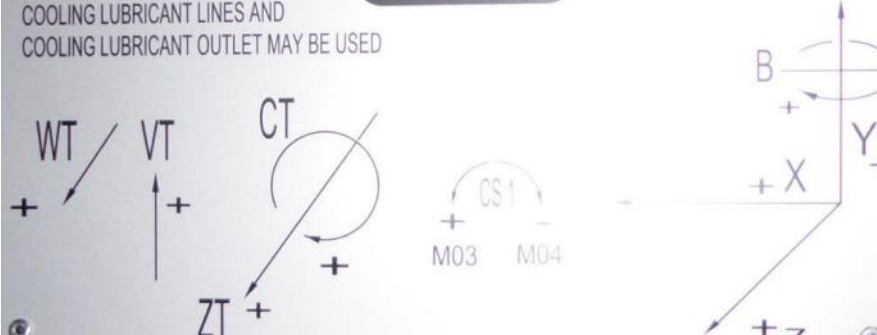
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q) OP 90 MAG SPECHT 500 DUO hmc, KUKA KR 210-2 2000 robot, BLEICHERT conveyor



MAG
MAG IAS GmbH
Selcher Straße 93 73084 Ellingen

MASCHINEN TYP TYPE OF MACHINE	Specht 500 DUO
DAIMLER EQUIPMENT-NUMMER	910100015318
MASCHINENNUMMER MACHINE NO.	X.0112.3293
AUFTRAGSNUMMER ORDER NO.	7013177
SCHALTPLAN-NR. WIRING DIAGRAM NO.	XD-1059-6572
BAUJAHR YEAR OF PRODUCTION	2012
BETRIEBSSPANNUNG OPERATION VOLTAGE	400V 3~150 Hz
STEUERSPANNUNG CONTROL VOLTAGE	24 V _{DC}
VENTILSPANNUNG VALVE VOLTAGE	24 V _{DC}
KURZSCHLUSSAUSSCHALTVERMÖGEN SHORT CIRCUIT RATING	100 kA
GESAMTSTROM NOMINAL FULL LOAD CURRENT	83 A
SICHERUNG IN DER ZULIEFERUNG MAIN SUPPLY FUSE	100 A

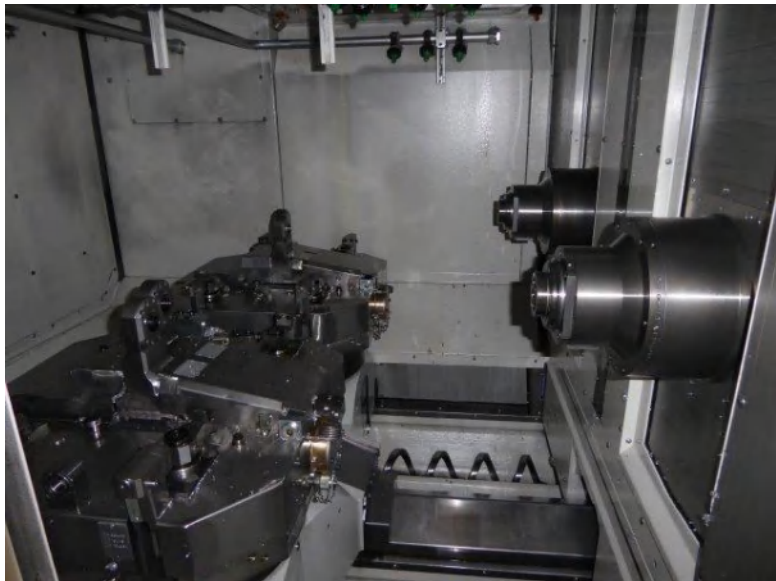
MADE IN GERMANY

NUR WERKZEUGE MIT MONTIERTEM KUEHLSCHMIERMITTELROHR UND KUEHLSCHMIERMITTELAUSTRITTS-OEFFNUNG VERWENDEN

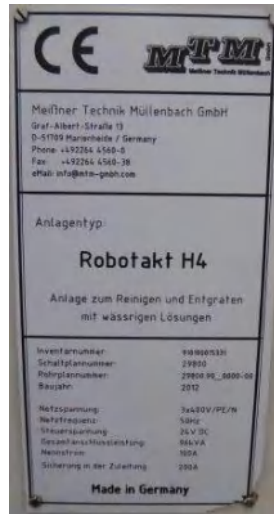
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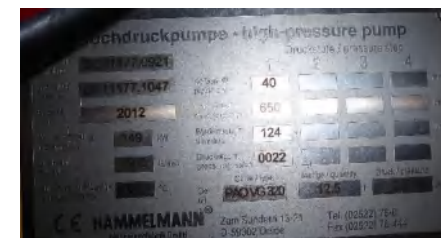
r) OP 100 MTM ROBOTAK 4 H high-pressure rotary-transfer washing unit with KUKA robot



- Station 1: loading / unloading
- Station 2: splash / flood washing on 9,5 bar
- Station 3: robot cell:
 - o Splash washing with 5 bar + rotation
 - o Deburring with 600 bar with three rotation lances
- Station 4: vacuum drying

L x W x H, ca. 12 x 6,5 x 6,5 m
max part weight 50 kg

HAMMELMANN high-pressure 650 bar pump:



s) OP 110 SIEMENS final checking and OP 120 BLEICHERT end of line + unloading



Contact: wchen@maynards.com

M [+86 186 2193 7752](tel:+8618621937752)

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