

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



 <b>MAG IAS GmbH</b> <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
BEDARFTENSTROM NOMINAL FULL-LOAD CURRENT	80 A
SICHERUNG IN DER ZULEITUNG MAIN SUPPLY FUSE	mex 105 A


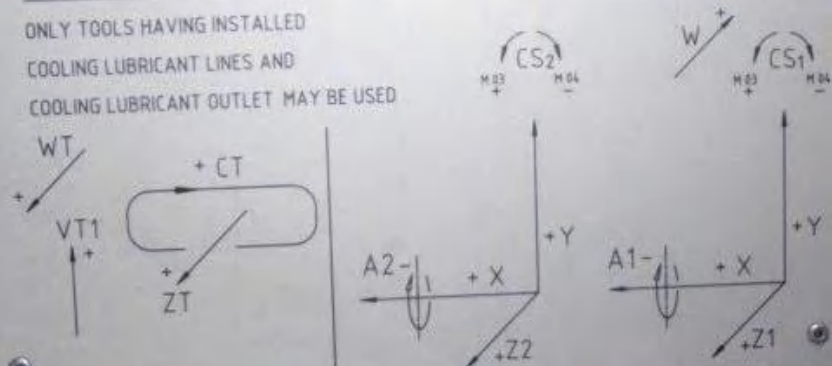
MADE IN GERMANY

NUR WERKZEUGE MIT MONTIERTEM KUEHLSCHMIERMITTELROHR UND KUEHLSCHMIERMITTELAUSTRITTS-OEFFNUNG VERWENDEN

KEINE PRESSLUFT ZUM REINIGEN DER MASCHINE VERWENDEN

DO NOT USE COMPRESSED AIR FOR CLEANING MACHINE

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


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

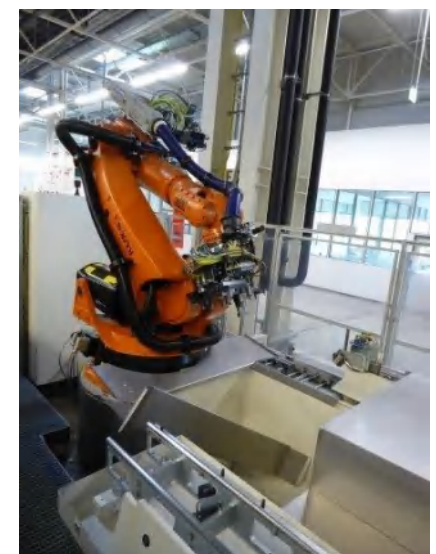
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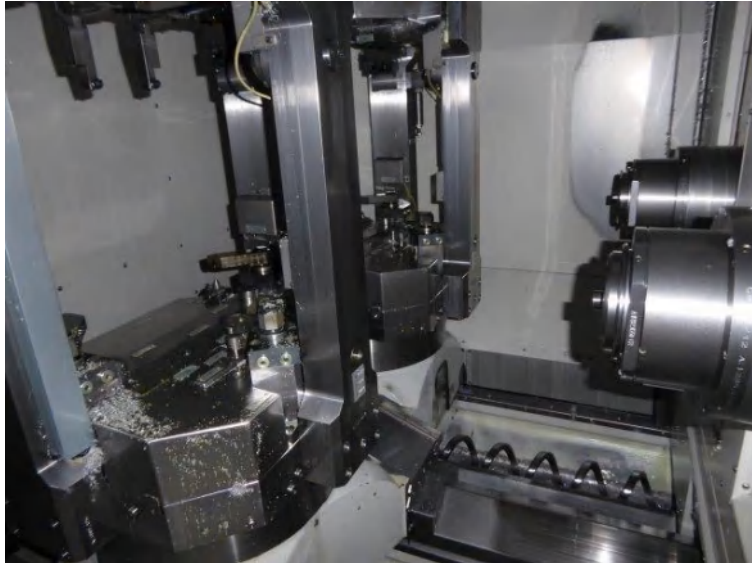
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d) OP 20.2 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor



**MAG**  
MAG IAS GmbH  
Salscher Straße 93 73054 Eisingen

MASCHINEN TYP TYPE OF MACHINE	Specht 500 DUO
DAIMLER EQUIPMENT-NUMMER MACHINE NO.	910100016297
MASCHINENUMMER 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 ZULIFFUNG MAIN SUPPLY FUSE	125 A

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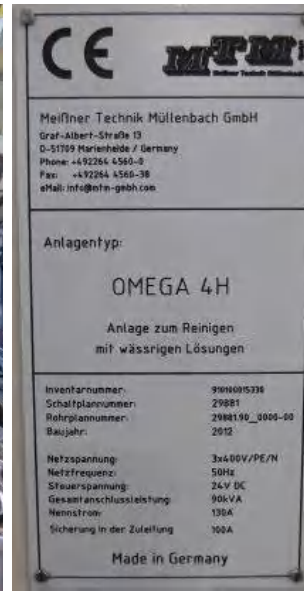
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e) OP 30 MTM OMEGA 4-H, 4-chamber rotary transfer washing unit



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

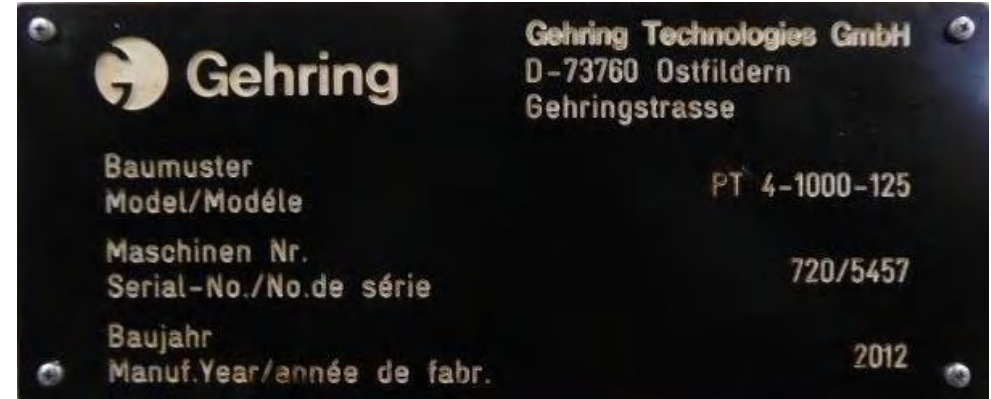
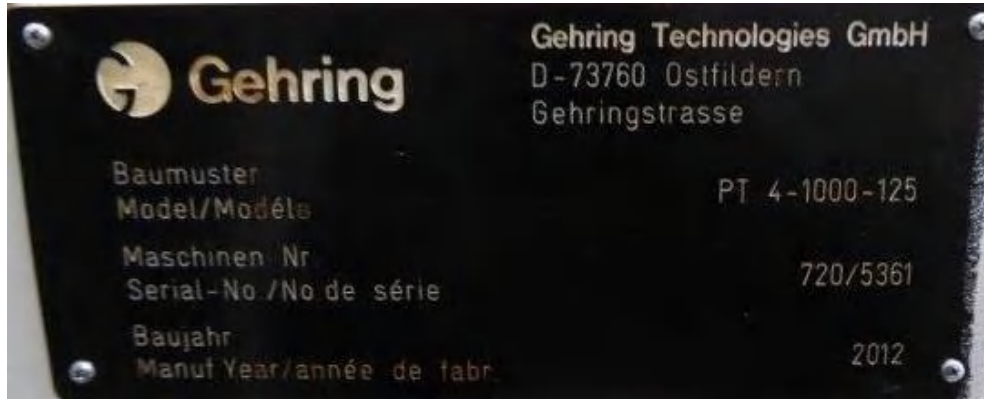


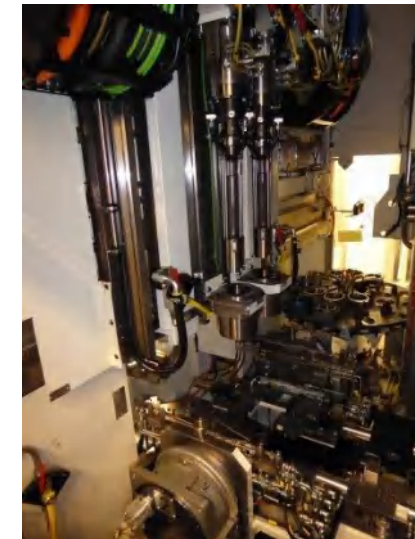
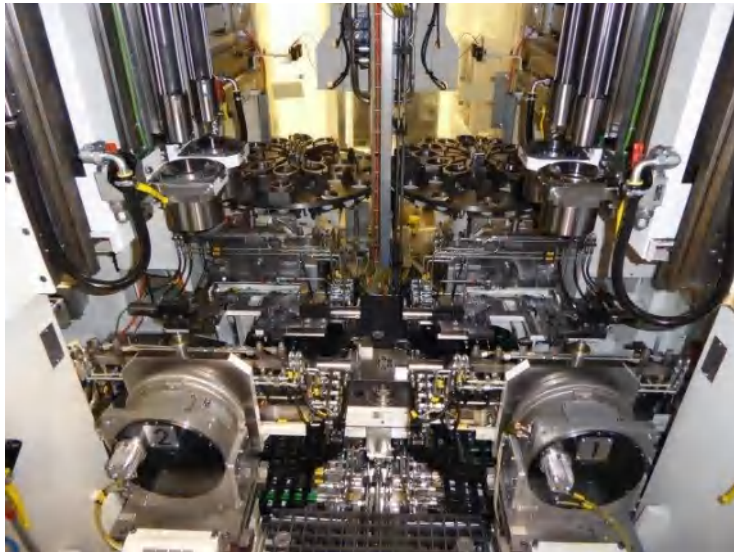
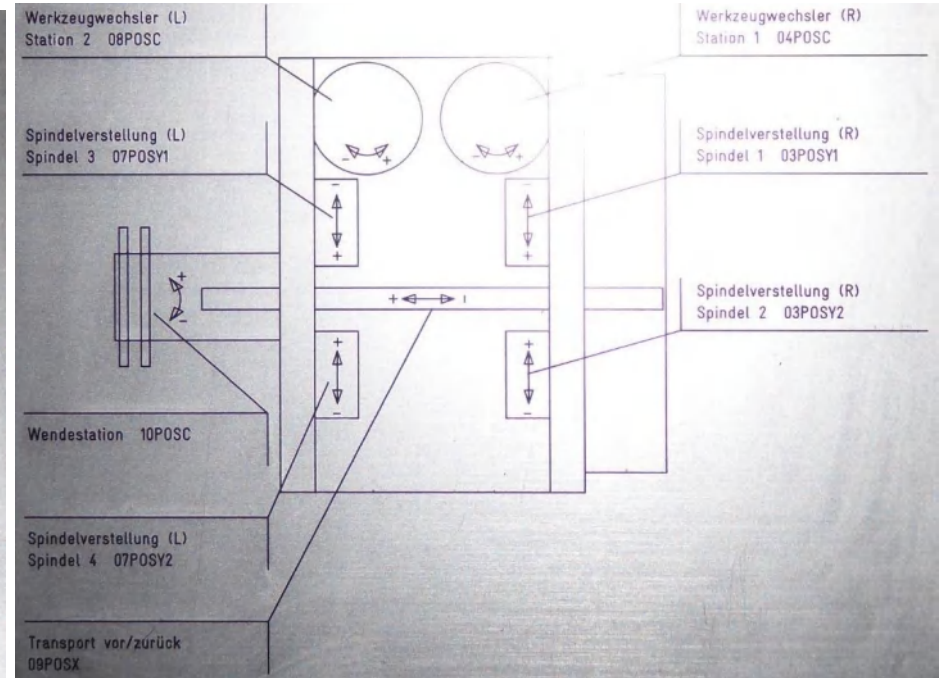
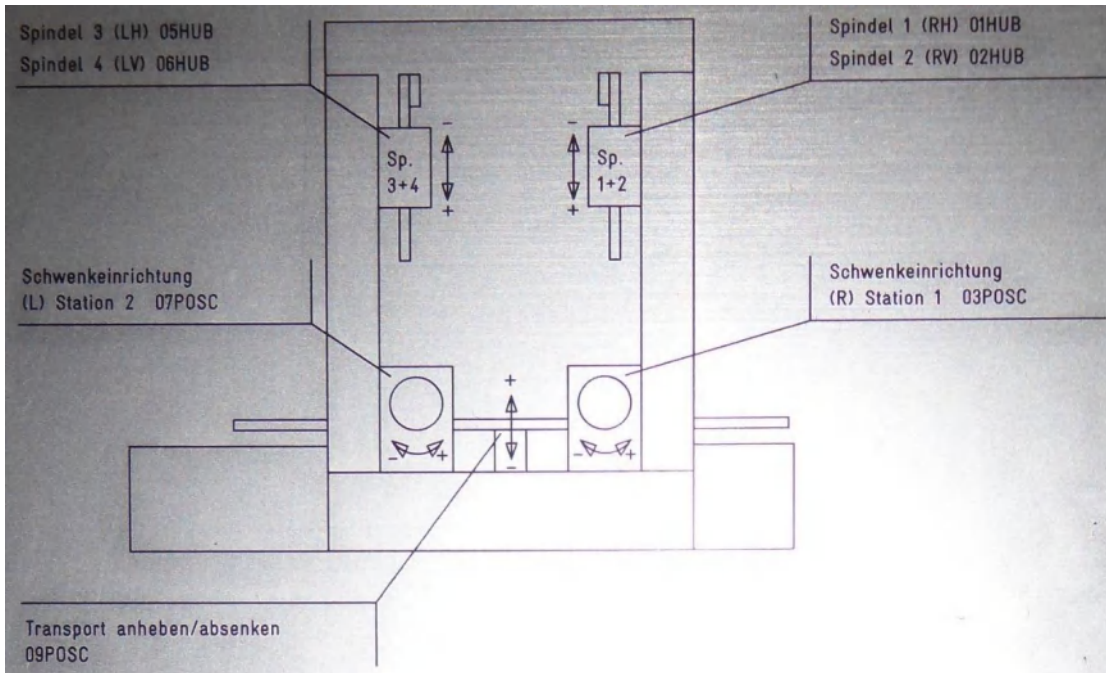
2x KUKA KR 360-2 F robots



n) OP 65 BLEICHERT tempering unit

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



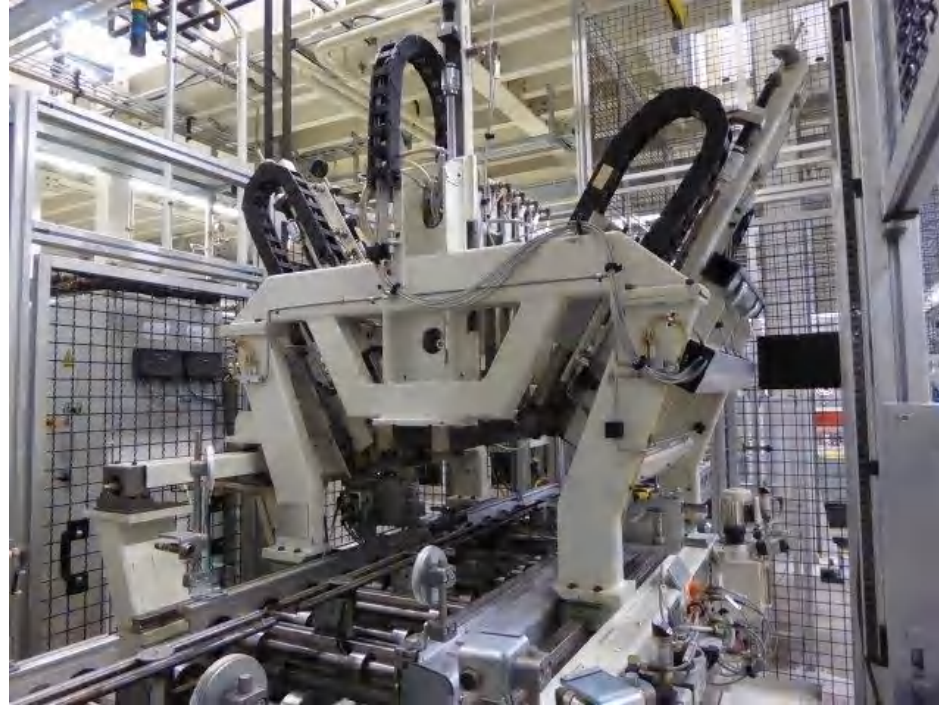




min/mx honing dia      40 – 105 mm  
 min/max honing stroke   5 – 500 mm  
 honing length            300 mm  
 L x W x H, ca.            8,5 x 6 x 4 m / 8,5 x 9 x 4 m


no. of honing spindles  
 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




 <b>MAG IAS GmbH</b> <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 <sub>DC</sub>
VENTILSPANNUNG VALVE VOLTAGE	24 V <sub>DC</sub>
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	



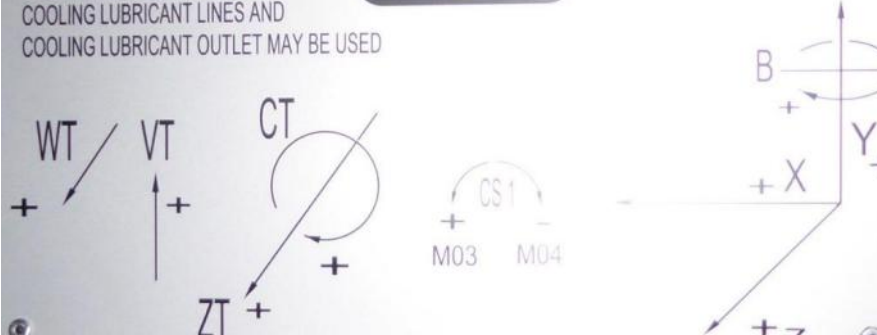
NUR WERKZEUGE MIT MONTIERTEM KUEHLSCHMIERMITTELROHR UND KUEHLSCHMIERMITTELAUSTRITTS-OEFFNUNG VERWENDEN

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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 <sub>DC</sub>
VENTILSPANNUNG VALVE VOLTAGE	24 V <sub>DC</sub>
KURZSCHLUSSAUSSCHALTVERMÖGEN SHORT CIRCUIT RATING	100 kA
GESAMTSTROM NOMINAL FULL LOAD CURRENT	63 A
SICHERUNG IN DER ZULIEFERUNG MAIN SUPPLY FUSE	63 A

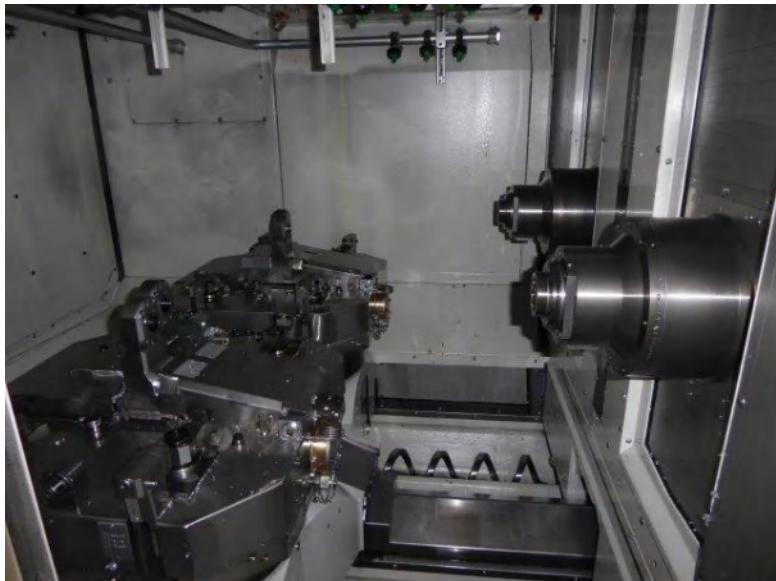
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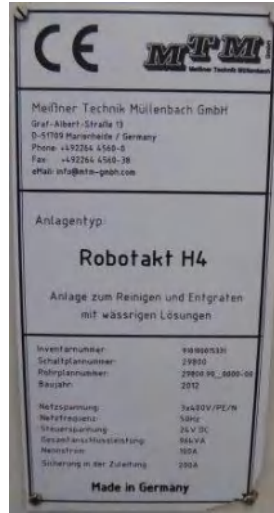
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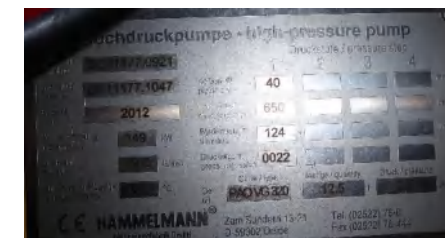


r) OP 100 MTM ROBOTAK 4 H high-pressure rotary-transfer washing unit with KUKA robot



- 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](mailto:wchen@maynards.com)

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Offers "plus 16% Buyers Premium" , ex location/foundation. Prior Sale and Errors reserved! Our actual T&Cs are valid!

**Appendix 1. 3 Liter V6 Aluminium Engine Block Line List**  
Capacity 200.000 per year

Pos.						Remarks	
	Qty	Make	Unit	EQ - Nr.	OP		YoM
1	1	Trumpf	engraving laser	910100015703-9	OP04	2012	
2	1	Bleichert	tempering	910100015703	OP05	2012	
3	1	MAG SPECHT 500 DUO	HMC	910100015515	OP10	2012	
4	1	Kuka	robot	910100015515-1	OP10	2012	
5	1	Bleichert (Provitec)	conveyor	910100015703	OP10	2012	
6	1	MAG SPECHT 500 DUO	HMC	910100015516	OP 20.1	2012	
7	1	Kuka	robot	910100015516-1	OP 20.1	2012	
8	1	Bleichert (Provitec)	conveyor	910100015703	OP 20.1	2012	
9	1	MAG SPECHT 500 DUO	HMC	910100016297	OP 20.2	2013	
10	1	Kuka	robot	910100016297-1	OP 20.2	2013	
11	1	Bleichert	conveyor	910100015703	OP 20.2	2013	
12	1	MTM	washer	910100015330	OP30	2012	
13	1	Kuka	robot	910100015640-1	OP40.1	2012	
14	1	Bleichert	conveyor	910100015703	OP40.1	2012	
15	1	Uraca Hochdruckpumpen	high-pressure pump	910100015640-3	OP40.1	2012	
16	1	Kuka	robot	910100015640-2	OP40.1	2012	
17	1	Hommel	leak test	910100015642	OP50.1	2012	
18	1	Kuka	robot	910100015642-1	OP50.1	2012	
19	1	Bleichert	conveyor	910100015641	OP52.1	2012	
20	1	BSN Thermoprozesstechnik	through feed furnace	910100015643	OP55.1	2012	
21	1	Kuka	robot	910100015644-1	OP60.1	2012	
22	1	Kuka	robot	910100015644-2	OP60.1	2012	
23	1	Kuka	robot	910100016747-1	OP40.2	2013	
24	1	Uraca Hochdruckpumpen	high-pressure pump	910100016747-3	OP40.2	2013	
25	1	Kuka	robot	910100016747-2	OP40.2	2013	
26	1	Jenoptik Industrial Metrology Germany GmbH	leak test	910100018855	OP50.2	2013	
27	1	Kuka	robot	910100018855-1	OP50.2	2013	
28	1	BSN Thermoprozesstechnik	through feed furnace	910100018856	OP55.2	2013	
29	1	Kuka	robot	910100018857-1	OP60.2	2013	
30	1	Kuka	robot	910100018857-2	OP60.2	2013	
31	1	Bleichert	tempering	910100015703	OP65	2012	
32	1	Gehring	rough-honing	910100015517	OP70.1	2011	
33	1	Gehring	rough-honing	910100015733	OP70.2	2012	
34	1	MAG SPECHT 500	HMC	910100015317	OP80	2012	
35	1	Kuka	robot	910100015317-1	OP80	2012	
36	1	Bleichert	conveyor	910100015703	OP80	2012	
37	1	MAG SPECHT 500 DUO	HMC	910100015318	OP90	2012	
38	1	Kuka	robot	910100015318-1	OP90	2012	
39	1	Bleichert	conveyor	910100015703	OP90	2012	
40	1	MTM	washer	910100015331	OP100	2012	
41	1	Siemens	final checking	910100015703	OP110	2013	
42	1	Bleichert	unloading	910100015703	OP120	2013	
43	1	PMF	testing		OP 20	2012	
44	1	PMF	testing		OP 60	2012	
45	1	PMF	testing		OP 70	2012	