

Subject to prior Sale we offer for Sale

Machining Line for Cylinder-Blocks of Cast-Iron Cylinder Blocks

formerly used for pre-machining of the 3 Liter V6 diesel engine block OM 642

YoM 2012, Capacity: 100.000 Pieces per Year in 3 Shifts on ca. 1.750 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 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 45.1 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 60.1 2x KUKA robots
- OP 60.1 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 80 MAG SPECHT 500 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



BLEICHERT 
...moving ideas

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Kabine Laserstation f. M276+OM642	
Kom.-Nr.	000201352
Zchnng.-Nr.	201352.3100
Baujahr	2012

Zu Informationen für den sicheren Gebrauch der Maschinen
siehe Betriebsanleitung.

1-11 025

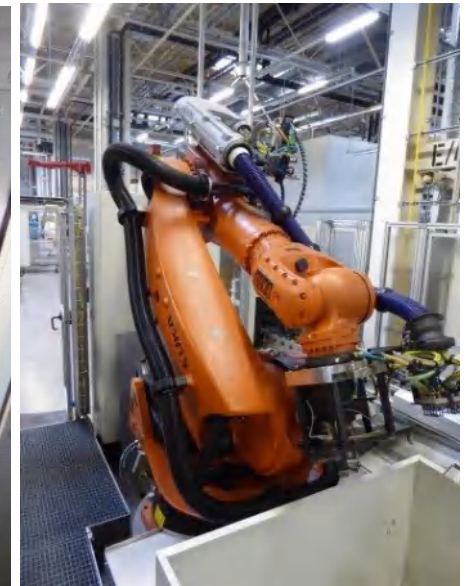
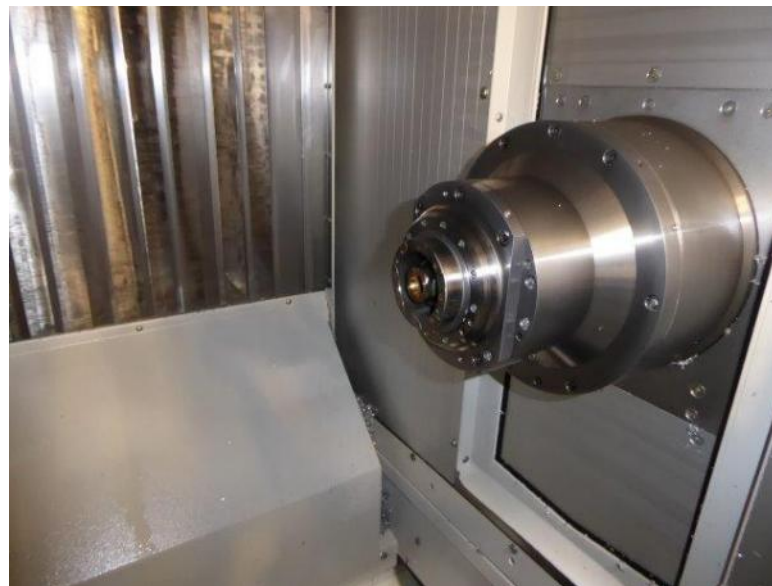
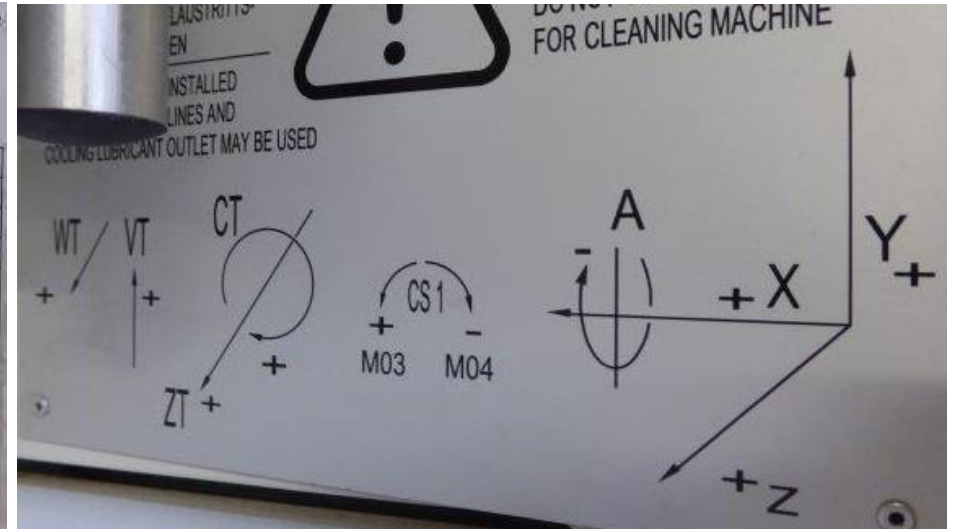
b) OP 10 MAG SPECHT 500 DUO hmc, KUKA KR 210-2-2000 robot, BLEICHERT conveyor



MAG
MAG IAS GmbH
Salzcher Straße 92 73554 Esslingen


MASCHINEN TYP TYPE OF MACHINE	Specht 500
DAIMLER EQUIPMENT-NUMMER	910100015291
MASCHINENNUMMER MACHINE NO.	X.0112.3296
AUFTRAGSNUMMER ORDER NO.	7013186
SCHALTPLAN-NR. WIRING DIAGRAM NO.	KD.1059.7972
BAUJAHR YEAR OF PRODUCTION	2012
BETRIEBSSPANNUNG OPERATION VOLTAGE	400V 3~ / 50Hz
STEUERSPANNUNG CONTROL VOLTAGE	24 V _{DC}
VENTILSPANNUNG VALVE VOLTAGE	24 V _{DC}
KURZSCHLÜßAUSCHALTERVERMÖGEN SHORT CIRCUIT RATING	10A 5A
GESAMTSTROM TOTAL CURRENT	80 A
NOMINAL FULL-LOAD CURRENT NOMINAL FULL-LOAD CURRENT	80 A
SICHERUNG IN DER ZULEITUNG MAIN SUPPLY FUSE	100 A

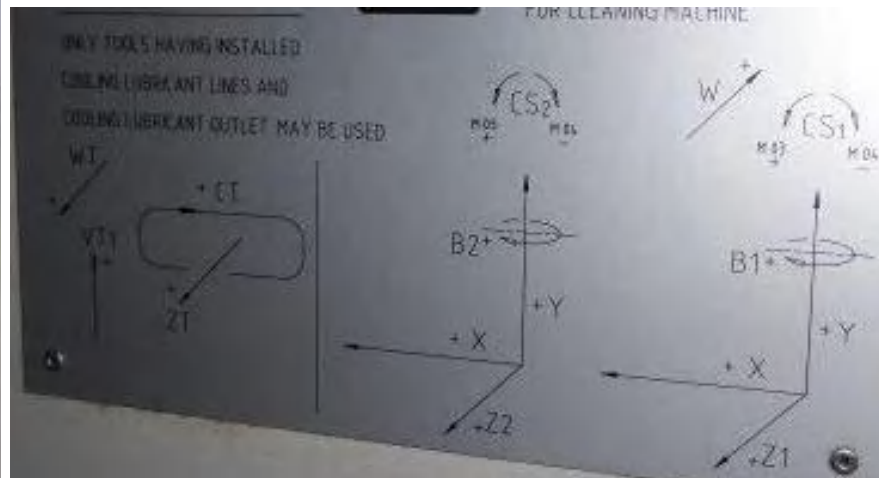
MADE IN GERMANY



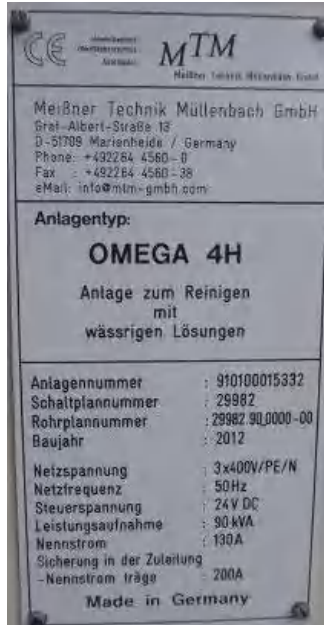
c) OP 20.1 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor



 MAG IAS GmbH <small>Saecher Straße 82 · 73254 Eisingen</small>	
MASCHINEN-TYP TYPE OF MACHINE	Specht 500 DUO
DAIMLER EQUIPMENT-NUMMER	91010015292
MASCHINENNUMMER MACHINE NO.	X:0112.3297
AUFTRAGSNUMMER ORDER NO.	7013161
SCHALTPLAN-NR. WIRING DIAGRAM NO.	XD.1059.8573
BAUJAHR YEAR OF PRODUCTION	2012
BETRIEBSSPANNUNG OPERATION VOLTAGE	400V 3~ / 50 Hz
STEUERSPANNUNG CONTROL VOLTAGE	V-
VENTILSPANNUNG VALVE VOLTAGE	24 V-
KURZSCHLUSSEINWIRKUNGSVERMOEGEN (SHORT-CIRCUIT RATING)	100 kA
GESAMTNEHMSTROM NOMINAL FULL-LOAD CURRENT	75 A
SICHERHEIT IN DER ZULEITUNG MAIN SUPPLY FUSE	100 A
MADE IN GERMANY	



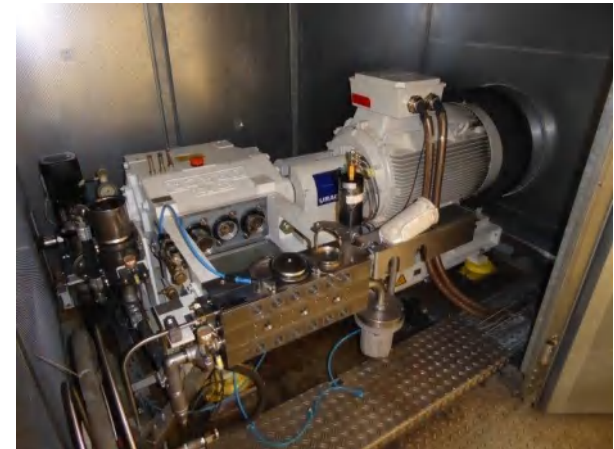
d) OP 30 MTM OMEGA 4-H, 4-chamber rotary transfer washing unit



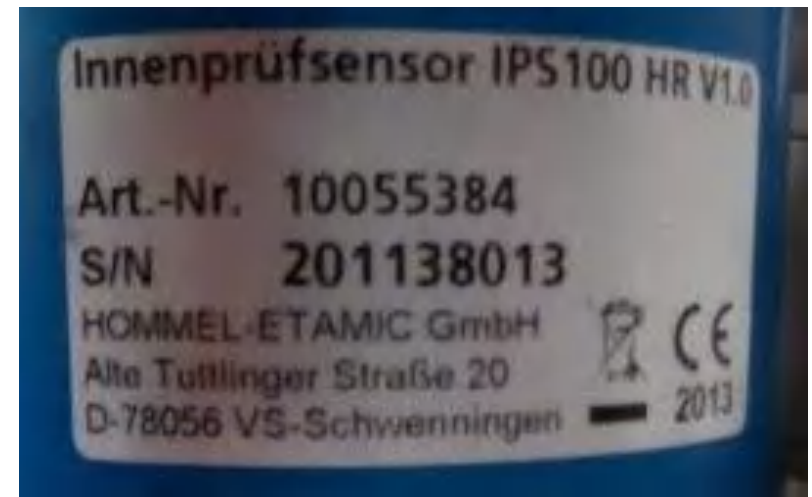
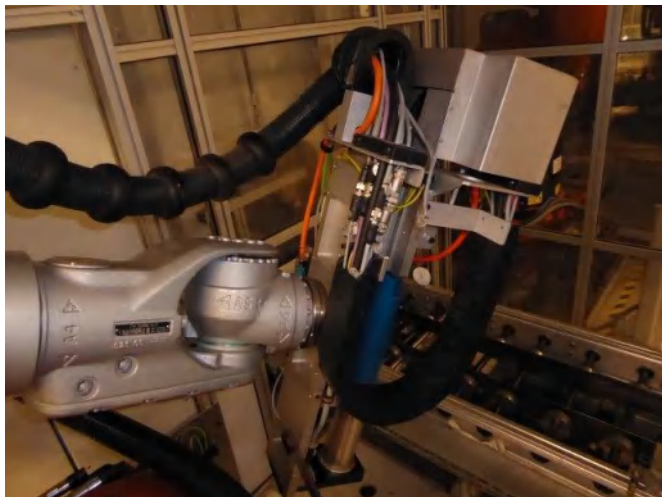
e) OP 40.1 cylinder bore coating unit -NOT PART OF LINE- (patented)

f) handling of OP 40.1

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



- g) OP 45.1 cleaning stations -NOT PART OF LINE- (patented)
- h) OP 50.1 HOMMEL pore-checking, KUKA KR 30-3 F robot



i) OP 52.1 BLEICHERT conveyor

OP 55.1 BSN through feed furnace

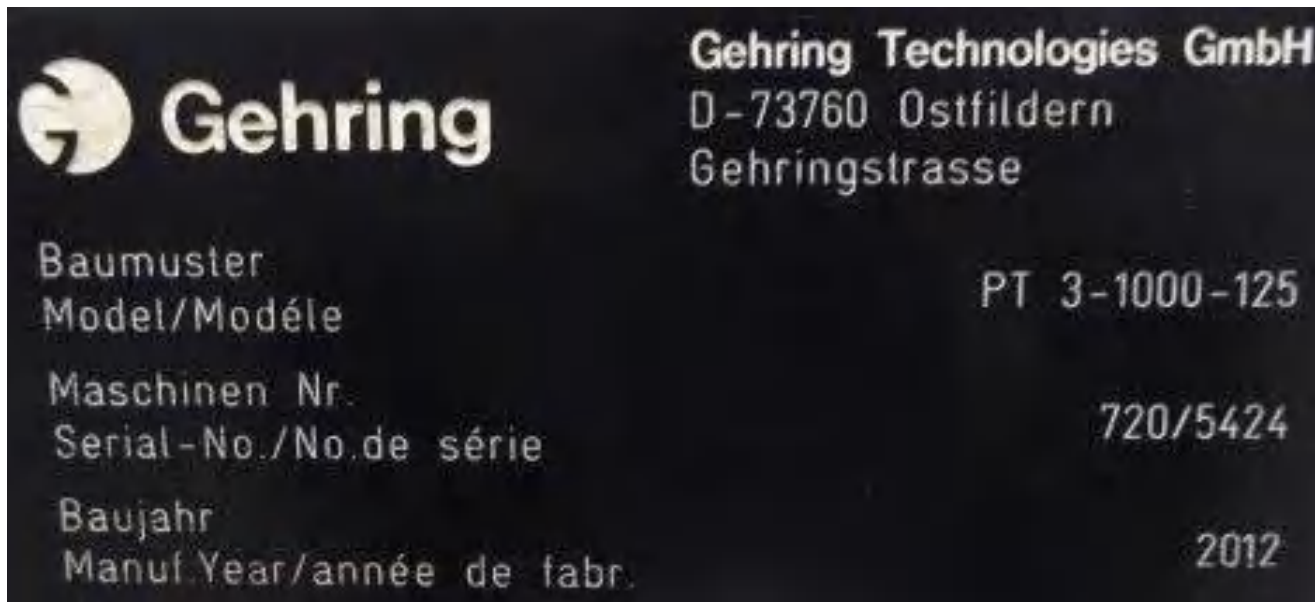


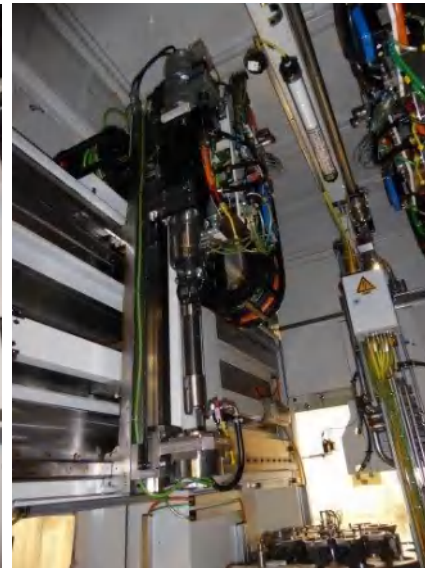
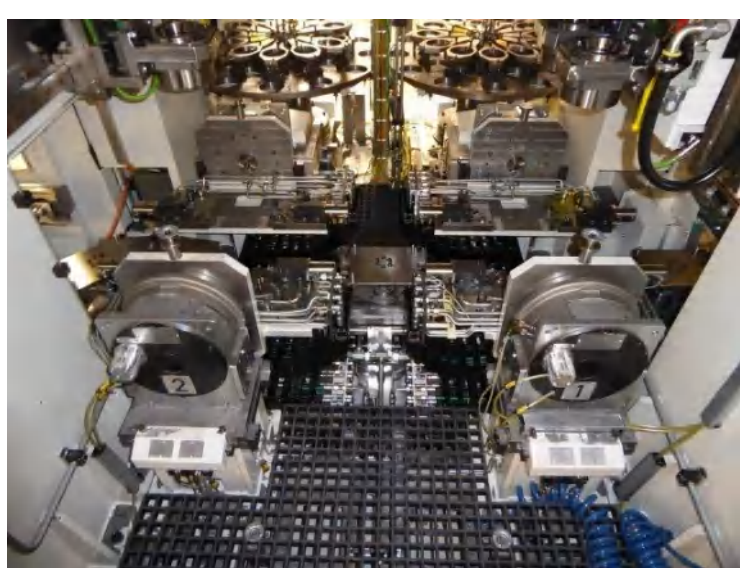
j) OP 60.1 cylinder bore coating unit -NOT PART OF LINE- (patented)

k) OP 60.1 2x KUKA KR 360-2 F robots



- l) OP 65 BLEICHERT tempering unit (for honing process)
- m) OP 70.1 GEHRING PT 3-1000-125 cylinder-bore honing machines





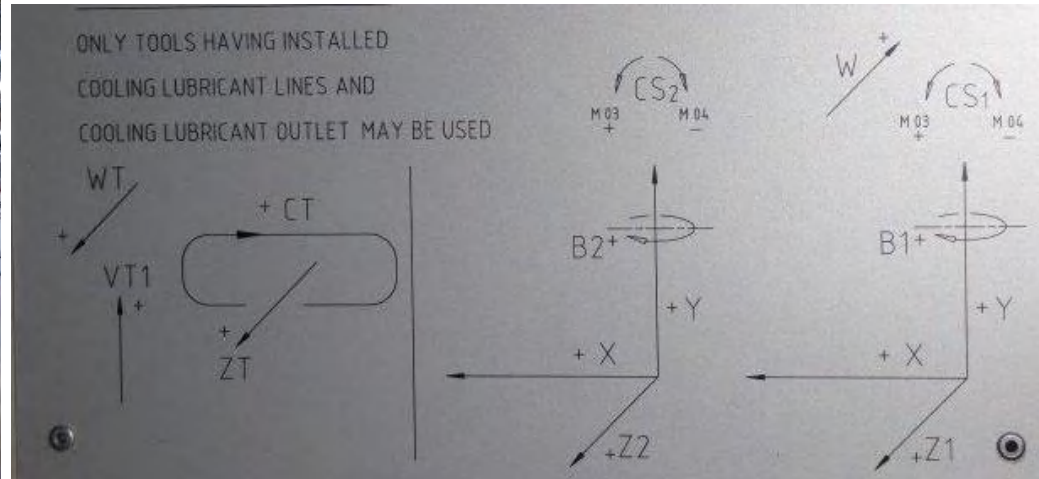
GEHRING measuring station




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 3
 tool changer, 2 pieces 2 x 12 positions
 spindle speeds 100 – 2.000 rpm
 weight, ca. 28 tons

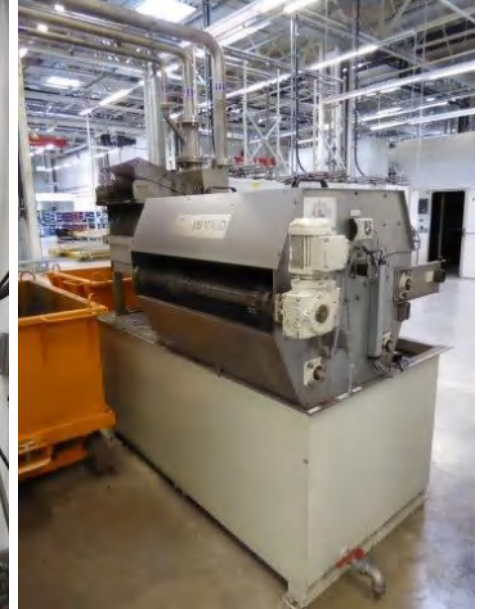
n) OP 80 MAG SPECHT 500 hmc, KUKA KR 210-2 2000 robot, BLEICHERT conveyor



 MAG IAS GmbH <small>Salscher Straße 93 73554 Ellingen</small>	
MASCHINEN-TYP	Specht 500 DUO
TYPE OF MACHINE	
DAIMLER EQUIPMENT-NUMBER	910100015293
MASCHINENNUMMER	X.0112.3298
MACHINE NO.	
AUFTRAGSNUMMER	7013182
ORDER NO.	
SCHALT PLAN-NR.	XD.1059.0573
WIRING DIAGRAM NO.	
BUILDJAHR	2012
YEAR OF PRODUCTION	
BETRIEBSSPANNUNG	400V 3~ / 50 Hz
OPERATION VOLTAGE	
STEUERSPANNUNG	24 V _{DC}
CONTROL VOLTAGE	
VENTILSPANNUNG	24 V _{DC}
VALVE VOLTAGE	
KURZSCHLUSSAUSSCHALTVERMÖGEN	100 kA
SHORT CIRCUIT RATING	
GESAMTSTROM	70 A
NOMINAL FULL-LOAD CURRENT	
SICHERUNG IN DER ZULEITUNG	max. 100 A
MAIN SUPPLY FUSE	
<small>MADE IN GERMANY</small>	



o) 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: Splash washing with 5 bar + rotation and 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



p) OP 110 and OP 120 BLEICHERT end of line + unloading



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