

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
Zchng.-Nr.	201352.3100
Baujahr	2012

Zu Informationen für den sicheren Gebrauch der Maschinen  
siehe Betriebsanleitung.

1-11 025

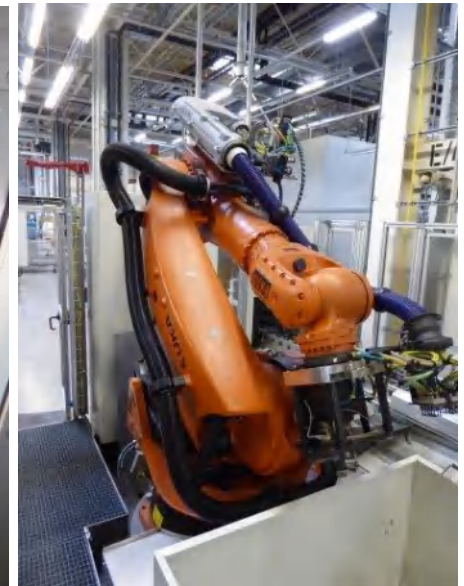
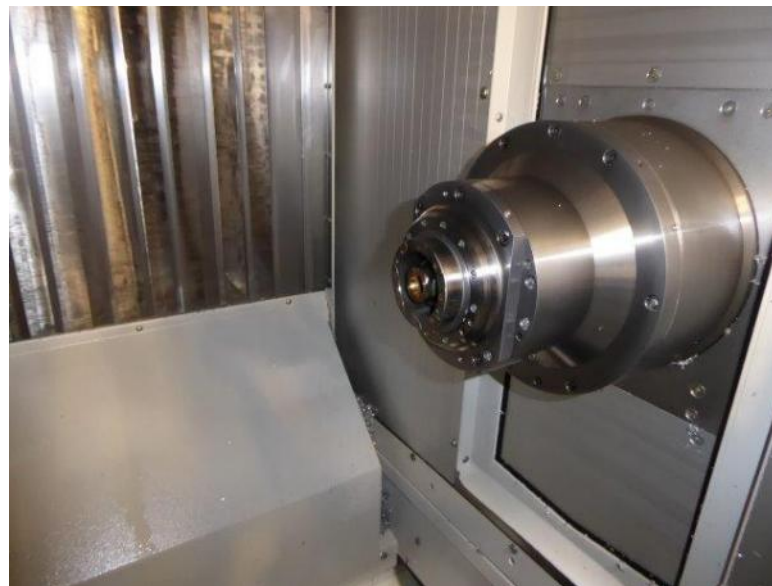
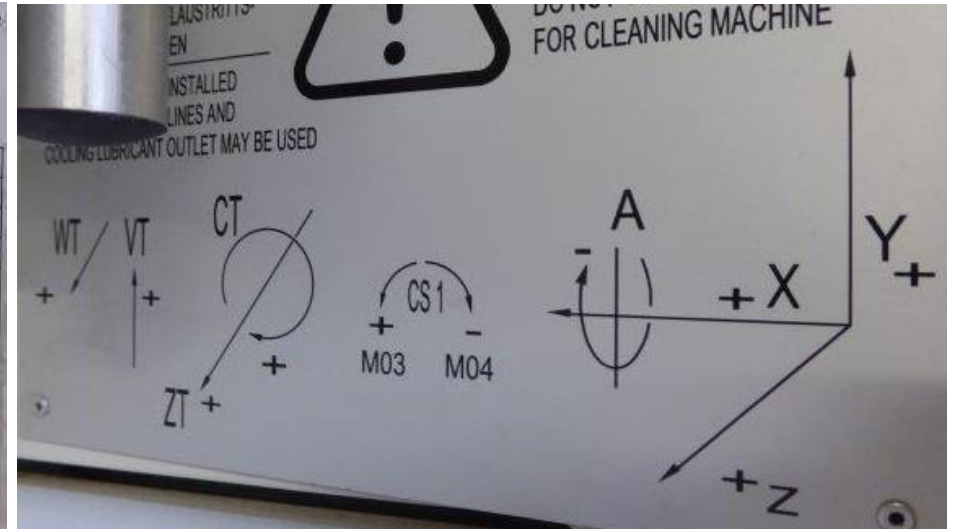
b) OP 10 MAG SPECHT 500 DUO hmc, KUKA KR 210-2-2000 robot, BLEICHERT conveyor



**MAG**  
MAG IAS GmbH  
Salzhofer Straße 92 73054 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 <sub>DC</sub>
VENTILSPANNUNG VALVE VOLTAGE	24 V <sub>DC</sub>
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

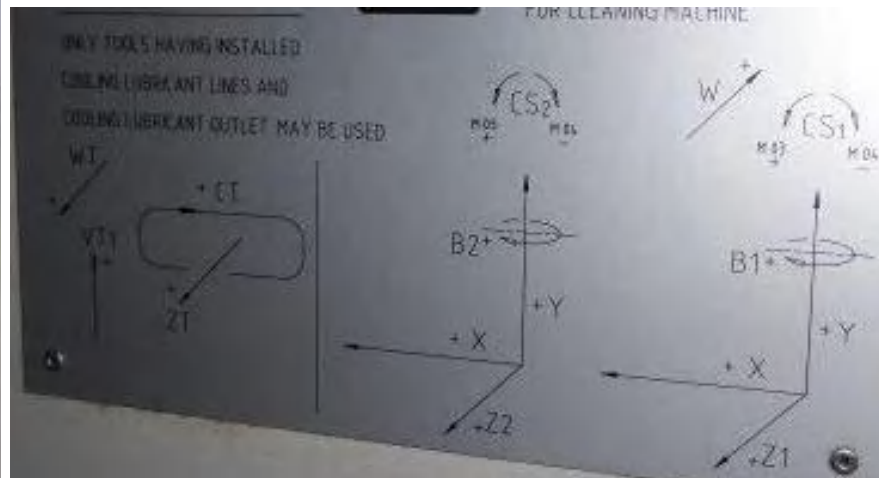
MADE IN GERMANY



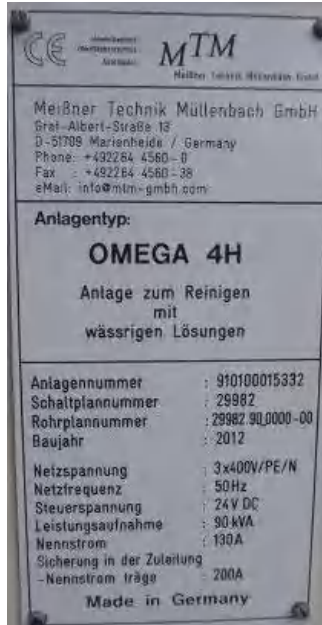
c) OP 20.1 MAG SPECHT 500 DUO hmc, KUKA robot, BLEICHERT conveyor



 <b>MAG IAS GmbH</b> <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
GESAMTNENNSTROM NOMINAL FULL-LOAD CURRENT	75 A
SICHERHEIT IN DER ZULEITUNG MAIN SUPPLY FUSE	100 A
MADE IN GERMANY	



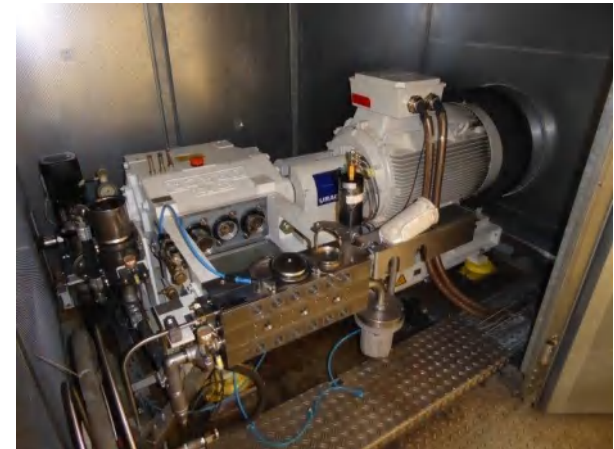
d) OP 30 MTM OMEGA 4-H, 4-chamber rotary transfer washing unit



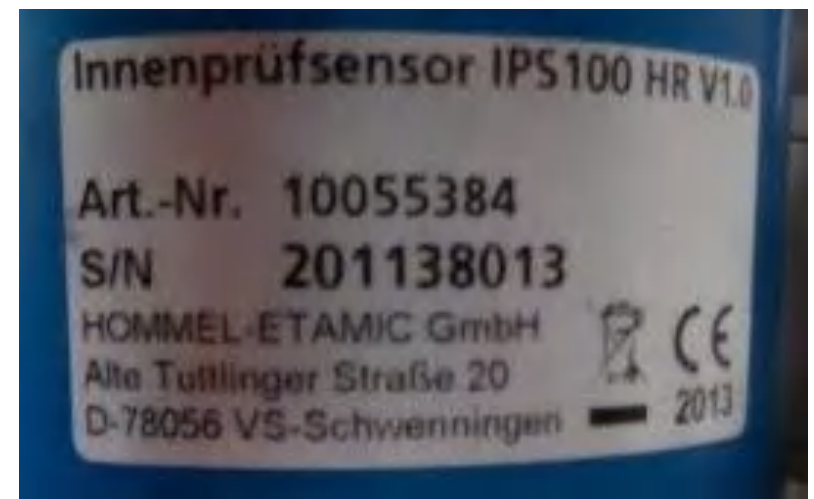
e) OP 40.1 cylinder bore coating unit -NOT PART OF LINE- (patented)

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

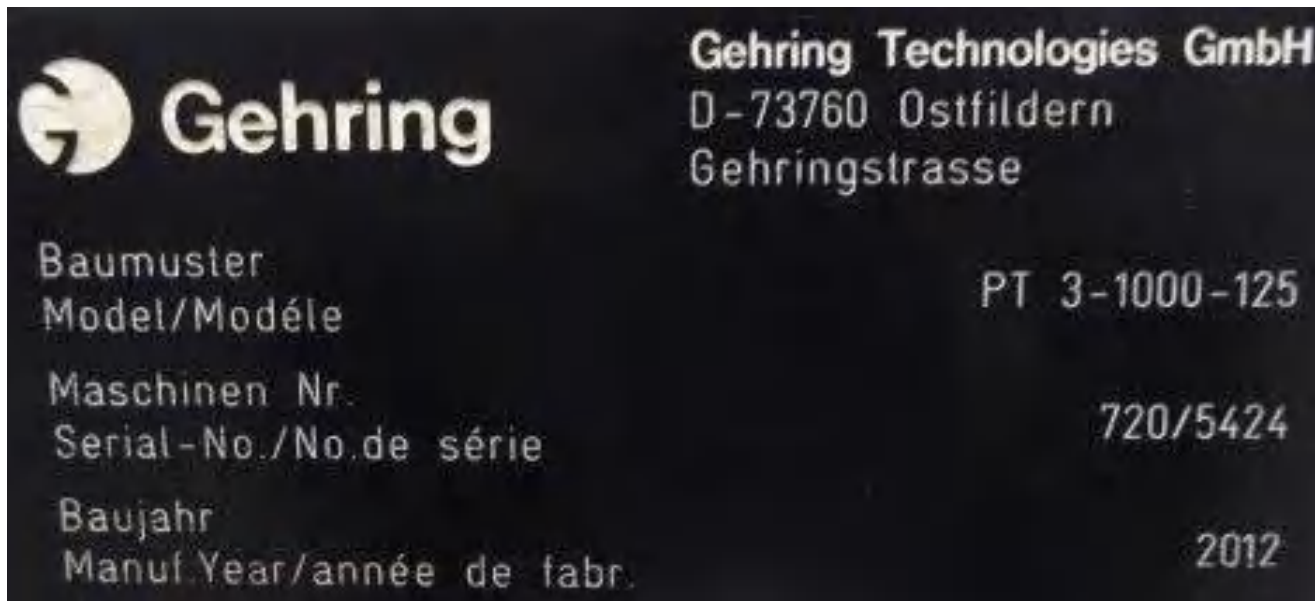


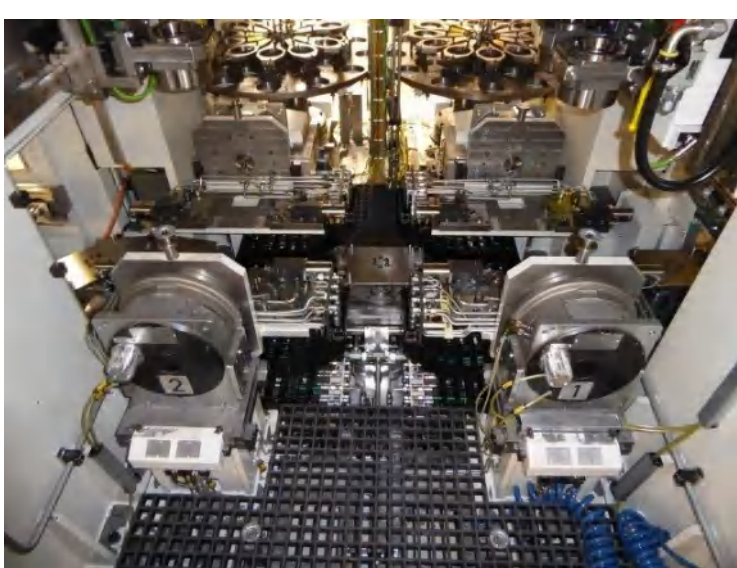
j) OP 60.1 cylinder bore coating unit -NOT PART OF LINE- (patented)

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





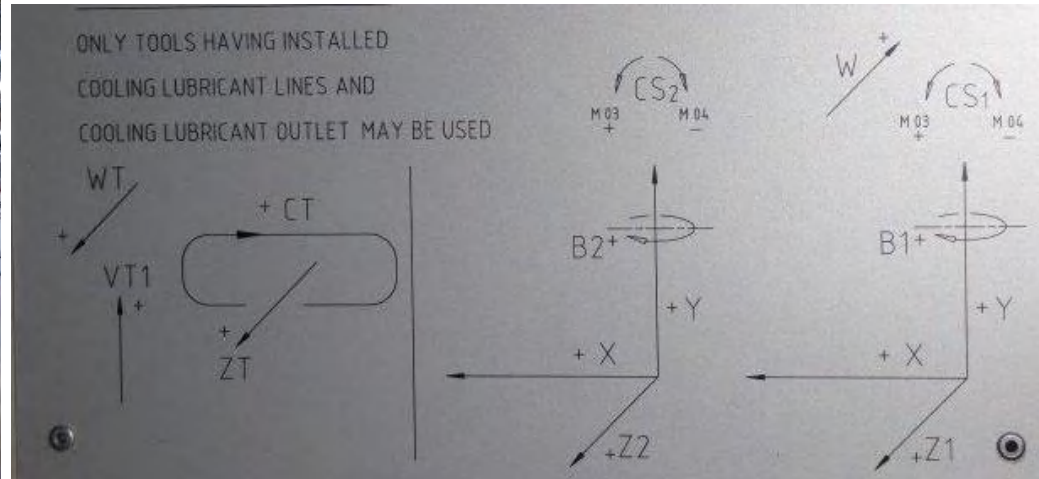
GEHRING measuring station




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

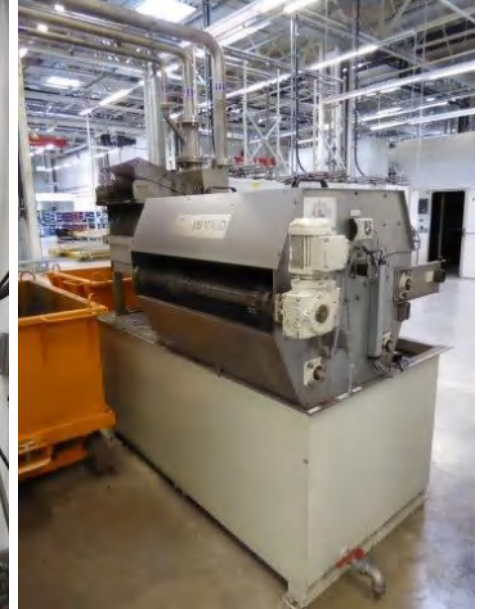
n) OP 80      MAG SPECHT 500 hmc, KUKA KR 210-2 2000 robot, BLEICHERT conveyor



 <b>MAG IAS GmbH</b> <small>Salscher Straße 93 73554 Ellingen</small>	
MASCHINEN-TYP TYPE OF MACHINE	Specht 500 DUO
DAIMLER EQUIPMENT-NUMBER	910100015293
MASCHINENNUMMER MACHINE NO.	X.0112.3298
AUFTRAGSNUMMER ORDER NO.	7013182
SCHALTPLAN-NR. WIRING DIAGRAM NO.	XD.1059.0573
BUILDJAHR YEAR OF PRODUCTION	2012
BETRIEBSSPANNUNG 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
GESAMTSTROM NOMINAL FULL-LOAD CURRENT	70 A
SICHERUNG IN DER ZULEITUNG MAIN SUPPLY FUSE	max. 100 A
<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!

**Appendix 1. 3 Liter V6 Cast Iron Engine Block Line List**  
Capacity: 100.000 pieces per year

Pos.	Maschine / Anlage						Remarks
	Qty	Make	Machine/Unit	EQ - Nr.	OP	YoM	
1	1	Trumpf	engraving laser	910100015844-14	OP04	2013	
2	1	Bleichert	tempering	910100015844-15	OP05	2013	
3	1	MAG SPECHT 500 DUO	HMC	910100015291	OP10	2012	
4	1	Kuka	robot	910100015291-1	OP10	2012	
5	1	Bleichert (Provitec)	conveyor	910100015844	OP10	2013	
6	1	MAG SPECHT 500 DUO	HMC	910100015292	OP 20.1	2012	without fire distinguisher
7	1	Kuka	robot	910100015292-1	OP 20.1	2013	
8	1	Bleichert (Provitec)	conveyor	910100015844	OP 20.1		
9	1	MTM	washer	910100015332	OP30		
10	1	Kuka	robot	910100015646-1	OP40.1	2012	
11	1	Uraca Hochdruckpumpen	high-pressure pump	910100015646-3	OP40.1	2012	
12	1	Kuka	robot	910100015646-2	OP40.1	2012	
13	1	Hommel	leak test	910100015648	OP50.1	2012	
14	1	Kuka	robot	910100015648-1	OP50.1	2012	
15	1	Bleichert	conveyor	910100015668	OP52.1	2012	
16	1	BSN Thermoprozesstechnik	through-feed furnace	910100015649	OP55.1	2011	
17	1	Kuka	robot	910100015650-1	OP60.1	2012	
18	1	Kuka	robot	910100015650-2	OP60.1	2012	
19	1	Bleichert	tempering	15844-8	OP65	2013	
20	1	Gehring	rough-honing machine	910100015282	OP70.1	2012	
21	1	MAG SPECHT 500	HMC	910100015293	OP80	2012	
22	1	Kuka	robot	910100015293-1	OP80	2012	
23	1	Bleichert	conveyor	910100015844	OP80	2012	
24	1	MTM	washer	910100015333	OP100		
25	1	Bleichert	final test	910100015844-12	OP110	2013	
26	1	Bleichert	unloading	910100015844-13	OP120		
27	1	PMF	testing		OP 20	2013	
28	1	PMF	testing		OP 60	2013	
29	1	PMF	testing		OP 70	2013	