

Subject to prior Sale we offer by Order of OPEL:

Machining Line for Blocks of 4-Cylinder Engines
with HELLER, HUELLER-HILLE, GEHRING, FROEHLICH
and a large range of other Machinery and Equipment, new 1992 - 2006

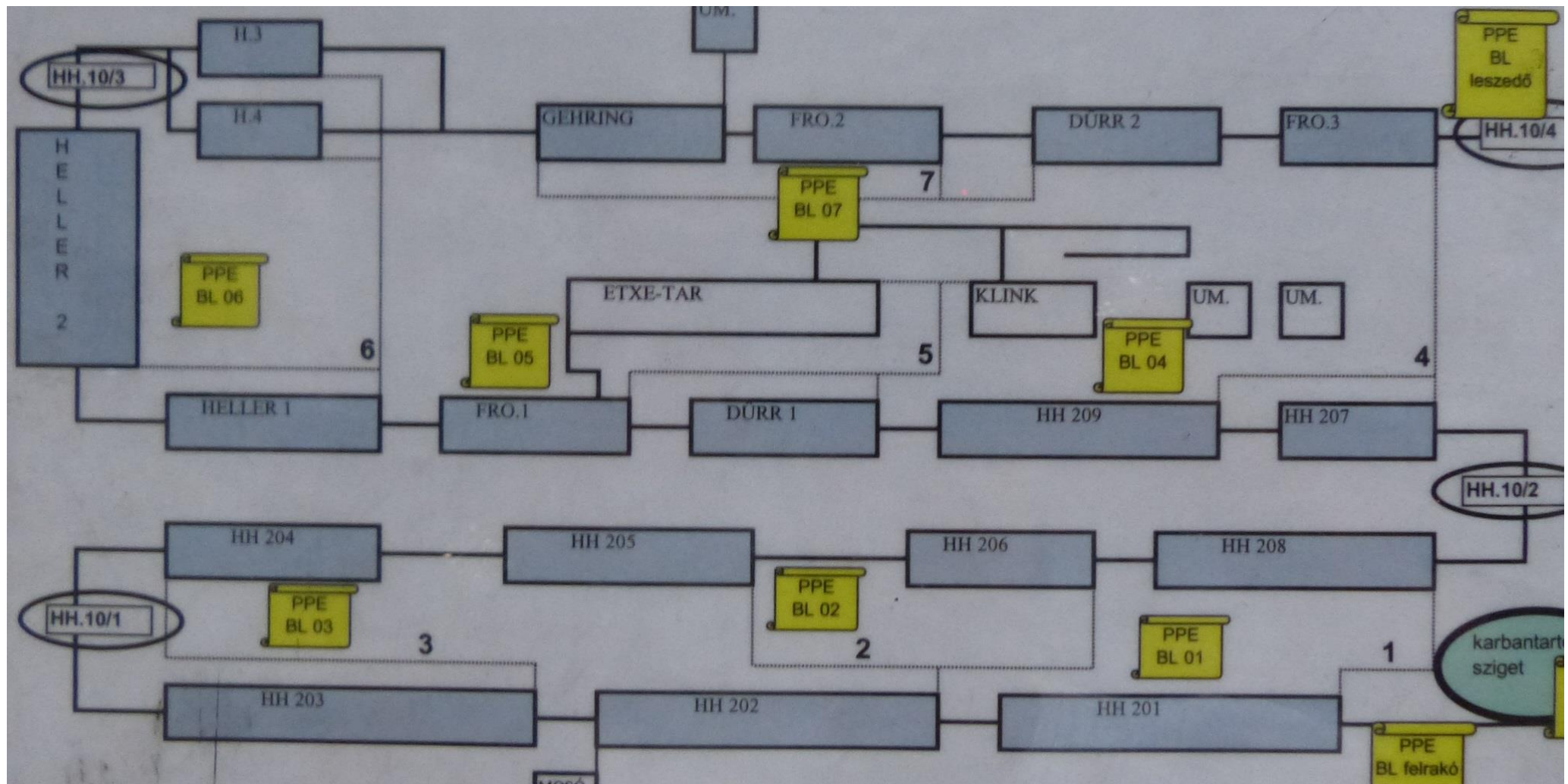


The following Machinery and Equipment is Part of the Engine Block Machining Line:

OP	Machine	Unit	Make	Model	YoM	Operation
10	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
20	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
30	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
40	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
50	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
60	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
70	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
75	Transfer machine	Machining	Heller	FST 61354	2004	Milling, Drilling, Boring, Tapping, etc.
80	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
90	Transfer machine	Machining	Hüller Hille		1991	Milling, Drilling, Boring, Tapping, etc.
100	Washing machine	Machining	Dürr	Ecoclean 31	1996	Washing of the blocks
105	Test machine	Measuring	Bayer	DLP 30 T	2006	Leaktest. Low oil pressure.
110	Assembly machine	Screw	Fröhlich	38872	1992	Assembly of the bearing caps
120	Transfer machine	Machining	Heller	FST 38254	2001	Transfer machine
130	Transfer machine	Machining	Heller		2001	Transfer machine
140	Transfer machine	Machining	Heller		1991	Heller 3
140	Transfer machine	Machining	Heller		1996	Heller 4
150	Transfer machine	Machining	Gehring		1992	Honing machine
151	Exhaust System	Exhaust	Keller	OENA 2/6 R V	2000	CBL Honing, Unit 1.1 inside 2.000 m ³ /h; 2.2 kW
152	Exhaust System	Exhaust	Donaldson	DMC-D4	2004	CBL Honing, Unit 1.1 inside filter 15.000 m ³ /h

153	Exhaust System	Exhaust	Krantz/CBI/Leroy	Ch B 30 III / LS 250MP	1992	CBL Honing, Unit 3 outside ventilator 27.500 m3/h; 55kW
154	Exhaust System	Exhaust	Krantz/CBI/Leroy	Ch B 30 III / LS 250MP	1992	CBL Honing, Unit 4 outside ventilator 23.500 m3/h; 55kW
155	Transfer machine	Machining	Gehring		2005	Honing Machine with Laser Unit
156	Central cooling system	Filtration	KÖBO/SACK	Dom Filter	1992	Petroleum Filtration System CBL Honing 3100 l/min
156	Exhaust System	Exhaust	Weger	AL 99	2001	CBL Honing, Unit 1.1 outside; 4500 m3/h
157	Exhaust System	Exhaust	Donaldson	DMC-D4	2004	CBL Honing, Unit 1 inside filter 15000 m3/h
158	Exhaust System	Exhaust	Krantz/CBI/Leroy	Ch B 18 1/4 III / LS 160L	1992	CBL Honing, Anlage 1 outside ventilator 6.800 m3/h; 18,5kW
159	Exhaust System	Exhaust	Krantz/CBI/Leroy	Ch B 33 III / LS 280MP	1992	CBL Honing, Anlage 5 outside ventilator 34.500 m3/h; 90kW
160	Measuring machine	Measuring	Fröhlich	38870	1991	Cylinder- and crankshaft bore 100%
170	Washing machine	Machining	Dürr	Ecoclean 32	2001	Washing of the blocks
180	Transfer machine	Machining	Fröhlich	38871	1992	Pressing caps, crewing and leak-test
200	Coordinate measuring device	Measuring	Sirio Leitz	688/146	1992	Measuring Equipment
200	Coordinate measuring device	Measuring	Sirio Leitz	688/144	1992	Measuring Equipment
301	Central Cooling System	Filtration	KÖBO/SACK	Vacuumfilter	1992	A1 emulsion filtration system for CBL (cast iron material), 36.000 l/min
304	Exhaust System	Exhaust	Krantz/Torit	3DF36C	1992	CBL, Unit 2 inside filter
305	Exhaust System	Exhaust	Krantz/CBI/Leroy	Ch B 30 III / LS 250MP	1992	CBL, Unit 2 outside ventilator 25.600 m3/h; 55 kW
306	Exhaust System	Exhaust	Aircon/Torit/ABB	LG0 / DF+8 / MKAA 132 SB	2001	CBL, Anlage 2.1 inside ventilator 6.000 m3/h; 9,2 kW

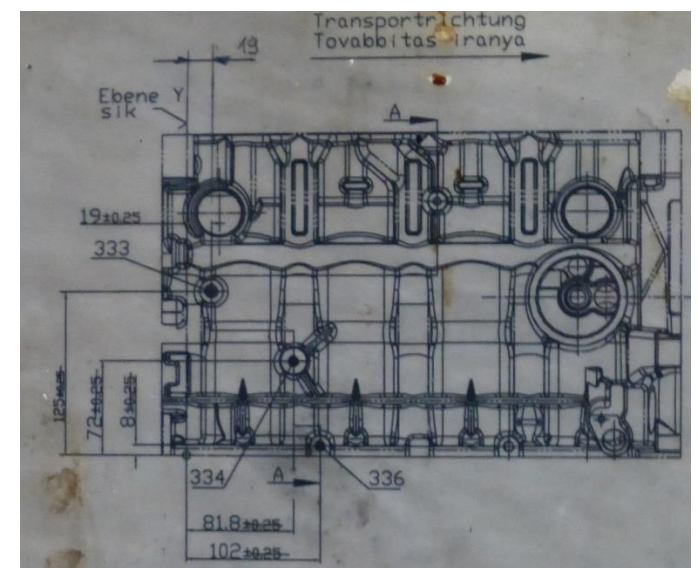
Engine Block Machining Line Layout

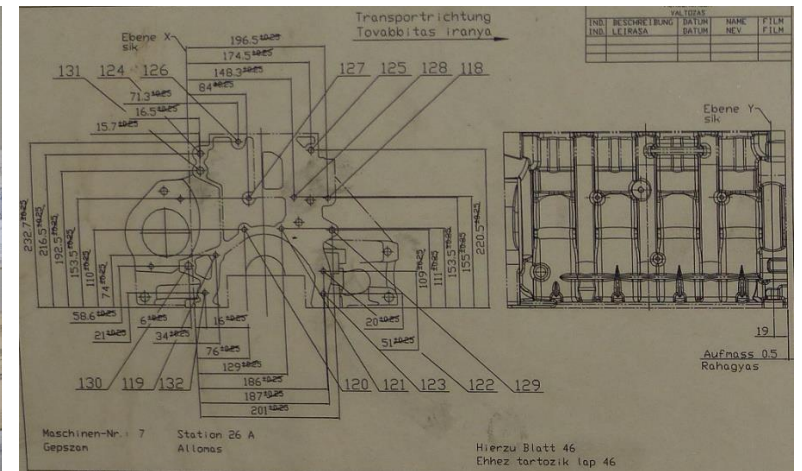


1) OP 10 + 20 – Loading of Raw Parts and HUELLER-HILLE Transfer-Machining Line

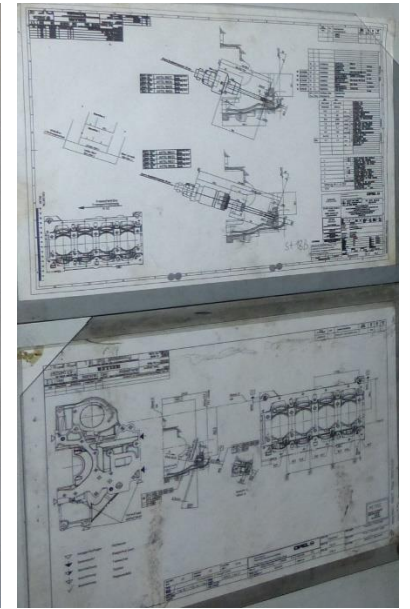


2) OP 30 – 70: HUELLER-HILLE Transfer Lines

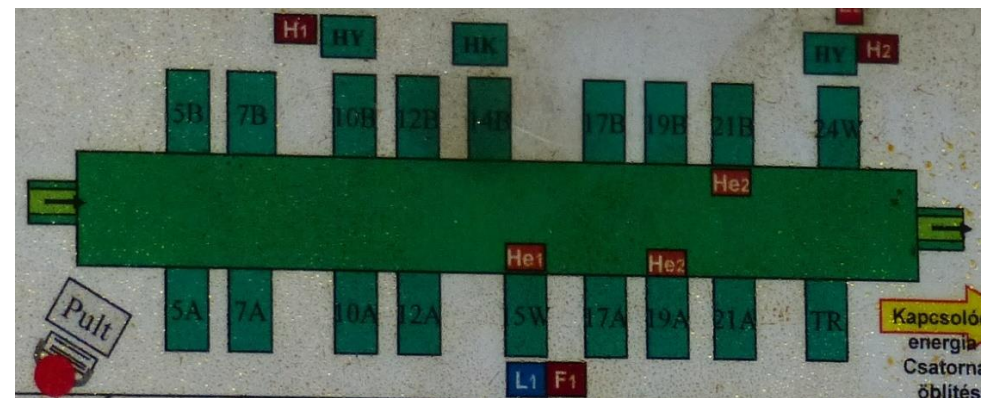
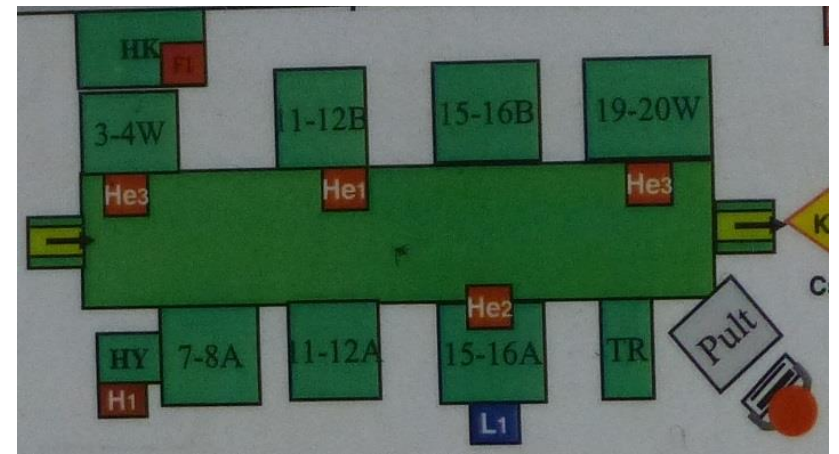




3) OP 75 – HELLER Transfer Machining Line



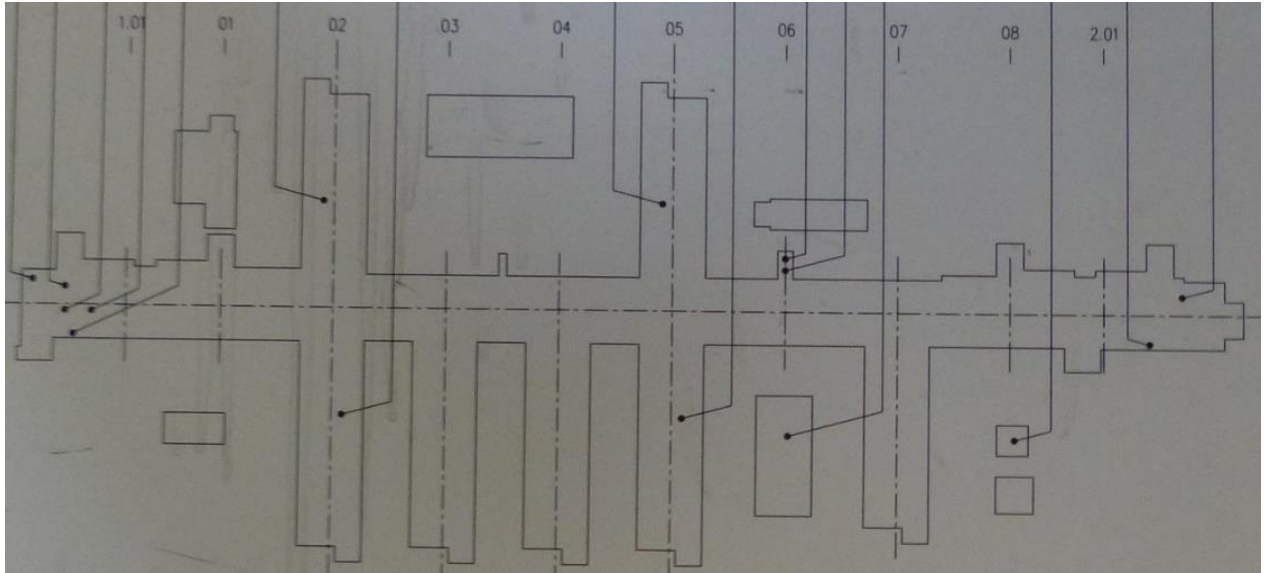
4) OP 80 + 90 – HUELLER-HILLE Transfer Lines



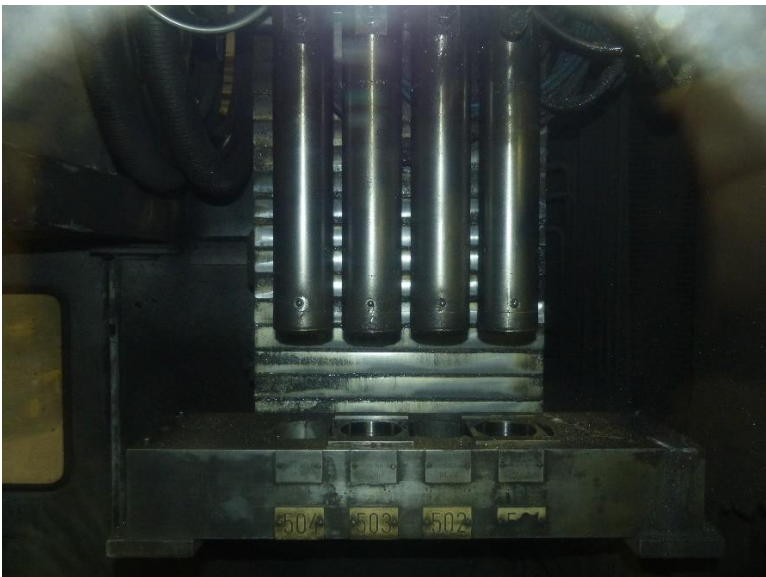
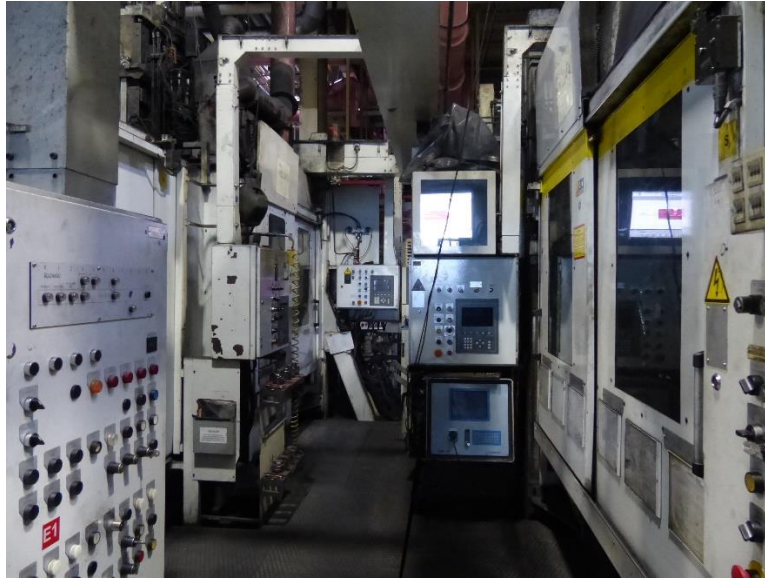
5) OP 100 – 105 – 110: DUERR Washer / BAYER Leak Test / FROEHLICH Screwing Unit



6) OP 120 + 130 – HELLER Transfer Line, new 2004



7) OP 140 + 150 – HELLER vertical cylinder boring machines, new 1991 + 1996



OP 150 – GEHRING Honing Machines



OP 155 – GEHRING Honing and Laser Oil-Pocket-Scratching Machines



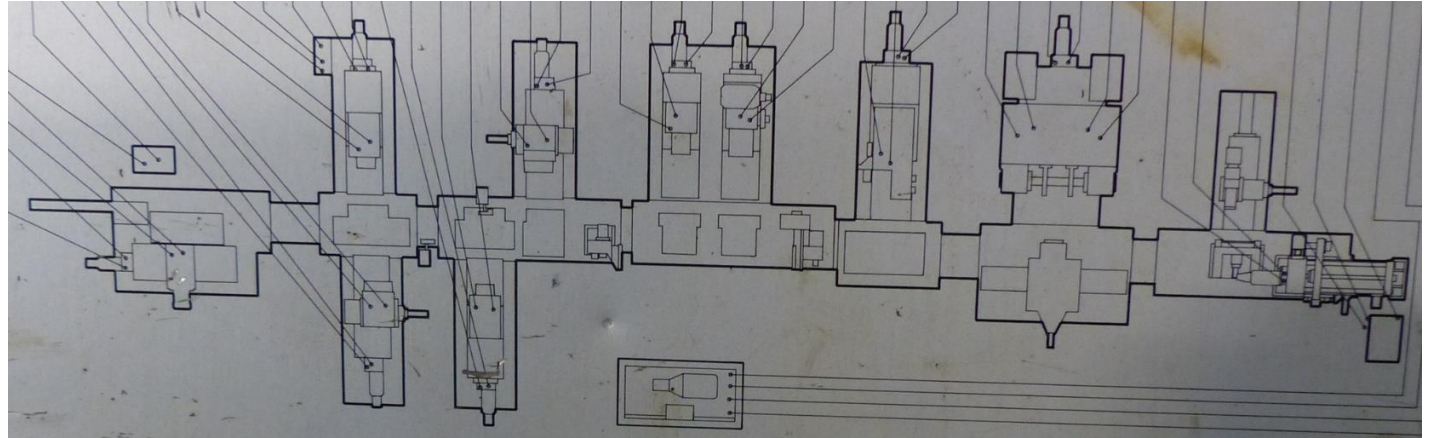
OP 160 – FROEHLICH Measuring Line



GEHRING Z-350-125 (1992) – Manual Vertical Honing Machine



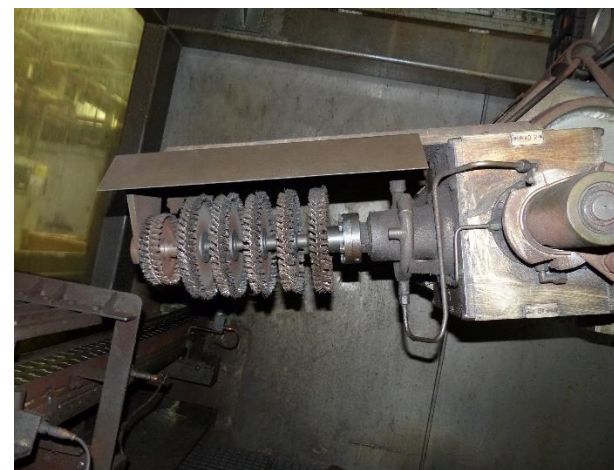
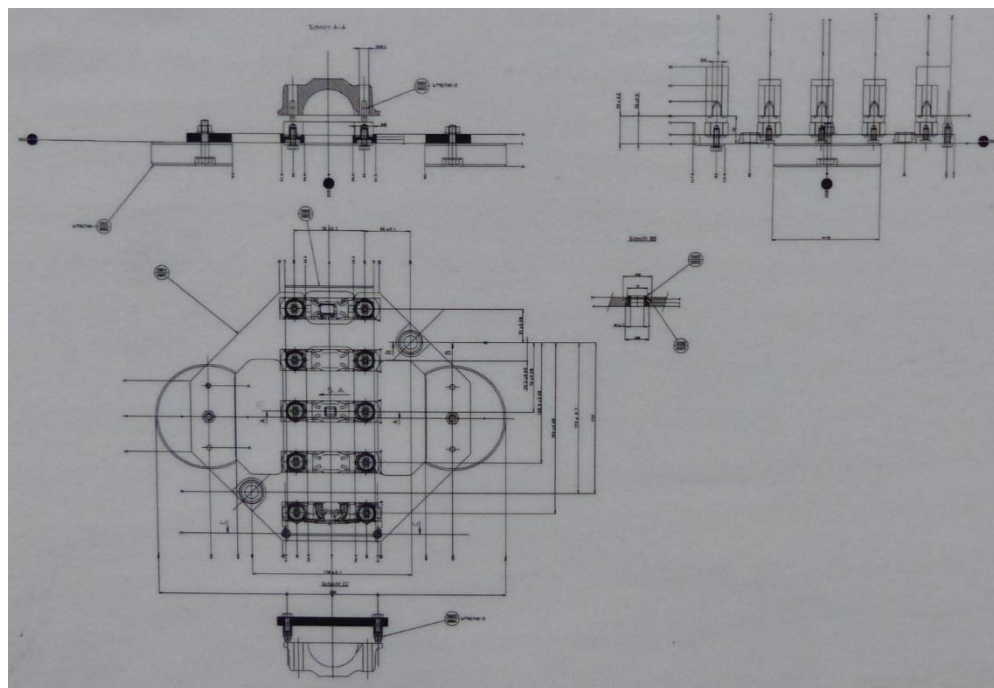
ETXE-TAR Oil-Hole Drilling Transfer Line for Crankshaft-Bearing-Caps



KLINK RASA 25-2500-650 External-Vertical Broaching Machine for Crankshaft Bearing Caps



DUERR Deburring / Brushing Machine (2007) for Crankshaft Bearing-Caps

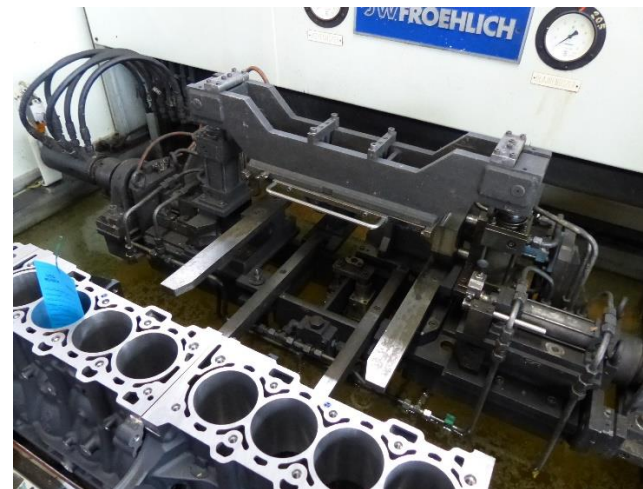


FROEHLICH Final testing and Pre-Assembly Stations





FROEHLICH Manual Leak-Test-Stand



Contact: andreas@maynards.com

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