

On behalf of GM Vauxhall / UK and OPEL Germany and Spain we offer for Sale by Tender



USI-VICKERS 500 to Blanking Press Line with moving bolster, de-coiler, straightener, feeder and shear

New 1980, Max capacity 500 to, Table / Ram dimensions 2.740 x 2.440 mm, Max stroke 305mm, Stroke adjustment 508mm, No of strokes 14 – 30 1/Min, Max shutheight 1.220mm, Height of bolster over floor 1.220 mm, Blank width 610 – 1.828 mm, Blank thickness 0,6 – 2,3 mm, Blank feed 75 – 4.000 mm

ExWorks Ellesmere Port, UK

For Sale ex location GM OPEL Zaragoza, Spain:



FAGOR ARRASATE Press Line (4 Presses, Line 5 / new 1981)

Press 1: 600tons single action mechanical press, bed 2.000 x 1.400 mm, slide stroke 600 mm, stroke adjustment 400mm, max shut height 800 mm, max 20 strokes/Min, bed cushion stroke 0 – 200 mm / 125tons, LxWxH 8 x 6 x 9 m, weight 220to

Press 2 – 4: 600tons single action mechanical press, bed 2.000 x 1.400 mm, slide stroke 600 mm, stroke adjustment 400 mm, max shut height 800 mm, max 20 strokes/Min, LxWxH 8 x 6 x 9 m, weight 220to

SCHULER + FAGOR ARRASATE Press Line (6 Presses, Line 4 / new 1981)

Press 1: SCHULER DBS 2-1.000-2,2-850 double action mechanical press, 600 + 400 to, bed 2.000 x 1.400 mm, slide stroke 850mm, blank holder stroke 800 mm, stroke and blankholder adjustment 200 mm, 10 – 230 strokes/Min, bed cushion 200mm/125to, main drive 122 kW, LxWxH 6 x 4,5 x 9 m, weight 155 to

Press 2 – 5: 600tons single action mechanical press, bed 2.000 x 1.400 mm, slide stroke 600 mm, stroke adjustment 400 mm, max shut height 800 mm, max 20 strokes/Min, LxWxH 8 x 6 x 9 m, weight 220to

FAGOR ARRASATE Press Line (5 Presses, Line 6 / new 1981)

Press 1 – 5: 600tons single action mechanical press, bed 2.000 x 1.400 mm, slide stroke 600 mm, stroke adjustment 400mm, max shut height 800 mm, max 20 strokes/Min, bed cushion stroke 0 – 200 mm / 125tons, LxWxH 8 x 6 x 9 m, weight 220to

All three a.m. Press Lines have moving bolsters, robot feeding + unloading, as well as part-handling between Presses

For Sale ex location GM OPEL Kaiserslautern, Germany:



800 to KOMATSU E 3 S 800 – 13 – 35 C

Transfer Press + Coil Line

new 1979, ram/station I 600 x 1.000 mm / ram station II – XIII 2.100 x 1.000 mm, ram stroke 400 mm, stroke adj. 50 mm, cushion stroke station I 140 mm / station II – XIII 150 mm, max die height 850 mm, stroke rate 3 – 12 pM variable / 24 pM fixed, distance between stations 350 mm, dimensions LxWxH 10x7x8 m, weight ca. 200 tons. Coil Line: de-coiler, max load 8 to, coil dia 1.450 x 700 mm / 0,5 – 3 mm / straightener with feeding and band adjustment unit / hydr. table / hydr. roll feeder, 50 – 400 mm, space required LxWxH 9x6x2 m, weight ca. 13 tons

For Sale ex location GM OPEL Ruesselsheim, Germany:



MÜLLER WEINGARTEN VU 600.29.60

Under-Floor Mechanical Press

New 1961, 600to, bed 2.800 x 1.800 mm, stroke 600mm, stroke adj. 500mm, 14–18 strokes/Min, max height 1.100 mm, Cushion; bed 110to/200mm / ram 70to/150mm



MÜLLER WEINGARTEN XXDVU Under-Floor Mechanical Press

New 1953, 500to, bed 2.800 x 1.800 mm, stroke 550m, stroke adj. 500mm, 14–18 strokes/Min, max height 1.100 mm, Cushion bed 110to/200mm / ram 70to/150mm

General Information:

- Inspections by appointment only! PRIOR SALE RESERVED !
- All Equipment becomes offered "AS IS, WHERE IS" !
- Although Information has been given from sources deemed reliable, MAYNARDS make no warranty or guarantee, expressed or implied, as to the accuracy of the information contained herein.
- All offers are subject to approval by the Seller and acceptance of Sellers OFFER TO PURCHASE.
- This Sale is based on the Terms & Conditions of GM OPEL and MAYNARDS

For Sale ex location GM OPEL Bochum, Germany:



Line Overview



WEINGARTEN



SCHULER



WEINGARTEN ZS 1.600.32, new 1976

bed 2.800x1.700mm, blank holder 3.050x1.850mm, slide 2.000x1.100mm, stroke of slide 950 mm, stroke adjustment 500 mm, no of strokes 10 – 16 /Min, max shut height 1.500 mm, draw cushion in bed, space required LxWxH: 6.600 x 6.200 x 8.700 mm, weight, ca. 275.000 kg

SCHULER P 2 E 2 Sq 500 / 2,9 / 0,65, new 1962

Bed + Slide 2.900 x 1.400 mm, stroke 650 mm, stroke adjustment 500 mm, no of strokes 12 – 16 /Min, max shut height 1.200 mm, ejector in slide 2.585 x 815 mm / 30 to, draw cushion in bed (3 cylinders) 2.610 x 810 mm / 70 to

**Complete Line for the tube bending, hydroforming, machining and cleaning of complex tube-type vehicle frame and chassis parts up to a dimension of ca. 1.500 x 1.500 x 100 mm
Year of Manufacture: 1996 / was in Production until July 2011**



Including:

- 3 off SCHULER HYDROFORMING Presses
- 2 off SCHWARZE WIRTZ Tube Benders
- 4 off FANUC Handling Robots
- HEISS Punching + Machining Unit
- TECHNO-COMMERZ Washing, Coating and Drying Unit

Main Features and Processes:

- Tubes supplied by fork lift (200 tubes of ca. dia 50 x 2.500 mm length in each storage magazine)
- Central master control system for status analysis of the complete process
- All production line components communicate via bus systems
- 2 operators required to run the line
- Fully automated transfer of parts
- Tooling provided with sensors to inspect the dimensional accuracy
- Automatic scrap removal via robot after bending or forming
- After hydroforming process 22 holes were punched into the part and slugs are folded back
- Tube end machining with gages to verify the accuracy of holes
- Final washing, coating and drying unit
- Automatic handling and loading of frame parts to cradles running on a rotation system

