

POSSIBLE ORIGINAL **SALE QUOTES**

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It is for this reason that buyers should avail themselves of the opportunity to make inspection prior to the sale. Information given is intended to provide general information of the equipment being offered and is subject to errors, omissions, additions or deletions.



Headquarters
 2375 Harrisburg Pike
 Grove City, OH 43123
 614-539-3000
 614-539-3001 Fax

PURCHASE ORDER

J12-0912SHOP

Date: 9/12/2012

Terms: 20% Down ARO; 80% Due Within 15 Days
 After Receipt of Equipment

F.O.B.: Advance Apex, Inc.

Ship Vendor
Via:

To:

Ellison Technologies
 5333 Muhlhauser Road
 Hamilton, OH 45011

Attn: Mike Sess
Phone: 513-874-2736 x 2026 - Cell:
Fax: 513-874-3254

BILL TO: Advance Apex, Inc.
 2375 Harrisburg Pike
 Grove City, OH 43123

SHIP TO: Advance Machining & Gear (Columbus)
 2375 Harrisburg Pike
 Grove City, OH 43123

PLEASE ENTER OUR ORDER FOR THE FOLLOWING, SUBJECT TO ALL INSTRUCTIONS & CONDITIONS AS SHOWN BELOW:

1 SN 8092000181B - DMG Sprint 20-8 Linear

Reference: Proposal ET-CIN320-MS Rev 2

Please submit invoice and we will send deposit.

\$260,000.00

\$260,000.00

DATE THIS ORDER IS DUE IN HOUSE
10/24/2012

Date Received In Full

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PLEASE CONFIRM RECEIPT OF THIS ORDER.

Total:

\$260,000.00

CONDITIONS

- Buyer reserves the right to cancel this order or any portion of it if delivery is not made when and as specified or if the quality of the order does not meet the specifications.
- No charge allowed for packing or cartage unless designated on this purchase order.
- By acceptance of this order, the Seller agrees not to use Buyer's drawings, samples or specifications which are known as trade secrets in part or in whole to produce or market said items to other entities.
- Seller hereby guarantees that Buyer against all losses of profits, damages or both resulting from any patent infringement by reason of purchasing goods covered by this contract. This guarantee also includes the reimbursement to the Buyer of all litigation costs which he may suffer as a result of a patent suit, in addition to the recoveries which may be secured against him or profits for damages.

Jeremy Hamilton

Direct Phone:

Direct Fax:

Email:



Headquarters
 2375 Harrisburg Pike
 Grove City, OH 43123
 614-539-3000
 614-539-3001 Fax

PURCHASE ORDER

J13-0621

Date: 9/12/2012

Terms: 25% Down, 75% Due Within 120 Days After
 Receipt of Equipment

F.O.B.: Advance Apex, Inc.

Ship Vendor
Via:

To:

Ellison Technologies 5333 Muhlhauser Road Hamilton, OH 45011	Attn: Mike Sess Phone: 513-874-2736 x 2026 - Cell: Fax: 513-874-3254
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BILL TO: Advance Apex, Inc.
 2375 Harrisburg Pike
 Grove City, OH 43123

SHIP TO: Advance Machining & Gear (Columbus)
 2375 Harrisburg Pike
 Grove City, OH 43123

PLEASE ENTER OUR ORDER FOR THE FOLLOWING, SUBJECT TO ALL INSTRUCTIONS & CONDITIONS AS SHOWN BELOW:

1	SN 8092000183B - DMG Sprint 20-8 Linear Reference: Proposal ET-CIN818-MS Dated 6/20/2013 <p style="text-align: center;"><i>Please submit invoice and we will send deposit.</i></p>	\$247,000.000	\$247,000.00
Date Received in Full <input style="width: 50px; height: 20px;" type="text"/>	<div style="border: 1px solid black; border-radius: 50%; padding: 10px; display: inline-block;"> DATE THIS ORDER IS DUE IN HOUSE 7/2/2013 </div>		
	PLEASE CONFIRM RECEIPT OF THIS ORDER.	Total:	\$247,000.00

CONDITIONS

1. Buyer reserves the right to cancel this order or any portion of it if delivery is not made when and as specified or if the quality of the order does not meet the specifications.
2. No charge allowed for packing or cartage unless designated on this purchase order.
3. By acceptance of this order, the Seller agrees not to use Buyer's drawings, samples or specifications which are known as trade secrets in part or in whole to produce or market said items to other entities.
4. Seller hereby guarantees that Buyer against all losses of profits, damages or both resulting from any patent infringement by reason of purchasing goods covered by this contract. This guarantee also includes the reimbursement to the Buyer of all litigation costs which he may suffer as a result of a patent suit, in addition to the recoveries which may be secured against him or profits for damages.

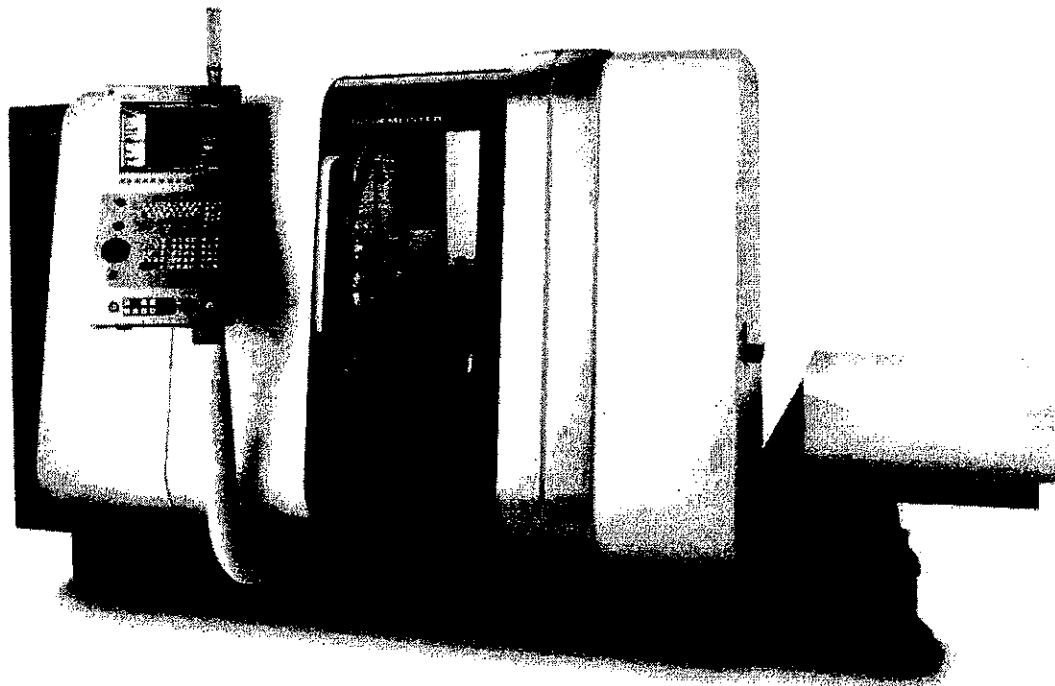
Jeremy Hamilton

Direct Phone:

Direct Fax:

Email:

DMG Sprint 20-8 Linear



Highlights

- **Linear drive** for maximum precision, speed and efficiency
- **6 + 2 axes, 2 Y-axes as standard**
- **2 tools** in simultaneous operation
- Thanks to the changing kit, the machine can be used as sliding headstock

GILDEMEISTER ITALIANA

Sprint 20-8 linear

Basic machine

I-J10010* Gildemeister Sprint 20|8 linear
with Fanuc control 310 is

Electrical variations - special frequency

I-J12020 Additional charge for
not standard frequency
(standard 50 Hz)

Electrics

I-Z0228 Additional price for USA
standard outlet 115 V

Special constructions

SK001 TX40T40MS 51 KVA

SK002 IEMCA Ideal 325/12' bar feed for Sliding Headstock
Pkg A
2 complete Channel Sets and 1 Spindle Liner

DMG Powertools

D-NT401* **DMG Netservice - client**
Green light for your machine
Will be installed on an external PCI

Special constructions services

SK004 IEMCA installation

Alternative options

Options basic machine

- I-J50023 Changing kit from steady
to sliding headstock
including application bush
type Dunner B260
and bush-spindle synchronism

- I-J50025 Kit for bar machining to diam. 25mm:
Diam. max.: 25 mm
Hexagon max.: 21 mm
Square max.: 17 mm
only for steady and sliding headstock

- I-J60110 Motorisation for rear working support
for 5 rotating tools including 5 spindles
with collet junction ESX/ER16

- I-J60501 Counter spindle collet cleaning
with coolant

Attachment

Technical Description

I-J10010
GILDEMEISTER SPRINT 20 | 8 linear two spindle Swiss turning automatic lathe,
with CNC-Fanuc control 310 is

TECHNICAL DATA

MAIN SPINDLE

Max. machining diameter	20 (25 Option)	mm
Stroke Z1	80	mm
Max spindle speed	10.000	rpm
Nominal power S1	3,7	kW

COUNTER SPINDLE

Max. machining diameter	20 (25 Option)	mm
Stroke Z2	300	mm
Max spindle speed	10.000	rpm
Nominal power S1	3,7	kW

CNC CONTROLLED AXES

Rapid traverse (excl. Y1)	40 (30)	m/min
Max acceleration X1	10	m/s ²
Feeding force (S1) axes Z1,Z2,X2,Y2	250	daN
Feeding force (S1) axis Y1	500	daN
Feeding force X1 linear axis	60	daN

SLIDE1

Stroke X 1	50	mm
Stroke Y 1	350	mm
6 position 12X12 tool holder		
5 driven tools incl. spindles, with junction ESX16		

SLIDE2

Stroke X 2	240	mm
4 pos. tool holder for external machining with junction 12X12		
4 pos. tool holder for internal machining diam. 20 mm.		
5 rotating tools incl. spindles with collet application ESX16 (option)		

COOLANT AND LUBRICATION EQUIPMENT

Coolant	emulsion	
Approx. conveyor tank capacity	250	l
Coolant pump max. capacity	120	l/min
Pump pressure	1,5	bar

NOISE LEVEL

Noise level according to ISO 230-5, ISO 3746, ISO 11202 < 70 dB_A

ELECTRICAL EQUIPMENT

Electrical cabinet according to EN 60204-1		
Power supply	37	kVA
Section of power supply cable	5x16	mm ²
Operating voltage	400 (+/-10%)	V
Frequency	50 (+/-1%)	Hz
Main fuse	60	A
Control voltage	24	V/DC
Lighting voltage	24	V/DC
Nominal current	54	A
Machine lighting protection level	IP 67	
Electrical Cabinet protection level	IP 54	

ENVIRONMENT CONDITIONS:

Admissible ambient temperature	+10/+35	°C
Maximum relative air humidity	max. 75	%
Maximum installation height above NSL	max. 1000	m

IMPORTANT ADVICE:

The machine must only be connected to TN-S type power supply.

For any other kind of power supply, a transformer with grounded secondary output star centre is required.

The neutral pole connection depends on the electrical configuration of the machine.

It is required to obey the cable section (power, neutral, ground) as shown on the wiring diagram.

If a differential switch is needed, this has to be a selective B or C type with variable current setting (min. value 300 mA) and with variable triggering time.

It is highly recommended to connect only one machine to each differential switch.

To prevent any risk of fire or explosion caused by external factors and in any case unpredictable during the running operations, Gildemeister Italiana SpA suggests the installation of safety systems (such as fire extinguishing units).

To reach the highest production standard, especially when machining with oil, Gildemeister Italiana SpA suggests the use of an additional chilling unit to control the coolant temperature.

SAFETY EQUIPMENT ACCORDING TO :

2006/42/EC; 2006/95/EC; 2004/108/EC

FANUC 310 is CNC Control (Flat colour video 15")

OPERATING REMARK:

Recommended straightness tolerance for the bar: 0,5mm/m

PAINTING:

Machine front	:	White Calcit- RAL 9010
Machine rear	:	Dark grey- RAL 7016
Sliding door	:	Dark black - RAL 9005

DIMENSIONS AND WEIGHT

LxWxH of the machine	2.200x1.050x1.770	mm
Approx. machine weight	4.200	kg

In case of order, Gildemeister Italiana S.p.A. has to confirm dimensions and weights as well as machine

painting and control panel according to the machine configuration.

DOCUMENTATION:

Operating manual
Programming manual
Wiring diagrams
Mechanical documentation
1 hard copy + 1 CD with .pdf files

BASE MACHINE CONFIGURATION:

- Chip conveyor belt type
- Collet application for main and counter spindle
- 6 pos. tool holder 12X12 on slide 1
- 5 driven tools on slide 1 with 5 spindles with junction ESX16
- Tool holder slide 1 for 6 fixed tools diam. 20mm
- Tool holder slide 2 with 4 fixed tools diam. 20 and 4 pos. 12x12
- C-axis for main- and counter spindle
- Electrical cabinet air conditioning
- Pump with fluxmeter
- Pneumatic ejector and workpiece unloading checking device
- Tape unloading workpiece
- Pneumatic cleaning system for counter spindle collet
- Mechanical preparation for oil mist filter
- Electrical and software interface for bar loader
- Angular synchronism between main and counter spindle
- 2 additional on/off outputs (4-M functions)
- Quadruple light warning
- Piece/time counter
- Software for bar feeding in overlap time
- Helical interpolation
- Constant cutting speed and rigid tapping

REMARKS:

The machine must only be connected to TN-S type power supply.

For any other kind of power supply, a transformer with grounded secondary output star centre is required.

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To prevent any risk of fire or explosion caused by external factors and in any case unpredictable during the running operations, Gildemeister Italiana SpA suggests the installation of safety systems (such as fire extinguishing units).

To reach the highest production standard, especially when machining with oil, Gildemeister Italiana SpA suggests the use of an additional chilling unit to control the coolant temperature.

Please notice that due to unforeseen events, wrong machine-programming, situations not monitored during the production process (such as "tool break) or due to critical materials (as titanium alloy or alloys with high level of

magnesium) and coolant fluids (cutting oil and emulsions with an oil percentage higher than 15%), a dangerous situation for the operator can occur in the near area of the machine (fire or explosion).
In order to prevent such danger Gildemeister Italiana S.p.A. requires the installation of protection system (fire extinguishing or anti-explosion systems) on its turning machines

To guarantee an optimal process capacity during the production, in particular during the machining with cutting oil, Gildemeister Italiana S.p.A. requires the application of a chiller system to monitor the coolant fluid's temperature.

GILDEMEISTER Italiana is not responsible for the damages occurred to the parts of the machine and/or to the tools in case of black out during the phases of tooling or automatic machining as well.
Furthermore GILDEMEISTER Italiana is available to offer adequate protection systems (Systems Power Failure BackUp) upon specific request of the customer.

D-NT401

The DMG Netservice establishes a secure VPN connection to the DMG Service installed on an external Computer.

By the help of the online connection:

- an immediate and comprehensive problem analysis,
- direct troubleshooting on machine control or
- software adaption can be managed.

Note:

To guarantee a smooth installation, the checklist of the DMG Netservice has to be completed before setting-up the machine. After warranty, a monthly fee in the amount of 25€ (net) per machine will be incurred.

There will be no online-costs incurred during the connecting between machine and DMG Service.

The delivery and terms of use of the DMG Netservice is based on the scope of supply and services for the DMG Netservice.

This information and the checklist for the installation of the DMG Netservice will be sent with the order confirmation of our machine or even go to www.dmgnetservice.com

On request we glad to provide you this information, please feel to ask for it.

INVESTMENT SUMMARY DMG Sprint 20-8 Linear

Machine and Options Description	
Sprint 20-8 linear with Fanuc 310is	
HP and Mist collector machine preparation for ChipBlaster D30-80, MistBlaster and 3 high pressure output,	
I-CJF310 Fanuc 310is Sprint 20-8	
I-J50023 Changing kit from steady to sliding headstock	
I-J50025 Kit for bar mach. to 25 mm	
I-J60110 Motorisation for rear working support	
I-J60501 Counter spindle collet cleaning	
I-X12005 USA Standard outlet 115V	
I-J12020 Add. cost for not stand. frequency (stand. 50 Hz)	
D-NT401 DMG Netservice - client	
TX40T40MS transformer	
IEMCA Ideal 325/12' barfeed for Sliding Headstock	
Freight to Advance CNC Machining	
Price for Advance Machining and Gear	\$ 247,000.00