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Headquarters
 2375 Harrisburg Pike
 Grove City, OH 43123
ISO 9001:2015
Certified

Purchase Order
DMG Speed 20

Date 6/26/2014
 Terms Special - See below

To: Ellison Technologies
 5333 Muhlhauser Road
 Hamilton, OH 45011

Attn: Mike Sess
 Phone: (513) 874-2736
 Fax: (513) 874-3254

F.O.B. Advance Apex, Inc.
 Ship Via Vendor

*Please reference purchase order number with all shipments.

Bill To: Advance Apex, Inc.
 2375 Harrisburg Pike
 Grove City, OH 43123

Ship To: Advance Apex, Inc.
 2375 Harrisburg Pike
 Grove City, OH 43123

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

Qty	Unit	Rev	Part Number - Description	Price Each	Total
1	ea		DMG Speed 20 - DMG Speed 20 / 11 linear, S/N 8085012057B per Proposal ET-CIN37475-MS Rev 2 dated 6/24/14 Terms - 25% Down, Balance Due 120 days after machine installation Order is contingent upon the purchase and payment of specified equipment by Champion Machinery to Advance Apex in the amount of \$305,000 on or before 9/30/14.	\$290,290.0 0	\$290,290.00

DATE THIS ORDER IS DUE IN HOUSE

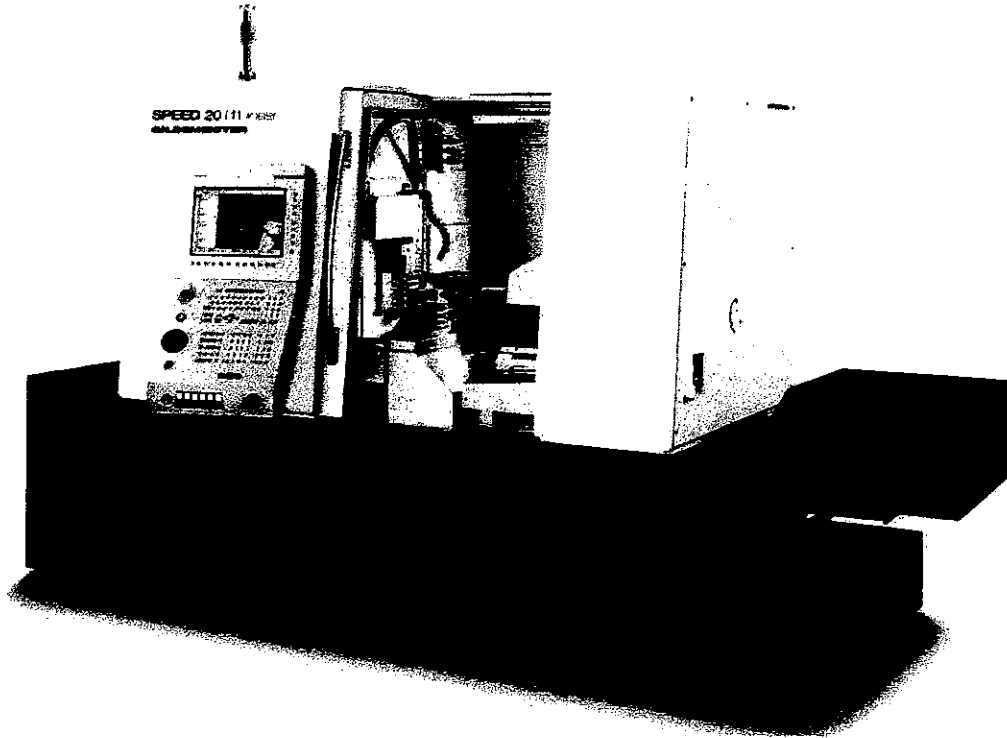
7/17/14

PLEASE CONFIRM RECEIPT OF THIS ORDER.

Total: \$290,290.00

Jeremy Hamilton
 Direct Phone: (614) 539-3000
 Direct Fax: (614) 539-3001
 Email: jeremy@advanceapex.com

DMG SPEED 20-11 Linear



SPEED 20-11 linear summary

- Basic machine**
- I-W10012 Speed 20-11 Linear Fanuc
- Fanuc Control**
- I-CWF310 Fanuc 160iTB Speed 20-11
- Options basic machine**
- I-W60501 Counter spindle collet cleaning
- I-W50025 Kit for bar machining till 25 mm
- Electrical variations - special frequency**
- I-W12020 Add. Charge f.spec. Frequency 50 Hz
- Electrics**
- I-Z0228 Add.charge for USA standard outlet 115 V
- Special constructions**
- SK001 TX40T51MS 51 KVA Transformer
- SK002 IEMCA Ideal 325/12' bar feed for Sliding Headstock
- DMG Powertools**
- D-NT401 DMG Netservice – client
- Basic Machine Installation**
- I-W90210 Commission basic machine, 3days
- Special constructions services**
- SK004 Basic course for FANUC, 3 days on customer site
- SK005 IEMCA install
- SK006 Freight to Grove City

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<u>List price</u>	<u>\$439,840.00</u>	<u>USD</u>
<u>Discount for Advance CNC Machining for 2014 purchase</u>	<u>\$149,550.00</u>	<u>USD</u>
<u>Total price for Advance CNC Machining</u>	<u>\$290,290.00</u>	<u>USD</u>

SN 808 5012053B - 1590

230K
fanuc
215

\$ 230,873
25 i. down
75 i. Net 122

~~\$ 246,746~~

Technical Description SPEED 20-11 linear

I-W10012

**GILDEMEISTER SPEED 20-11 linear two spindle Swiss Turn CNC- Lathe, 11 axis version
 with CNC-Fanuc control**

TECHNICAL DATA

MAIN SPINDLE

Max. machining diameter	mm	20(25 Option)
Long.stroke of spindle head Z1	mm	240
Spindle speed max	rpm	10.000
Nominal power S1	kW	3,7
Power S2 30 min	kW	5,5

COUNTER SPINDLE

Max. machining diameter	mm	28,5
Long.stroke of spindle Z2	mm	300
Spindle speed max	rpm	10.000
Nominal power S1	kW	3,7
Power S2 30 min	kW	5,5

CNC CONTROLLED AXIS

Fast positioning speed	m/min	40
Acceleration of all axis	m/sec ²	5/10
Feedforce of all axis (excl. X1 and X3)	daN	250
Feedforce X1 and X3 linear axis	daN	60

SLIDE1

Stroke X 1	mm	40
Stroke Y 1	mm	240
6 position 12X12 toolholder		
4 driven tools with holders ESX16		

SLIDE2

Stroke X 2	mm	310
Stroke Y 2	mm	120
3 position 12X12 toolholder		
4 position Ø20 toolholder		
4 driven tools with holders ESX16		

SLIDE3

Stroke X 3	mm	75
Stroke Y 3	mm	240
Stroke Z 3	mm	150
2 position 12X12 toolholder		
6 position Ø20 toolholder		
4 driven tools with holders ESX16		

COOLANT AND LUBRIFICATION EQUIPMENT

Coolant tank, capacity approx.	l	250
Capacity of coolant pump max	l/min	120

Standard pressure	bar	30
Loss lubrication unit	l	2,9

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	KVA	37
Section of power supply cable	mm ²	5x16
Operating voltage	Volt	400 (+/-10%)
Frequency	Hz	50 (+/-1%)
Main fuse	A	63
Control voltage	V/DC	24
Lighting voltage	V/DC	24
Nominal current	A	54
Machine lighting protection level	IP 67	
Electrical Cabinet protection level	IP 54	

ENVIRONMENT CONDITIONS:

admissible ambient temperature	+15 to +35°C	+59 to +95°F
maximum relative air humidity	75%	
maximum installation height above NSL	1000 m	3280 ft

IMPORTANT ADVICE:

The machine can only be connected to TN-S type power supply. For any different power supply type it is needed a transformer with secondary output star centre grounded.

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 electrical scheme.

If a differential switch is need, it is to be a selective one, B or C type, with variable current setting (min. value 300 Ma) and with variable triggering time. It is suggested to connect one machine per 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 chiller unit to control the coolant temperature.

SAFETY EQUIPMENT ACCORDING TO :

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

OPERATING REMARK:

Bar's dimensional tolerance: max h11

It is necessary to use bars with straightness < 0.5mm/m according to the methods indicated in the norm EN 10278:2002

Bar's dimensional tolerance in case of utilization of rotating bushes (Swiss type Kit): max h9

FANUC 160iT CNC Control (Flat colour video 15")

PAINTING:

Machine front:	light grey NCS 1502
Machine rear:	dark grey NCS 5502
Sliding door:	satined stainless steel

DIMENSIONS AND WEIGHT

LxWxH of the Machine

mm 3.053x1.210x1.960

Machine weight approx.

Kg 4.640

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:

operation manual

technical handbook

programming manual

wiring diagrams

handbook numerical control

mechanical documentation

1 hard copy in the language agreed in the contract

1 CD with .pdf files, 1 set in italian and 1 set in the language agreed in the contract

BASE MACHINE CONFIGURATION:

- Collet application for main-and counter spindle
- Synchronised rotating bush for bush type Duenner B260
- C-axis for main- and counter spindle
- 6- pos. tool holder 12x12 slide 1
- 4 driven tools slide 1 with ESX16 spindles
- Chip Conveyor belt type, H 600 mm
- 2-pos. tool holder 12x12 slide 3
- 4 driven tools slide 3 with ESX16 spindles
- Tool holder slide 3 for 6 fixed tools with diam.20mm
- 3-pos. tool holder 12x12 slide 2
- 4 driven tools slide 2 with ESX16 spindles
- Tool holder slide 2 for 4 fixed tools with diam.20mm
- Pneum. ejector and workpiece unloading belt
- Pneumatic cleaning system for counter spindle collet
- Mechanical preparation for oil mist filter
- Electr. prep. and software for bar loader
- Angular synchronism between the spindles
- N°2 supplm.ON/OFF outputs (4-M functions)
- Automatic machine shut down
- Polygon turning software
- constant cutting speed and rigid tapping
- helical interpolation
- spindle speed control
- piece/time counter
- Flat colour video 15"
- Triple light warning
- Tool radius compensation
- Direct control of radii, chamfer and edges
- Axes displacement with reduced force
- Protection of programs with password
- Software for bar feeding in overlap time
- Electrical Cabinet air conditioning

REMARKS:

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 (max viscosity 32 CST at 40°C), 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.