

50,000 SQ. FT. FORGE TOOLING AND BEARING COMPONENT MANUFACTURER
INCLUDING OKUMA MULTUS CNC TURN-MILL CENTERS TO 2015, COATING AND
HEAT-TREATING EQUIPMENT, SIP CNC JIG BORES, EDM'S, CNC AND MANUAL GRINDERS,
TOOLROOM, TOOLING, INSPECTION AND SUPPORT EQUIPMENT

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ASHLAND PRECISION TOOLING, LLC

1750 S. Baney Rd. – Ashland, Ohio 44805

70 Miles Southwest of Cleveland, Ohio

SALE DATES: WEDNESDAY, NOVEMBER 20TH, STARTING AT 9:00 AM

Inspection: Day Prior from from 10:00 AM to 4:00 PM
or by appointment with jeffjr@cia-auction.com



(4) Okuma Multus B400 and B200 CNC Turn Mill Centers (to 2015)



Mitsubishi Model MV2400S Advance Type 3
CNC Wire EDM



SIP 4000 CNC Horizontal Jig Borer, 46" x 67", Fanuc (Swisstronics
Retrofit)



62" Head Cincinnati Milacron Four-Axis Vertical
Universal CNC Grinder w/ Side Grinding Spindle



Complete Heat Treat and Metal Coating
Department



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NEW 2011

(2) Okuma Multus B400 Six-Axis CNC Turning and Milling Centers



NEW 2011

Okuma Multus B200 Six-Axis CNC Turning and Milling Center



(2) Okuma Model LB45II-M CNC Turning Centers w/ Live Tooling



**Okuma Model Macturn-30 Multi-Axis CNC Turning Center



NEW 2015

Okuma Model Multus B400II Six-Axis CNC Turning and Milling Center

CNC WIRE EDM'S

Mitsubishi Model MV2400S Advance Type 3 CNC Wire EDM; s/n 56DM2986 (2017), Approx. 4,150 Hours, Mitsubishi W31MV-2 Control, V350V Power Supply, 25" x 33" Table Area, 4,145 hours Showing (New 2017)

Charmilles Model Robofil 6020SI CNC Wire EDM; s/n 193576 (1998), Charmilles Type Generator Control & Power Supply, 36" x 23" Mecatool Table
Sinker EDM on Bridgeport Base w/ Power Supply

CNC TURNING AND MILLING CENTERS

Okuma Model Multus B400II Six-Axis CNC Turning and Milling Center; s/n 187044 (6/2015), 4,400 Hours, Okuma P300S Control, X, Z, C, W Axis, 15" Chuck, 40-Pos. ATC, HSK Spindle, 28" Swing Over Bed, 59" Center Distance, Travels: X-27", Y-9", Z-59", C-360°, Main Spindle Speeds: 30 to 3,800-RPM, Mill Spindle Speeds to 6,000 RPM, 30-HP (New 2015)

(2) **Okuma Model B400 Six-Axis CNC Turning and Milling Centers;** s/n 125658 (10/2006) w/ OSP-P200L Control, s/n 157398 (9/2011) w/ OSP-P200LA Control, X, Z, C, W, 15" Chuck, 60" Centers, 40-Pos. ATC, HSK

Tooling, 28" Swing Over Bed, 59" Center Distance, Travels: X-27", Y-9", Z-59", C-Axis 360 Degree, B-Axis Indexing Angle 225 Degree, Main Spindle Speeds: 30 to 3,800-RPM, Mill Spindle Speeds to 6,000 RPM, 30-HP (New as 2011)

Okuma Multus B200 Six-Axis CNC Turning and Milling Center; s/n 153872 (3/2011), OSP-P200L Control, Tailstock, 23.5" Swing Over Saddle, 23.5" Distance Between Centers, 6" Chuck, Main & Sub Spindle Speed - 6,000 RPM, Milling Spindle

Speed 12,000 RPM, Travels: X-19.7", Z-31.5", W-31.89", C-Axis 360 Degree, B-Axis Indexing Angle 225 Degree (New 2011)

****Okuma Model Macturn-30 Multi-Axis CNC Turning Center;** 21" Max. Swing, 48" Centers,

Mazak Model Integrex 2005Y CNC Turning and Milling Center; s/n 142889 (4/1999), Mazatrol Fusion 640MT Control, 10" Chuck, Approx. 40" Centers, 40-Pos. ATC, Chip Conveyor, Chip Blaster, Hi-Pressure Coolant System (Out of Service)

HOLLOW SPINDLE LATHE

48" x 108" Leblond 15" Hollow Spindle Model 5029

N/C Flat Bed Lathe; GE 1050 Control, 32" Chuck, 29" Swing Over Cross Slide, 6-Pos. Turret, 75-HP Motor, 132" Overall Bed Length

CNC LATHES

(2) **Okuma Model LB45II-M CNC Turning Centers w/ Live Tooling;** s/n 0136, w/ OSP 700L Control (Approx. 1998), s/n 0269, w/ OSP 100L Control (Approx. 2001), 15" Chuck, Approx. 84" Centers, 34" Swing Over Way Covers, 24" Swing Over Carriage, 12-Pos. Turret, Chip Conveyor

• (10) Live Tool Heads; Right Angle & Straight

Hardinge Conquest TS-51SP Model CS-51 CNC Turning Center w/ Live Tooling; Fanuc 18T Control, 8" Chuck, 12-Pos. Turret, Tailstock, Chip Conveyor

Hardinge Conquest 42 CNC Turning Center; s/n 8220, Fanuc OT Control, 6" Chuck, 10-Pos. Turret, Tailstock

Cincinnati Milacron Model 10U-40 CNC Turning Center; s/n 532U010-83-019, Acramatic 900 Control, 9" Chuck, Tailstock, Chip Conveyor

LNS Hydrobar Bar Feed

SIP JIG BORERS

SIP Type 4000 Model 65 CNC Horizontal Jig Borer; s/n 12929, Fanuc 16i-M Control, 46" x 67"



INDUSTRIAL REAL ESTATE FOR SALE OR LEASE

49,500 Sq. Ft. Industrial Building on Approx. 24.7 Acres

For more info contact: Jack Gant, Broker, jgant@gant-realty.com, 330-264-4242 Office



**Swisstronics
Retrofit**

**6-Axis
CNC**

SIP 4000 CNC Horizontal Jig Borer, 46" x 67", Fanuc (Swisstronics Retrofit)



Eimeldingen Vertical CNC Table



Retrofitted

SIP Model 7R High Column CNC Vertical Jig Borer



**NEW
2017**

Mitsubishi Model MV2400S Advance Type 3 CNC Wire EDM

Main Table, 36" x 36" Rotary Table, 59" Cross Travel, 16" W-Axis, 24" Spindle Travel, 47" Vertical Travel, No. 50 Taper, Spindle Speeds to 3,000 RPM (Retrofitted by Swisstronics)

- **Eimeldingen Vertical CNC Table SIP Model 7R High Column CNC Vertical Jig Borer;** s/n 129, Fanuc 18M Control, 39" x 62" Table, 55" Longitudinal Table Travel, 40" Horizontal Spindle Travel, 71" Max. Distance to Table, 63" Bet. Columns, 56" Vertical Travel of Cross Rail, 12" Quill Travel, 18-Spindle Speeds: 40 to 2,000 RPM (Retrofitted by Swisstronics)
- **SIP Hydroptic 6A Precision Vertical Jig Borer;** s/n 3905, 33" x 43" Table, 40" Longitudinal Table Travel, 28" Horizontal Spindle Head Travel, 39" Maximum Distance Spindle To Table, 43" Distance Between Columns, 31" Vertical Travel Of Cross Rail, 37" Maximum Distance Table To Cross Rail, 18-Spindle Speeds: 40 To 2000 RPM, 12" Spindle Quill Travel, 2,200 Lbs. Maximum Table Work Piece Capacity

SIP Model MP-3K Vertical Jig Borer; s/n 388, 15" x 20" Table

CNC VERTICAL TURNING CENTER

Werth Model 1218S-VNC-T5 CNC Vertical Turning Center; s/n 9246-0596, Fanuc 16T Control, 12" Chuck, 30" Swing, 5-Pos. Turret Head, 24" Approx. X-Axis, 17" Approx. Z-Axis

CNC MACHINING CENTERS Sunstrand Omnimill Universal CNC Machining Center; Delta Tau CNC Control & Custom Servo, Inc. Servo Drives, 48" Dia. Rotary Table, 60-Pos. ATC,

- **Large Quantity Omnimill Toolholders**

****Okuma Model MA-550VB CNC VMC;** 22" x 51" Table

Monarch Model VMC45B CNC Vertical Machining Center; Fanuc 16M Control, 19" x 42" Table, No. 50 Taper, 24-Pos. ATC

****Sajo HM-450 CNC Horizontal Mill;** 23" x 82" Table, Heidenhain Controller

(2) Bostomatic Model 300 CNC Vertical Machining Centers; 12" x 42" Table

BORING MILLS

5" Giddings & Lewis Model PC-50 Four-Axis CNC Horizontal Boring Mill; s/n 445-1074, G&L Numeripath 8000 Control, 48" x 98" Table, Travels: X-92", Y-66", Z-52", 50-Taper

3" DeVlieg Model 3H-48 Spiramic Jig Mill; s/n 8317, 36" x 48" Table

MACHINE ACCESSORIES AND TOOLING

(20) Vidmar Cabinets Loaded with Perishable and Indexable Tooling Machine Accessories; 12" Tsudakoma Model RB300L 4th-Axis Table, 30" Hydraulic Rotary Table, No. 50 Holders, Vises, Angle Plates, Setup Equipment



15" Hole

48" x 108" Leblond 15" Hollow Spindle Model 5029 N/C Flat Bed Lathe



5" Giddings & Lewis Model PC-50 Four-Axis CNC Horizontal Boring Mill

WEBCAST BIDDER INSTRUCTIONS

- **Bidders in the United States** will receive approval forms from our office upon registering for the auction on www.bidspotter.com, pending the Auctioneers review of the information provided you will be approved at the Auctioneers discretion.
- **Bidders outside of the United States** must post a deposit of approx. 25% of their planned spending budget or \$5,000.00 minimum with Cincinnati industrial auctioneers in order to be approved to bid. Those who do not post the deposit will not be approved. **period.**

BidSpotter.com



**Okuma Model MA-550VB CNC VMC



Werth Model 1218S-VNC-T5 CNC Vertical Turning Center



Large Quantity CNC Lathe Tooling



SIP Hydroptic 6A Precision Vertical Jig Borer



24" x 72" Thompson Hydraulic Surface Grinder



Heald / CNC Eng. Inc. Model Cinternal 2 Five-Axis CNC I.D. Grinder



62" Heald Cincinnati Milacron Four-Axis Vertical Universal CNC Grinder w/ Side Grinding Spindle



Cincinnati Milacron Model #2-OMV Centerless Grinder



14" x 40" Jones Shipman Model 1307 Universal O.D. Cylindrical Grinder



Heald Model 2EF73 Gagematic I.D. Grinder



24" Sundstrand Model H24 Vertical Spindle Rotary Surface Grinder

CNC UNIVERSAL GRINDER

62" Heald Cincinnati Milacron Four-Axis Vertical Universal CNC Grinder w/ Side Grinding Spindle; s/n 40599, Retrofitted CNC Control by Miller Technical Systems w/ Unit-Drive V/S Drives, 62" T-Slotted Chuck, 68" Max. Swing, 48" Electric Chuck, Heald U-60-8653 Universal Grinding Head, Rebuilt by Sopko w/ 12" x 1-1/2" Wheel, Side Grinding Head w/ 12" Wheel, Turret Head, X, Z, A, D Controlled Axis, 10-HP Heald Model 400 Head, Approx. 48" Vertical Rail Travel (Retrofitted 1999)

I.D. GRINDERS

Heald / CNC Eng. Inc. Model Cinternal 2 Five-Axis CNC I.D. Grinder; Job No. 18639-1, Fanuc Oi-TF Control, Retrofitted 2018, X, Z, U, B, A, 12" Electric Chuck, Rear Turret w/ (4) Grinding Spindles, (1) Needs Rebuilt, 36" Max. O.D., 12" Vertical, Updated Electrics, Spindle Control Cabinet, Hansen Coolant, Chiller (Retrofitted 2018)

Heald Model 2EF73 Gagematic I.D. Grinder; s/n 48161, OS Walker Chuck Control, PB Control, Coolant

O.D. GRINDERS

14" x 40" Jones Shipman Model 1307 Universal O.D. Cylindrical Grinder; s/n B012171, (2) Wheel Heads, Swing Around I.D. Spindle, Sony DRO, PB Control

10" x 40" Jones Shipman Model 1305 Universal O.D. Cylindrical Grinder; s/n B013737, (2) Wheel Heads, Swing Around I.D. Spindle, Sony DRO, PB Control

12" x 36" Brown & Sharpe Model 3 O.D. Grinder; DRO, Coolant

10" x 24" Landis Universal O.D. Grinder w/ Swing Down I.D. Spindle

CENTERLESS GRINDER

Cincinnati Milacron Model #2-OMV Centerless Grinder; s/n 91610MV90-0119, 8" Thru-Feed, 1/16" to 3-3/4" O.D.

SURFACE GRINDERS

24" x 72" Thompson Hydraulic Surface Grinder; s/n 6065699, Coolant, New Hydraulic Motor

• 8" x 48" & 6" x 60" Tilting Electric Chucks

16" x 36" Gallmeyer & Livingston Model 570 Hydraulic Surface Grinder; s/n 570202, Incremental, Dresser, PB Control, Coolant

24" Sundstrand Model H24 Vertical Spindle Rotary Surface Grinder; s/n 4468, 27.5-HP Motor, 16" x 2" x 8" Grinding Wheel

(2) 16" Heald Model 261 Horizontal Spindle Rotary Surface Grinders; s/n's 30367 & 30235, 2-Axis DRO, OS Walker Control, Mist Collector

12" x 36" Brown & Sharpe Micromaster Hydraulic Surface Grinder; s/n 523-1236-119, Coolant

8" x 24" Brown & Sharpe Micromaster Hydraulic Surface Grinder; Updated Digital Control, Coolant

TOOL GRINDERS

(3) Brown & Sharpe No. 13 Universal Tool Grinders; s/n 525-13-2704, w/ Setco 4301GY Spindle & s/n 2624 & 6806

Cincinnati No. 2 Tool Grinder

6" Hammond Grinder w/ DC in Base

Lars Model 500CG Single Lip Tool Grinder

KNUCKLE PRESS

800 Ton Minster Model 900-800 Knuckle Joint Press; s/n 3228, 1/2" Adj., 28" x 36" Bed, 18" x 22" Ram, Approx. 8" Stroke, PB Control

COATING EQUIPMENT

Plasma Technik Plateg Type PP-60-700x1000 Plasma Nitride Coater; s/n A2149 (1997), 27.5" x 39.3" Vacuum Vessel, 23.6" x 27.5" Working Area, 600 Deg. C Max. Layout for Process Temp.

Multi-Arc Nitride Coating Vessel for Tin, Crn, TiAlN; 1/8" to 22" O.D. Part Cap. 1,000 Lbs. Max Weight, (8) 100-Amp Multi-Arc Power Supplies, Vacuum Pump, Surface Engineering Group PVD Software, See website for details

Multi-Stage Dip Wash Line; Dual Chamber S/S Wash Tank, Poly Tank Washer, 3-Stage Di-Oxized Water Tank, 24" x 22" x 6" Baskets

ALLCASE QUENCH FURNACE

Surface Combustion Model 36-48 Super Proelectric Allcase Natural Gas Fired Quench Furnace; s/n BC-41101-1, 1,400 Degree Min - 1,750 Degree Max Temp., Model DEDP-ER-36-48 Charge Cart, Model Electrically Heated Spray Washer, PB Control

Surface Combustion RX Generator; s/n C-6937-1, Size T-I-N, 1200 CFH, 1950 Degree Max Temp

VACUUM QUENCH FURNACE

C.I. Hayes Model VSQD-202436 Vacuum Quench Furnace; s/n 15636, Approx. 20" x 24" x 36" Max., 2,400 Deg. F Max. Temp, Vacuum Nitrogen Atmosphere, 22" x 36" x 4" D Baskets, 500 Lb. Cap., PB Control, 144-KW, See website for details



16" x 36" Gallmeyer & Livingston Model 570 Hydraulic Surface Grinder



(2) 16" Heald Model 261 Horizontal Spindle Rotary Surface Grinders





800 Ton Minster Model 900-800 Knuckle Joint Press



Surface Combustion Model 36-48 Super Proelectric Allcase Natural Gas Fired Quench Furnace



Plasma Technik Plateg Type PP-60-700x1000 Plasma Nitride Coater



Multi-Arc Nitride Coating Vessel for Tin, Crn, TiAlN

MISC. HEAT TREAT

(4) Leeds & Northrup Electric Homo Furnaces; Models: (2) 09470-364X, 9470-UB-26-40S & 9464-UB-16-40, 1400 Degree Max Temp.

Lindberg Type 11-RO-183618-20A Electric Furnace

Therm-Monic Model CE-1500 Induction Heater

60" x 48" x 36" Approx. Chamber Webber Freezer

Insinger Model Commander 18-5 Washer

Iconel Baskets, Tongs, Parts

FINISHING EQUIPMENT
48" Lapmaster Model 48F Four-Head Lapper; s/n 4800014, (4) 20" Heads

24" Wheelabrator Rotary Table Abrasive Blast Machine; s/n A13232, Bucket Elevator Reclaim

(2) 24" x 48" Zero Model BNP55-7 Abrasive Blast Cabinets w/ Reclaim

24" x 42" Zero Model 55-600-DP

Abrasive Blast Cabinet w/ Reclaim Vibra-Finish Model VF7 Vibratory Finishing Bowl; s/n 7693, PB Control 3-HP Schauer Model VA4BC Speed Lathe

Lapmaster Model 12 Lapper

Air Flow Model BCH2 Portable Dust Collector

Adjusta-Vibe Vibratory Finishing Bowl

Noblewest Model 60 Marking Machine; s/n 6524



C.I. Hayes Model VSQD-202436 Vacuum Quench Furnace



24" Wheelabrator Rotary Table Abrasive Blast Machine



48" Lapmaster Model 48F Four-Head Lapper



Vibra-Finish Model VF7 Vibratory Finishing Bowl



C.I. Hayes Model VSQD-202436 Vacuum Quench Furnace



(4) Leeds & Northrup Electric Homo Furnaces



WEDNESDAY, NOVEMBER 20TH



TOOLROOM MACHINERY

16" x 14" HEM Model 1200A Automatic Horizontal Band Saw; s/n 271288, Approx. 24" Bar Feed

K&T Model 315-S15 Universal Horizontal Milling Machine; s/n 5473020, Universal Head, DRO, 15" x 68" Table

20" x 78" Monarch Model 2013-78 Engine Lathe; s/n 46262, Taper

**20" x 48" Mori-Seiki Model MS1050 Engine Lathe

18" x 60" Leblond Regal Engine Lathe; s/n 13E-214, DRO

Mitts & Merrill No. 3 Mechanical Keyseatter

26" DoAll Model 2613-3

Vertical Band Saw; s/n 198-74413, Welder, Power Table

1 1/2-HP Bridgeport Vertical Milling Machine; s/n 122825, 42" Table, DRO

Sunnen Model MBB-1680DMS Hone; s/n 72056

Electro Arc Model Rebuild Tap Disintegrator w/ Auto Feed

H-FRAME PRESSES

200 Ton Enerpac Electric Hydraulic H-Frame Press

100 Ton OTC Electric Hydraulic H-Frame Press

MISC. MACHINERY

LNS Bar Champfering Machine

Weatherhead T-462 Hose Crimper

Rigid Model 535 Pipe Threader

20" Stone Abrasive Saw

(2) Lincoln Powermig Welders
Flex-Arm Pneumatic Tapper on Heavy Die Cart

Numerous Small Grinders, Drills, Saws, Sanders

20" Clausing Floor Drill

ASHLAND PRECISION TOOLING, LLC



(2) 24" Allen Sliding Head Drills

FORKLIFT, TRUCK AND RELATED

**20,000 Lb. Taylor Model Y-20-WON Pneumatic Tire Diesel Forklift

**18,000 Lb. Clark Yardlift Model CFY150B Pneumatic Tire Forklift

8,000 Lb. Hyster Model S80XL LP Gas Solid Tire Lift Truck; s/n D004V02674K, 121" Lift, 84"

Collapsed Mast, 7,300 Hours
 2010 Ford F150 Pickup Truck; Vin #KEO2719, Miles: 111,000, Engine; 4.6 Liter
Genie Model AWP-20S Man Lift Advance & Clarke Walk Behind Floor Scrubbers

AIR COMPRESSORS
 (2) 25-HP Kaeser Model ASD-25T Air Compressors; Built-In Model ABT-60 Dryers, Approx. 16,600 Run Hours & 10,250 Load Hours (New 2014)

INSPECTION
 (10) Vidmar Cabinets Loaded with Inspection Tools and Gages O.D. Micrometers to 36" Dia.
 DEA Coordinate Measuring Machine; s/n SW1189, 24" x 18" & 16" Approx. Cap.
 DEA Swift Coordinate Measuring Machine; 24" x 48" Table (Out of Service)
 30" OPG Model OQ-30B Optical Comparator; s/n OQB-30181, Digital Control w/ Readouts

Struers Discotom-2 Lab Polisher; s/n 3681934
 United Digital Hardness Tester Antonik Model ADT-12 Digital Hardness Tester; s/n 91DT106
 Excel Model Script Laser Engraver
 Sheffield Bendix Cordax 3000 Coordinate Measuring Machine
 Granite Surface Plates to 6' x 8'
 14" x 48" Sundstrand Bench Center

BUILDING AND MACHINE PARTS
 (20) Vidmar Cabinets Loaded w/ Machine & Building Maintenance Parts
 Large Quantity Maintenance Area with Motors, Drives, Consumables, Electrical, Hydraulic, Pneumatic Components

More photos at cia-auction.com

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IMPORTANT NOTICE:

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DIRECTIONS

Approx. 60 Miles South of Cleveland off I-71, just west of the Ashland County Fairgrounds use GPS for best results

AUCTIONEERS

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TERMS OF SALE

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15% ONSITE BUYER'S PREMIUM
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