

Enquiry ID: EM00655
Enquiry made by: Emmanuel Bertrand
Company: Promill Stolz
Address: RN12 28410
Serville
France
Mollart Quote No: QM0667
Prepared by: IP
Date: 9 June, 2008

ITEM 1. QTY 1.

**MOLLART LD8-150 EIGHT SPINDLE PELLET DIE
DEEP HOLE DRILLING MACHINE** to specification

described and as illustrated at our web site

<http://www.mollart.com/pdfs/pelletdie.pdf>

Gundrilling Diameter for all spindles : 1.5mm-10mm

Maximum Drilling Stoke : 150mm

Maximum die outside diameter : 1550mm

Minimum die outside diameter : 550mm

Maximum Y axis movement : 500mm

'B' Axis full 4th accuracy : +/-_6sec

MACHINE GUARDS. All enclosing Sliding Access Perimeter Guarding and with electrical safety interlocks to workpiece and machine access opening and internal light.

PROCESS MONITORING SYSTEM & SPECIAL SOFTWARE to monitor Coolant Pressure and cutting load on spindle and feed motors with Automatic Tool Retract at pre-set trip limits and settable via MOLLART tool screen on Fanuc Control. To include:-

- Special generic program for shop floor use
- Special counter boring cycle routines
- Auto die set up
- Position Re trace for broken drills

HIGH PRESSURE COOLANT with Magnetic chip conveyor with deep bed paper filter for 20 Micron Filtration, 2 x 90 Litre Variable Delivery Coolant Pumps and valving. System Capacity : 2500 Litres.

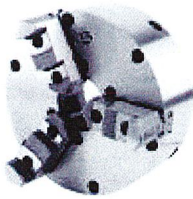
Basic Machine and Coolant System with Fixtures and Tooling at extra cost.

€ 584,112



MACHINE OPTIONS

ITEM 2. QTY 1.



800MM WORK HOLDING MANUAL CHUCK to hold components up to 700mm internal bore. Chuck jaws are quoted as separate items. To include one set of three standard base jaws to suit the 800mm chuck.

€ 10,332

Special outrigger jaws available upon request.

ITEM 3. QTY 8.

*Part. CANON
new*

BUSH HOLDERS

~~Dia. 8mm x 75mm reach~~

€ 315 each $\times 8 = 2520$

Dia. 12mm x 75mm reach

€ 315 each $\times 8 = 2520$

ITEM 4. QTY 4

*CANON
new*

DRILL BUSHES standard 8mm OD bushes to suit the above with an internal diameter 1.4 – 5mm

€ 70 each $\times 4 = 280$

DRILL BUSHES standard 12mm OD bushes to suit the above with an internal diameter 5 – 8mm

€ 35 each $\times 4 = 140$

ITEM 5. QTY 1.



OIL MIST EXTRACTOR MOUNTED TO THE MACHINE to include all necessary mounting brackets & ducting to guards.

Aspiration

€ 3,344

ITEM 6. QTY 1.



REFRIGERATED OIL COOLER recommended to maintain stable coolant temperature in long shift operation. Unit will include tank mounted heat exchanger and necessary fittings.

€ 13,679

ITEM 7. QTY 1.



OIL RECLAMATION CENTRIFUGE for recovering oil from swarf. Automatic system complete with plinth for swarf bin positioned under conveyor. Also includes conveyor extension to deposit swarf directly into the top of the unit.

€ 26,394

For and on Behalf of Mollart Limited

Ian Petitt
Sales Director

Σ 643 321

MOLLART LD8-150 8 SPINDLE
PELLET DIE DEEP HOLE DRILLING MACHINE.

Number of Spindles	: 8
Gundrilling Diameter Range	: 1.5mm - 10mm per Spindle
Maximum Drilling Depth	: 150mm
Maximum die outside diameter	: 1550mm
Minimum die outside diameter	: 500mm
'B' Axis	: Full 4th (+/- 6 sec repeatability)
'Y' Axis	: 400mm nominal
Maximum Component Dia.	: 1500mm
Spindle Nose Bore	: 10mm (Collet Type)
Control System	: GE <u>Fanuc</u> Powermate 'iH'
A.C. Spindle Motor Power	: 3.4 kW x 8 Continuous
Spindle Speed Range	: 0 – 14,000 RPM
Drill Feed Range (A.C. Infinitely Variable)	: 0 - 1000mm per minute
Rapid Traverse Speed	: 10 Metres per minute
Feed Motor Power (Stall Torque)	: 6 Nm
Floor Area of Machine	: 4500 x 4500mm
Weight of Machine	: 15000 Kg
Electrical Supply	: 400 Volts, 3 Ph, 50 Hertz. (European Market) : 460Volts, 3 Ph, 60 Hertz (American Market)
Control Voltage	: 24 Volts DC
Rated Supply Current	: 120 Amps

TERMS AND CONDITIONS

DELIVERY

10 Months, Ex works from our Acknowledgment of Order and subject to prior orders.

CONDITIONS OF SALE

Mollart standard terms and conditions of sale enclosed with this quotation form part of this offer.

PAYMENT TERMS

30% on our Acknowledgment of Order.

60% on Machine Acceptance in our works and prior to delivery.

10% on Machine Acceptance in your works or one month after delivery whichever is the earlier.

If the customer fails to accept delivery on the due date they shall nevertheless make any payment conditional on delivery as if the goods had been delivered.

MACHINE COLOURS

Mollart standard colours are Light Grey base & Guards RAL 7035, with Blue opening Guards RAL 5005

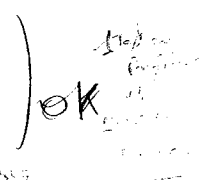
CARRIAGE

Plus insurance to be at additional cost.

IMPORT DUTY AND LOCAL TAXES

Import duty and local taxes are the responsibility of the customer.) 

ACCEPTANCE

Mollart to demonstrate the machine with our standard cutting test. Customers own cutting tests can be offered by prior arrangement. 

COMMISSIONING

Prices include for the services of our Engineer for a period of 10 days for Installation and Operator Training in your works. This is after the machine has been positioned and all necessary services connected by the customer. Additional time required by the customer will be charged at our daily rate of £ 440 per 8 hr day plus travel and hotel expenses at cost will be applicable.

MACHINE SPECIFICATIONS

May change at any time without prior notice.

VALIDITY

This Quotation is valid for acceptance for a period of 60 days, after which time we reserve the right to submit a revised quotation in respect of price and/or delivery.

PRICES

Mollart Engineering Ltd will offer a Fixed prices in EUROS for duration of Contract for delivery stated on our Acknowledgment of order but may be subject to variation in the event of an extension to delivery caused other than directly by Mollart Engineering Ltd. The rate of Exchange between the EURO will be confirmed and agreed at the time of order.

CONFIRMATION OF ORDER

No order shall constitute a Contract until its acceptance in writing by Mollart Engineering Ltd. No orders can be cancelled without Mollart Engineering Ltd., written consent and it is an implied condition of such cancellation that the purchaser shall indemnify Mollart Engineering Ltd., against all loss and expense incurred on the Contract.

ORDER PLACEMENT

TO : Mollart Engineering Limited,
Roebuck Road,
Chessington,
Surrey. KT9 1LR.
England

OUR BANK DETAILS

HSBC Bank PLC
54 Clarence Street
Kingston Upon Thames
Surrey
England
KT1 1NP

Sort Code: 40 05 15
Account No: 59103218
IBAN: GB77MIDL40051559103218
SWIFT Code:- MIDLGB22

MOLLART V.A.T. NUMBER

VAT No. GB 391 5679 13

WARRANTY

Machine is guaranteed for 12 months against faulty materials and workmanship from date of final machine acceptance in your works, or 15 months from the date of Shipment, whichever is the earlier. The Warranty does not cover damage to machine or associated equipment caused by operator error or misuse of the machine.

APPENDIX 'A'
PRODUCTION STUDY FOR PART:- Z0143_47

STUDY FOR THROUGH HOLE DRILLING ONLY @ 5.2mm DIAMETER

PRODUCTION STUDY FOR PROMILL STOLZ	
DRAWING No:-	Z0143_47
DIAMETER FOR DRILLING IN MM	5.2
REQUESTED NUMBER OF HOLES PER ROW	276
NUMBER OF ROWS PER DIE	30
ACTUAL NUMBER OF HOLES PER ROW TO BE DIVISIBLE BY 16 IS EITHER 272 OR 288	272
DIE THICKNESS IN MM	100
MATERIAL	NORMAL PELLET DIE STEEL
TOTAL NUMBER OF HOLES	8160
FEED RATE PER MIN APPLIED IN MM /MIN	100
TOTAL CYCLE TIME FOR DIE IN HRS	18.842

N.B ALL TIMES ARE @ 100% EFFICIENCY

of 856565