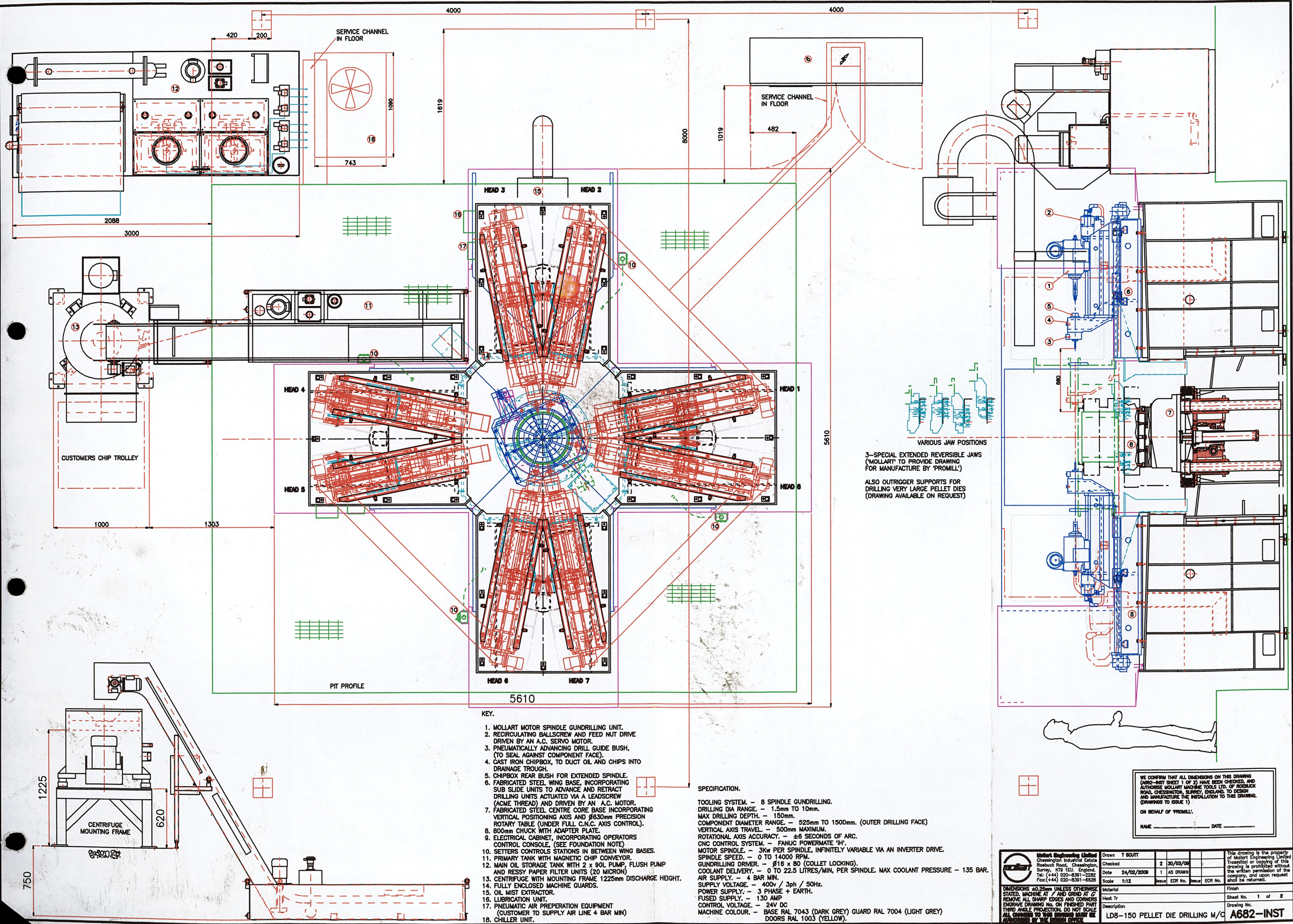




KEY.

1. MOLLART MOTOR SPINDLE GUNDRILLING UNIT.
2. RECIRCULATING BALLSCREW AND FEED NUT DRIVE DRIVEN BY AN A.C. SERVO MOTOR.
3. PNEUMATICALLY ADVANCING DRILL GUIDE BUSH, (TO SEAL AGAINST COMPONENT FACE).
4. CAST IRON CHIPBOX, TO DUCT OIL AND CHIPS INTO DRAINAGE TROUGH.
5. CHIPBOX REAR BUSH FOR EXTENDED SPINDLE.
6. FABRICATED STEEL WING BASE, INCORPORATING SUB SLIDE UNITS TO ADVANCE AND RETRACT DRILLING UNITS ACTUATED VIA A LEADScrew (ACME THREAD) AND DRIVEN BY AN A.C. MOTOR.
7. FABRICATED STEEL CENTRE CORE BASE INCORPORATING VERTICAL POSITIONING AXIS AND 630mm PRECISION ROTARY TABLE (UNDER FULL C.N.C. AXIS CONTROL).
8. 800mm CHUCK WITH ADAPTER PLATE.
9. ELECTRICAL CABINET, INCORPORATING OPERATORS CONTROL CONSOLE. (SEE FOUNDATION NOTE).
10. SETTERS CONTROLS STATIONS IN BETWEEN WING BASES.
11. PRIMARY TANK WITH MAGNETIC CHIP CONVEYOR.
12. MAIN OIL STORAGE TANK WITH 2 x 90L PUMP, FLUSH PUMP AND RESSY PAPER FILTER UNITS (20 MICRON).
13. CENTRIFUGE WITH MOUNTING FRAME 1225mm DISCHARGE HEIGHT.
14. FULLY ENCLOSED MACHINE GUARDS.
15. OIL MIST EXTRACTOR.
16. LUBRICATION UNIT.
17. PNEUMATIC AIR PREPERATION EQUIPMENT (CUSTOMER TO SUPPLY AIR LINE 4 BAR MIN).
18. CHILLER UNIT.

SPECIFICATION.

TOOLING SYSTEM. - 8 SPINDLE GUNDRILLING.
DRILLING DIA RANGE. - 1.5mm to 10mm.
MAX DRILLING DEPTH. - 150mm.
COMPONENT DIAMETER RANGE. - 525mm to 1500mm. (OUTER DRILLING FACE)
VERTICAL AXIS TRAVEL. - 500mm MAXIMUM.
ROTATIONAL AXIS ACCURACY. - ± 6 SECONDS OF ARC.
CNC CONTROL SYSTEM. - FANUC POWERMATE 'H'.
MOTOR SPINDLE. - 3Kw PER SPINDLE, INFINITELY VARIABLE VIA AN INVERTER DRIVE.
SPINDLE SPEED. - 0 TO 14000 RPM.
GUNDRILLING DRIVER. - $\phi 16 \times 80$ (COLLET LOCKING).
COOLANT DELIVERY. - 0 TO 22.5 LITRES/MIN, PER SPINDLE. MAX COOLANT PRESSURE - 135 BAR.
AIR SUPPLY. - 4 BAR MIN.
SUPPLY VOLTAGE. - 400v / 3ph / 50Hz.
POWER SUPPLY. - 3 PHASE + EARTH.
FUSED SUPPLY. - 130 AMP.
CONTROL VOLTAGE. - 24V DC.
MACHINE COLOUR. - BASE RAL 7043 (DARK GREY) GUARD RAL 7004 (LIGHT GREY) DOORS RAL 1003 (YELLOW).

WE CONFIRM THAT ALL DIMENSIONS ON THIS DRAWING (BASED ON SHEET 1 OF 2) HAVE BEEN CHECKED, AND AUTHORIZED MOLLART MACHINE TOOLS LTD. OF ROEBUCK ROAD, CHESSINGTON, SURREY, ENGLAND, TO DESIGN AND MANUFACTURE THE INSTALLATION TO THIS DRAWING. (DRAWINGS TO ISSUE 1)

ON BEHALF OF PROMILL:

NAME _____ DATE _____

	Mollart Engineering Limited Cheshington Industrial Estate Roebuck Road, Chessington, Surrey, KT9 1EU, England. Tel: (+44) 020-8361-2282 Fax: (+44) 020-8361-6628		Drawn	T SCUTT				This drawing is the property of Mollart Engineering Limited. Transmittal or copying of this drawing is prohibited without the written permission of the company, and upon request shall be returned.
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	Date	24/02/2008		1	AS DRAWN			
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DIMENSIONS ± 0.25 mm UNLESS OTHERWISE STATED. MACHINE AT / AND GRIND AT / REMOVE ALL SHARP EDGES AND CORNERS ENGRAVE DRAWING NO. ON FINISHED PART THIRD ANGLE PROJECTION. DO NOT SCALE ALL CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGN OFFICE			Material				Finish	
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