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Ref. No.:

837-0915800

## **Overview and Technical Data:**

# **NAGEL - 2VS10-60 SV-NC vertical dual Honing Machine**

**[NAGEL](#)**



NNA

Year of Build:

Jan 2005

## Description:

### Used NADEL 2 VS 10 - 60 SV - NC vertical honing machine

Machine with two Honspindeln for machining 6-Zylinderblocks

CNC control: Siemens SPS S7 + NAGEL spindle control unit MS U3

#### Technical specifications:

- Spindle RPM 40 - 300
- Max Hydraulic Stroke length: 20 - 600 mm
- Lift speed: up to 25 m / min stepless
- Tool connection cylindrical
- Spindle speed 80 - 400 rpm infinitely variable
- Hydraulic tank capacity 800l
- Rotary drive 2x 5.5 kW = 11 KW
- Air metering device
- Total connection 48kW
- Machine height 4700 mm

Machine output: 8 workpieces / h at 100% utilization

Rareness 0.008 mm

Bore tolerance 105,000 - 105 025 mm

Surface Rz 5 ?m

Honing time 400 sec

Off time 50 sec.

Cycle time 450 sec.

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Nagel builds both conventional stroke honing machines as well as single pass "precidor" honing systems. Proper honing technology is selected based on the part. Every machine is custom designed specifically for the application by utilizing proven subsystems.

High Volume Production Honing Systems are fully automated and require very little operator intervention. Some of the features of the equipment include:

- Post process gauging after every honing station, integrated to tool wear compensation system
- Servo controlled mechanical tool expansion and wear compensation system for high stock removal and bore accuracy
- Hydraulic tool expansion and wear compensation system for fine surface finishes
- Hydraulic / Servo controlled oscillation system
- Servo driven precision spindle
- Automatic tool changer (optional)
- Centralized lubrication system with reservoir level and dirty filter monitoring
- Hydraulics system with flow and dirty filter monitoring
- Pneumatic line pressure monitoring, system shuts system off if the pressure drops below the limit
- Centralized coolant system with coolant flow, level and dirty filter monitoring and optional coolant level compensation system
- Automatic part transfer from station to station and complete integration into customer automation
- SPC capabilities
- PLC control with Windows based HMI
- Incorporation of other secondary operations such as part marking and final gauging

## Technical Data:

## **Technical Data:**

Control:

[SIMATIC S7](#)

## **Buyer Information:**

Condition:

[Very good condition](#)

Available:

[Sold](#)

Sold as:

[EXW \(Ex Works - Incoterm\)](#)

VAT:

[19 %](#)

Buyers Premium:

[16 %](#)

Location:

Germany

## **Images:**



1





3





5















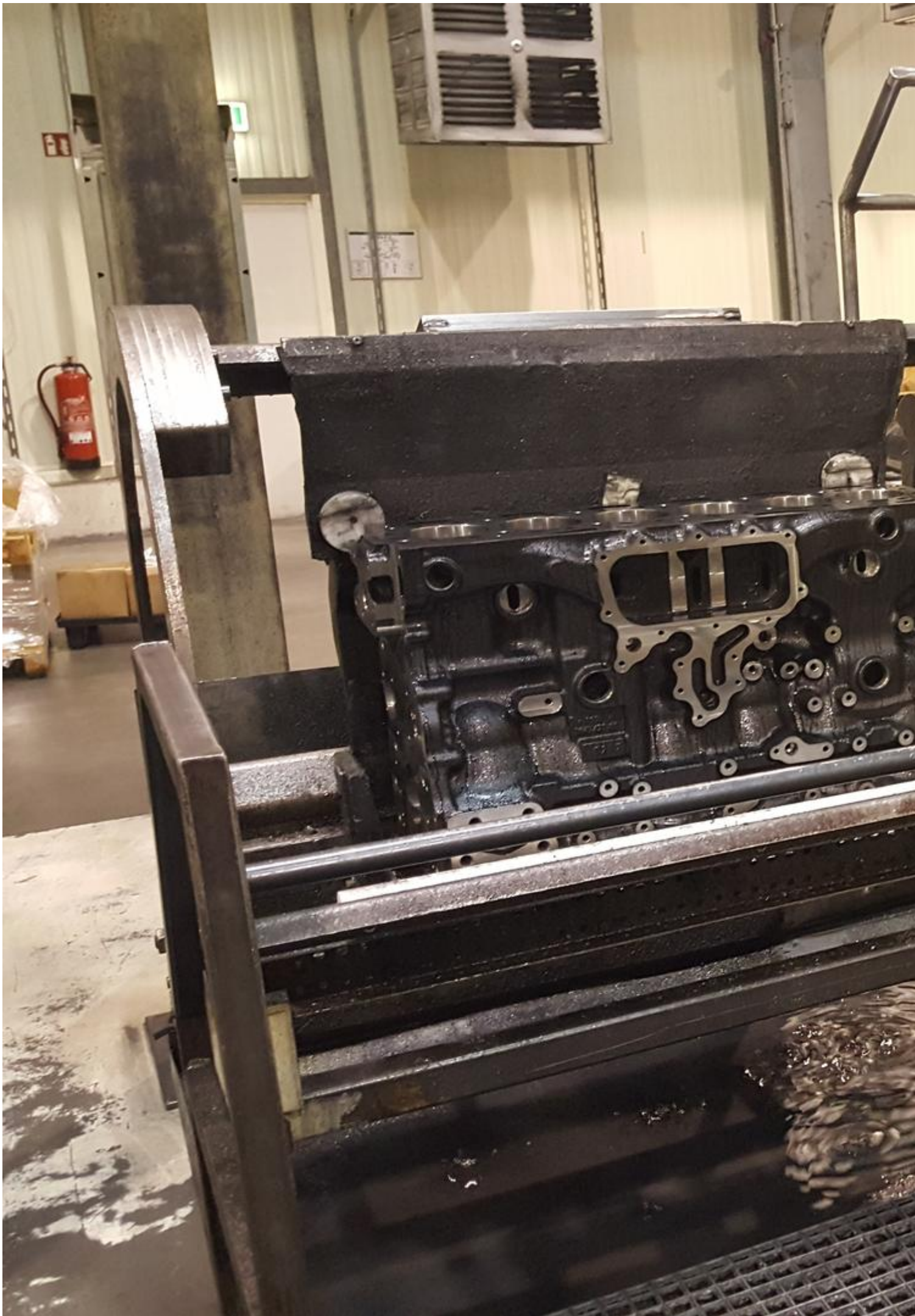




















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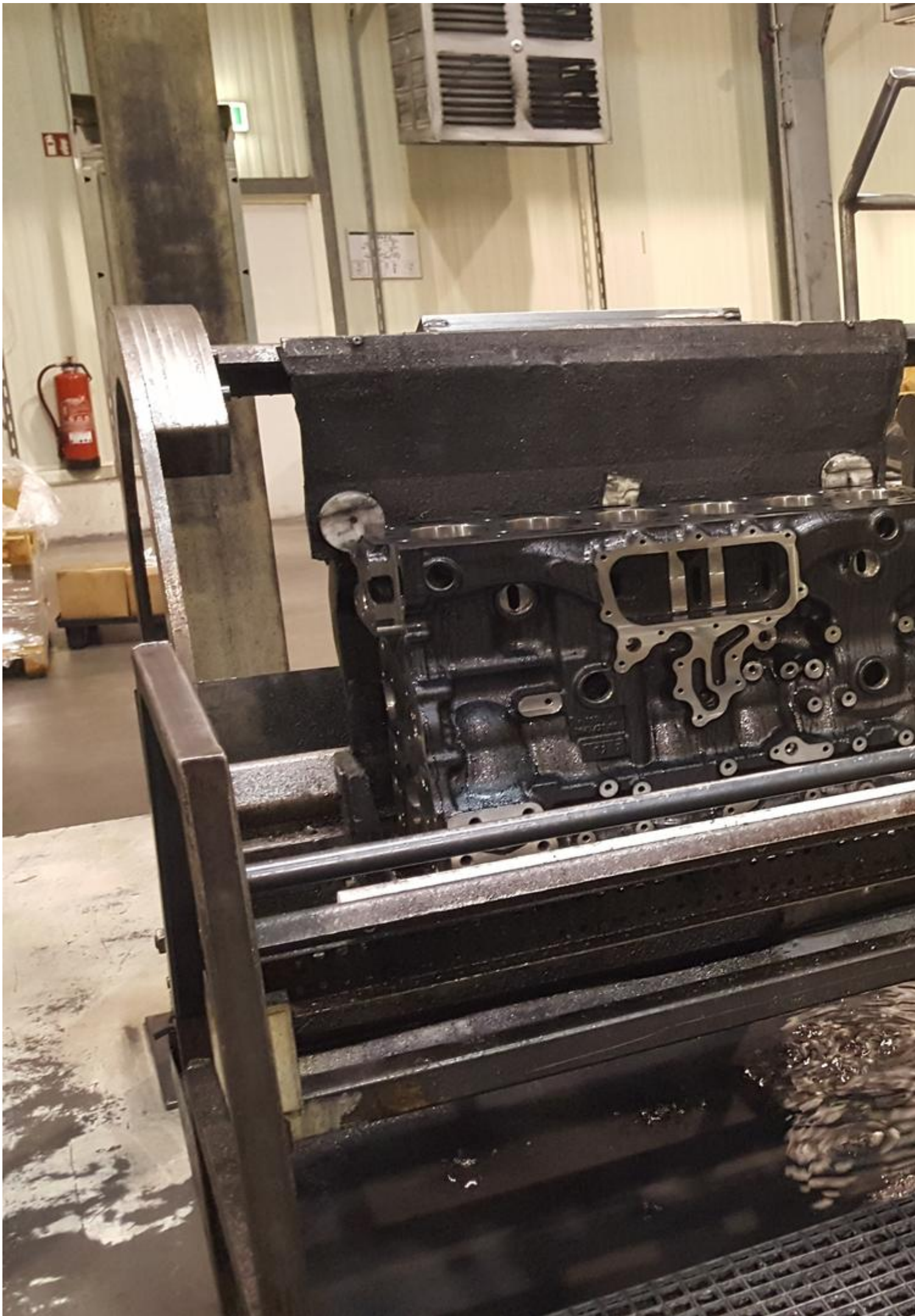






















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