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Ref. No.:

1524-06131824

### **Overview and Technical Data:**

## **Used Wheel Rim Production Line by Leifeld & Ideal – Model Leifeld TF 650**

**LEIFELD**



Year of Build:  
Jan 1992

## Description:

# Used Wheel Rim Production Line by Leifeld & Ideal – Model Leifeld TF 650

For sale is another complete production line for manufacturing steel wheel rims, centered around a Leifeld shrinking and expanding machine (Type TF 650 CNC). The line is complemented by a fully equipped welding cell from Ideal and all necessary peripheral systems. Thanks to detailed documentation, including the original machine data card, the line is precisely specified and perfectly suited for steel wheel rim producers.

This production line offers a proven and robust configuration to cover the entire manufacturing process, from sheet metal infeed to the finished wheel rim.

Used Leifeld wheel rim production line (TF 650) with Ideal welding system for sale. Complete production line for steel wheels, incl. bending machine & deburring unit.

## Highlights of the Line

- Core Component:** The renowned **Leifeld TF 650 CNC** shrinking and expanding machine (YOM 1992).
- Complete Welding Cell:** Including an **Ideal Welding System (AS220AF)** and an **Ideal Weld Seam Deburring Machine (EV0500)**.
- Comprehensive Peripherals:** With a sheet metal loading station, bending machine, hydraulic power units, and a weld fume extractor.
- Well-Documented:** Original machine data card and technical documents are available.
- Includes Workstation:** Comes with workshop equipment, a PC terminal, and a printer.

## Detailed Technical Specifications

Component	Manufacturer	Type/Description	Year of Mfg. (YOM)	Technical Data/Notes
Main Machine	Leifeld	Automatic Rim Shrinking & Expanding Machine <b>TF 650 CNC</b>	1992	Workpiece inner Ø: 300 mm, max. sheet thickness: 2.5 mm, clamping force: 70/40 t, connected load: 45 kW, control: Electro-hydraulic
Sheet Metal Loading Station	Systematic	AW12	1991	For infeed of raw material
Bending Machine	Unknown	4-Roll Bending Machine with handling system	Unknown	-
Rim Welding System	Ideal	AS220AF	1991	S/N 213023, for welding the rim shells

Component	Manufacturer	Type/Description	Year of Mfg. (YOM)	Technical Data/Notes
<b>Weld Seam Deburring</b>	Ideal	EV0500	1991	S/N 213024, for finishing the weld seam
<b>Weld Fume Extractor</b>	Keller	Uni-Star-XG	1988	S/N 88/5613
<b>Hydraulic Press</b>	Import (Russia)	PYXE25S	> 35 years	Max. pressing force 25 t
<b>Hydraulic Power Unit 1</b>	Wertenbach	-	1997	-
<b>Hydraulic Power Unit 2</b>	-	-	-	Capacity 250 L of oil
<b>Workshop Equipment</b>	Garant	Drawer Cabinet with 7 drawers	-	-
<b>Office/IT Equipment</b>	Hewlett Packard	Laser Printer LaserJet Pro 400 M401DNE	-	Incl. work terminal with keyboard, mouse, RM barcode scanner

For further technical details, documentation, or to schedule an inspection, please do not hesitate to contact us.

This wheel rim production line represents an excellent opportunity to acquire a proven and comprehensive manufacturing capacity.

## Technical Data:

### Technical Data:

Control:

[CNC](#)

### Buyer Information:

Condition:

[Normal wear](#)

Available:

[Sold](#)

Sold as:

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

VAT:

[19 %](#)

Buyers Premium:

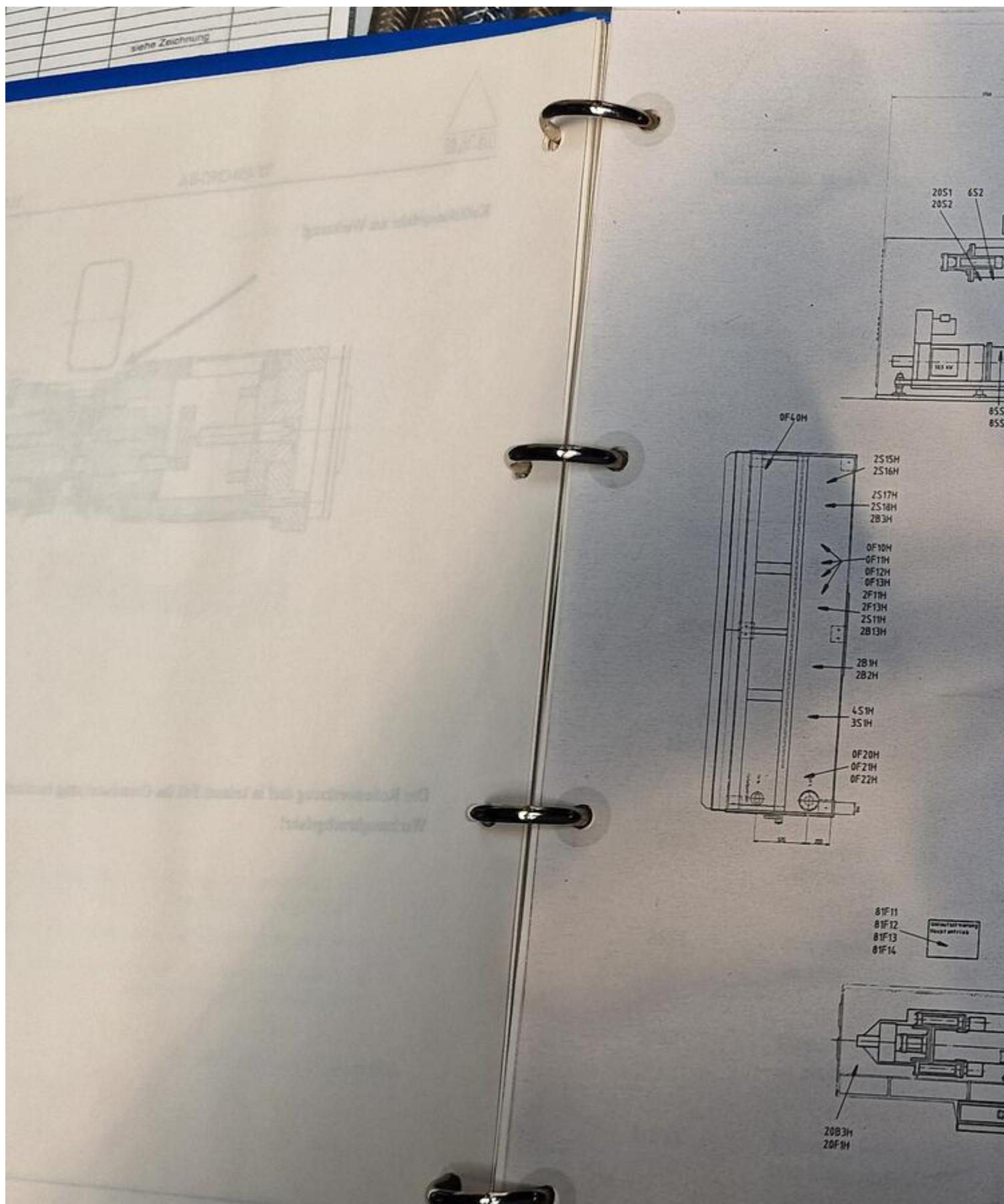
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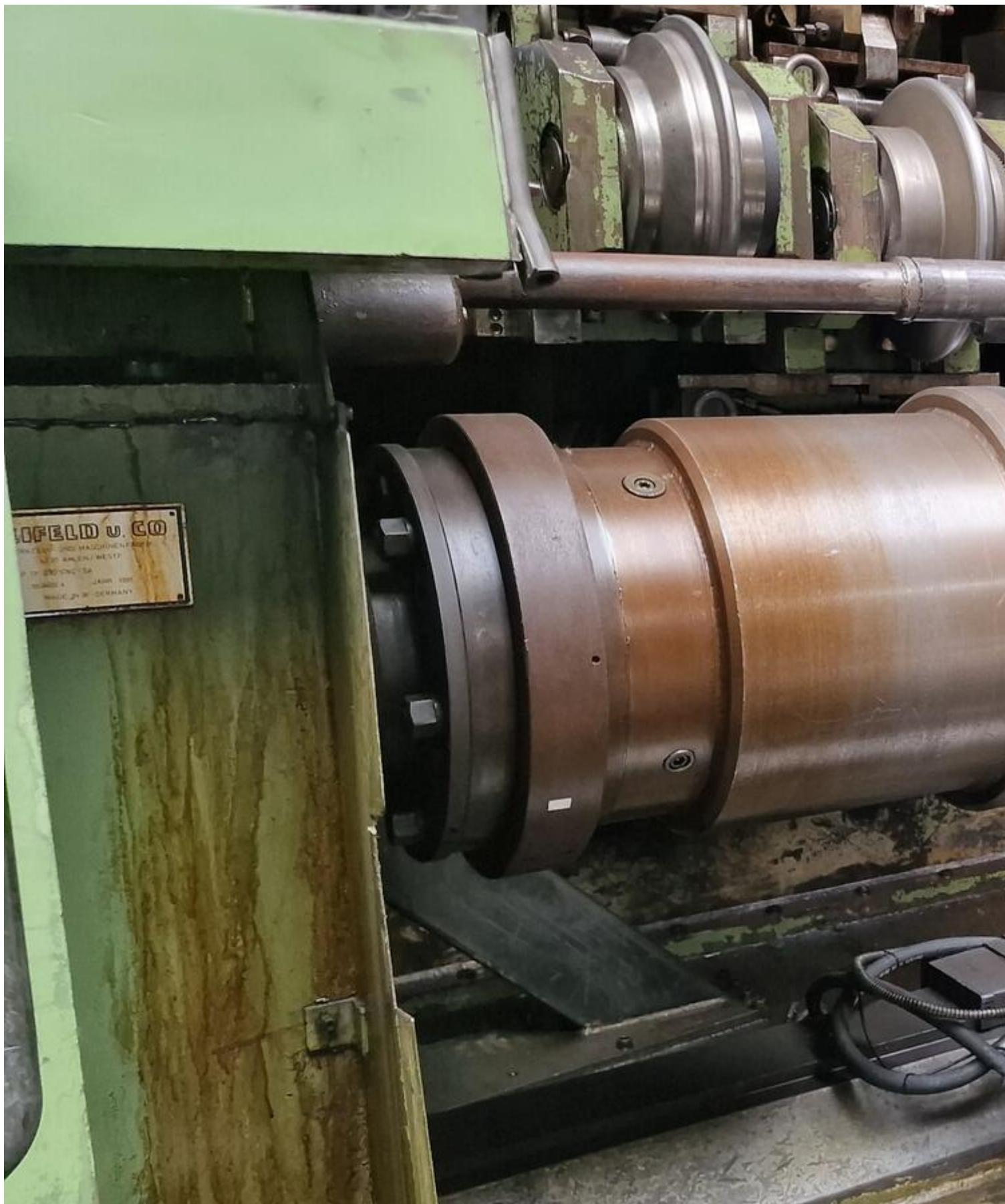
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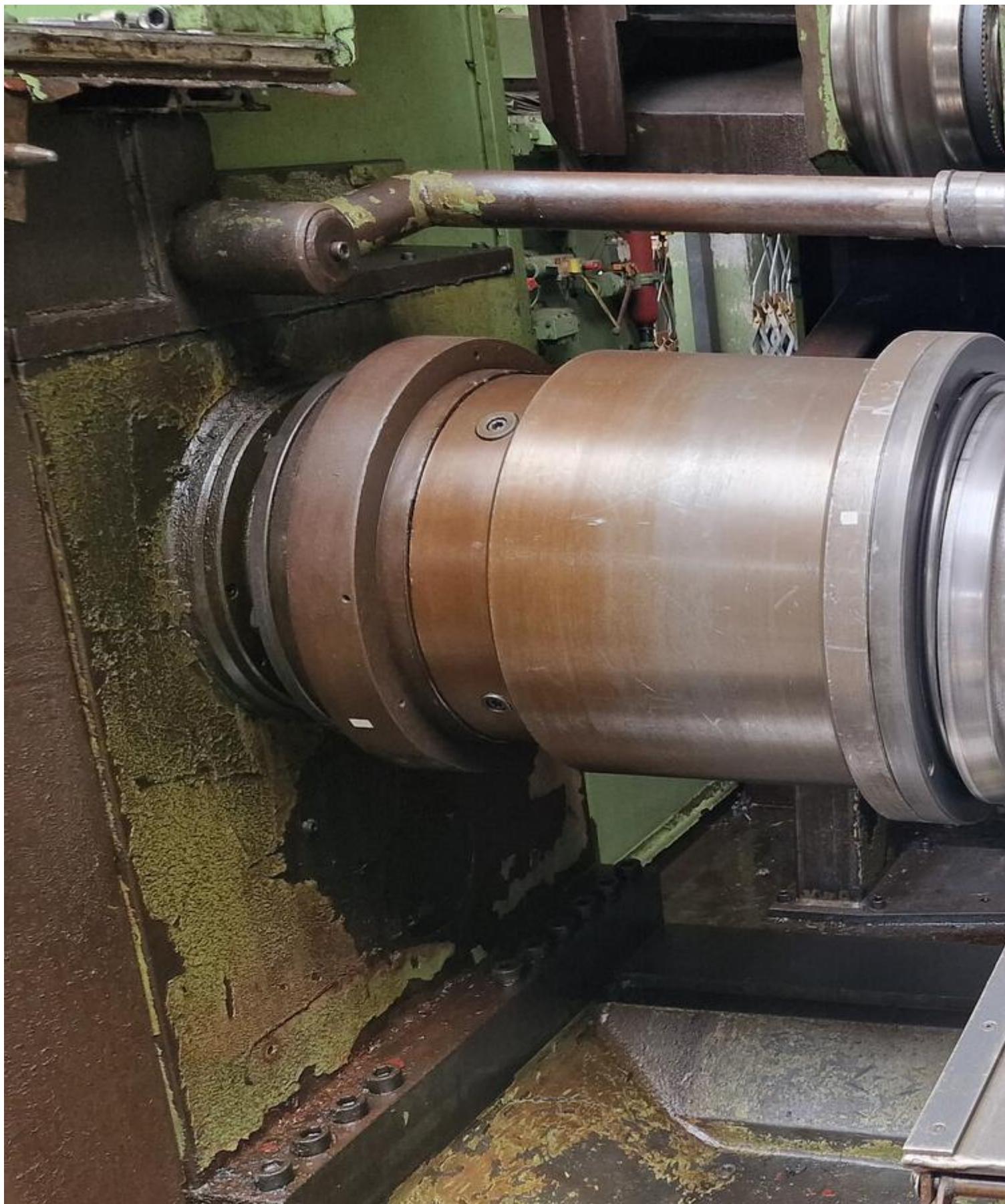
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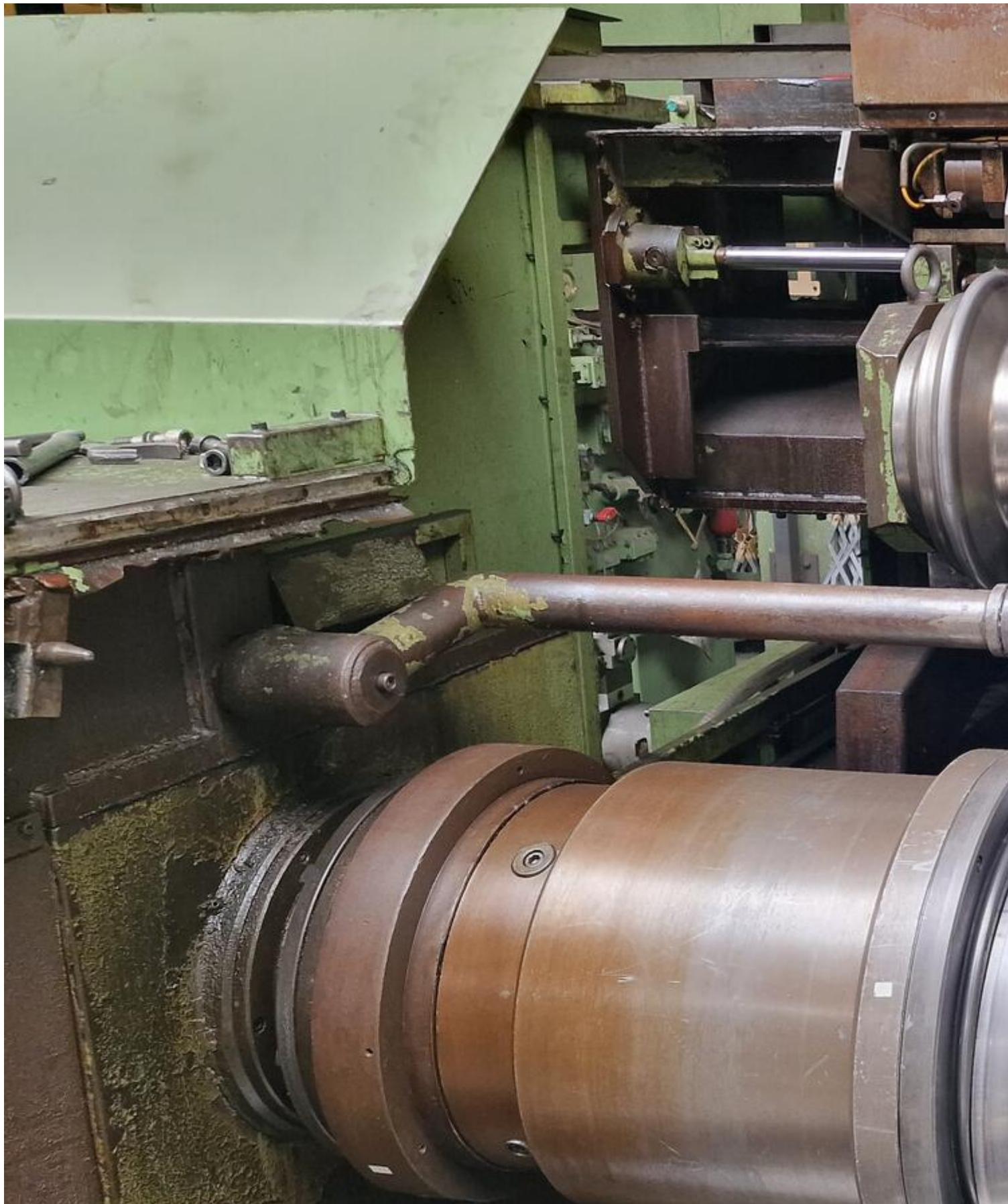
### Images:





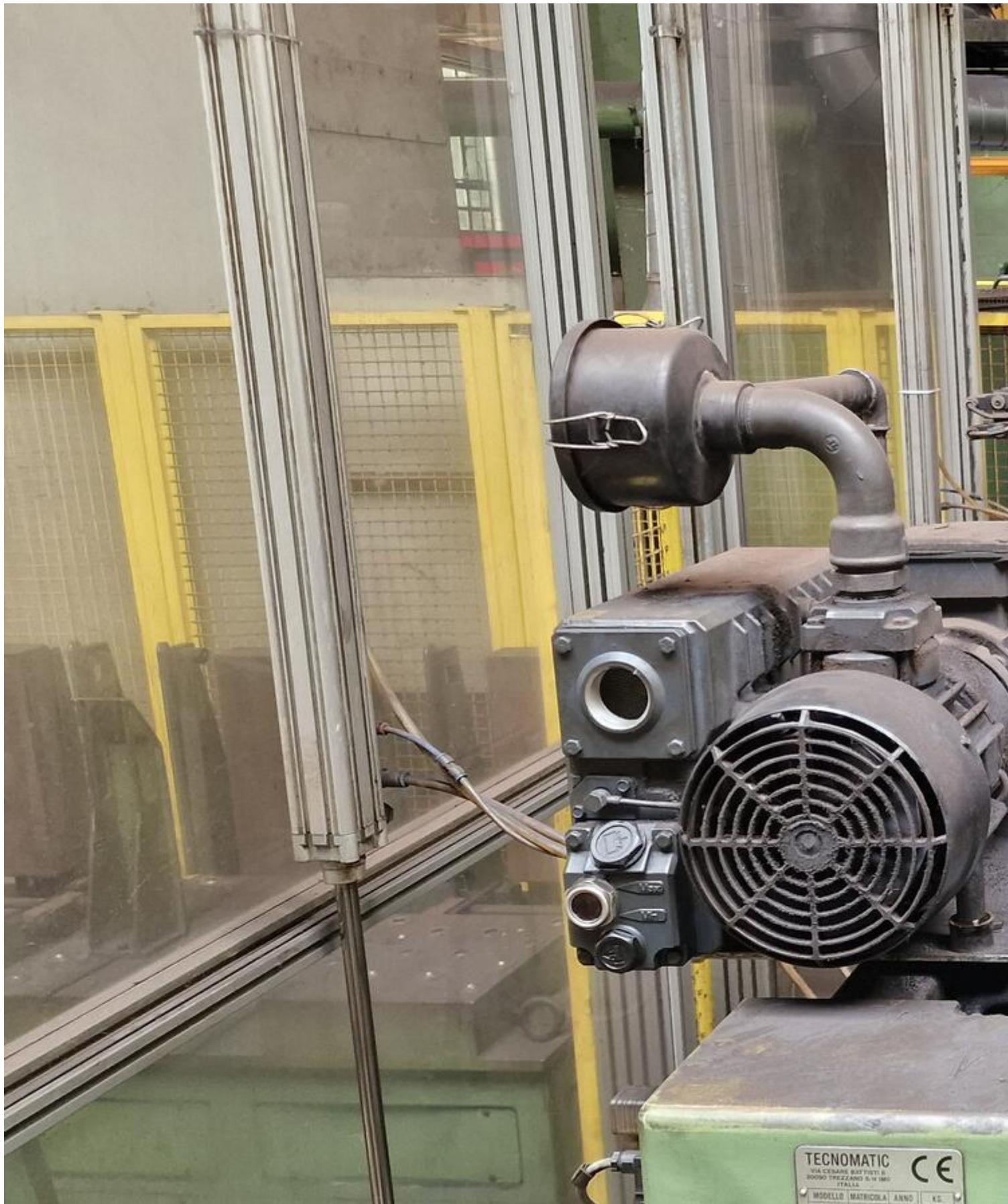














8 Kurzzeichen nach AWF 310		AWF® Werkzeugmaschinenkarte für TF 650 CNC - EA																		Maschinenkarte				
Grundzeichen		FISCHBACHER																		Maschinenkarte				
G Bezeichnung		G Baujahr																		G Kostenstelle				
G Typ	G Bezeichnung	G Baujahr	G Liefer-Tag	G Masch.-Gruppe	G Bestell-Nr. Täg: 29.11.90																			
G Hersteller	TF 650 CNC - EA	10.3482.4	G Liefer-Nr.	G Internes Kennzeichen																				
G Leiter	Leifeld u. Co.,	4730 Ahlen /Westf.	G Innenleben.	G Standort	G Anschaffungskosten																			
Technische Daten		G Zubehör/Sondereinrichtungen																		Besonders geeignet für				
Einsatzbereich:		4 hydraulische Rollen- Tiefbettfelgenringen in Antriebe																		die Herstellung von Tiefbettfelgenringen in einer Aufspannung				
Werkstückinnendurchmesser min.		300 mm																						
Werkstückinnendurchmesser max.		571,5 mm																						
Maulweite der Felgenringe min.		1 Transporteinrichtung																						
Maulweite der Felgenringe max.		75 mm																						
max. umzuformende Materialdicke bezogen auf		4 fach Werkzeugmagazin																						
Steuerung		Kombinierte PNC/CNC-																						
STM22:		Steuerung																						
- bei Tiefbettfelgenringfertigung		6,5 mm																						
- bei Schrägschulterfelgenringfertigung		7,0 mm																						
- bei Drückarbeiten aus der Ronde		12,0 mm																						
max. Umlauf-Durchmesser		1 200 mm																						
Spitzenhöhe der Maschine		700 mm																						
Maschinenbreite		4 820 mm																						
Spitzenweite		1 900 mm																						
Ausstoßberührt		Ausstoßberührungsplan 50 005 601 16 02 - 0																						
Spindelkastenseitig		70/400 mm																						
Ausstoßberührt		1 250 mm																						

# TECHNISCHE ÜBERWACHUNGS-VEREIN BAYERN e.V.

## Bezeichnung

**Certifikat / Certificate / Certificato / Certificado**  
Ihre die Einheitung von Sicherheitsventilen

Auf Wunsch der Firma **Mannesmann Rexroth GmbH, 87770 Lahr/Main**, wurden  
mit dem Prototyp der oben genannten Firma nachstehend bezeichnete  
Sicherheitsventile mit Hydraulik von dem Unterzeichneten eingestellt:

A solicitud de la sociedad  
Mannesmann Rexroth GmbH,  
D-8770 Lahr/Main,  
son ajustadas este dia sobre el  
banco de prueba de la firma  
arriba mencionada y utilizando  
aceite hidráulico las válvulas de  
seguridad por el infrasigno:

Se adjunta della ditta  
Mannesmann Rexroth GmbH,  
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de prueba de la firma  
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vole di sicurezza con olio oleodi-  
namico tirando il scatoscritto:  
di cui si fa constato.

**Mannesmann Rexroth GmbH**

**Handstempel**



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Assessment and Sale of Used Assets world wide

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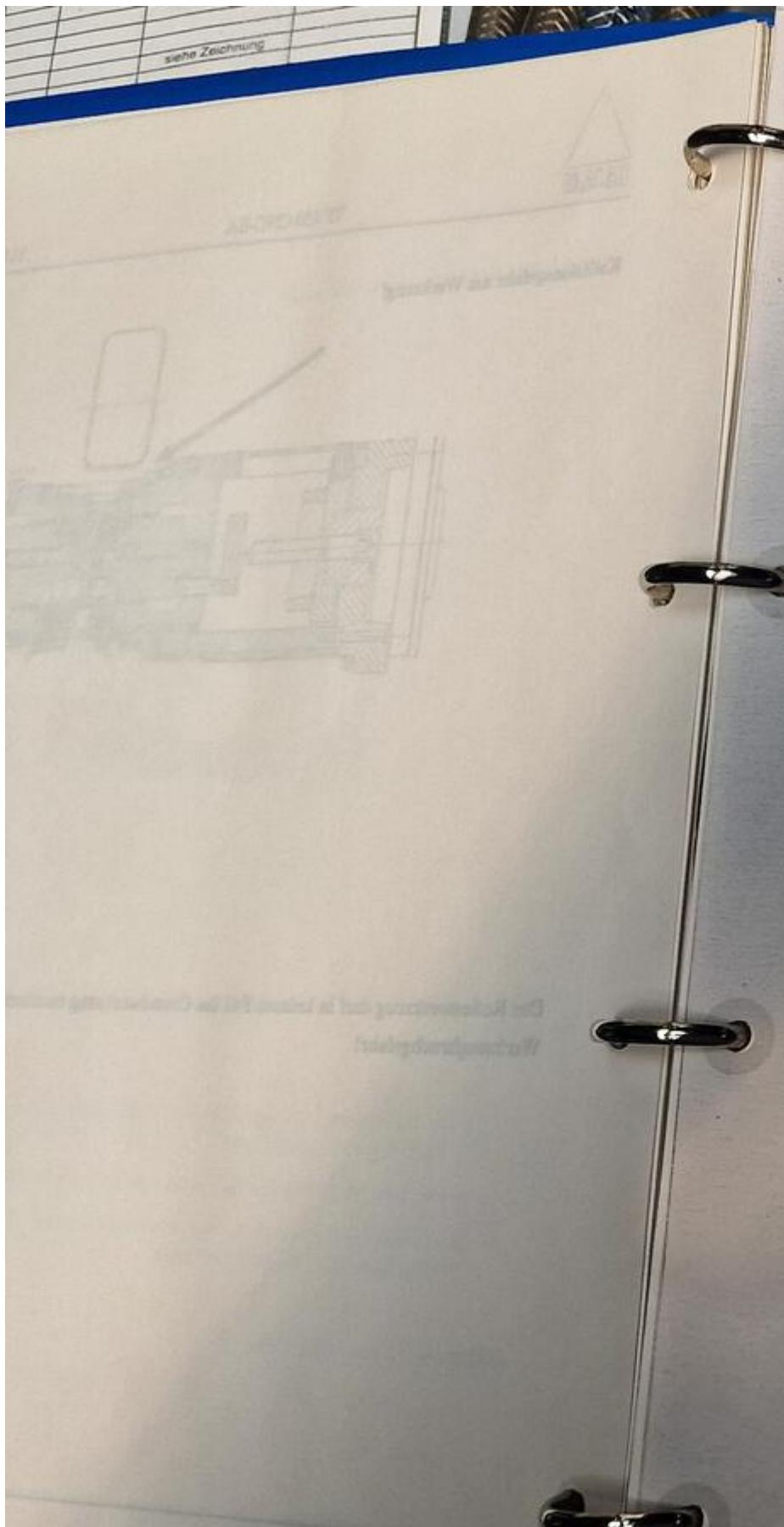
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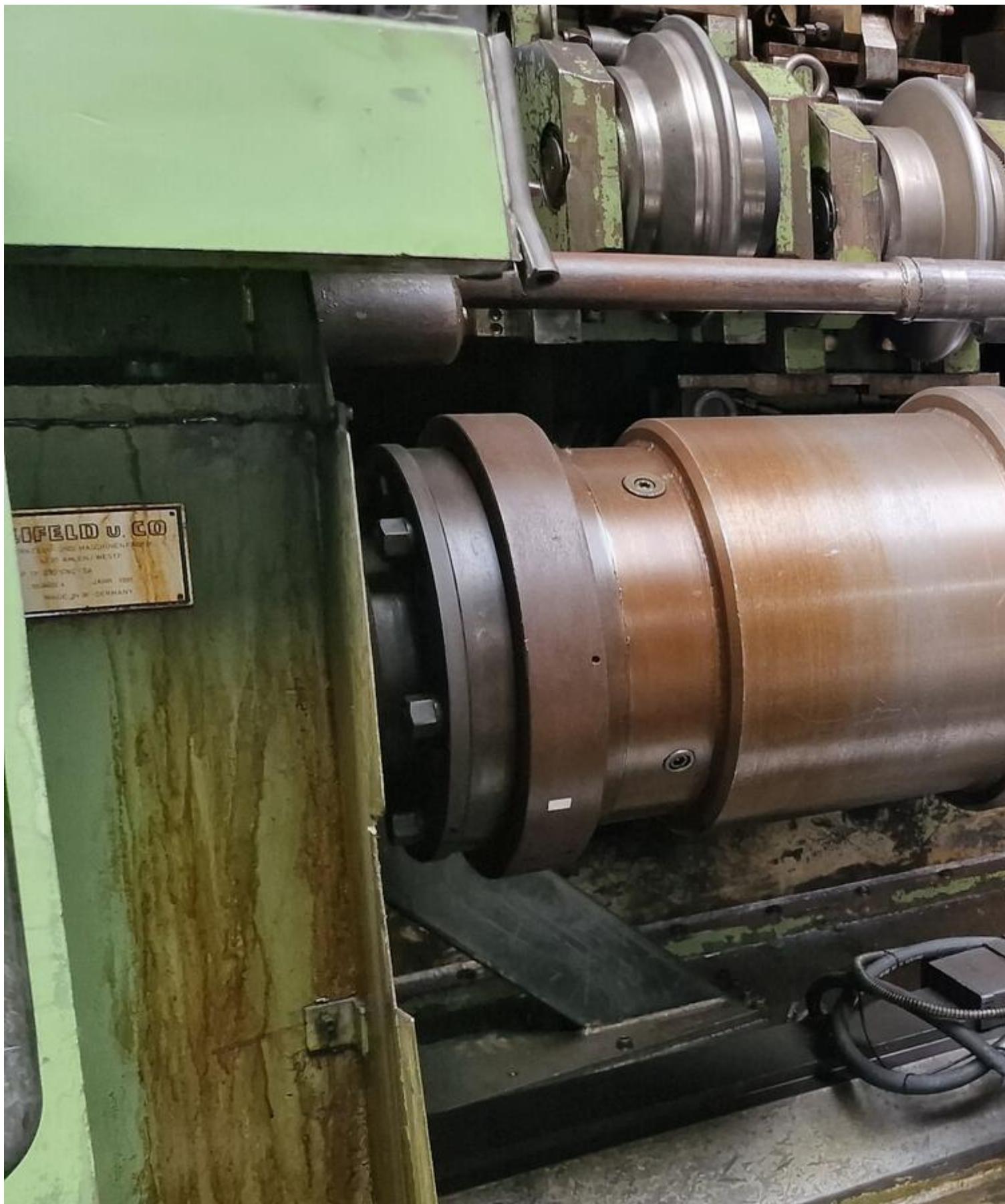
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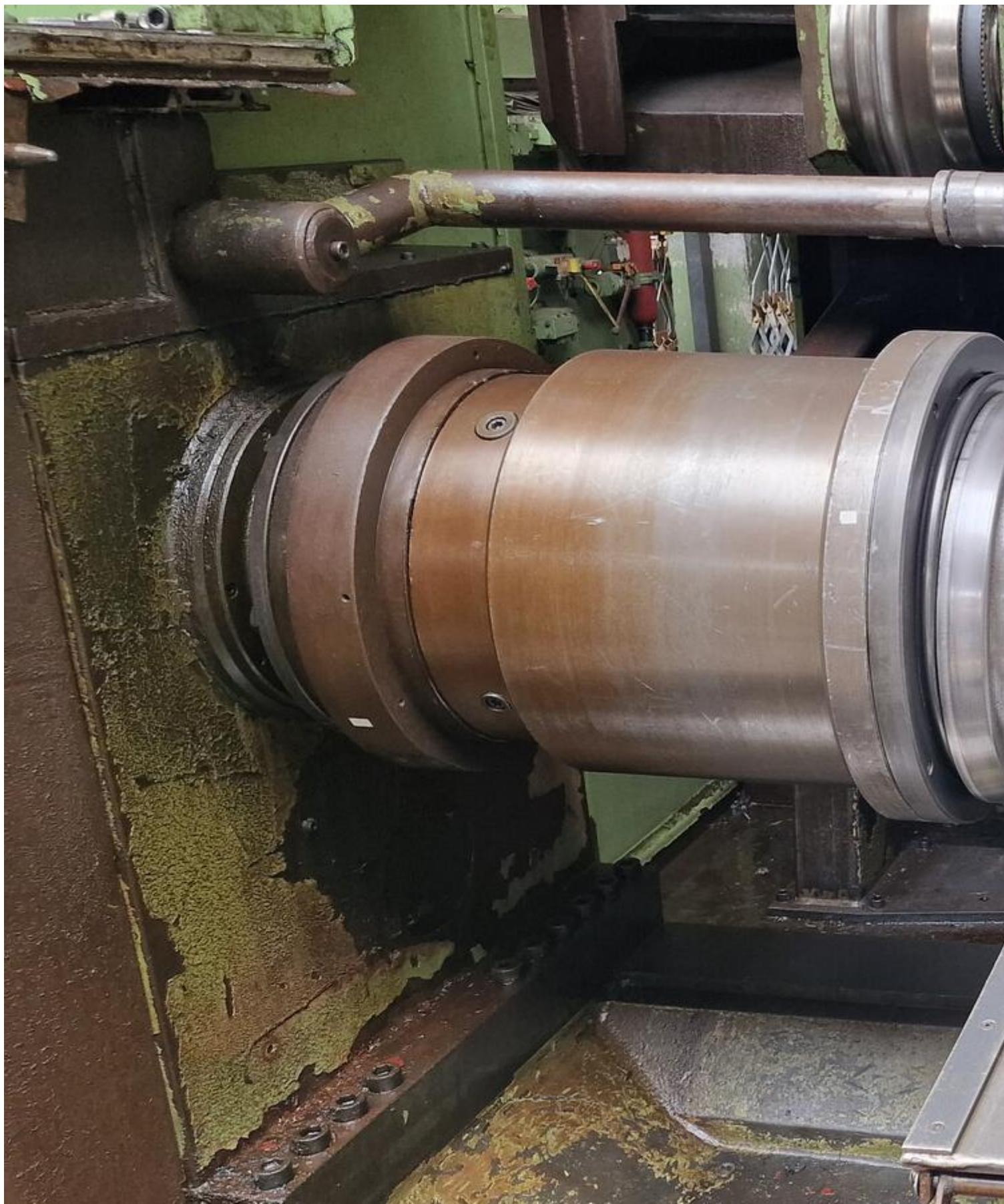
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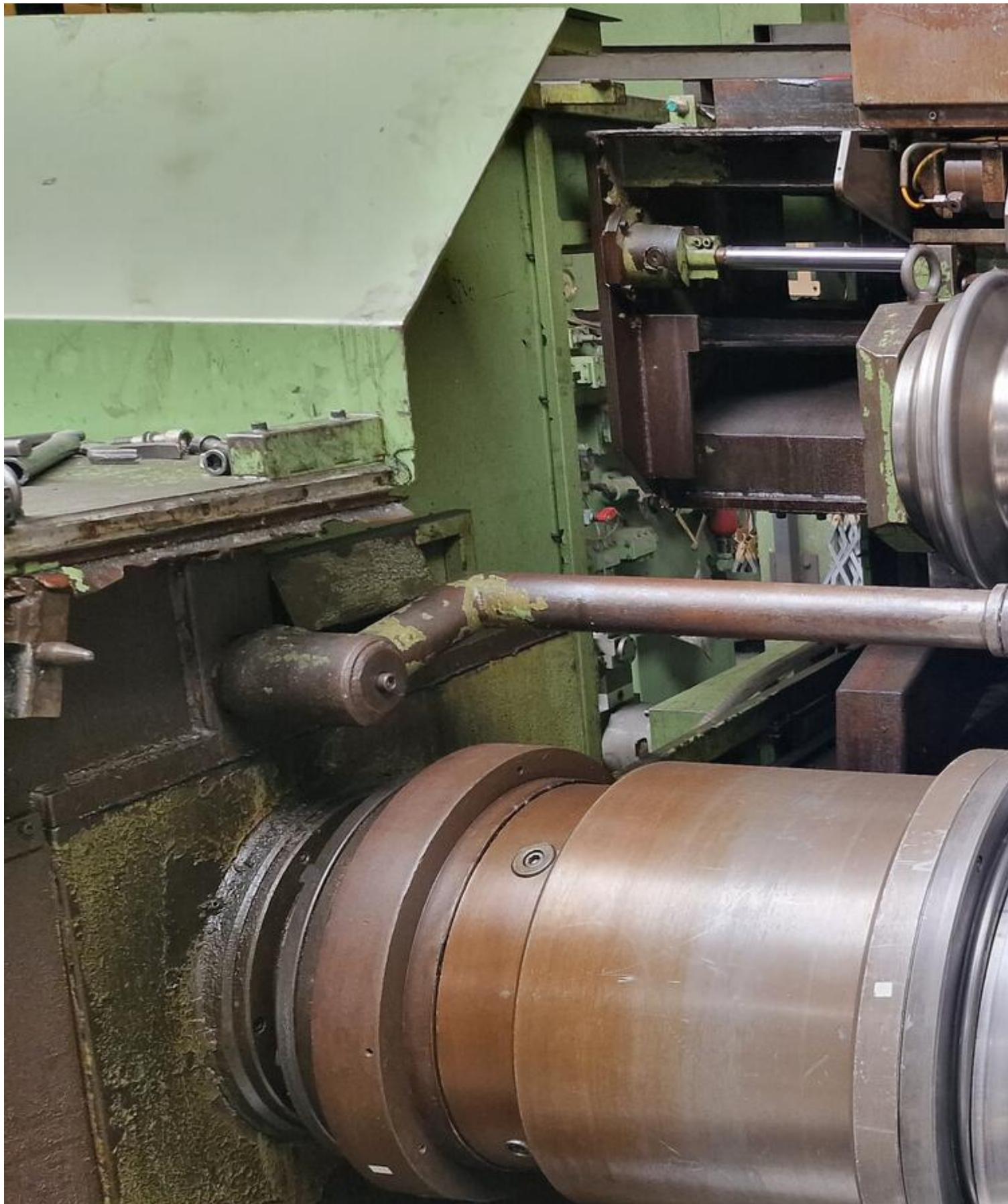
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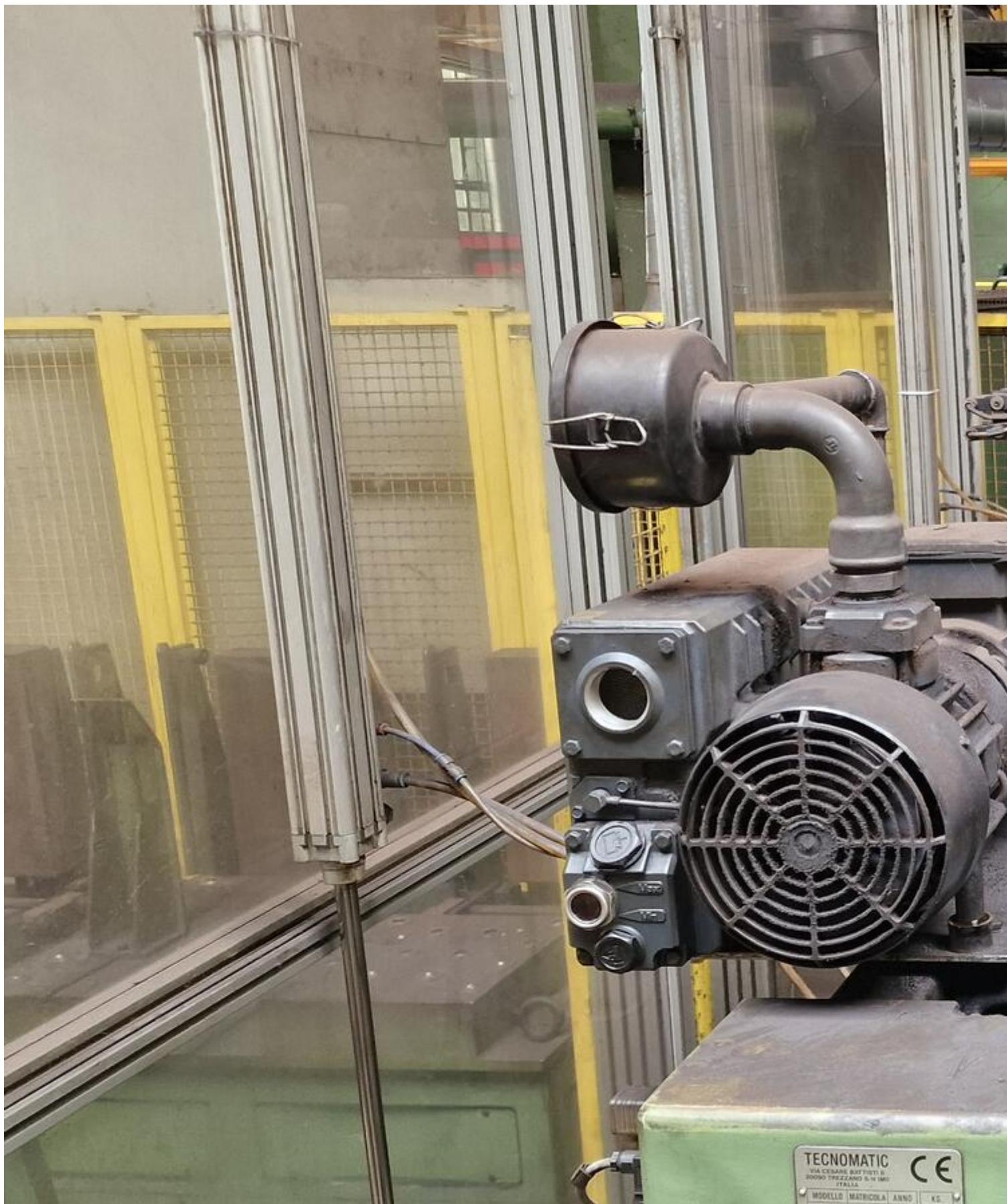














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G Bezeichnung		Aut. Felgen-Einzieh- u. Aufweitmaschine																		Bestell-Nr.				
G Typ	TF 650 CNC - EA	G Baujahr 1991																		Bestell-Nr.				
G Hersteller	Leifeld u. Co.,	10.3482.4	G Liefer-Tag	30.06.92	G Masch.-Gruppe																			
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