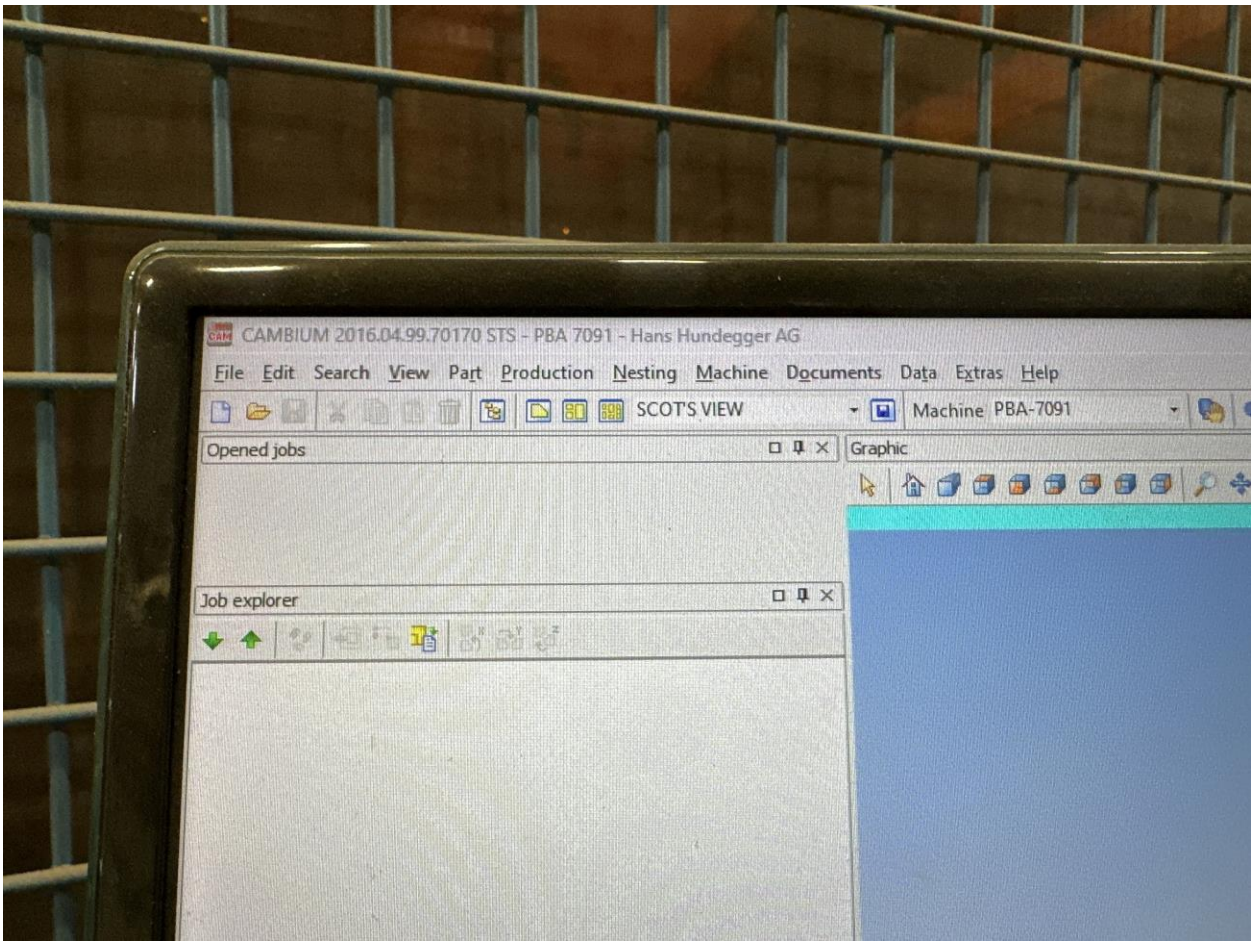
Overall view of the machine

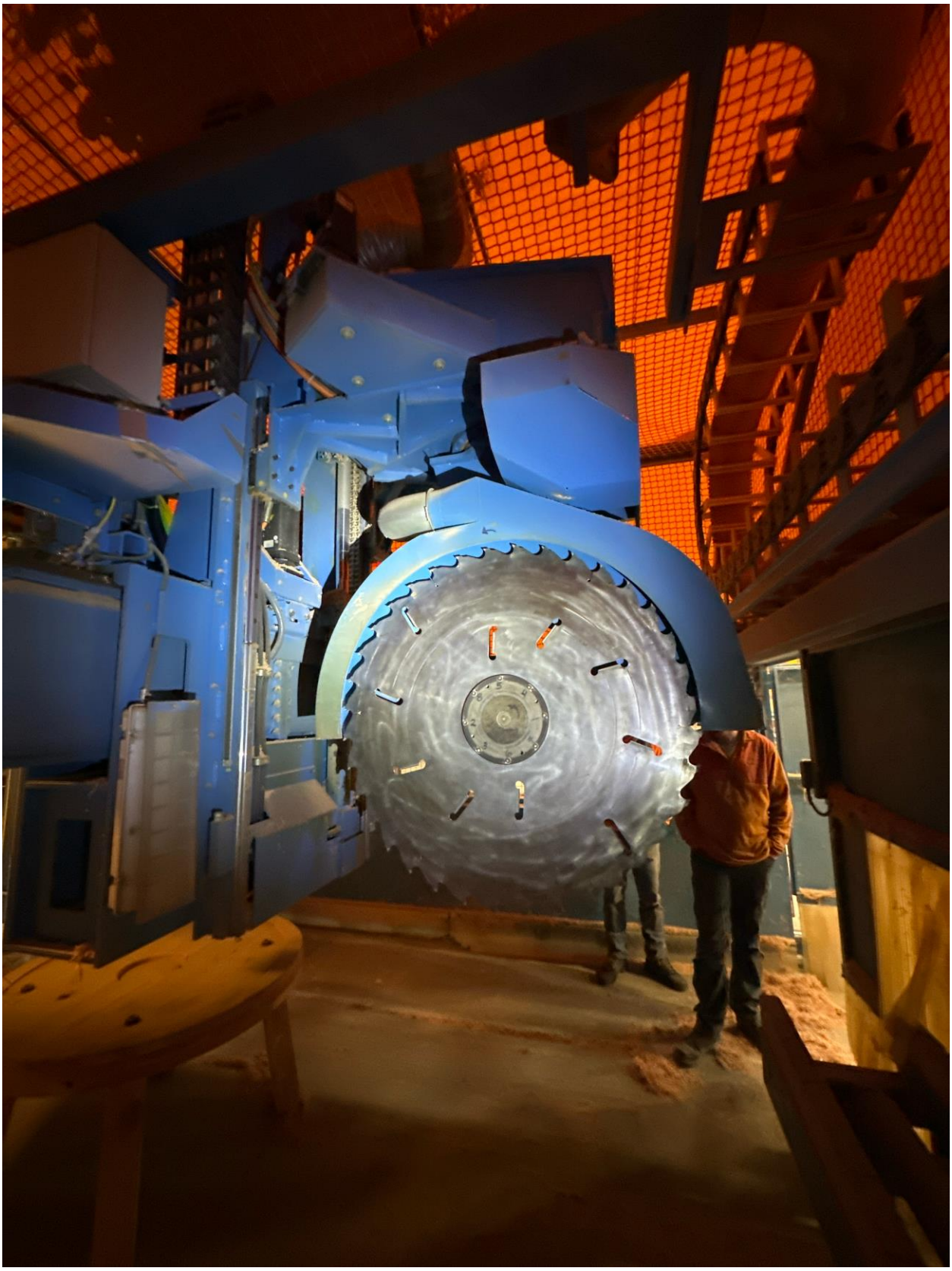
The powered roller system was installed, but never commissioned.

Cambium version

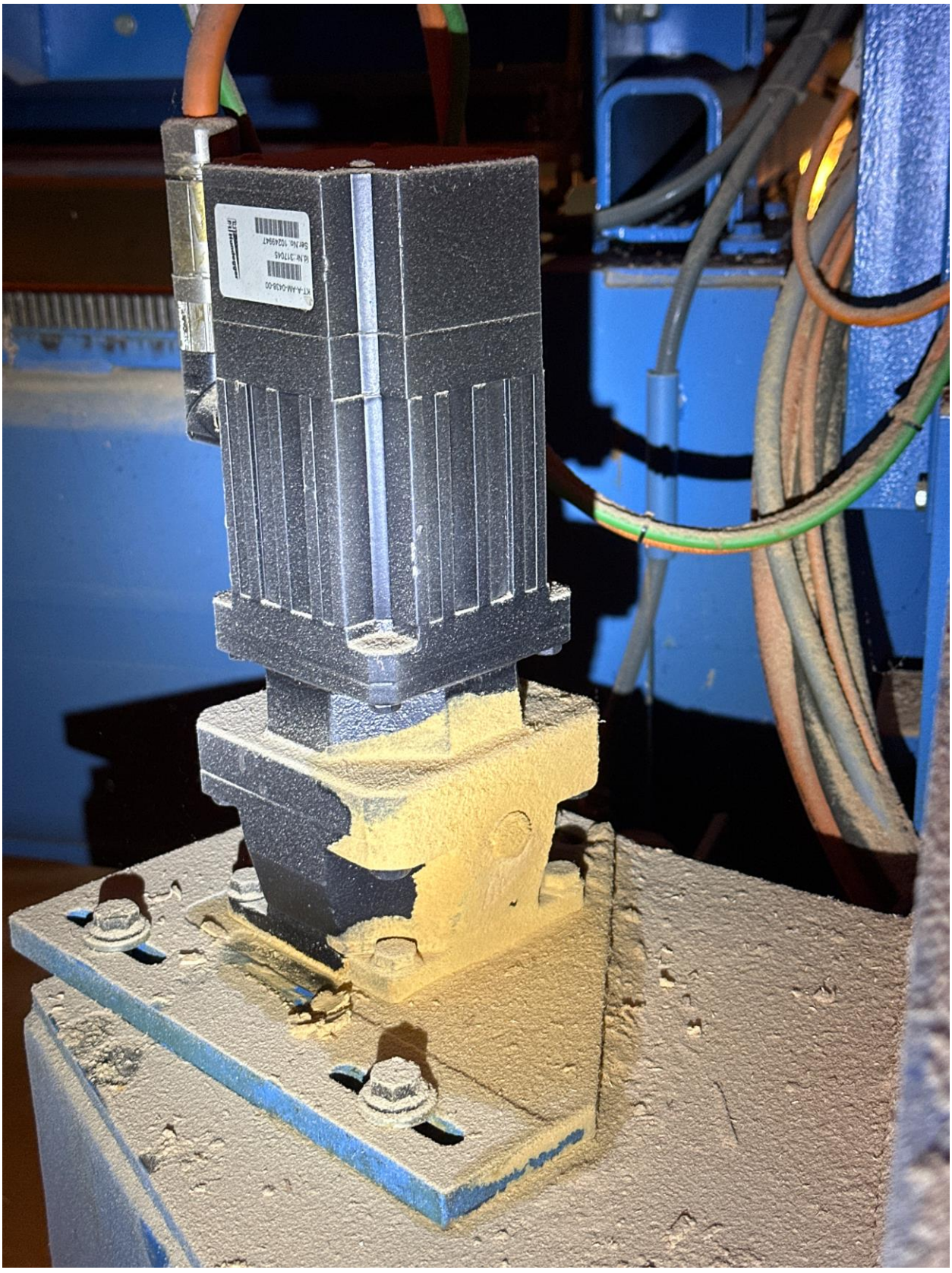


X and Y axis move, seem to be pretty smooth. It looks like the X axis drive pinions have been swapped out at some point.
I have disposal and vacuum lip tube system are both working.
Machine overall length from end of impact wall to end of impact wall is 135 feet.
X axis Rail length is 118 feet.
Table dimension is 87 feet long by 10 feet wide.
X axis rails look to be in very good shape.

Saw unit
Bearing appeared to have been getting greased, bearings themselves looking good shape, the axis chain doesn't show anywhere so blade is in good shape



When we press emergency stop, we got a overcurrent error on the Y axis drive for the gantry. Probably needs a new brake resistor. I could've swore the arrow said Y axis the first time. The second time I saw it it said X axis. You may recommend new drives and resistors.
The saw angle axis motor looks to have a slow oil leak. Part number for the motor is KT – A – AM – 0438–00.

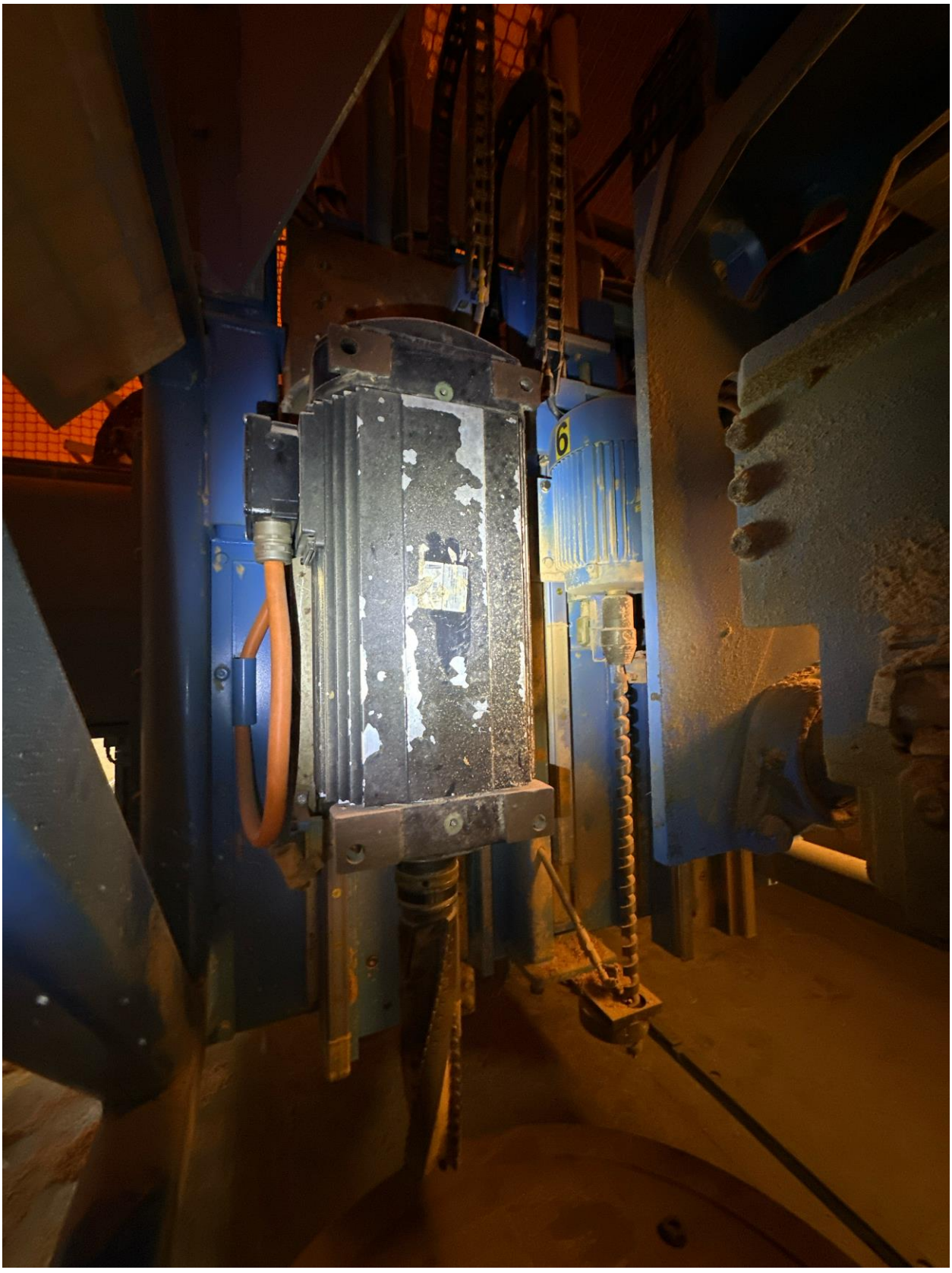


Fluorescent light units inside the saw cabinet are struggling. Higher would recommend replacing them with LED units.

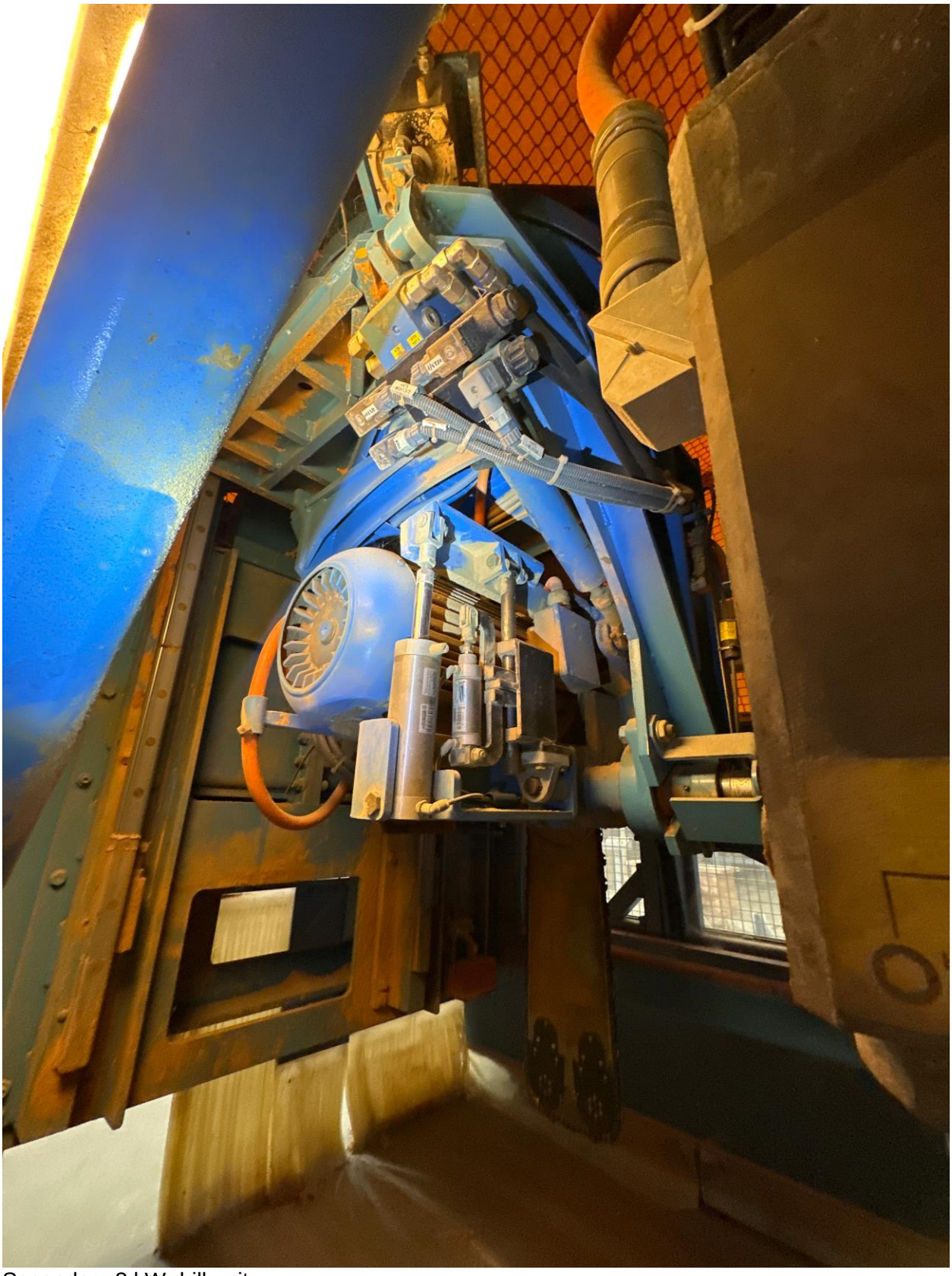
Reckerth milling spindle with HSK 80 Manuel chalk. Motor started up and ran a warm-up cycle fine.

Pneumatic drill unit with a 3 kW drive motor

22 kW vertical milling motor with HSK 80 manual chuck

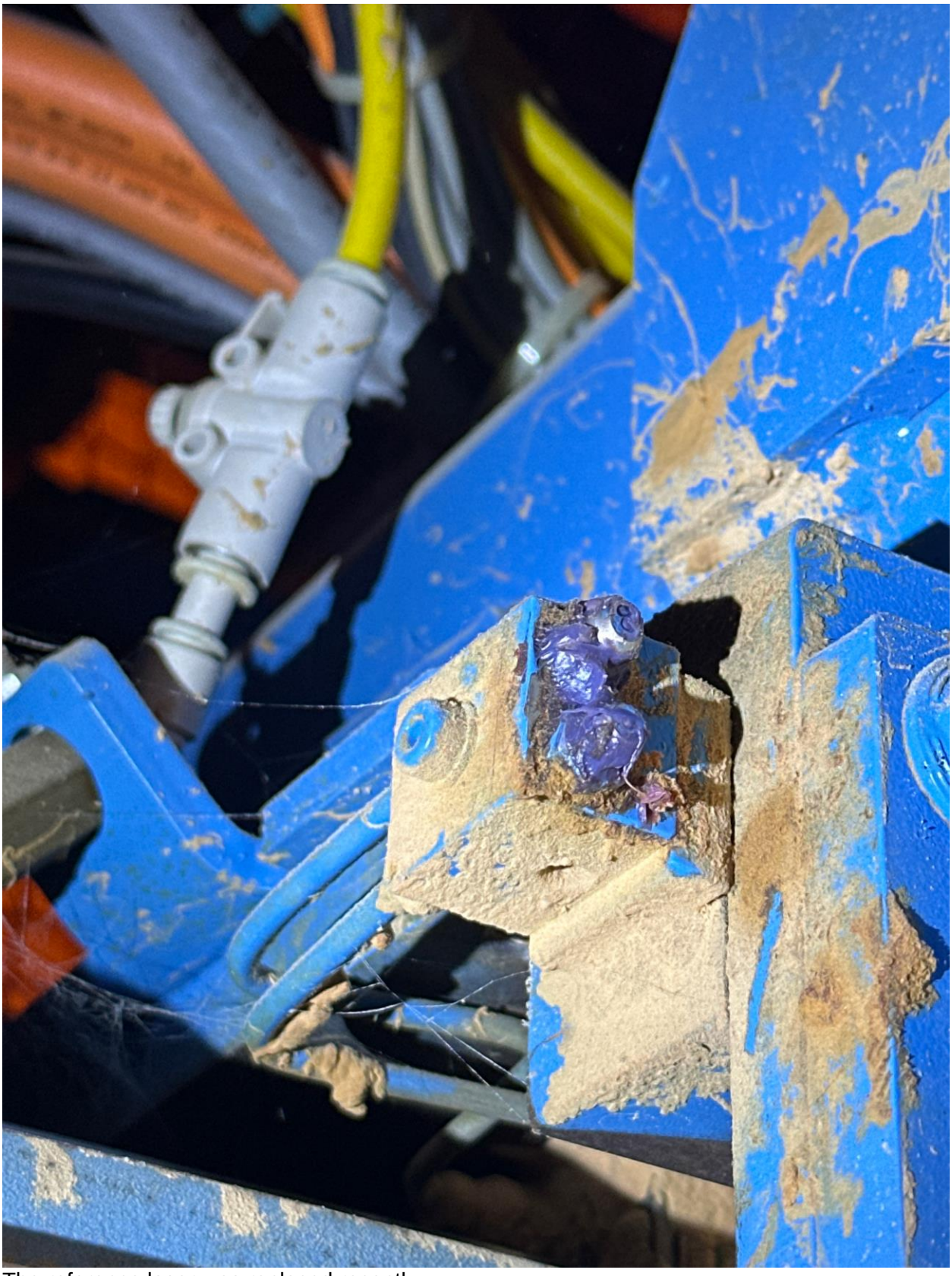

6

Chainsaw unit. Appears to be outfitted with the 20 inch bar and standard 3/8 inch chain.



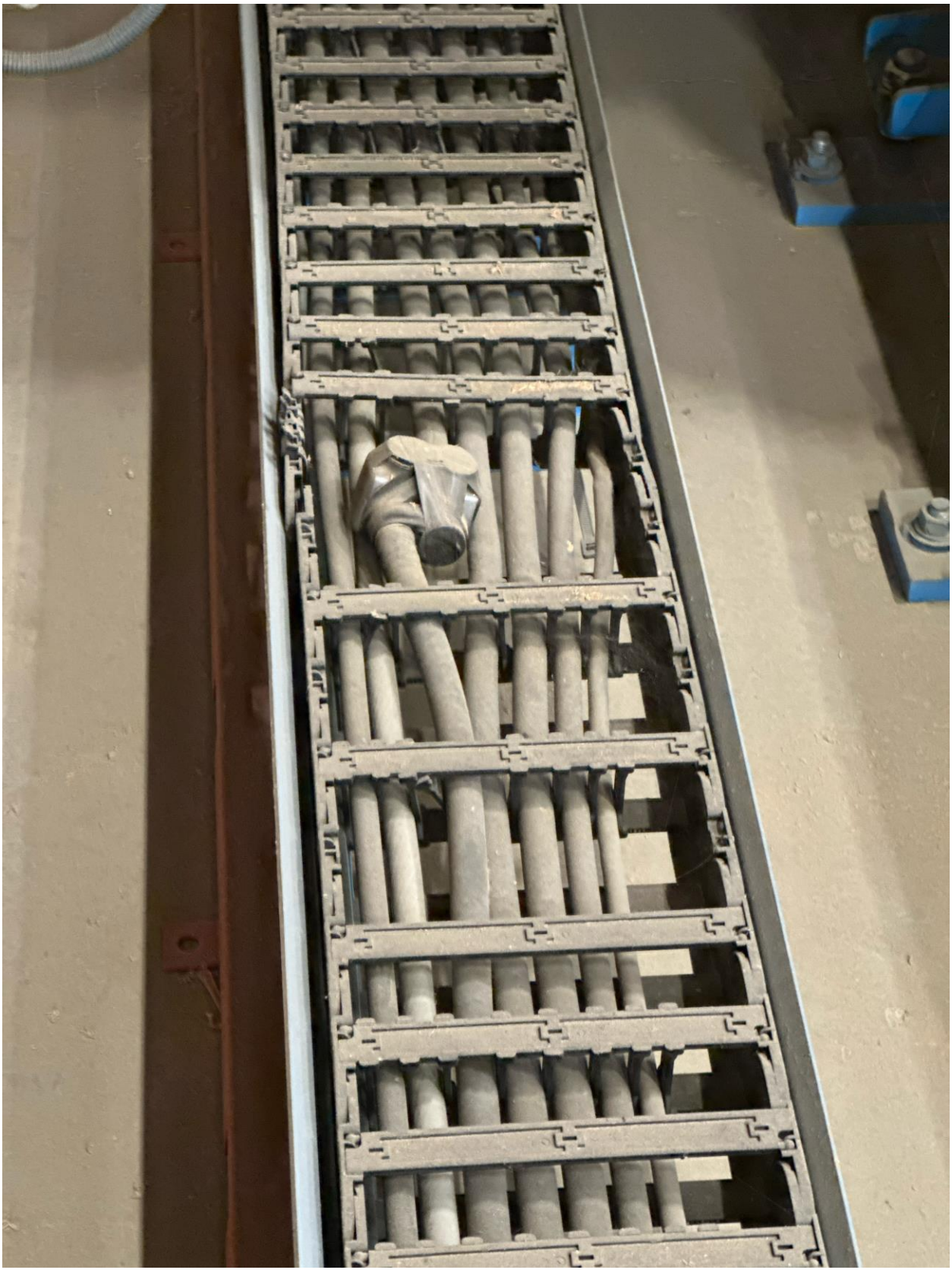
Secondary 3 kW drill unit.

Close view of the greasing system on the Y axis linear guides.



The reference laser was replaced recently.

There are two extra safety door sensors preinstalled with the machine.

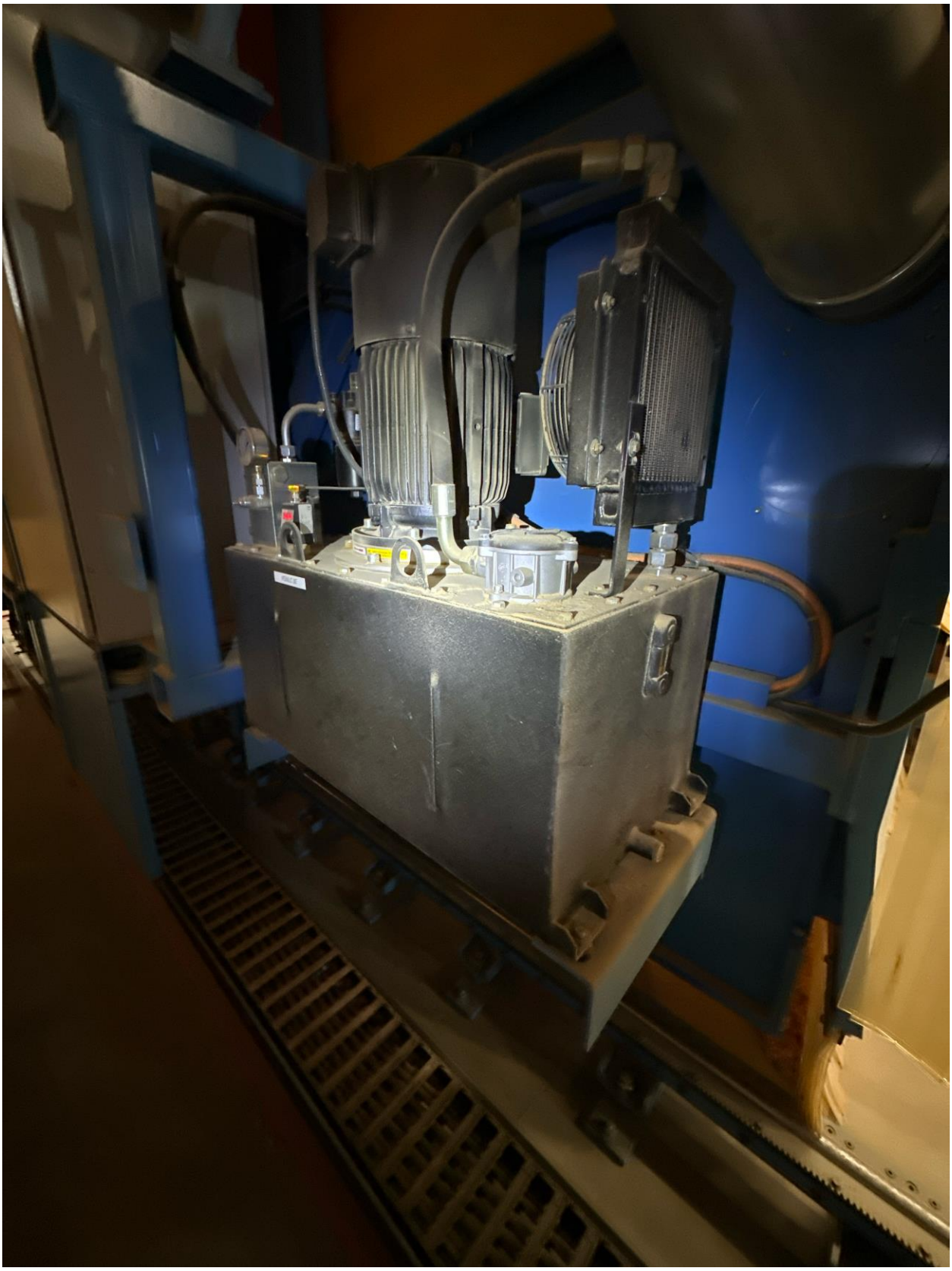


The X axis power chain looks like it is in good shape except for this spot where it looks like one of the main power carrier cables was broken and repaired with a split bolt. We need to figure out the gauge of that cable and quote replacement.
There are extra parts available. Drillbits, chainsaw, chains, a chainsaw bar for the larger 12 mm chain with chain, some safety switches, sensors, etc.
there was also a toolbox with a couple of the wrenches for changing the mill had, and a grease gun for the asonic grease.

Hydraulic unit looks to be in very good shape.
It generates pressure to move the units around without any problems.
I recommend an oil change and filter replacement.
The filter elements are MF1002P25NBP01 and 28067


Filter Nr.: 28067
Element Nr. 27612
Baujahr 09/13
Max. Betriebsüberdruck (bar):
Inhalt des Druckraumes (l):

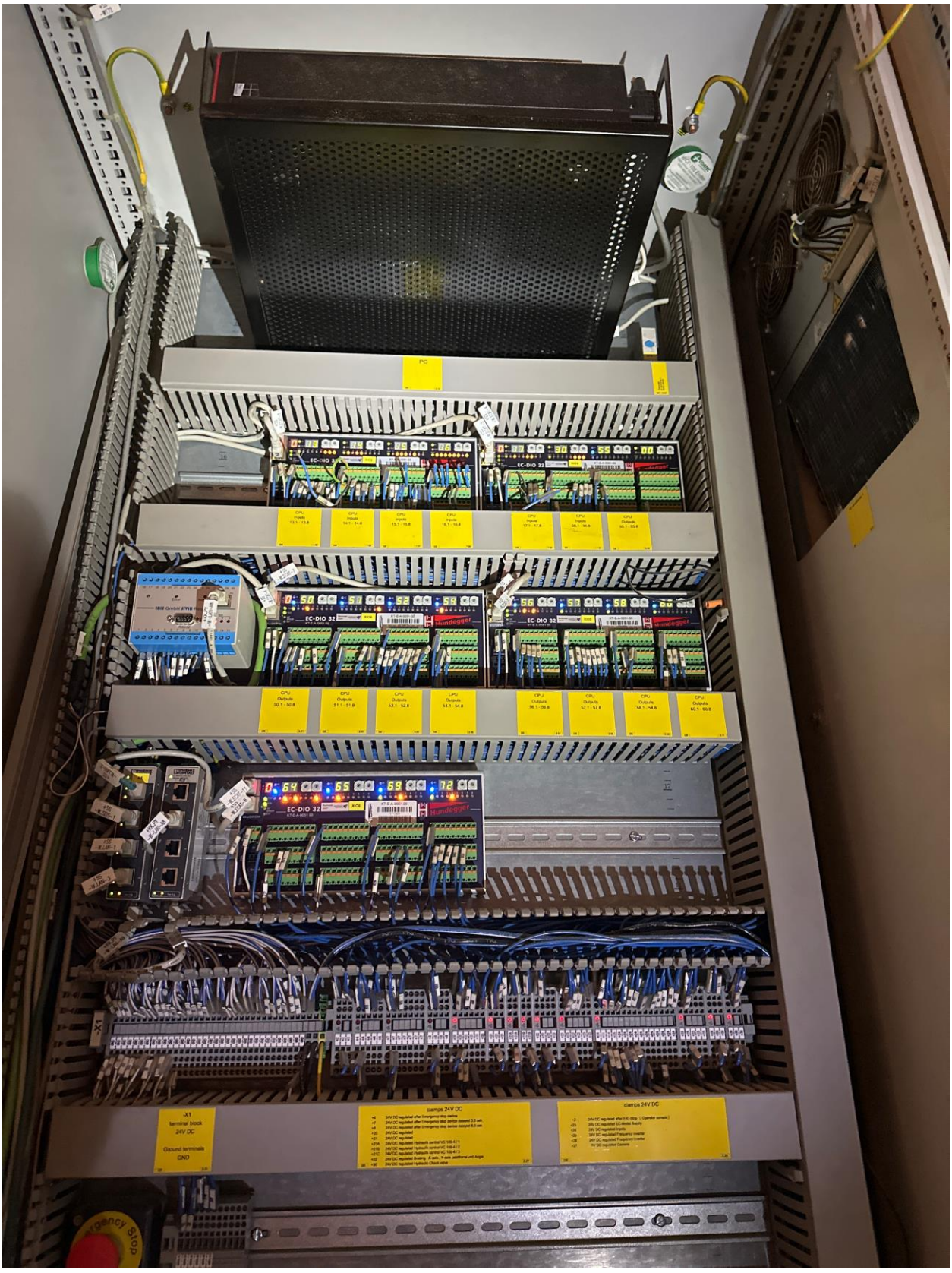

MPFILTRI s.p.A.
MADE IN ITALY
Filtro/Filter
MPF1002AG3P25NBP01
Filter Element
MF1002P25NBP01
130P005347



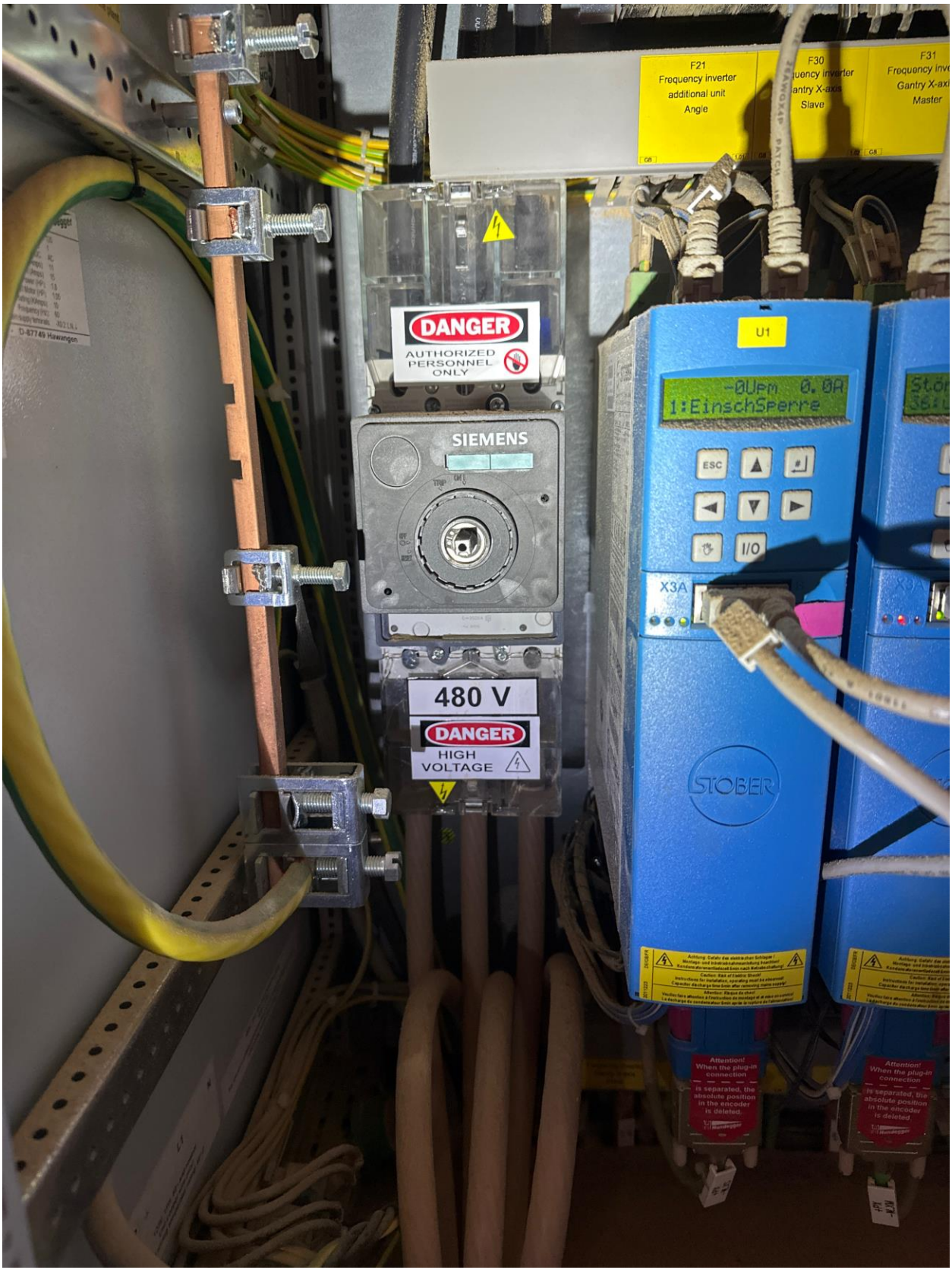
Spindle motor chiller unit the unit had not been cleaned for a while, and was a little bit low on coolant. I recommend changing the coolant.
You recommend a 20% mixture of distilled water and glycol.

Control side of the circuit cabinet looks good, no faults or other apparent issues.

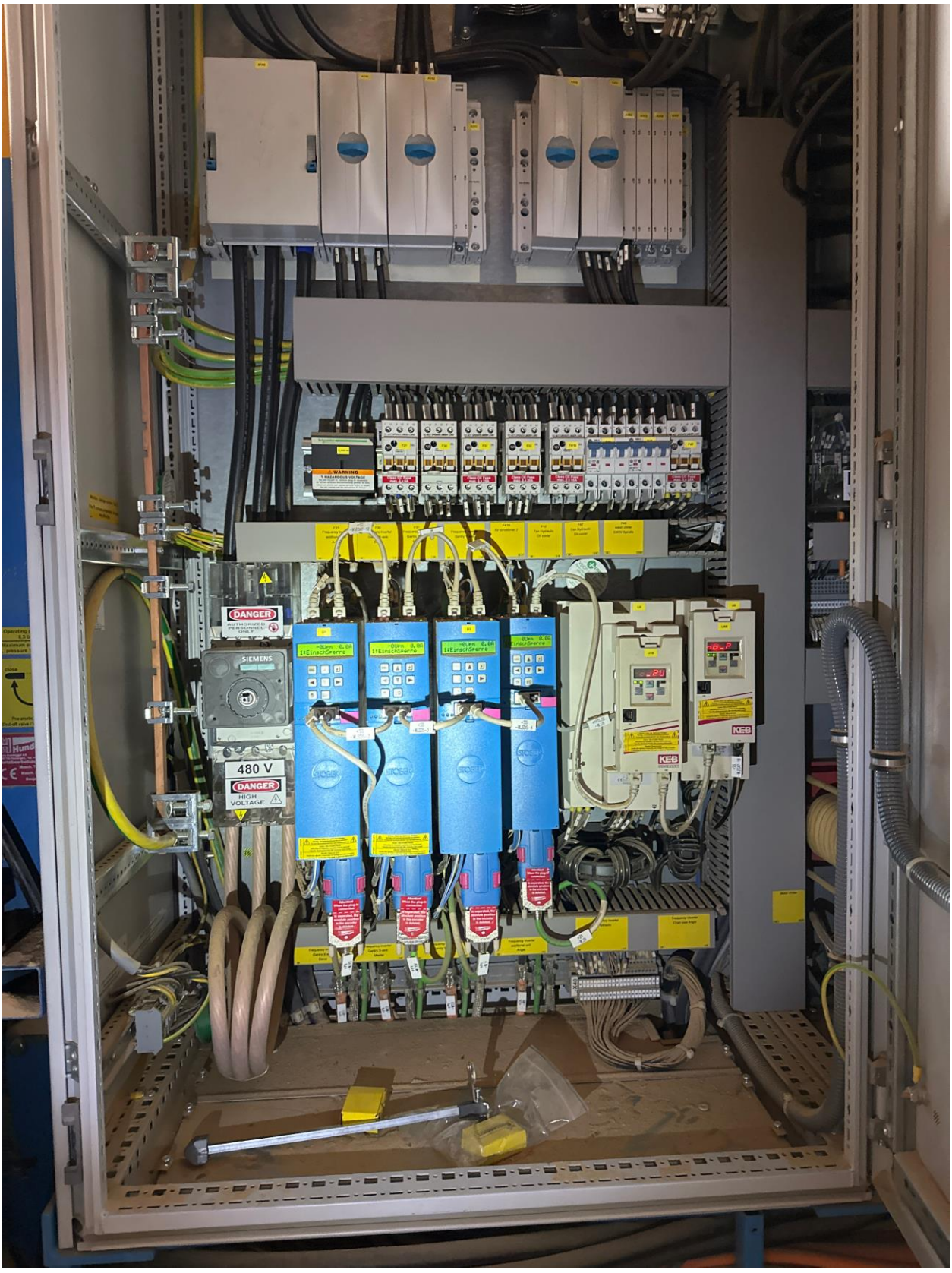

Em.-Stop
SICK
XTIO1
XTIO2
XTIO3
XTIO4
XTK1
XTK2
X_CPU


PC
EC-DIO 32
Hundegger
-X1
terminal block
24V DC
Ground terminals
GND
clamps 24V DC
clamps 24V DC
Emergency Stop

The locking rod for the main circuit cabinet door has broken. Looks like it’s a Siemens brand disconnect.
Manufacturer part number MLFB3VL9300–3 HF06


F21
Frequency inverter
additional unit
Angle
F30
Slave
F31
Master
DANGER
AUTHORIZED
PERSONNEL
ONLY
SIEMENS
480 V
DANGER
HIGH
VOLTAGE
U1
-0Upm 0.0A
1:EinschSperre
ESC
I/O
X3A
STÖBER

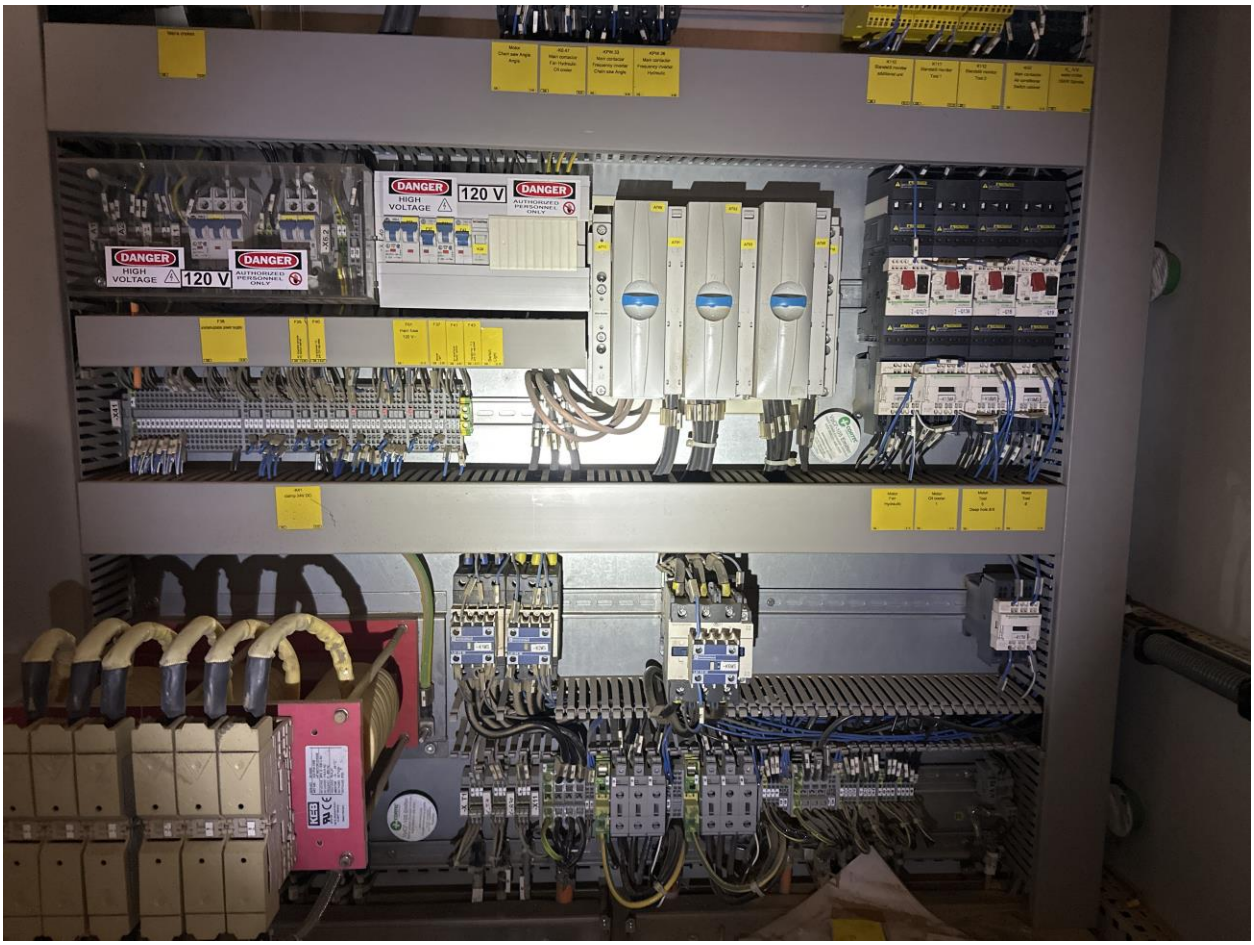
High voltage section the only error apparent on this side of the cabinet is the overvoltage error on the gantry X axis master motor drive mentioned before.


DANGER
AUTHORIZED PERSONNEL ONLY
SIEMENS
480 V
DANGER
HIGH VOLTAGE
WARNING
HAZARDOUS VOLTAGE
KEB

Second, half of the high voltage section.


KEB
SIEMENS
MW
WARNING
HAZARDOUS VOLTAGE
DANGER
HIGH VOLTAGE
120 V
DANGER
AUTHORIZED PERSONNEL


SIEMENS
DRP-480S-24
WARNING
HAZARDOUS VOLTAGE



Bent panel on the right rear side of the machine

The panel right next to the right hand access door is also bent

The left side rear panel is also fairly bent out of shape.

Spare tooling – extra 80 mm and mill with 40 mm and mill and a couple of HSK adapters. Also a 20 inch and a 24 inch saw bar.

A couple of disc mills with HSK adapters. One 20 mm and one 100 mm.

Tested all axes. Every axis moves and can find a position in F2 positioning mode.

After turning the machine off and back on a couple of times, saw that the circular saw C axis also got an overvoltage error. That's weird. Something seems to be affecting all the Stöber drives. Maybe all have bad brake resistors? We also saw a error 3:42 temperature brake resistor error for the gantry Y axis. It only seems to happen on an emergency stop.

All the safety devices appear to be working normally.
I tested all the tooling. Every tool works, except for drill unit five. It has a broken spring on the drill guide, so we couldn't really get it to stay in place in order to make a drilling, but all the other saws and mills and drills work.