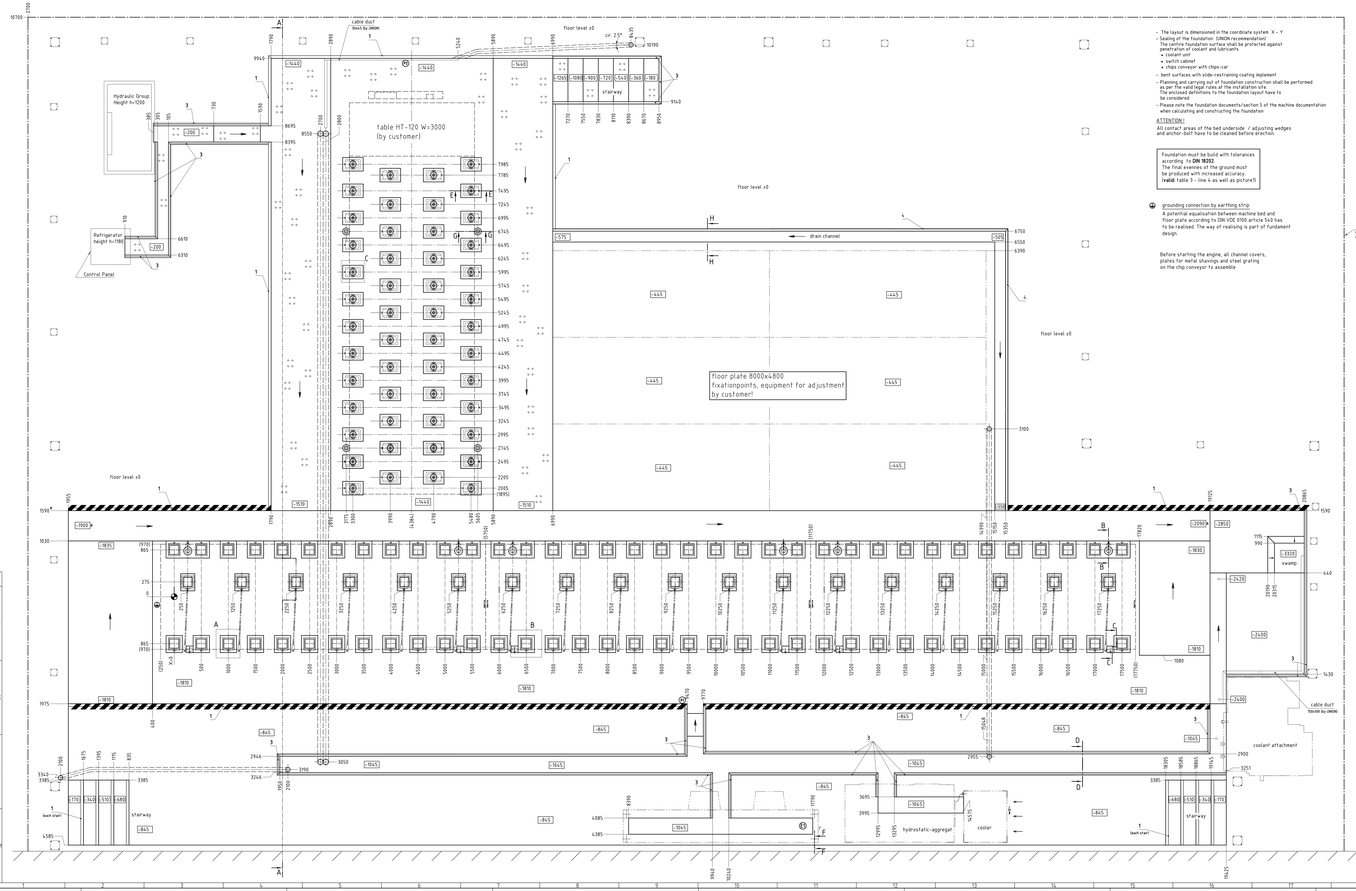


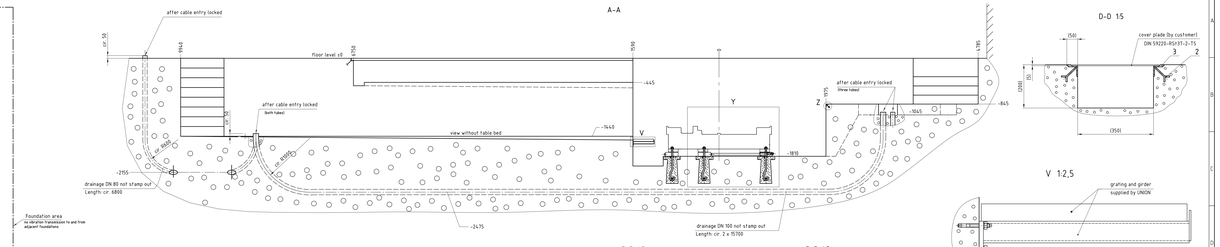
- The layout is dimensioned in the coordinate system X - Y
- Sealing of the foundation (UNION recommendation)
  The foundation and adjacent surface shall be protected against penetration of coolant and lubricants.
  - coolant unit
  - switch cabinet
  - chips conveyor with chips-car
- bent surfaces with side-restraining coating implement
- Planning and carrying out of foundation construction shall be performed in accordance with rules of the installation site.
  The enclosed definitions fix the foundation layout have to be considered
- Please note the foundation documents/section 5 of the machine documentation when calculating and constructing the foundation

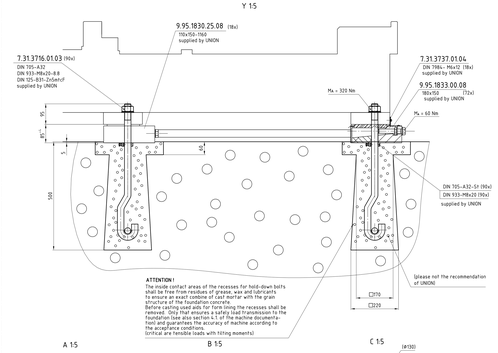
ATTENTION !
All contact areas of the bed underside / adjusting wedges and anchor-bolt have to be cleaned before erection.

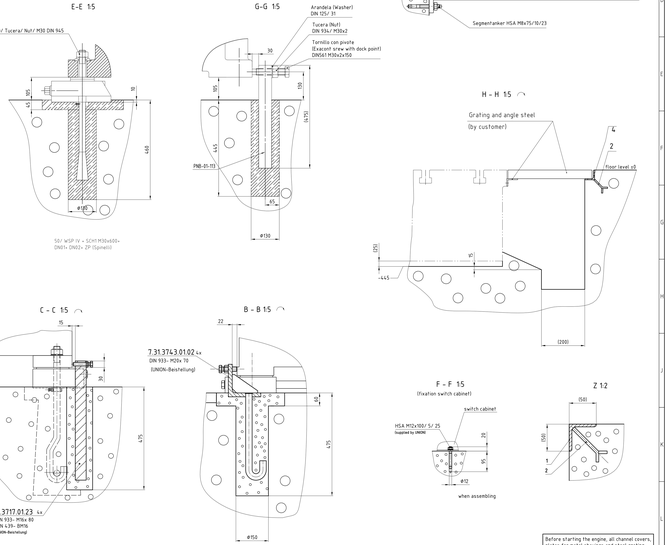
Foundation must be build with tolerances according to **DIN 18202**.
The final evenness of the ground must be produced with increased accuracy (**valid:** Table 3 - line 4 as well as picture9)

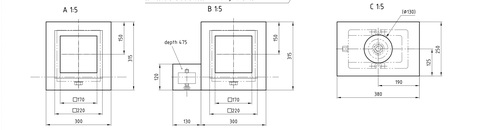
grounding connection by earthing strip
A potential equalisation between machine bed and floor plate according to DIN VDE 0100 article 540 has to be realised. The way of realising is part of fundament design.

Before starting the engine, all channel covers, plates for metal shavings and steel grating on the chip conveyor to assemble









(E1) switch cabinet

1) 480V 60 Hz
connected load 14,3 kVA
nominal current 16,8 A
pre-fuse 230 A
line cross section 4x 10? mm²

2) prefuse connection
120 V / 60 Hz
connected load 4 A
pre-fuse 16 A
line cross section 2,1 mm²

(P1) pneumatics inlet machine
nominal pressure 10 bar (minimal 6 bar)
V = 12 m³ /h
connected line NW10
filtration required 40 µm

(P2) pneumatics inlet table
nominal pressure 10 bar (minimal 6 bar)
V = 1 m³ /h
connected line NW6
filtration required 40 µm

Unknown

Table BOST HT-120
connected load and pneumatics inlet
unknown

yellow-black stripes / danger zone
slope
zero point - foundation layout

* dependent on chip-conveyor

XXX foundation hight related by floor level
machine layout is only valid with machine number

Pipes in the foundation
Wire inside for cable isitallation!

All depth measurements are dependent on the height of the floor plate!

* dependent on chip conveyor

Before starting the engine, all channel covers, plates for metal shavings and steel grating on the chip conveyor to assemble!

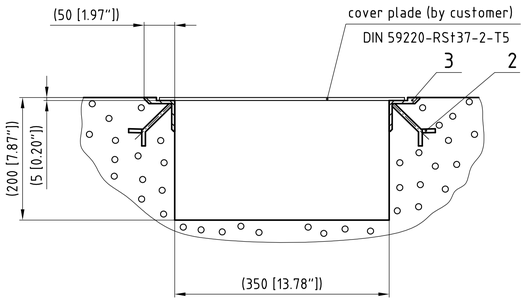
customer: United Precision Services, Inc.

Parts to be provided by the customer !

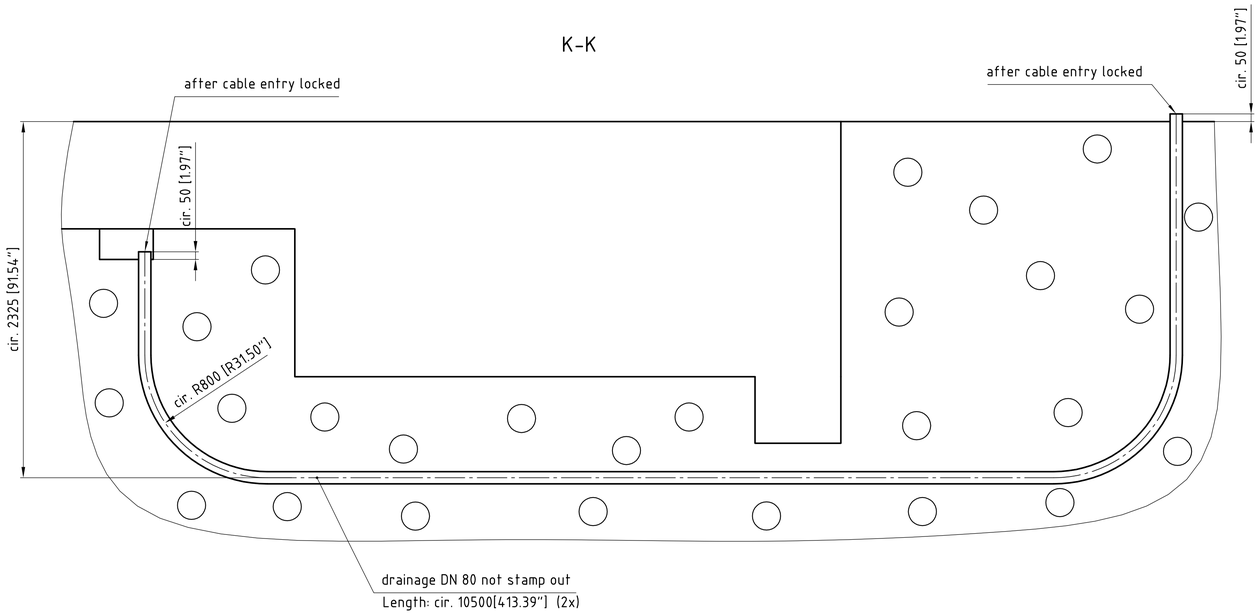
Pos.	pieces	designation	dimension	[standard/material]	comment
1	4,5m	angle steel	L75x75	[DIN1028-RSt37-2]	
3	6,5m	flat bar/ angle steel	50x8/ 40x40x5	Wichtler Stahlhandel Wtm. Thyssen	
		Kreuzverbindungen	Profil 40 20x 4Tx Thyssen		
2	4,45	anchor iron	FI35x14x80	[DIN931-St37]	
4	26,m	angle steel	L50x5	[DIN 1028-St37]	

										CAD-Zeichnung erstellt in AutoCAD	Name: Datum: Normgeprüft: Freigabe:
										Ersetzt durch: Ersetzt für:	Name: Datum: Gezeichnet: 13.01.10 Geprüft: Freigabe:
										Ersetzt durch: Ersetzt für:	Name: Datum: Gezeichnet: 13.01.10 Geprüft: Freigabe:
											Ersetzt durch: Ersetzt für:
											Name: Datum: Gezeichnet: 13.01.10 Geprüft: Freigabe

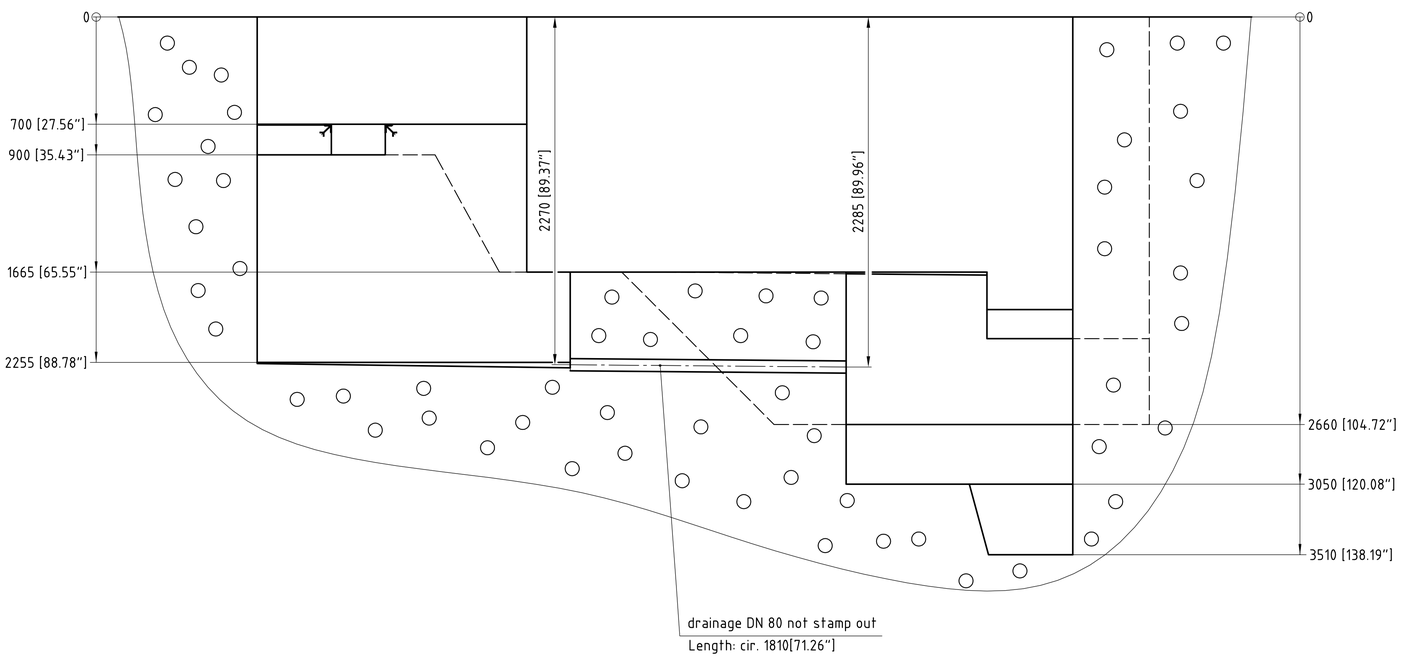
D-D 1:5



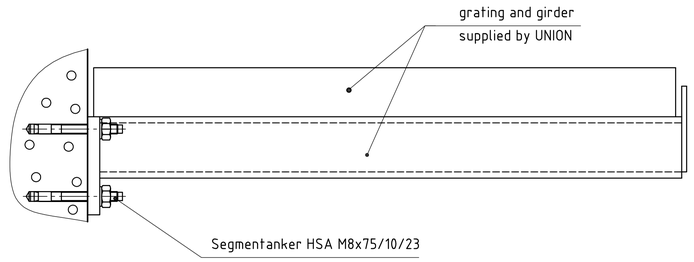
K-K



J-J



V 1:2,5



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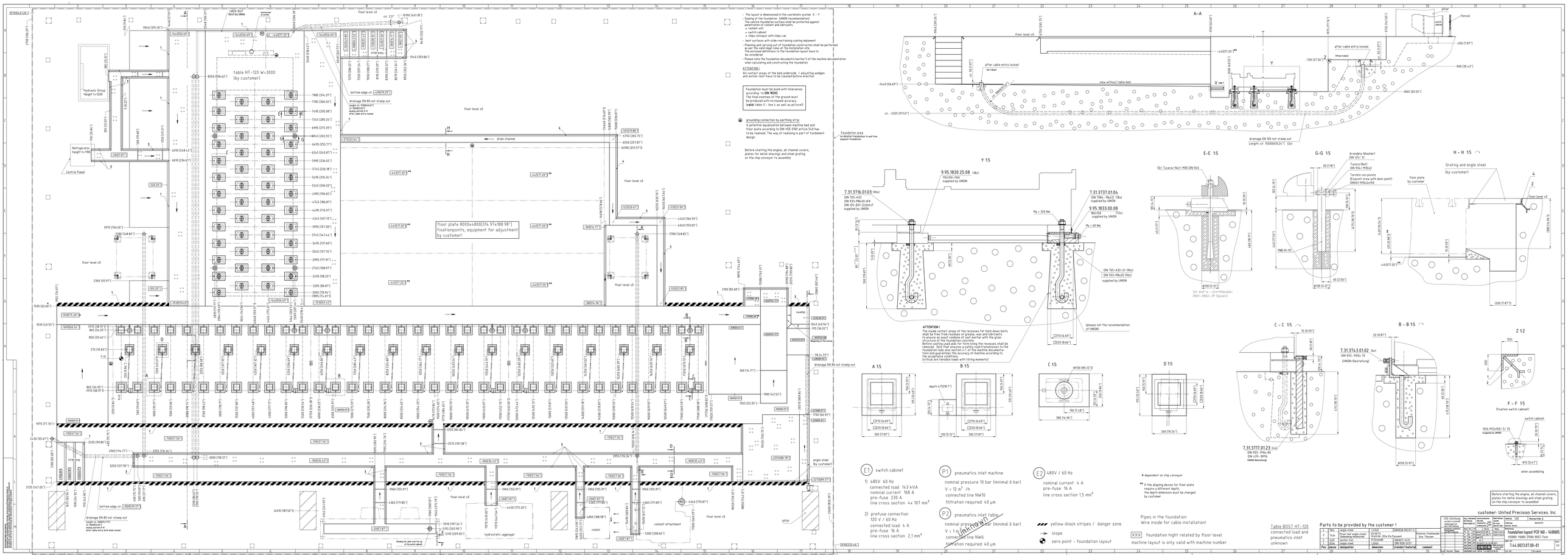
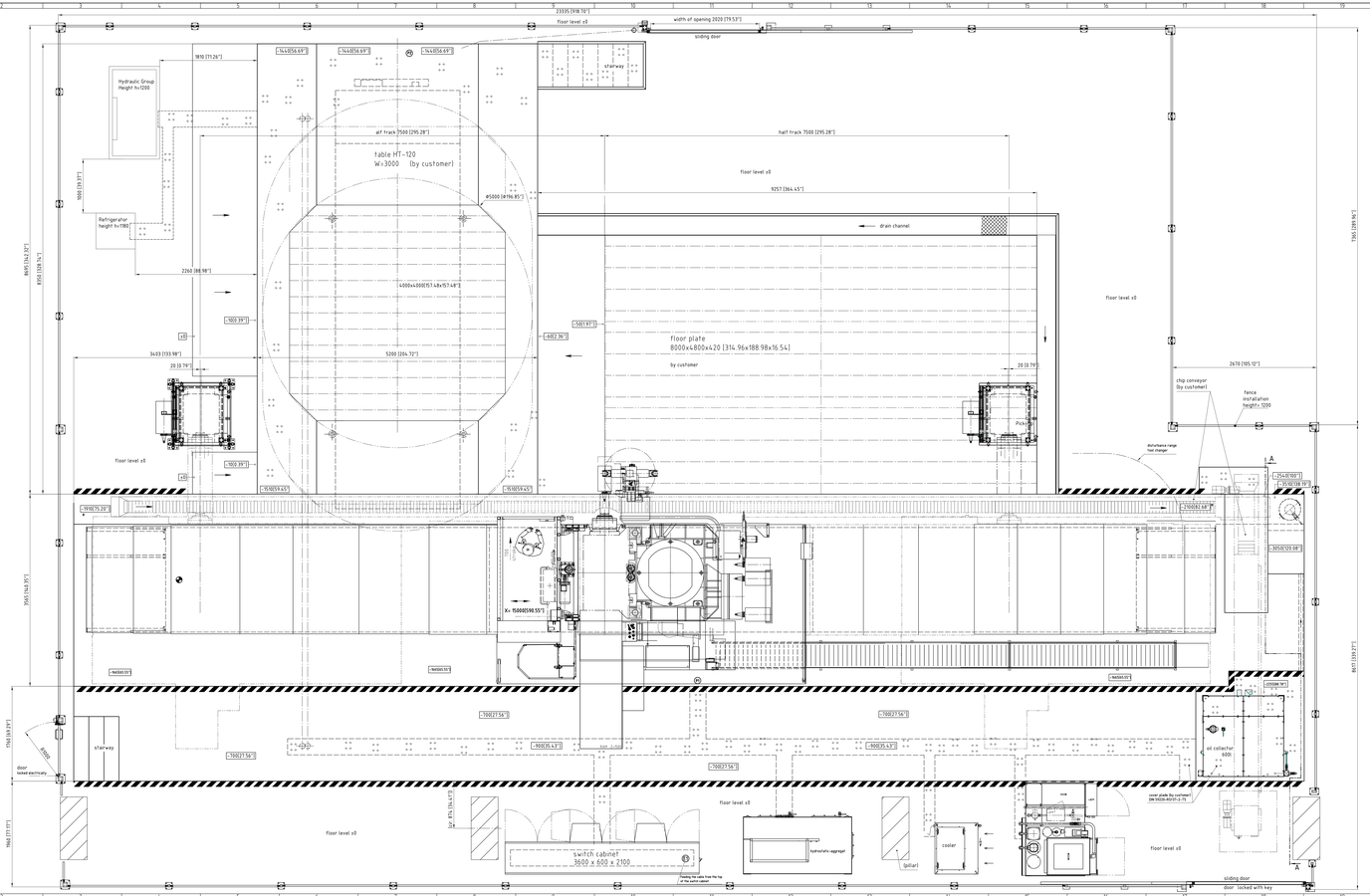
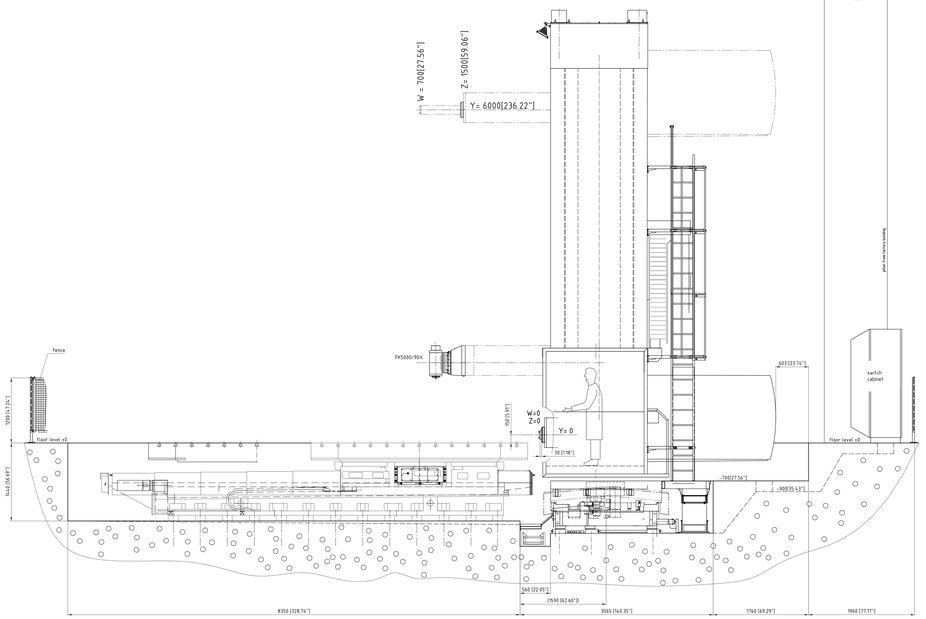
CAD-Zeichnung -erstellt in AutoCAD -Änderungen nur über CAD zulässig	ALLg. Toleranzen ISO 2768-mK, Koord.maße ±0,1			Werkstückkanten DIN 6784 Innenkanten ↗ l=1,6 Außenkanten ↗ l=0,2		Oberflächen-rauheit Ra in µm DIN ISO 1302	Maßstab 1:20	Masse (kg, fertig) 0
							Halbzeug:	Werkstoff:
							Rohteil- Mat.Nr.	
alle Rechte vorbehalten, Schutzvermerk nach DIN 34 beachten	Über	bis	Tol.		Datum	Name	Benennung:	
	0.5	6	±0.1	gezeich.	10.08.11	Haettasch	foundation layout PCR 160 - 1400005	
	6	30	±0.2	konstr.	24.08.11	Haettasch	X15000/ Y6000/ Z1500/ BOST-Tisch	
	30	120	±0.3	geprüft				
	120	315	±0.5	AV				
	315	1000	±0.8	aktualisiert am -24.08.2011			Ident.-Nr.:	Blatt
	1000	2000	±1.2	UNION	UNION-Werkzeugmaschinen GmbH Chemnitz		7.44.0023.07.00-01	2/2
	2000	4000	±2.0					
Ä.Ind.	And.mitt.	Name	4000	8000	±3.0	EDV Nr. 7.44.0023.07.00-01	Ers. für:	Ers. durch:

A1


- The layout is dimensioned in the coordinate system X - Y
- Sealing of the Foundation (UNION recommendation)
The top of the foundation surface shall be protected against penetration of coolant and lubricants
- coolant unit
- switch cabinet
- chips conveyor with chips-car
bent surfaces with side-restraining coating (apleum)
- Planning and carrying out of foundation construction shall be performed as per the valid legal rules at the installation site.
The enclosed definitions fo the foundation layout have to be observed.
- Please note the foundation documents/section 5 of the machine documentation when calculating and constructing the foundation
ATTENTION!
All contact areas of the bed underside / adjusting wedges and anchor-bolt have to be cleaned before erection.
Foundation must be build with tolerances according to DIN 18202
The final evenes of the ground must be produced with increased accuracy.
(valid: table 3 - line 4 as well as picture5)
grounding connection by earthing strip
A potential equalisation between machine bed and floor plate according to DIN VDE 0100 article 540 has to be realised. The way of realising is part of fundament design.
Before starting the engine, all channel covers, plates for metal shavings and steel grating on the chip conveyor fo assemble
table HT-120 W=3000 (by customer)
Hydraulic Group Height h=1200
Refrigerator height h=1180
Control Panel
floor plate 8000x4800(314.97x188.98") fixationpoints, equipment for adjustment by customer
drain channel
floor level ±0
bottom edge cr. -1450(79.29")
drainage DN 80 not stamp out
Length cr. 2580(101.6") or 4660(183.5") analog section A-A after cable entry locked
swarf
angle steel (by customer)
coolant attachment
hydrostatic-aggregat
cooler
pillar
Fixing the cable from the top of the switch cabinet
A-A
floor level ±0
after cable entry locked (all holes)
view without table bed
drainage DN 100 not stamp out Length cr. 15600(614.24") (2x)
Foundation area on vibration transition to and free adjacent foundations
pillar
(fence)
switch cabinet
Y 15
9.95.1830.25.08 (18x)
150x150-150J0
supplied by UNION
7.31.3716.01.03 (14x)
DIN 705-A32
DIN 933-M6x20-8.8
DIN 125-B31-2x5mh9
supplied by UNION
7.31.3737.01.04
DIN 7984- M6x12 (18x)
supplied by UNION
9.95.1833.00.08
180x150 (12x)
supplied by UNION
Ma = 320 Nm
Ms = 60 Nm
DIN 705-A32-5t (14x)
DIN 933-M6x20 (14x)
supplied by UNION
(please not the recommendation of UNION)
ATTENTION !
The inside contact areas of the recesses for hold-down bolts shall be free from residues of grease, wax and lubricants and shall be cleaned before the first pour with the grain structure of the foundation concrete.
Before casting used aids for form lining the recesses shall be removed. Only that ensures a safety load transmission fo the foundation (see also section 5.1 of the machine documenta-tion). Observance of the accuracy of machine according to the acceptance conditions.
(critical are tensile loads with tilting moments)
E-E 15
50/ Tuerca/ Nut/ M30 DIN 985
50/ WSP/ Fv = SCH1 M30x600+ 2NUT+ DN82+ 2P (Spanish)
G-G 15
Arandela (Washer) DIN 125/ 31
Tuerca (Nut) DIN 934/ M30x2
Tornillo con pivote (Excavat screw with dock point) DIN561 M30x2x150
H - H 15
Grating and angle steel (by customer)
floor plate by customer
floor level ±0
A 15
B 15
depth 475(18.7")
C 15
D 15
C - C 15
7.31.3717.01.23 (6x)
DIN 933- M16x 80
DIN 439- BM16
UNION-Beschlag
B - B 15
7.31.3713.01.02 (6x)
DIN 933- M20x 70
(UNION-Beschlag)
Z 12
F - F 15
(fixation switch cabinet)
switch cabinet
HSA M12x100/ 5/ 25
supplied by UNION
when assembling
E1 switch cabinet
1) 480V 60 Hz
connected load 143 kVA
nominal current 168 A
pre-fuse 230 A
line cross section 4x 107 mm²
2) prefuse connection
120 V / 60 Hz
connected load 4 A
pre-fuse 16 A
line cross section 2,1 mm²
P1 pneumatics inlet machine
nominal pressure 10 bar (minimal 6 bar)
V = 12 m³ /h
connected line NW10
filtration required 40 µm
P2 pneumatics inlet table
nominal pressure 6 bar (minimal 6 bar)
V = 1 m³ /h
connected line NW6
filtration required 40 µm
unknown
E2 480V / 60 Hz
nominal current 4 A
pre-fuse 16 A
line cross section 1,5 mm²
* dependent on chip conveyor
** If the aligning device for floor plate require a different depth, the depth dimension must be changed by customer
yellow-black stripes / danger zone
slope
zero point - foundation layout
Pipes in the foundation:
Wire inside for cable installation!
XXX foundation hight relatedly floor level
machine layout is only valid with machine number
Table BOST HT-120
connected load and pneumatics inlet
unknown
Parts to be provided by the customer !
customer: United Precision Services, Inc.
Foundation layout PCR 160 - 1400005
VIBRIG 1980/ 7980/ 8051-1lach
Before starting the engine, all channel covers, plates for metal shavings and steel grating on the chip conveyor fo assemble
7.44.0023.07.00-01
UNION





yellow-black stripes / danger zone

slope

zero point - foundation layout

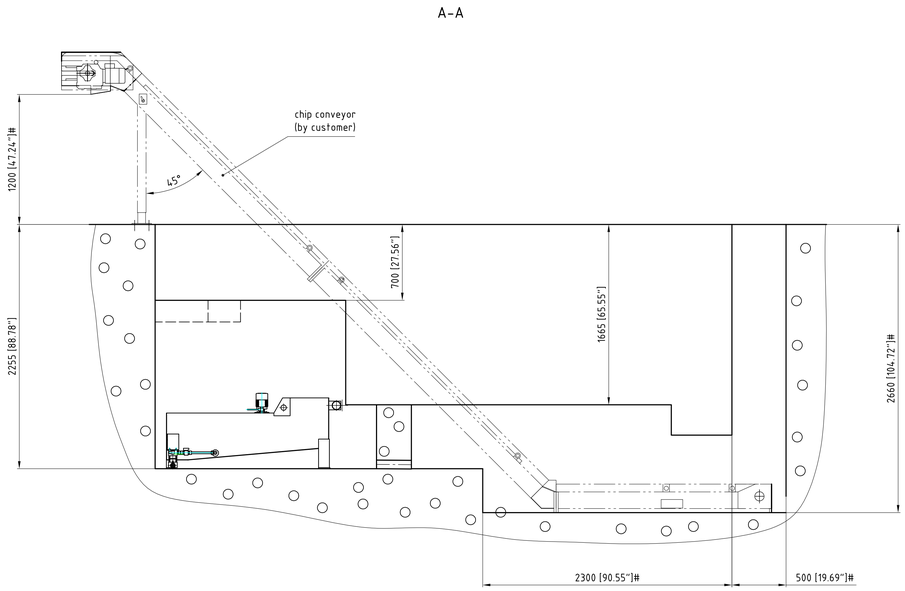
* dependent on chip conveyor

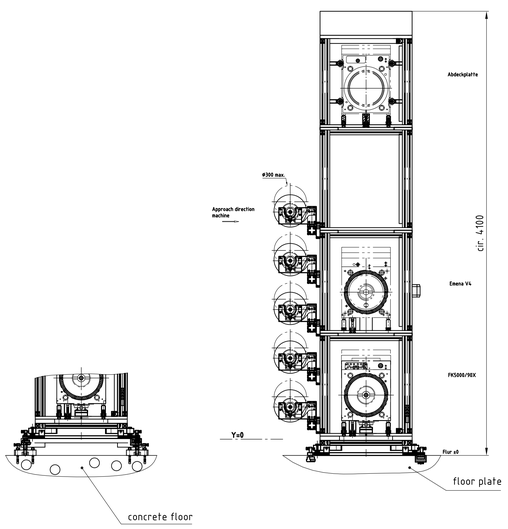
XXX foundation hight related by floor level
machine layout is only valid with machine number

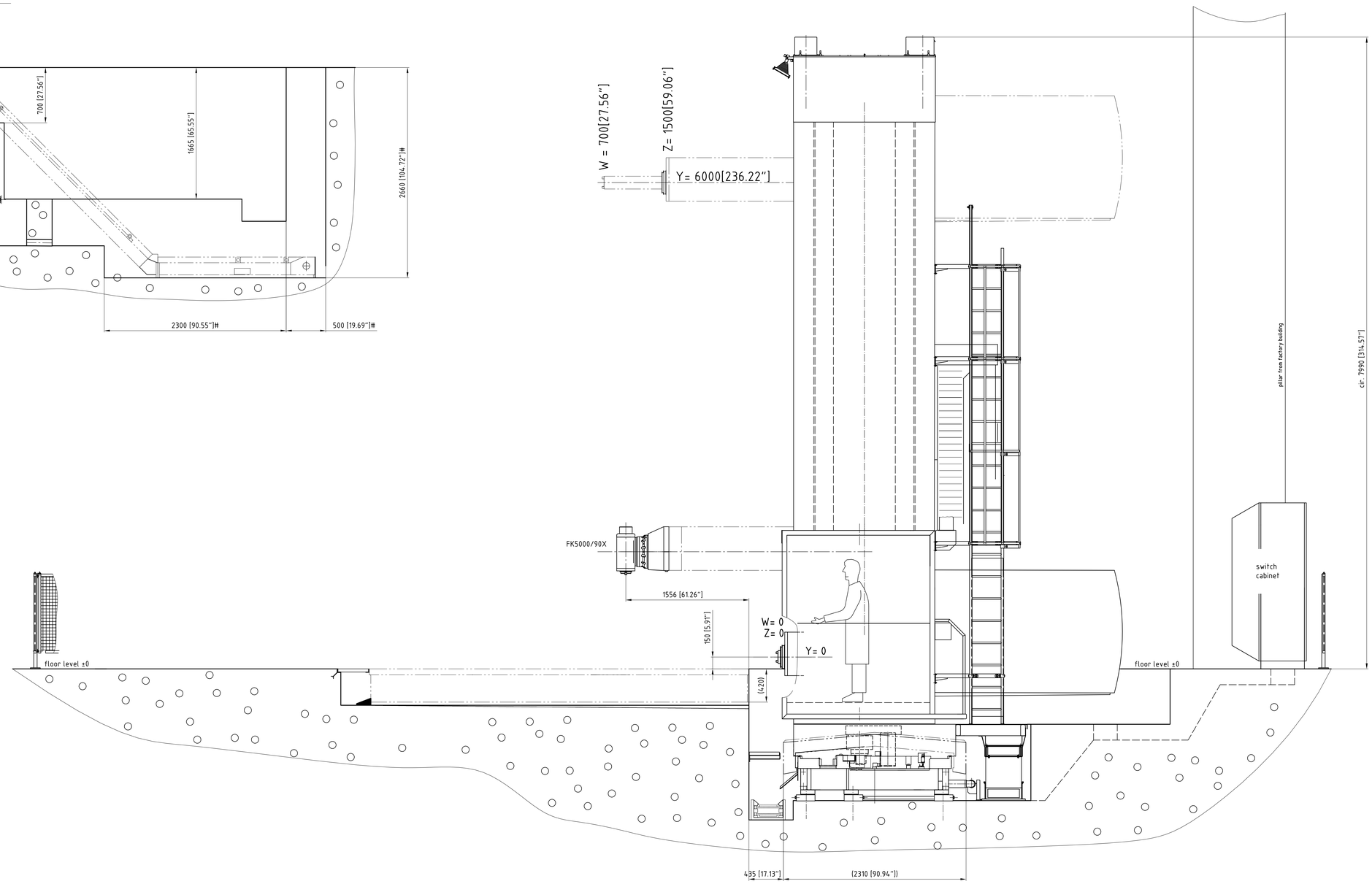
Before starting the engine, all channel covers, plates for metal shavings and steel grating on the chip conveyor fo assemble!

customer: United Precision Services, Inc.

KX-Zeichnung erstellt in Autocad	Benj. Valentin	Benennung: Machine layout PCR 160 - 14000QS	Date/Name	Name	Scale: 1:20	Paper-Size: A2	
Änderungen nur mit Genehmigung	04.04.22		Drawn	Benj. Valentin	Sheet: 1		
Weitergabe sowie Vervielfältigung dieser Unterlage, sowie Verwertung und Mitteilung ihres Inhalts nicht gestattet!			Checked		Sheet-Size: A2		
			Approved		Machine: PCR 160		
			Date	Name	Machine layout		
			04.04.22	Benj. Valentin	Machine Layout PCR 160 - 14000QS		
			04.04.22	Benj. Valentin	KT6000/ 7000/ 2700/ 8017 Tisch		
			04.04.22	Benj. Valentin			
			04.04.22	Benj. Valentin			
			04.04.22	Benj. Valentin







E1 switch cabinet

1) 480V 60 Hz
connected load 143 kVA
nominal current 168 A
pre-fuse 230 A
line cross section 4x 107 mm^2

2) prefuse connection
120 V / 60 Hz
connected load 4 A
pre-fuse 16 A
line cross section 2,1 mm^2

P1 pneumatics inlet machine

nominal pressure 10 bar (minimal 6 bar)
V = 12 m^3/h
connected line NW10
filtration required: 40 µm

P2 pneumatics inlet table

~~nominal pressure 10 bar (minimal 6 bar)~~
~~V = 1 m^3/h~~
~~connected line NW6~~
~~filtration required: 40 µm~~
unknown

Table BOST HT-120
connected load and
pneumatics inlet
unknown

All depth measurements are dependent on the height of the floor plate!

dependent on chip conveyor

customer: United Precision Services. Inc.

CAD-Zeichnung -erstellt in AutoCAD -Änderungen nur über CAD zulässig			ALLg. Toleranzen: ISO 2768-mK, Kant.maße ±0,1			Werkstückkanten DIN 6784 Innenkanten / Außenkanten		Oberflächenrauheit Ra in µm DIN ISO 1302		Maßstab 1:20		Masse bg. fertigt 0			
alle Rechte vorbehalten, Schutzvermerk nach DIN 34 beachten			Über	bis	Tol.					Halbzeug- Rohteil- Mat.Nr.				Werkstoff:	
			0,5	6	±0,1	Bearb.	04.08.11	Haertlsch		Benennung: Machine Layout PCR 160 - 1400005 X15000/ Y6000/ Z1500/ BOST Tisch					
			6	30	±0,2	Gepr.	04.08.11	Haertlsch							
			30	120	±0,3	ÄV									
			120	315	±0,5	geplottet am: 04.08.2011									
			315	1000	±0,8	UNION Werkzeugmaschinen GmbH D-09116 Chemnitz				Ident.-Nr.: 7.44.0024.07.00-04				Blatt 2/2	
			1000	2000	±1,2										
			2000	4000	±2,0										
Änd.	Änd.mit.	Name	4000	8000	±3,0	ERV Nr. 7.44.0024.07.00-04				Ers. für:				Ers. durch:	

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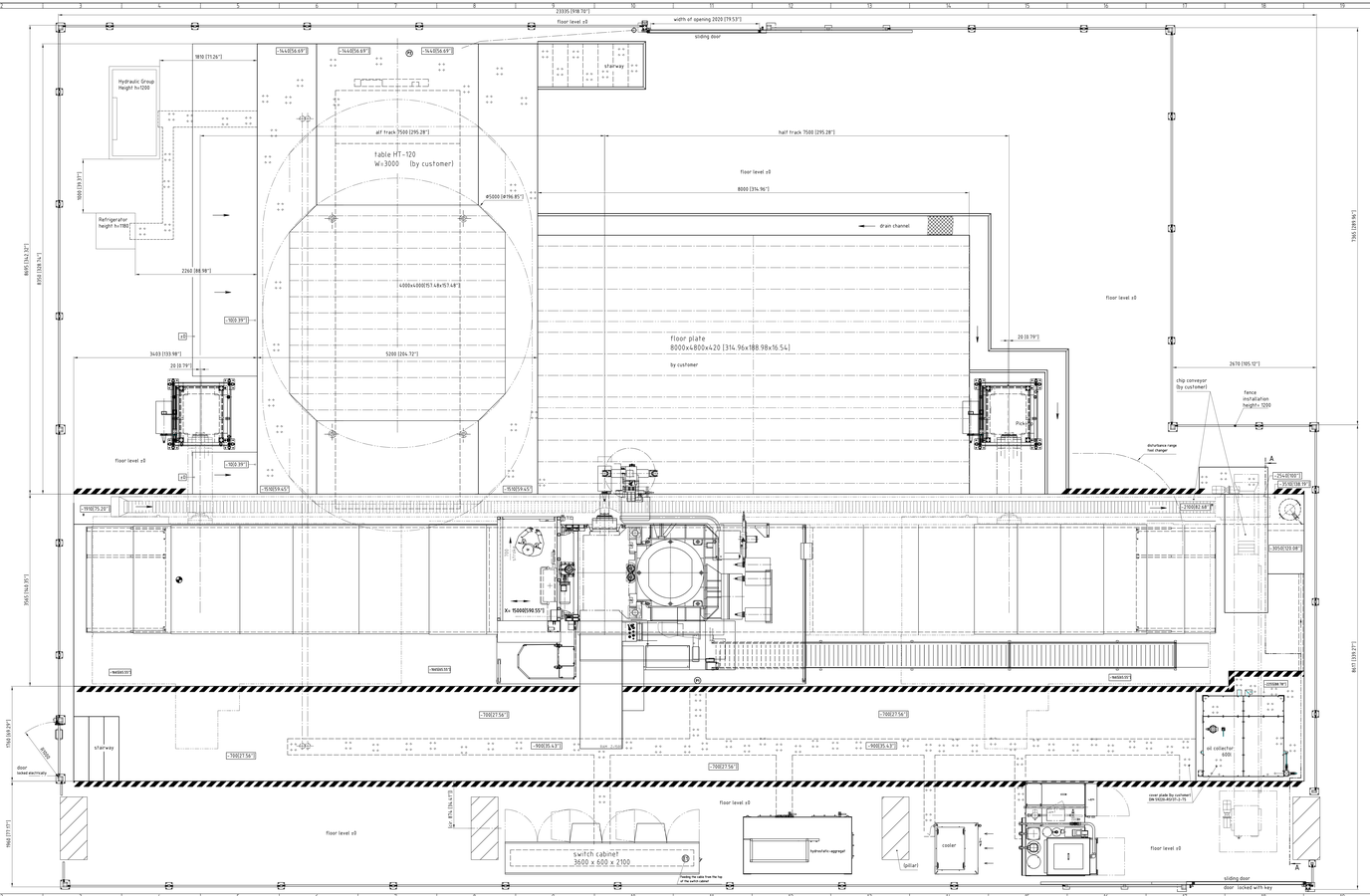

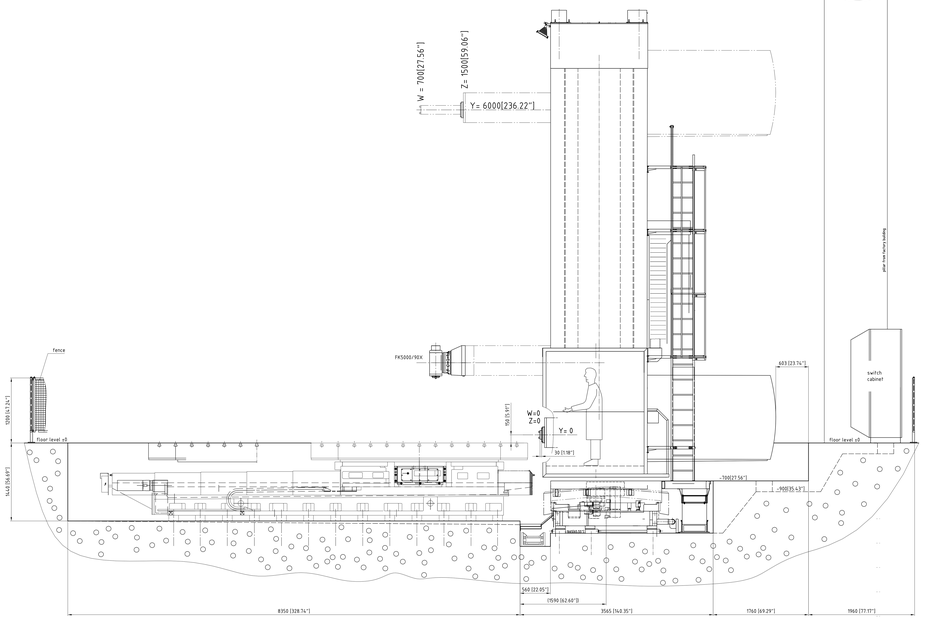

yellow-black stripes / danger zone

slope

zero point - foundation layout

* dependent on chip conveyor

XXX foundation hight related by floor level

machine layout is only valid with machine number

Before starting the engine, all channel covers, plates for metal shavings and steel grating on the chip conveyor fo assemble!

customer: United Precision Services, Inc.

KX-Zeichnung erstellt in AutoCAD	Benj. Valentell	Benennung des Blattes	Machine Layout PCR 160 - 14000QS	Name	Datum	Unterschrift	Maßstab	1:20	Blatt-Nr./Anzahl Blätter 2
Alle CAD-Zeichnungen sind mit dem Stand der Technik erstellt	07.04.21	Benennung des Blattes	KT6000/ 7000/ 2700/ 8000/ 15x5	Gezeichnet	Benj. Valentell	07.04.21	Maßstab	1:20	wanscott
Änderungen	Ver.	Datum	Name	Geprüft			Normalmaß		
	00	07.04.21	Benj. Valentell	Normalmaß			Gewicht		
	01	14.04.21	Benj. Valentell	Benennung des Blattes			Machine Layout PCR 160 - 14000QS		
	02	14.04.21	Benj. Valentell				KT6000/ 7000/ 2700/ 8000/ 15x5		
	03	14.04.21	Benj. Valentell						
	04	14.04.21	Benj. Valentell						
	05	14.04.21	Benj. Valentell						
	06	14.04.21	Benj. Valentell						
	07	14.04.21	Benj. Valentell						
	08	14.04.21	Benj. Valentell						
	09	14.04.21	Benj. Valentell						
	10	14.04.21	Benj. Valentell						
	11	14.04.21	Benj. Valentell						
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	14	14.04.21	Benj. Valentell						
	15	14.04.21	Benj. Valentell						
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	30	14.04.21	Benj. Valentell						
	31	14.04.21	Benj. Valentell						
	32	14.04.21	Benj. Valentell						

UNION
EUROPEAN
MACHINE TOOLS

Machine Layout PCR 160 - 14000QS
KT6000/ 7000/ 2700/ 8000/ 15x5

Dok.-Nr.: 7.44.0024.07.00-05

Blatt: 1/1

Erst. Datum: Name: | Zeichnungsnummer: 7.44.0024.07.00-05 | Ersetzt für: | Ersetzt durch:

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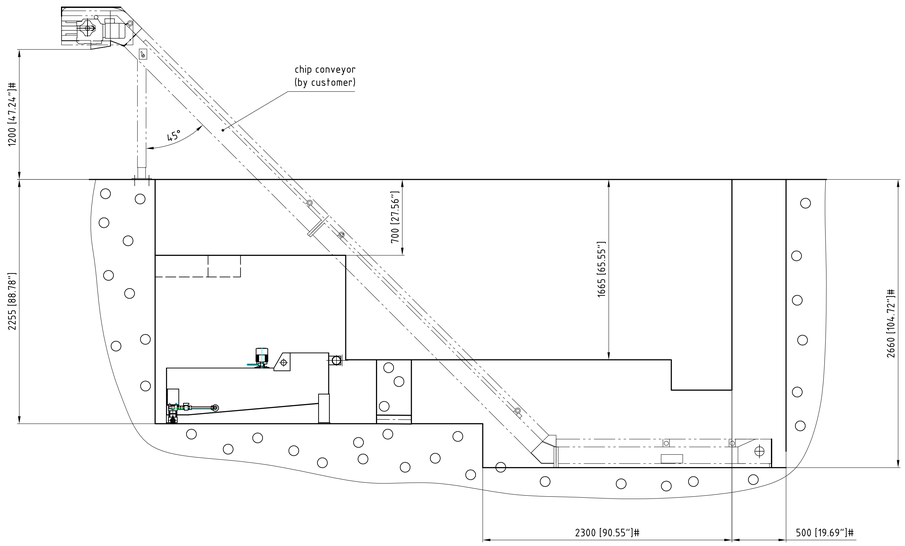
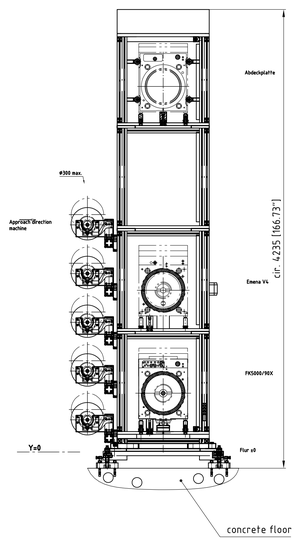
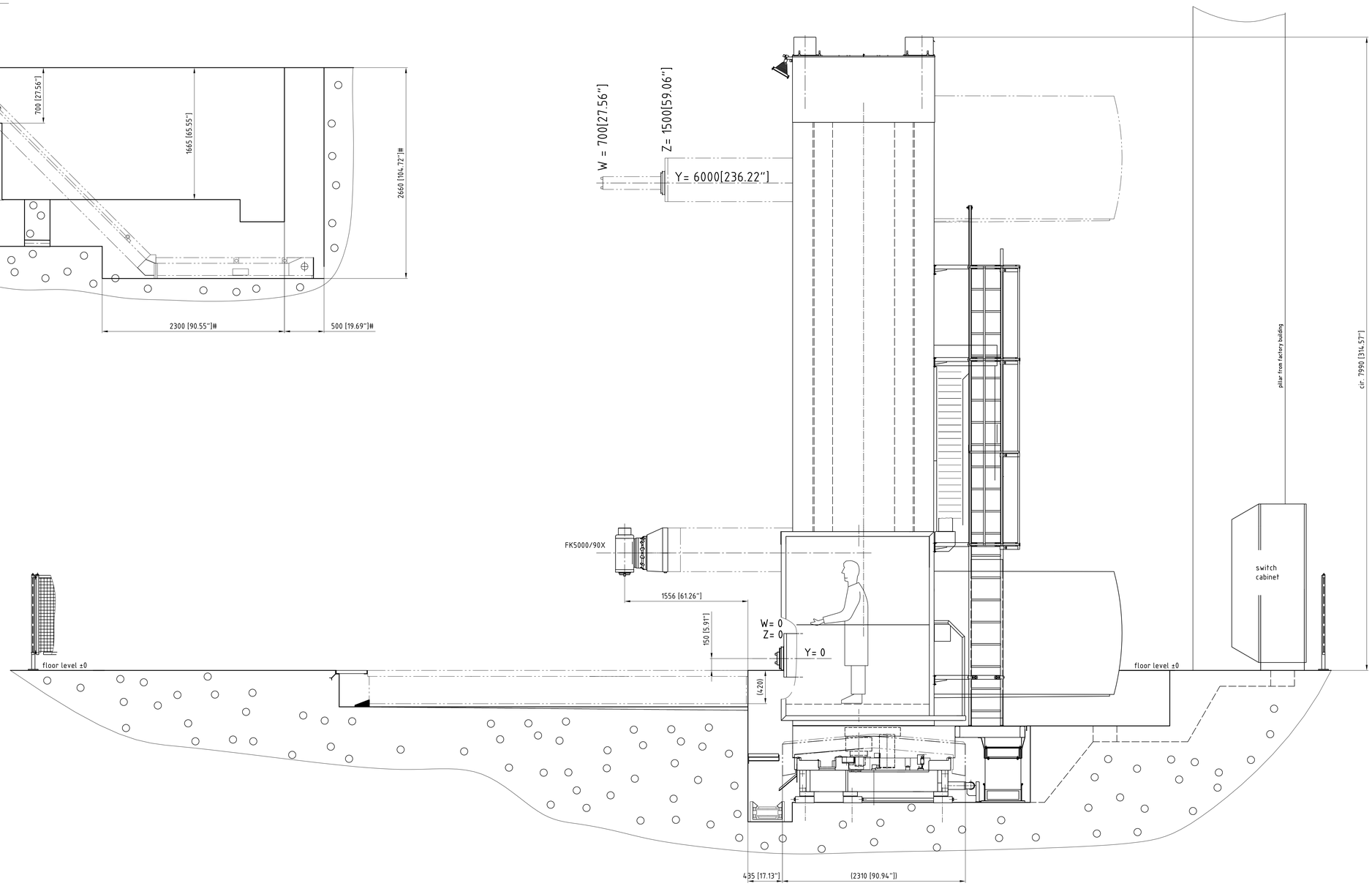
A-A







E1 switch cabinet

1) 480V 60 Hz
connected load 143 kVA
nominal current 168 A
pre-fuse 230 A
line cross section 4x 107 mm^2

2) prefuse connection
120 V / 60 Hz
connected load 4 A
pre-fuse 16 A
line cross section 2,1 mm^2

P1 pneumatics inlet machine

nominal pressure 10 bar (minimal 6 bar)
V = 12 m^3/h
connected line NW10
filtration required: 40 µm

P2 pneumatics inlet table

~~nominal pressure 10 bar (minimal 6 bar)~~
~~V = 1 m^3/h~~
~~connected line NW6~~
~~filtration required: 40 µm~~
unknown

Table BOST HT-120
connected load and
pneumatics inlet
unknown

customer: United Precision Services. Inc.

All depth measurements are dependent on the height of the floor plate!

dependent on chip conveyor

CAD-Zeichnung -erstellt in AutoCAD -Änderungen nur über CAD zulässig				Allg. Toleranzen: ISO 2768-mK, Koord.maße ±0,1		Werkstückkanten DIN 6784, innenkanten ±0,5 außenkanten ±0,2		Oberflächenrauheit Ra in µm DIN ISO 1302		Maßstab 1:20	Masse (kg, fertig) 0
										Halbzeug- Rohteil- Mat.Nr.	Werkstoff:
alle Rechte vorbehalten, Schutzvermerk nach DIN 34 beachten				Über	bis	Tol.		Datum	Name	Benennung: Machine Layout PCR 160 - 1400005 X15000/ Y6000/ Z1500/ BOST Tisch	
				0,5	6	±0,1	Bearb.	08.08.11	Haeftasch		
				6	30	±0,2	Gepr.	08.08.11	Haeftasch		
				30	120	±0,3	ΔV				
				120	315	±0,5	geplottet am 08.08.2011				
				315	1000	±0,8	UNION Werkzeugmaschinen GmbH D-09116 Chemnitz			Ident.-Nr.: 7.44.0024.07.00-05	Blatt 2/2
				1000	2000	±1,2					
				2000	4000	±2,0					
				4000	8000	±3,0	DV Nr. 7.44.0024.07.00-05			Ers. für:	Ers. durch:
Änd.	Änd.mit.	Name									

Die überlassenen Zeichnungen und Gestaltungsvorschläge bleiben unser Eigentum. Es ist ohne unsere Zustimmung nicht erlaubt, sie Dritten zugänglich zu machen oder zu anderen Zwecken als zu dem vereinbarten Zweck verwenden zu lassen. Auch nach Erfüllung der Aufträge sind diese Unterlagen unverzüglich zurückzusenden.