MARION MANUFACTURING - MORTON, IL FACILITY

Horizontals

	18 PALLET POOL SYSTEM			24 PALLET POOL SYSTEM	
Machine Number	M589	M593	M596	M3506	M3508
Mfg	Toyoda	Mori Seiki	Mori Seiki	Mori Seiki	Mori Seiki
Model	FA630	MH-630	MH-630	SH8000	SH8000
Year	1998	1998	1999	2002	2002
Horsepower	30/22	25/22	25/22	50/40	50/40
Table Size (Pallet)	24.8 X 24.8	24.8 X 24.8	24.8 X 24.8	31.5x31.5	31.5x31.5
X Travel	33.276	39.37	39.37	51.1	51.1
Y Travel	35.433	43.34	43.34	49.2	49.2
Z Travel	36.417	42.15	42.15	43.3	43.3
Gear Range 2	8000	6000	6000	10000	10000
# of Tools	120	180	180	240	240
Max Tool Length	19.7	19.7	19.7	19.7	19.7
Max Tool Diameter	11.8	11.8	11.8	12.6	12.6
Max Tool Weight	60	66	66	66	66
Rapid Traverse X & Y	1181	787.4	787.4	1653	1653
Rapid Traverse Z	1181	787.4	787.4	1653	1653
Chip to Chip Toolchange	2	2.5	2.5	2.5	2.5
Rigid Tapping	Y	Y	Y	Y	Y
High Pressure Coolant	Y	Y	Y	Y	Y
Coolant Thru	Y	Y	Y	Y	Y
Probe Capability	Y	Y	Y	Y	Y
Full 4th Capability	N	N	N	N	N

Horizontals

	STAND ALONE MACHINES								
Machine Number	M597	M44	M59	M40	M58	M549	M551	M552	M580	M588	M590
Mfg	Mori Seiki	Mori Seiki	Nigata	Mitsubishi	Daewoo	Mori Seiki	Mori Seiki	Mori Seiki	Mori Seiki	Mori Seiki	Mori Seiki
Model	MH-630	MH-633	SPN63A	MH80D	H100	MH-40	MH-40	MH-403	SH-630	SH-630	SH-630
Year	1999	2001	2005	1998	2003	1996	1994	200	1998	2001	1998
Horsepower	25/22	30	40	25	35	15/10	15/10	15/10	40/33	40/33	40/33
Table Size (Pallet)	24.8 X 24.8	24.8 X 24.8	24.8 X 24.8	31.5 X 31.5	39.4 X 39.4	15.7 X 15.7	15.7 X 15.7	15.7 X 15.7	24.8 X 24.8	24.8 X 24.8	24.8 X 24.8
X Travel	39.37	39.348	39.4	49.2	78.7	22.046	22.046	22.046	33.1	33.1	33.1
Y Travel	43.34	33.5	34.6	39.4	49.2	21.656	21.656	21.656	31.9	35.8	31.9
Z Travel	42.15	36.2	31.5	41.3	49.2	24.0157	24.0157	24.0157	38.9	38.9	38.9
Gear Range 2	6000	50-10000	50-8000	30-4000	25-4500	6000	6000	7000	10000	15000	10000
# of Tools	180	60	60	80	90	40	40	60	180	180	180
Max Tool Length	19.7	19.7	17.7	19.7	23.6	11.8	11.8	11.8	19.6	19.6	19.6
Max Tool Diameter	11.8	4.7	9.4	5	11.8	5.9	5.9	5.9	11.8	11.8	11.8
Max Tool Weight	66	66	66	33	55	26.4	26.4	26.4	66	66	66
Rapid Traverse X & Y	787.4	1100	1969	787	472	787.4	787.4	787.4	1260	1260	1260
Rapid Traverse Z	787.4	1100	1772	590	472	787.4	787.4	787.4	1260	1260	1260
Chip to Chip Toolchange	2.5	4.6	5.5	9	12	1.5	1.5	1.5	2.5	2.5	2.5
Rigid Tapping	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y
High Pressure Coolant	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y
Coolant Thru	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y
Probe Capability	Y	Y	Y	Y	Y	N	N	Y	Y	Y	Y
Full 4th Capability	N	Y	N	N	N	N	N	N	Y	N	N

Lathes

Machine Number	M35	M38	M531	M584	M592	M594
Mfg.	Femco	Femco	Okuma	Okuma Howa	FUJI	Mori Seiki
Model	WNCL-35	WNCL-30	2SP-30H	2SP-V55	ANW41T	SL-303B-7
Year	1996	1997	1994	1999	1999	2000
Horsepower	30/40	15/20	18/18	40/40	40/40	30/24.8
X Travel	11.31	6	8.66	13.5	10.433	9.8
Z Travel	45.27	18	9.05	26.1	18.11	31.5
Max Turning Diameter	21.25	3	12.2	21.7	12.2	16.5
Max Swing	12.8 Radially	5 Radially	12.5	28	12.5	16.75
Chuck Size	15"	Collet	12	24	12	12
Dist. Between Centers	49.6				5" max	129.3
Gear Range 1	2500	4000	3500	2000	3000	2500
# of Tools	12	12	12	12	12	10
Rapid Traverse X	236	236	9.44	787.4	20	590 3/5
Rapid Traverse Z	420	420	1181	787.4	20	944 8/9
Chip to Chip Toolchange	4	4	2.7	3	2.7	2
Constant Surface Speed	Y	Y	Y	Y	Y	Y
High Pressure Coolant	Y	N	N	N	N	N
Coolant Thru	Y	Y	Y	Y	Y	Y
Bar Feeder	N	Y	N	N	N	N

Verticals

Machine Number	M21	M27	M46	587
Mfg	Mitsubishi	Mitsubishi	Mitsubishi	Mori Seiki
Model	MV60	MV-60	MV-5C	MV-65 APC
Year	1990	1992	2000	1998
Horsepower	15	15	15	20/15
X Travel	39.348	39.348	31.5	60
Y Travel	23.66	23.66	20.1	25.66
Z Travel	21.675	29.6125	18.1	25.6
4th Diameter	12.6	12.6		

Misc

Machine Number	Lapper
Mfg	
Model	
Year	
Horsepower	
X Travel	
Y Travel	
Z Travel	
4th Diameter	

4th Max Swing	**10.151 radially**	**11.5 radially**		**67 X 25.56**				**26" dia. Ring**								
Gear Range 1	**20-800**	**20-800**		**6000**												
Gear Range 2	**801-4000**	**801-4000**	**80-8,000**	**6000**												
# of Tools	**24**	**40**	**18**	**40**												
Max Tool Length	**15**	**15**	**9.84**	**13.78**												
Max Tool Diameter	**5**	**5**	**3.35**	**9.5**												
Max Tool Weight	**33**	**33**	**15**	**44**												
Rapid Traverse X & Y	**590.5**	**590.5**	**1181**	**590.55**												
Rapid Traverse Z	**472.4**	**472.4**	**787**	**472.44**												
Chip to Chip Toolchange	**9**	**9**	**3**	**2.5**												
Rigid Tapping	**Y**	**Y**	**Y**	**Y**												
High Pressure Coolant	**N**	**N**	**Y**	**Y**												
Coolant Thru	**N**	**N**	**Y**	**Y**												
Coolant Adapter	**Y**	**N**	**Y**	**N**												
Adapter Block	**Y**	**Y**	**Y**	**N**												