

DYNABEST GmbH
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Hydraulische Pressen
 Hubgesteuerte Richtpressen
 DUNKES Check-Lift-System
 Innenhochdruckanlagen
 Pneumatische Pressen
 Universal-Nietmaschinen
 Sondermaschinen
 Engineering

Your Inquiry dated
 21-Aug-2013/meeting

Your ref.
 Kevin Zhao

Our ref.
 Hö/ba

Dep./Direct no.
 VKF/-27

Date
 03-Sep-2013

BUDGET-QUOTATION NO. P 5921-13-A

| Pc. | D e s i g n a t i o n | Unit Price / EUR | Total Price / EUR |
|-----|-----------------------|------------------|-------------------|
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Customs Tariff No.: 8462 9980



Picture: *DUNKES* Wobble Riveting Machines – standard series (5 kN – 40 kN)
 with optional foot control



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Pos. 1

1 **DUNKES** WOBBLE RIVETING MACHINE, MODEL DNX 05

TECHNICAL DATA:

| | | |
|--|------|-----------|
| Force (6 bar) | kN | 7,5 |
| Max rivet diameter, Steel full rivet material ST 37 | mm | 7 |
| Stroke | mm | 50 |
| Daylight | mm | 100 |
| Throat | mm | 100 |
| Table size w x d | mm | 115 x 160 |
| T-slot length-wise in table, DIN 650 | mm | 8H8 |
| Outlet in table, Ø | mm | 32 |
| Adjustable rivet times | unit | 0-10 |
| Motor power | kW | 0,25 |
| Voltage (60 Hz) | V | 230/400 |
| Rivet head size | | 1 |
| Connection diameter | inch | R 3/8 |
| Net weight approx. | kg | 80 |

Price

11.300,00



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Pos. 1.1

1 **DUNKES** WOBBLE RIVETING MACHINE, MODEL DN 2

TECHNICAL DATA:

| | | |
|--|------|-----------|
| Force (6 bar) | kN | 20 |
| max rivet diameter, steel full rivet material ST 37 | mm | 12 |
| Stroke | mm | 100 |
| Daylight | mm | 120 |
| Throat | mm | 120 |
| Table size w x d | mm | 210 x 205 |
| T-slot length-wise in table, DIN 650 | mm | 12H8 |
| Outlet in table, Ø | mm | 50 |
| Adjustable rivet times | unit | 0-10 |
| Motor power | kW | 0,55 |
| Voltage (60 Hz) | V | 230/400 |
| Rivet head size | | 2 |
| Connection diameter | inch | R 3/4 |
| Net weight approx. | kg | 180 |

Price

12.500,00

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Pos. 1.2

1 **DUNKES** WOBBLE RIVETING MACHINE, MODEL DNX 2

TECHNICAL DATA:

| | | |
|--|------|-----------|
| Force (6 bar) | kN | 20 |
| max rivet diameter, steel full rivet material ST 37 | mm | 12 |
| Stroke | mm | 100 |
| Daylight | mm | 240 |
| Throat | mm | 200 |
| Table size w x d | mm | 210 x 270 |
| T-slot length-wise in table, DIN 650 | mm | 12H8 |
| Outlet in table, Ø | mm | 50 |
| Adjustable rivet times | unit | 0-10 |
| Motor power | kW | 0,25 |
| Voltage (60 Hz) | V | 230/400 |
| Rivet head size | | 2 |
| Connection diameter | inch | R 1 |
| Net weight approx. | kg | 270 |

Price

13.500,00

| Pc. | D e s i g n a t i o n | Unit Price / EUR | Total Price / EUR |
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Pos. 1.3

1 DUNKES WOBBLE RIVETING MACHINE, MODEL DN 4

TECHNICAL DATA:

| | | |
|--|------|-----------|
| Force (6 bar) | kN | 40 |
| max rivet diameter, steel full rivet material ST 37 | mm | 20 |
| Stroke | mm | 54 |
| Daylight | mm | 179 |
| Throat | mm | 200 |
| Table size w x d | mm | 210 x 270 |
| T-slot length-wise in table, DIN 650 | mm | 12H8 |
| Outlet in table, Ø | mm | 50 |
| Adjustable rivet times | unit | 0-10 |
| Motor power | kW | 1,1 |
| Voltage (60 Hz) | V | 230/400 |
| Rivet head size | | 3 |
| Connection diameter | inch | R 1 |
| Net weight approx. | kg | 300 |

Price

14.700,00

TECHNICAL FEATURES OF EACH MACHINE :

- Force variably adjustable
- Ram speed regulation variably adjustable
- Stroke limitation inc. micrometer screw variably adjustable
- Rivet time variably adjustable
- Two-hand safety control
- Automatic rivet run
- Standard rivet snap

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ATTACHMENT FOR ALL MACHINE MODELS:

Pos. 2

1 Frame stand, 700 mm
 (steel weldment)

Price 980,00

Pos. 3

1 Switch-over to floor operation (lock)
 A save tool is required for foot operation!

Price 370,00

Pos. 4

1 Stroke counter, 6 digits

Price 150,00

Pos. 5

1 Measuring tape, mounted at the sleeve of depth stop,
 for a better pre-adjustment of depth-stop

Price 160,00

Pos. 6

1 Maintenance unit (oiler, filter)

| | | |
|--------------|---------------------|---------------|
| Price | DNX 05 | 220,00 |
| Price | DN 2 / DNX 2 | 320,00 |
| Price | DN 4 | 390,00 |

Work-holding devices to be supplied by the customer.

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Pos. 7

Force / distance measuring for all riveting machine models

Force / distance measuring device, mounted adaptive on each riveting machine



Picture 1 : Example of equipment with a force/path measuring device on a standard riveting machine, model DN 2

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Following Items are required for this purpose:

Pos. 7.1

- 1 **Riveting force / path control** (*indirect detection*):
make KISTLER

Riveting force / path measuring device for process manufacturing, LCD monitor integrated at the front side in a switchgear cabinet. (please also see picture 1).

Pos. 7.2

Force / path measuring system:

Mechanical assembly existing of following units:

- 1 DMF-P A 300, model 4737 - controller for force / path signal
- front panel with LCD – screen and keyboard
- all connections are available on plugs
- with main switch and pluggable 110-230 V AC-connector
- complete software integrated

Integrated sensor connectors Y-axis (pressure force):
DMS- full bridge or 0 10 V signal

Integrated sensor connectors X-axis (pressure force)
Potentiometric sensors and 0 10 V signal.

Standard features:

- Display of pressure force / path curve on integrated LCD screen
- Output of pressing data (actual value / set value) over serial interface (RS 232) or optional printer (Centronics interface)
- Up to 32 selectable set point records
- Up to 8 programmable pressure force / path windows per set value
- Evaluation of with IO output and NIO output (24 V active) for resource control, galvanic separated
- Final position monitoring
- Block force monitoring
- Complete system self monitored
- Sub-D cable plug (50 terminals 9307)

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- 1 Force sensor, mounted at the front of the press frame



Force sensor

- 1 measuring cable for the force sensor inc. double sided plugs
- 1 Path sensor, mounted in an additional bracket, distance 50 mm



Path sensor

- 1 measuring cable for the force sensor inc. double sided plugs

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Pos. 7.3

Activation of pressing-in-path control by integrated SIEMENS-control S7-300, mounted in the switchgear cabinet.
Switchgear cabinet mounted on a console on the left side of the riveting machine.

Price for Pos. 7.1 – 7.3

16.800,00

Pos. 7.4

Additional control extention:

After notice of malfunction appears, an acoustic signal is given by the riveting machine when the riveting process is finished and the riveting head is in home position in TDC.

The acoustic signal can be cleared via removable key switch after removal of the N.I.O. part from the customer-supplied workholding device.

Surcharge

650,00

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SERVICE ITEMS:

Pos. 8

Documentation 2-fold in English, according to DIN EN ISO 12100-1 / 2 and labelling of the machine in English

Included in the machine price

Pos. 10.1

Documentation 2-fold in CHINESE, according to DIN EN ISO 12100-1 / 2 and labelling of the machine in CHINESE

Price will be charged according to costs incurred

Pos. 9

FOB Hamburg, incl. seaworthy packaging

| | |
|----------------------------|-----------------|
| Price, DNX 05, DN 2 | 1.400,00 |
| Price, DN 4, DNX 2 | 1.800,00 |

alternatively:

Pos. 9.1

FOB German Airport
Packaging for transport by airfreight (wooden crate)

| | |
|----------------------------|-----------------|
| Price, DNX 05, DN 2 | 1.300,00 |
| Price, DN 4, DNX 2 | 1.700,00 |

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Commercial Conditions

Price Quotation: Ex works, excl. packaging, excl. transport insurance, duty unpaid (on the basis of INCOTERMS)

Quotation Validity: 31-Oct-2013

Delivery Period: **Approx. 3 – 4 months**, i.e. after agreement and after all technical and commercial details were clarified.

In case the supplier needs some documentation or parts from the purchaser, which are necessary for construction, the purchaser shall place them at supplier's disposal free of any charges. Period of delivery is subject to receipt of this documentation. In case additional changes will be necessary from the part of the purchaser, which influence construction, the delivery period will change in accordance to the job to be performed.

Delivery: in accordance to attached Terms of Delivery, No. 188 incl. following supplement:

We exclude the following:

The liability for follow-damages, i.e. damages which do not arise or are not arisen at the delivered part itself.

The liability for delay damages, i.e. further-going claims arising from delay damages are excluded. In case of delay the customer can cancel the contract but cannot request compensation because of non-fulfilment.

This is not valid if DUNKES can be charged for doing it wilfully or with gross negligence.

Payment: 100 % payable after advice of ready for dispatch with 10 days before delivery, strictly net

Varnishing: green, in accordance to RAL 6011
special colour on request against additional charge

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Warranty:

We accept a material guarantee for a period of 12 months, at the most 13 months after delivery. Provision is an operation in line with our operating manual.

Within the guarantee time the maintenance of the riveting machine has to be carried out and documented as stated in the operating manual.

Not included in the guarantee are wearing parts.

In case the delegation of one of our assemblers should become necessary within this time of warranty, following additional costs will arise:

- Flight GERMANY – CHINA
- Return flight CHINA - GERMANY
- Travel time for flight there and return
- Expenses, hotel accommodation, hire car, etc.

The service times on site will be carried out free of costs within the warranty time.

If spare parts are exchanged, the defective spare part has to be returned to us free of costs.

Erection/Initial Operation:

To be executed by you, or to be effected by our assembler against evidencing documentation, to your account.

Place of Jurisdiction:

Seat of Supplier

The machine will be accepted in our works.

**S. DUNKES GmbH
Maschinenfabrik**

i. A. Kuno Hölldampf