

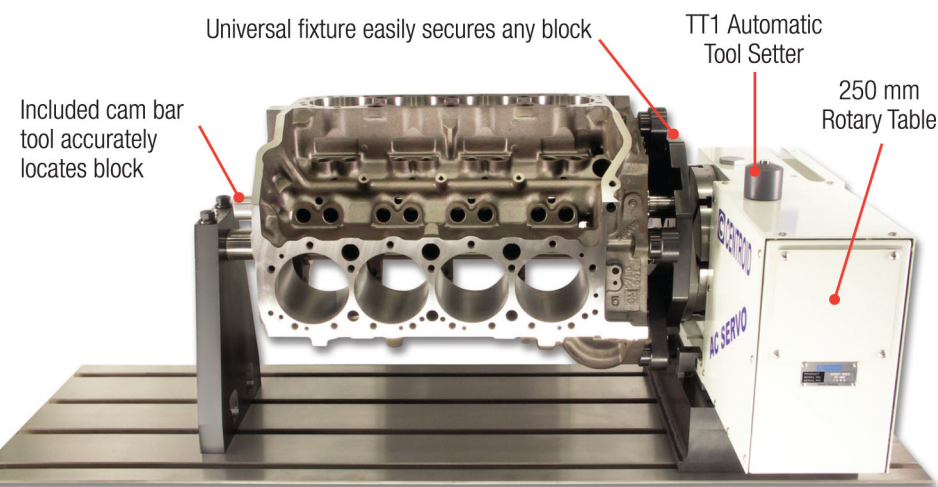
Discover the CENTROID advantage with the B4250 CNC Engine Block Machining Center: We provide the machine, tooling, software, and personalized on-site training you need to be successful. In addition to the included ready-to-run block programs, our conversational software gives you the power & flexibility to easily add new blocks and operations, so you'll never need to purchase additional programs or edit G-Code. The CNC control, digitizing probe, universal block fixture, and software are all made in the USA by CENTROID, allowing us to provide unmatched service and support. Contact your CENTROID representative today to start building race-winning engines with the B4250!

B4250 Machine Specifications

Table Size:	18" x 56" (457 mm x 1422 mm)
Longitudinal travel (X):	41" (1041 mm)
Cross travel (Y):	21" (533 mm)
Vertical travel (Z):	34" (864 mm)
Spindle nose to table top:	39" (991 mm)
Spindle center to column:	22" (659 mm)
Maximum table load:	2420 lbs (1100 kg)
Spindle power:	10 HP / 7.5 kW
Spindle speed:	6000 RPM
Automatic Tool Changer:	24 Position Swing Arm
Rapid feed rates (X, Y, Z):	X-400, Y-400, Z-350 IPM
Accuracy:	0.0005" (0.0127 mm)
Repeatability:	0.0002" (0.006 mm)
Axis drive motors (X, Y, Z):	1 kW AC Brushless Servos
Coolant pump:	1/8 HP / 55 Gal. Capacity
Auto lubrication pump:	150 W
Power requirement:	14 kVA, 50-60 Hz, 208-240v, 3-phase
Air requirement:	90-100 PSI
Machine Footprint:	L 134" (3404 mm), W 92" (2337 mm), H 123" (3124 mm)
Shipping Footprint:	L 88" (2235 mm), W 96" (2438 mm), H 98" (2490 mm)
Weight:	Machine: 10,077 lbs (4,570 kg) Fixture: 612 lbs (278 kg)
Boring Diameter Range:	0.984" – 1.26" (25 – 32 mm), 2.68" – 5.91" (68 – 151 mm)*
Boring Depth (Max):	9.5" (242 mm)*
Milling Width (Max):	12" (305 mm)*

*as tooled

Universal Block Fixture



Warranty

One year warranty for parts, labor and technical support.

M400 CNC Control Features

Standout Control Features Include: Intercon conversational software with Engine Block interface, digitizing and probing cycles, graphical program preview, automatic tool measurement, sub-programs and macros, rigid tapping, extensive canned cycles including threadmilling, cutter radius compensation, Millwrite engraving software, part scaling and mirroring, and Mold Magic moldmaking software.

Standard block programs: Pre-loaded programs for Small and Big Block Chevrolet, Ford, and Chrysler with the ability to easily modify or create your own program for any block in minutes!

Standard Tooling Package



Included Standard Tooling Package*:

- Cylinder Boring Tool
- Tool Setting Micrometer
- 12" Deck Surfacing Tool
- Lifter Boring Tool and Lifter Spot Facing Tool
- Cylinder Bore Chamfering Tool
- Main Cap Conversion Tooling
- Digitizing Touch Probe



Open machine configuration also available



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CENTROID™

B4250
CNC Engine Block Machining Center



B4250

CENTROID

Do More With a CENTROID!



1 Probe

Automated probing provides quick & easy block setup. Probe any standard or custom points, verify data, and compare to blueprint.

2 Select Program

Load existing or easily create new programs using probed, blueprint, or custom data. No G-code required!

3 Cut

The selected operations are performed with the push of a button.

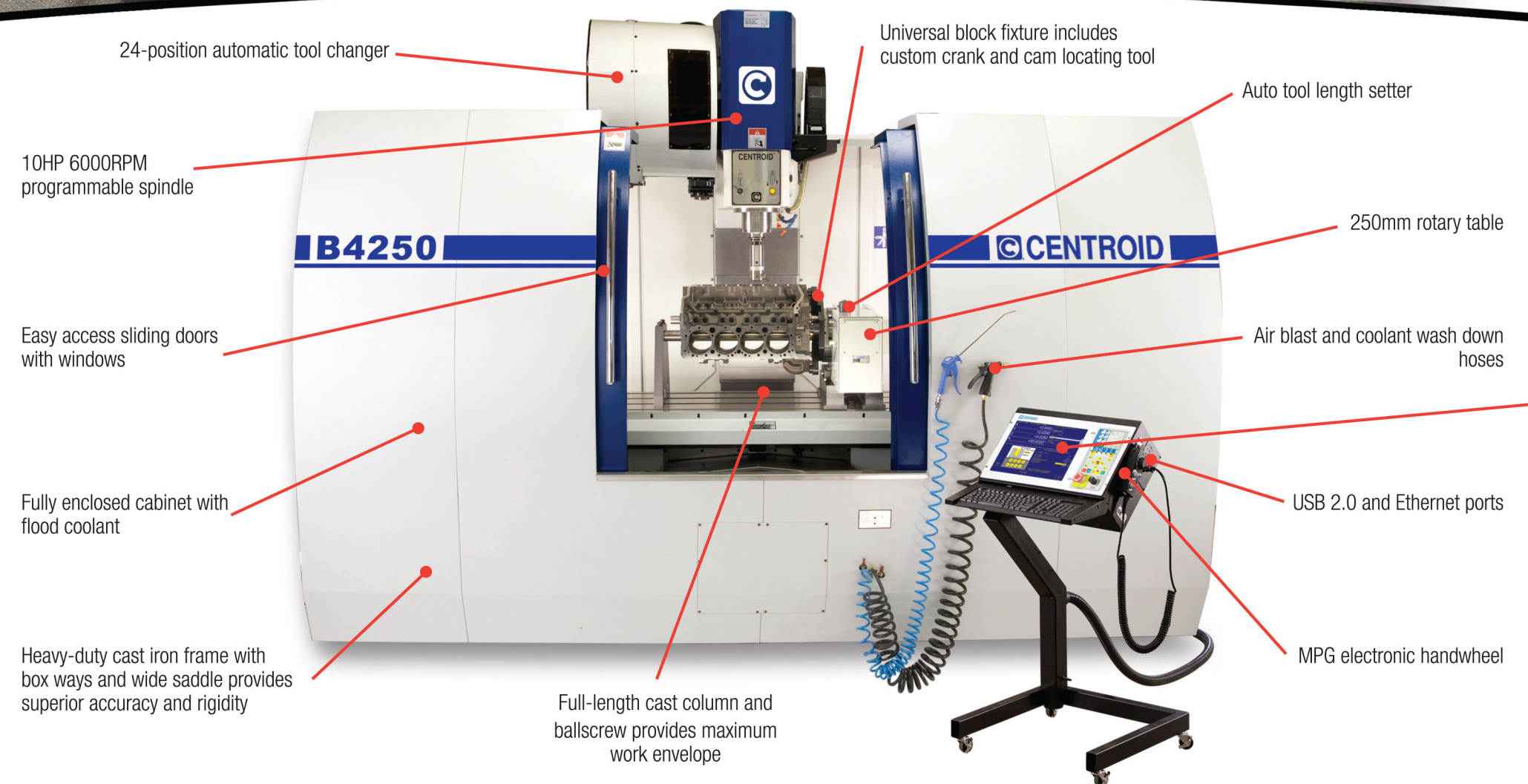
4 Generate Report

Create detailed reports including blueprint data and deviations. Even add your own custom logo!

CENTROID									
Customer Information:									
Customer Name: Wilson Racing									
Tel. Number: 814-665-1212									
Block Details:									
Block Name: Chevrolet VB - Small Block 350									
Block Notes: decked, bored cylinders, bored lifters									
Additional Notes: none									
Block Database Information:									
Number of Cylinders	Number of Decks	Deck Height	Bore Diameter	Bore Spacing	Bore Depth	Block Offset			
8.0000	80.0000	9.0250	4.0000	4.4000	6.0000	0.8800			
Number of Lifters	Intake Lifter Angle	Exhaust Lifter Angle							
16.0000	41.0000	41.0000							
Cylinder Bore Details:									
Cylinder Number	Blueprint X	Blueprint Y	Probed X	Probed Y	Probed Bore Dia.	X Deviation	Y Deviation	Bore Deviation	
1	2.4000	0.0000	2.3972	0.0032	4.0092	-0.0028	0.0032	0.0092	
2	6.8000	0.0000	6.7953	0.0037	4.0112	-0.0047	0.0037	0.0112	
3	11.2000	0.0000	11.1844	0.0048	4.0098	-0.0056	0.0048	0.0098	
4	15.6000	0.0000	15.5968	0.0061	4.0087	-0.0032	0.0061	0.0087	
5	2.0000	0.0000	3.2750	0.0052	4.0103	-0.0042	0.0052	0.0103	
6	7.6000	0.0000	7.6151	0.0021	4.0099	-0.0049	0.0021	0.0099	
7	12.0000	0.0000	12.0748	0.0048	4.0078	-0.0054	0.0048	0.0078	
8	16.4000	0.0000	16.4745	0.0055	4.0095	-0.0095	0.0055	0.0095	

- Turnkey System Includes**
- ✓ 4-Axis machining center
 - ✓ M400 CNC control
 - ✓ Universal block fixture
 - ✓ Conversational block software
 - ✓ On-site personalized training
 - ✓ Standard tooling package
 - ✓ Digitizing probe
 - ✓ Auto tool length setter
 - ✓ 24-position automatic tool changer
 - ✓ MPG electronic handwheel
 - ✓ Industry's best warranty and support

Easily digitize block profiles for use in lightening with the included probe and software. Copy and cut nearly any 3D shape, and reproduce hard-to-find or unavailable parts!



24-position automatic tool changer

Universal block fixture includes custom crank and cam locating tool

Auto tool length setter

10HP 6000RPM programmable spindle

250mm rotary table

Easy access sliding doors with windows

Air blast and coolant wash down hoses

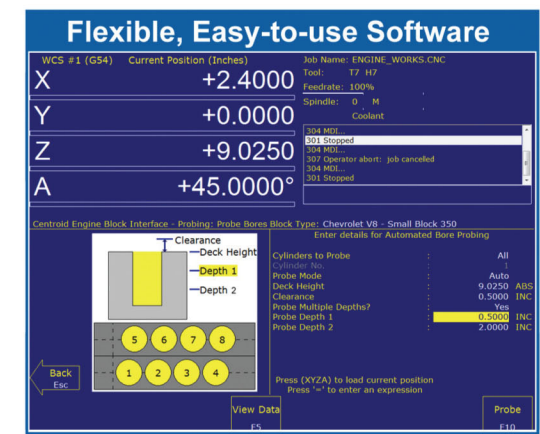
Fully enclosed cabinet with flood coolant

USB 2.0 and Ethernet ports

Heavy-duty cast iron frame with box ways and wide saddle provides superior accuracy and rigidity

Full-length cast column and ballscrew provides maximum work envelope

MPG electronic handwheel



Flexible, Easy-to-use Software

CENTROID's innovative conversational block-machining software allows you to quickly create or modify programs for any block. No G-code knowledge required. Expand your machine's capabilities at any time to include 5-axis cylinder head porting with an optional 5-axis upgrade!

