

MATERIAL PREPARATION



Laser cutting

| DEVICE | NUMBER OF CUTTING TORCHES INCL. BEVEL HEAD | NUMBER OF TABLES | TABLE SIZE IN [M] | MAX. PLATE THICKNESS |
|-----------|--|------------------|-------------------|----------------------|
| Microstep | 1 | 2 | 2 x 6 | Steel: 25 mm |

Plazma cutting

| DEVICE | NUMBER OF CUTTING TORCHES | NUMBER OF TABLES | TABLE SIZE IN [M] | MAX. PLATE THICKNESS |
|--|---------------------------|------------------|-------------------|----------------------|
| SPL-P 6001,15 Kjellberg Hi Focus 130 | 1 | 1 | 2 x 6 | - Steel: 20 mm |

Acetylen cutting

| DEVICE | NUMBER OF CUTTING TORCHES | NUMBER OF TABLES | TABLE SIZE IN [M] | MAX. PLATE THICKNESS |
|----------------------------------|---------------------------|------------------|-------------------|----------------------|
| Messer Griesheim CORTA P 3000 | 4 | 1 | 2 x 6 | Steel: 200 mm |

MATERIAL PREPARATION



BENDING/WELDING



Bending

| DEVICE | TABLE SIZE [M] | FORCE [KN] / ELEVATION[MM] |
|----------------|----------------|----------------------------|
| TrumaBend V320 | 4 | 3200 / 365 |

Welding

| DEVICE | CURRENT / A | PROTECTIVE ATMOSPHERE |
|-----------------------------|--------------------------|--------------------------|
| Welding set Kemppi MIG/MAG | 450 A | Ar+CO2+O2 |
| Welding robot | 30 - 500 A | |
| Uniaxial positioner - robot | D1400 – 4000 | Lifting capacity 1000 kg |
| Uniaxial positioner - robot | D700 - 1300 | Lifting capacity 500 kg |
| Welding positioners | Lifting capacity 9000 kg | |

BENDING/WELDING



MECHANICAL PROCESSING



NC centers

| DEVICE | WORKPIECE SIZE [MM] MAX [KG] | TABLE SIZE [M] |
|-------------------------|------------------------------|------------------|
| WF-80NC | 1600 x 1000 x 950 / 3000 kg | 850 x 850 – 1600 |
| WH-10CNC | 1250 x 1100 x 1000 / 3000 kg | 1000 x 1120 |
| WHNQ 13/15 CNC | 3500 x 2500 x 1600 | 2200 x 1800 |
| WQF80NCA | 1600 x 1000 x 2000 | 1600 x 840 |
| WMC1500S CNC | 1500 x 900 x 850 | 1700 x 850 |
| FANUC VMC1300S CNC | 1300 x 650 x 400 | 1500 x 650 |
| TAKANG DCM2152 CNC 5osé | 5200 x 2750 x 1100 | 5000 x 1800 |

CNC centers

| DEVICE | CLAMPING FACE | TABLE MOVEMENT X, Y, Z - W |
|--------------------------|---------------|----------------------------|
| FC 50 | 500 x 2000 | 500 x 560 x 1250 |
| FGCV50 | 1120 x 220 | 840 x 250 x 250 |
| CNC TAKANG DCM 2152 | | 5200 x 2750 x 1100 |
| TOS VARNSDORF WHQ 13 CNC | | 3500 x 2500 x 1600 - 800 |

MECHANICAL PROCESSING



Lathe turning

| DEVICE | SWING CLEARANCE / WORKPIECE DIAMETER [MM] | DISTANCE BETWEEN CENTRES/ MAX. WORKPIECE LENGTH [MM] |
|---------------|---|--|
| LTC-35XLY CNC | 540 | 2030 |
| SPT-16 NC | 160 | 500 |
| SPT-32 NC | 320 | 1500 |
| SUI40, 1M63B | 630 / 350 | 2800 |
| SV18RD | 180 | 800 |
| SN50B | 500 | 2100 |

Drilling

| DEVICE | WORKPIECE SIZE [MM] | TABLE SIZE [MM] |
|--------|---------------------|-----------------|
| VR4 | 590 (height) | 550 x 550 |
| VR5 NC | 1400 x 800 x 700 | 1600 x 1000 |

MECHANICAL PROCESSING



MECHANICAL PROCESSING



SURFACE FINISHING



| DEVICE | WORKPIECE SIZE [M] MAX. [KG] | NOTE |
|-------------------|------------------------------|--------------|
| Blasting | 0,45 x 0,9 x 0,32 / 1 500 kg | |
| Blasting | 10x5x4 | |
| Painting + drying | 10,6 x 4,9 x 4,3 | Wet painting |

SURFACE FINISHING

