

LIST OF MACHINES

Milling and turning center SKODA SR2 – 200 / 6m

year of construction 2008

max. swing over bed:	2,500 mm
max. swing over slide:	2,500 mm
distance between centers:	6,000 mm
max. machining weight:	30 t (between the peaks), optional 56 t
control:	Sinumerik 840 D

Milling and turning center Wohlenberg PC1S – 1600

year of construction 1995

max. swing over bed:	1,600 mm
max. swing over slide:	1,280 mm
distance between centers:	5,000 mm
max. machining weight:	16 t
control:	Sinumerik 880 T

Vertical turning machines Dörries – Scharmann

•VCE 2000; *year of construction 1991*

max. swing:	2,000 mm
faceplate diameter:	1,600 mm
max. turning length:	900 mm (overrunning height 1,050 mm)
control:	Sinumerik 850 T

•Contumat; *year of construction 2000*

with driven tools

max. swing:	1,600 mm
faceplate diameter:	1,400 mm
max. turning length:	890 mm
control:	Sinumerik 840 D

CNC – floor type boring machine Pama Speedram 2

year of construction 2000

traverse path (X Y (Z+W)):	9,000 x 2,400 x 1,700 mm
floor plate:	5,000 x 3,000 mm
- max. load capacity:	15 t/m ²
rotary table:	2,000 x 2,000 mm
- max. load capacity:	25 t
control:	Sinumerik 840 D

CNC machining centers Heller

• *MCP-H 250; year of construction 1998*

traverse path (X Y Z):	800 x 800 x 710 mm
clamping area:	630 x 500 mm
control:	Sinumerik 840 D

• *MCP-H 250 HS; year of construction 1996*

traverse path (X Y Z):	800 x 800 x 710 mm
clamping area:	630 x 500 mm
control:	uni-Pro 90

Center lathe Heyligenstaedt Heynumat HN 25 UK 2000

year of construction 1998

with driven tools

max. swing over bed:	890 mm
max. swing over slide:	660 mm
distance between centers:	2,000 mm
control:	Sinumerik 840 C

Moving column milling machine Kekeisen UFF 4000

year of construction 1997

traverse path (X Y Z):	4,000 x 1,500 x 1,200 mm
clamping area:	4,200 x 1,000 mm
with integrated rotary table:	1,000 x 1,000 mm
control:	Sinumerik 840 C

CNC milling machine CME BF 03

year of construction 1993

transfer path (X Y Z):	2,000 x 1,000 x 1,000 mm
clamping area:	850 x 2,000 mm
control:	Heidenhain TNC 415

CNC tool and universal grinding machine Schütte WU 305

year of construction 2000

transfer path (X Y Z):	400 x 400 x 250 mm
control:	Sinumerik 840 D

Surface and profile grinding machine ELB Perfekt BD 15/750

year of construction 2001

grinding length:	1,500 mm
grinding width:	750 mm
grinding height:	400 mm

Conventional machining

turning: up to d630 x 2,500
cross drilling up to 1,600 mm delivery

Process engineering:

CAM oriented 2-D, 2.5-D programming

Assembly

We take over assembly of big or heavy equipment parts, components or complete machines as well as large technical devices. Our assembly are is optimally equipped for such tasks. Even complex erection work like mounting of antifriction bearings can be handled.

Heating of components: via unshielded flame or annealing furnace
Welding: E-, MAG, WIG Welding (test certificate acc. to EN 287-1)
Shrink fitting of components

Painting system

• Paint-spray line with drying

Painting cabin big max. work piece dimensions 3,800 x 8,000 x 4,400 height, max. 50 tons
Painting cabin small max. work piece dimensions 1,950 x 3,500 x 2,000 height

Heat treatment

In cooperation with our subsidiary *Köppern Entwicklungsgesellschaft (KEG)*

Annealing furnace

Max. temperature: 1,000 ° C
Specific characteristics: Precise temperature measurement via use of up to 16 charge thermo elements, temperature preciseness better than ± 5 K (DIN 17052)
Usable space: 2,000 x 2,000 x 1,800 mm
Weight of work piece up to 12 tons
Hardening: exposed to air
Applications : stress relief annealing, heat treatment, soft annealing, recrystallization annealing, hardening of steel castings, solution annealing

Curing oven:

Max. temperature: 1,250 ° C
Specific characteristics: Precise temperature control
Usable space: 1,600 mm diameter, 1,800 mm height
Weight of work piece up to 12 tons
Hardening: rapid cooling via water aerosol or air
Inert atmosphere: N₂ , N₂/H₂

Crane capacities

• Manufacturing section: 2x20 tons, 1x32 tons (weight of work piece max. 40 tons)
• Assembly section: 2x50 tons / 1x20 tons (weight of work piece max.100 tons (2x50 tons))