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CUTTING, WELDING,
GALVANISING, SHOT BLASTING,
PAINTING, BENDING,
DIE CUTTING/PUNCHING

SERVICE CATALOGUE

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CONTENTS:

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ABOUT THE COMPANY:

- we specialise in the manufacture of steel structures and metal processing,
- we employ a team of experienced specialists, competent in the execution of difficult and complex services,
- we ensure technical advice and design services,
- we work using specialised and precision machinery,
- we have an in-house galvanising facility,
- we conduct non-destructive testing.

QUALITY CERTIFICATIONS:

Metal structure manufacturer certification per **EN 1090**

Quality management system per **ISO 9001:2009**

Quality management system per **AQAP 2110:2009**

NATO Commercial and Government Entity **(NCAGE) Code 2312H**

Environmental management system per **ISO 14001:2005**

Occupational health and safety management system per **PN-N 18001:2004**

Quality Certification per **EN ISO 3834-2**

Certificate for International Welding Engineers

DANOBAT AUTOMATIC CUTTING AND DRILLING UNIT

Modern machine providing the following operations:
- drilling,
- deepening,
- spudding,
- marking,
- writing and tracing.

The drilling unit works with HSS as well as carbide tools up to an opening diameter of 40 mm with a material thickness of 40 mm.

Technical parameters	
Min./max. drilling diameter	6/40 mm
Min./max. drilling thickness	6/40 mm
Max. form dimensions	1000 x 400 mm
Tool positioning speed	20 m/min.
Vertical pressure force	4 x 1.5 t

DANOBAT AUTOMATIC DRILLING UNIT

The Danobat automatic drilling unit provides the following services: drilling, deepening, threading and spudding as well as marking.

The T3CH unit supports both HSS as well as carbide tools.

Technical parameters	
Min./max. drilling diameter	6/40 mm
Min./max. drilling thickness	6/40 mm
Max. form dimensions	1000 x 400 mm
Min. form dimensions	80 x 6 mm
Vertical pressure force	4 x 1.5 t

GEKA ALPS 150 AUTOMATIC SQUARE FORM PROCESSING LINE

The automatic line provides marking, die-cutting and cutting of squares. It is equipped with a complete system enabling the marking, die-cutting and cutting of squares; the unit is numerically controlled and programmed using the CNC-PC control system.

Technical parameters	
L max.	150 x 15 mm
L min.	35 x 4 mm
Vertical pressure (marking)	730 KN
Character count (optional)	5 x 10 characters
Max. hole diameter	31 mm
Cutting station force	1900 kN

GEKA HYDRACROP 165 - UNIVERSAL HYDRAULIC CUTTER

The Hydracrop station provides the following services:

Technical characteristics	
Hole stamping	Max. diameter 40 x 30 mm, 34 x 34 mm
Square cutting	Max. 205 x 205 x 25 mm
Rod cutting	Square up to 60 mm, round up to 60 mm
C-, T-, or I-shaped profile cutting	Up to 180 mm
Flat profile cutting	Up to 750 x 20 mm, 400 x 30 mm

Ermaksan HGD 3100 hydraulic cutter

The hydraulic cutter permits the cutting of sheet steel with dimensions of:

Technical characteristics	
Max. thickness	13 mm
Max. width	3100 mm

GEKA Bendicrop 60S hydraulic cutter

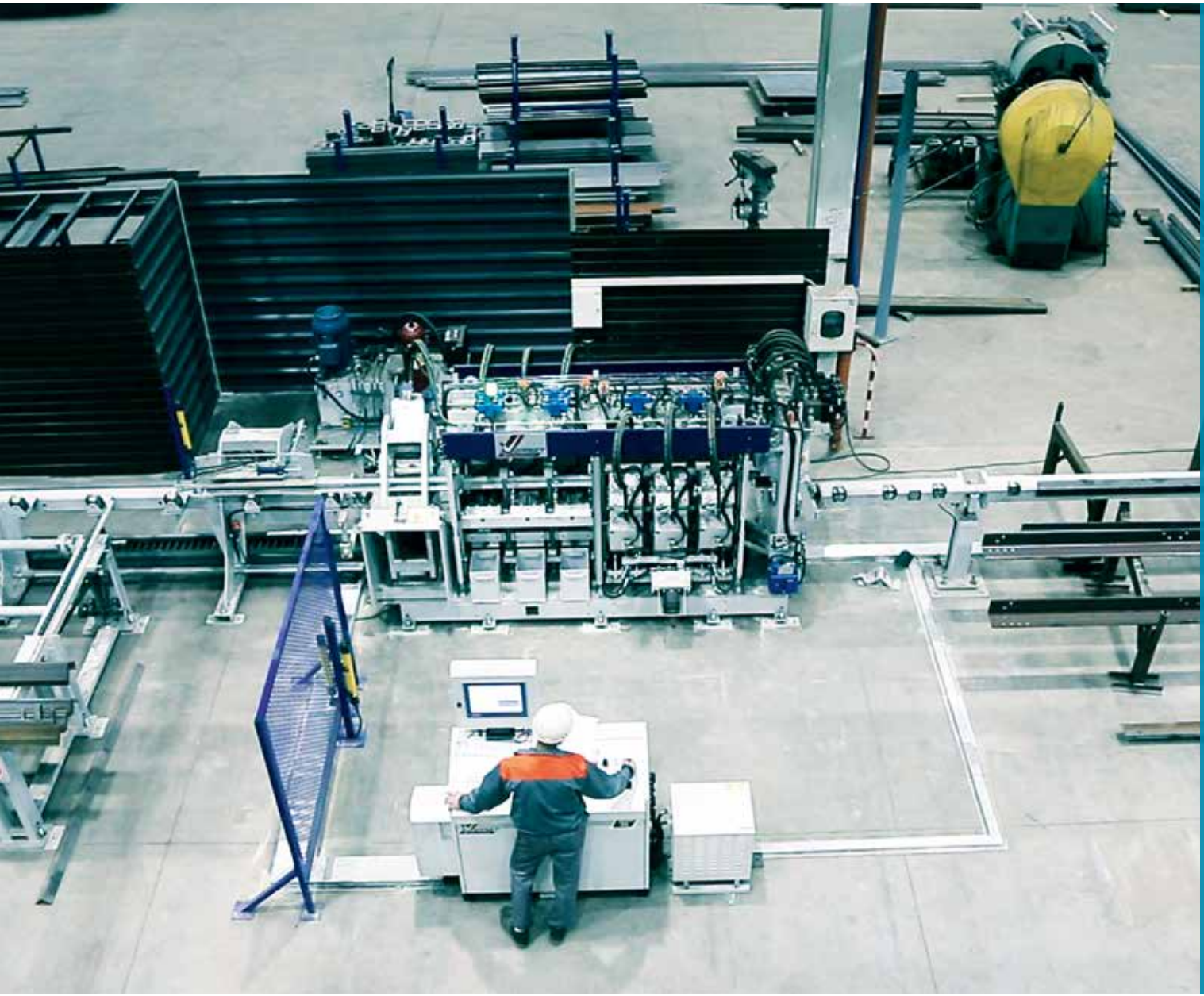
Technical characteristics	
Flat profile cutting up to	350 x 15 mm
Cutter length	356 mm
Square trimming at 45° angle, up to	70 x 70 x 7 mm
Round rod cutting	diameter 45 mm
Square rod cutting	40 mm
Drilling, max. diameter and thickness	40 x 11 mm

VERNET BEHRINGER VP-X 166 AUTOMATIC SQUARE PROCESSING LINE

The line is used for marking, punching and cutting of squares. The line is numerically controlled and programmed using the CNC-PC control system.

The line is equipped with the following system:
- chain-powered storage unit with rotary arm for storage and loading of squares,
- Rolotok transport system, gripper,
- 65T marking head,
- perforation system,
- guillotine,
- receiving rolotok system.

Technical parameters	
L max.	160 x 15 mm
L min.	40 x 4 mm
Pressure force (marking)	65 t
Pressure force (die cutting)	76 t
Max. diameter	Ø 32 mm
Cutting station force	230 t



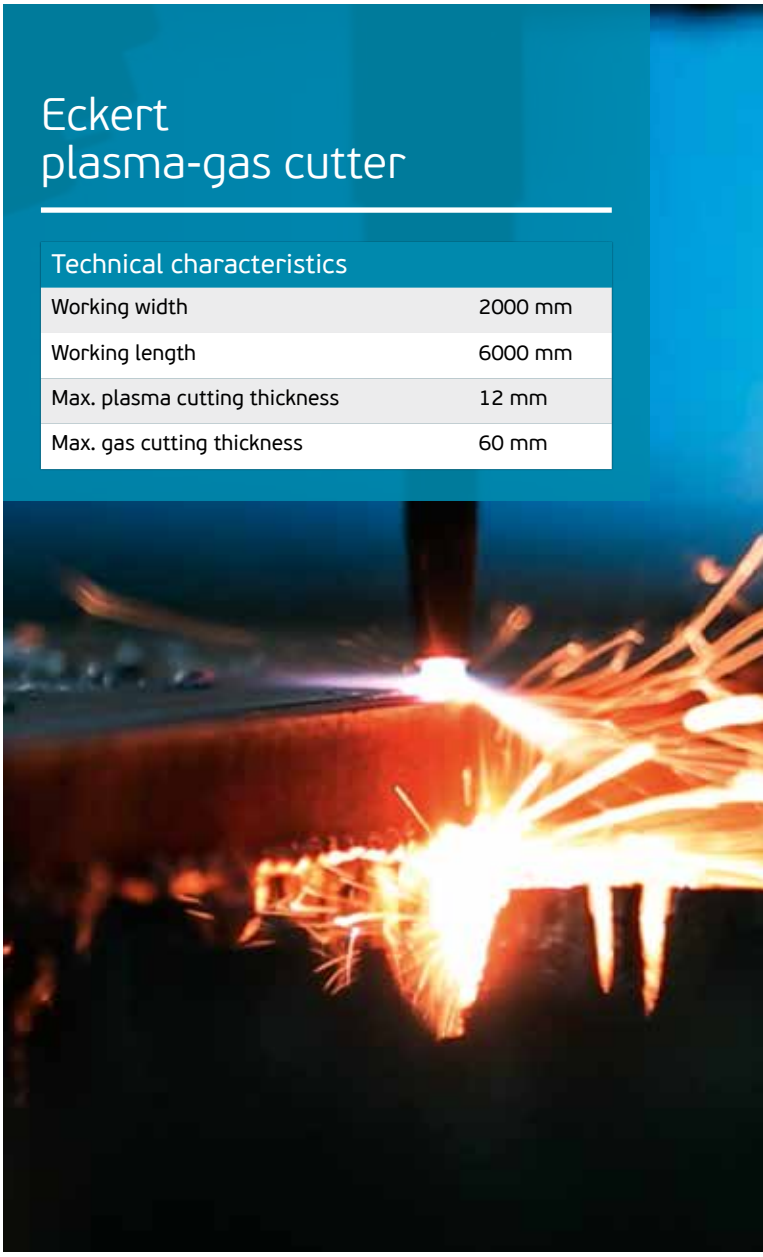
3D STIGAL PLASMA-GAS CUTTER, 3D CUTTING OR 3D BURNER CUTTING

Technical characteristics	
Working width	3000 mm
Working length	14000 mm
Max. plasma cutting thickness	40 mm
Max. gas cutting thickness	100 mm

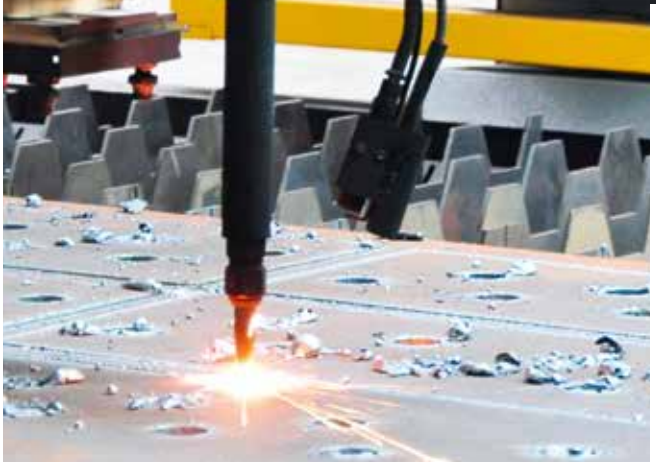
Pipe cutting rotary unit	
Diameter range	50 – 300 mm
Max. pipe length	12000 mm
Max. wall thickness	35 mm

Eckert plasma-gas cutter

Technical characteristics	
Working width	2000 mm
Working length	6000 mm
Max. plasma cutting thickness	12 mm
Max. gas cutting thickness	60 mm



/PLASMA-GAS CUTTING/



ROTARY-ROLL CLEANING UNIT

Processing of long and flat pasts, such as: sheet components, profiles, steel structure components, transported using roller conveyor.

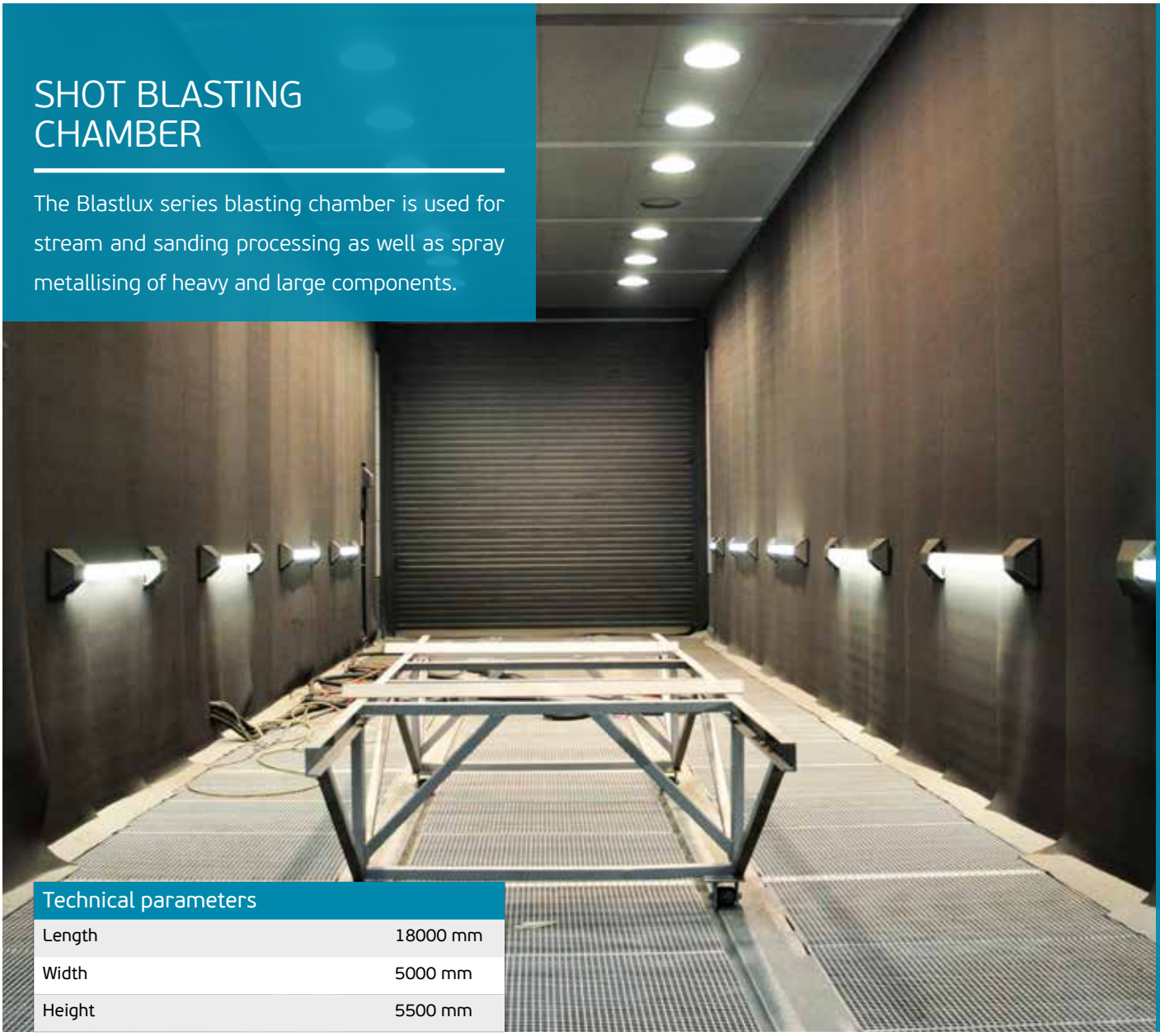
Usage:

removal of rust, scale, surface preparation ahead of painting.

Technical parameters	
Max. part width	2000 mm
Max. part height	500 mm
Input roll length	16000 mm
Output roll length	12000 mm
Minimum component wall thickness	3 mm

SHOT BLASTING CHAMBER

The Blastlux series blasting chamber is used for stream and sanding processing as well as spray metallising of heavy and large components.



Technical parameters	
Length	18000 mm
Width	5000 mm
Height	5500 mm

PROFESSIONAL WELDING SHOP

We execute steel structure welding services.
Our employees hold various certifications and permits, i. e. International Welding Engineer certificates.
We also provide non-destructive testing in-house.
We hold a manufacture **Quality Control Certificate per EN 1090-1 (EXC3 class).**

RAIL GANTRY FOR THE WELDING OF T - ANDI-SHAPED PROFILES

Technical parameters
Welding method MAG
Web working height 1600 mm, and working width 800 mm with automatic correction
Welding length 12000 mm
Web positioning units
Hydraulic compensating pressure application
Structure integrated with two welding power sources

KAWASAKI FA06E WELDING ROBOT

Welding robot equipped with:
- two rotary stations with dimensions of 6.5 m x 2.5 m, and a load bearing capacity of 5 t.
- Kawasaki FA06E arm, with Fronius TransPuls Synergic 5000 welding equipment.

DOUBLE SET OF HYDRAULIC PRESS BRAKES

Technical specifications	
Pressure force	2 x 5000 kN
Working bending length	12200 mm
Column extension	500 mm
Table width 500 mm	500 mm
Max. bending thickness	22 mm

Press brakes are used for cold sheet forming. Thanks to their construction, they permit very precise bending, ensuring bending angle repeatability and adaptation of the parameters to the bent material and to its mode of formation - the bend order.
The double set of press brakes is a quick and economic machine permitting precision metal sheet bending.

Ermaksan CNC HAP 6100/200 press brake

Technical specifications	
Working length	6100 mm
Pressure force	200 t

HACO press brake

Technical specifications	
Working length 4300 mm	4300 mm
Pressure force	300 t

VARIOBEND DB 6.1,50 HYDRAULIC BENDING MACHINE WITH TOP-DOWN BENDING OPTION

This machine is used for the manufacture of profiles bent from sheets or bands.

Technical specifications	
Working length	6400 mm
Max. sheet thickness	
Steel	1.5 mm
V2A	1.0 mm
Aluminium	2.0 mm
Max. bending angle	140°
Extension	1250 mm
Bending thickness	0°-140° -3.5 s
Rear buffer working range	5 - 1250 mm
Buffer finger count	8 pcs.

HYDRAULIC HORIZONTAL PRESS

Technical specifications	
Max. force	250 t
Piston stroke length	500 mm
Max. opening depth: 260 mm	2.0 mm
Max. height of part to be straightened	400 mm
Straightening and bending ability	profiles
Flat profile	360 x 60 mm
Pipe	180 mm
Square pipe	160 x 160 mm
Square	180 x 16 mm

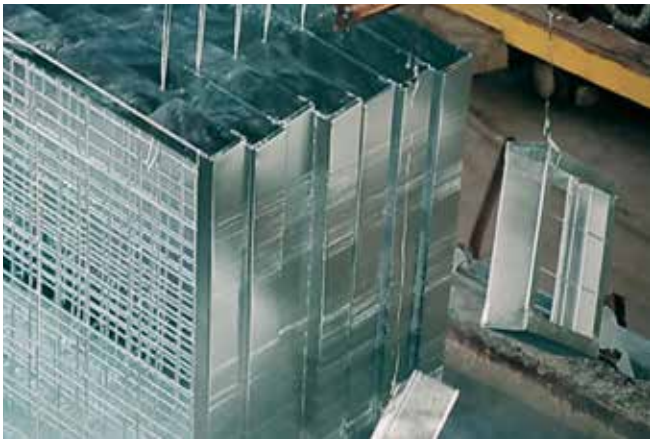
EUROMAC MTX FLEX 12 CNC PUNCHING MACHINE FOR SHEET PROCESSING

The punching machine is used to provide complete and 3D sheet processing. It guarantees cutting any shapes reflecting the cutting template from sheets. It ensures high production performance for repeatable components. It also offers recutting, threading, etc.

Technical specifications	
Pressure force (punching)	220 kN
Max. working range	1500 x 5000 mm
Positioning precision	+/- 0.1
Sheet thickness range	0.0 - 5 mm
Max. sheet weight	150 kg
Max. cutting speed	1000 punches/min.
Max. marking speed	2000 punches/min.

MESH THERMAL BONDING MACHINE WARO SAR 2500

Technical specifications	
Mesh bonding from wire of diameter	2 - 6 mm
Number of lengthwise wires	2 - 16
Max. mesh length	6000 mm
Max. mesh width	2500 mm
Min. eye size	50 x 20 mm



HOT DIP GALVANISING

Zinc bath size
Length x width x depth 7000 x 1500 x 2800 mm
Maximum working dimensions of coated components: 6800 x 1400 x 2400 mm
Maximum component unit weight - up to 3 t.

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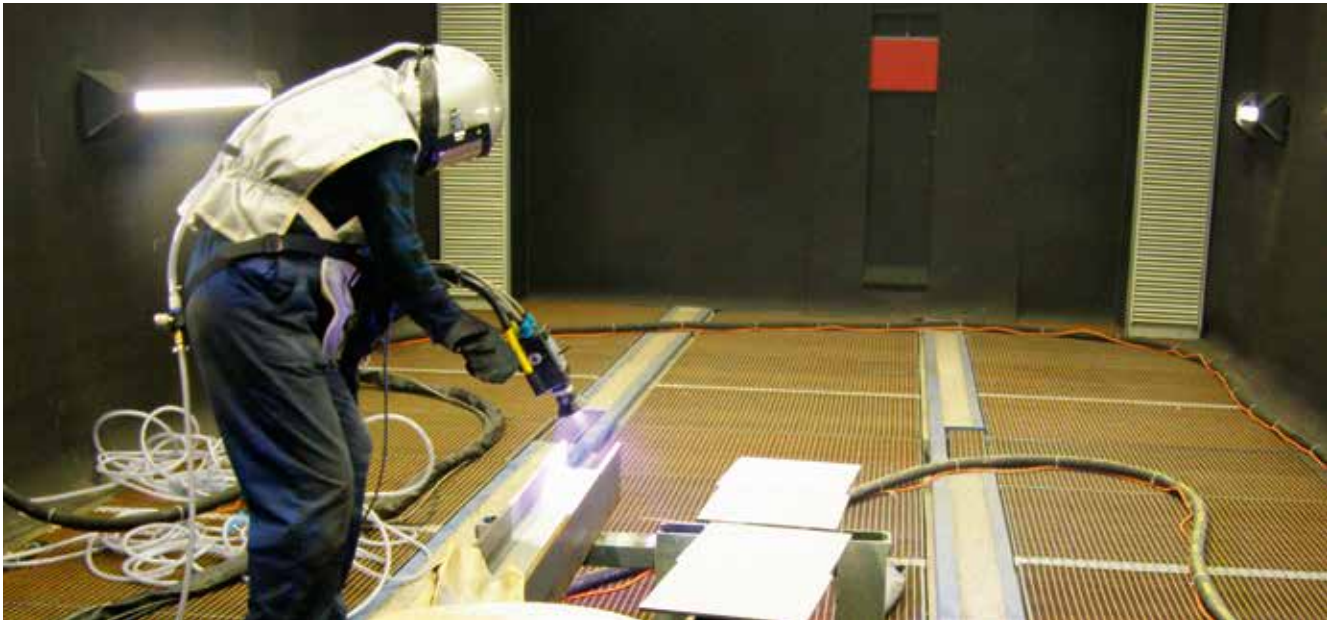
PAINT SHOP

A professional, spacious paint shop with an area of 500 sq m allows the execution of corrosion protection through spray painting - in a Duplex system as well.

SPRAY METALLISING

This serves to protect iron and steel against corrosion. Through metallising, one can achieve various corrosion resistance levels, depending on the coating material used. The coat can be of zinc or aluminium. These materials guarantee high resistance to intense corrosive environments.

Using this method, we can protect the metallised for a period of 15-50 years, without additional maintenance measures.

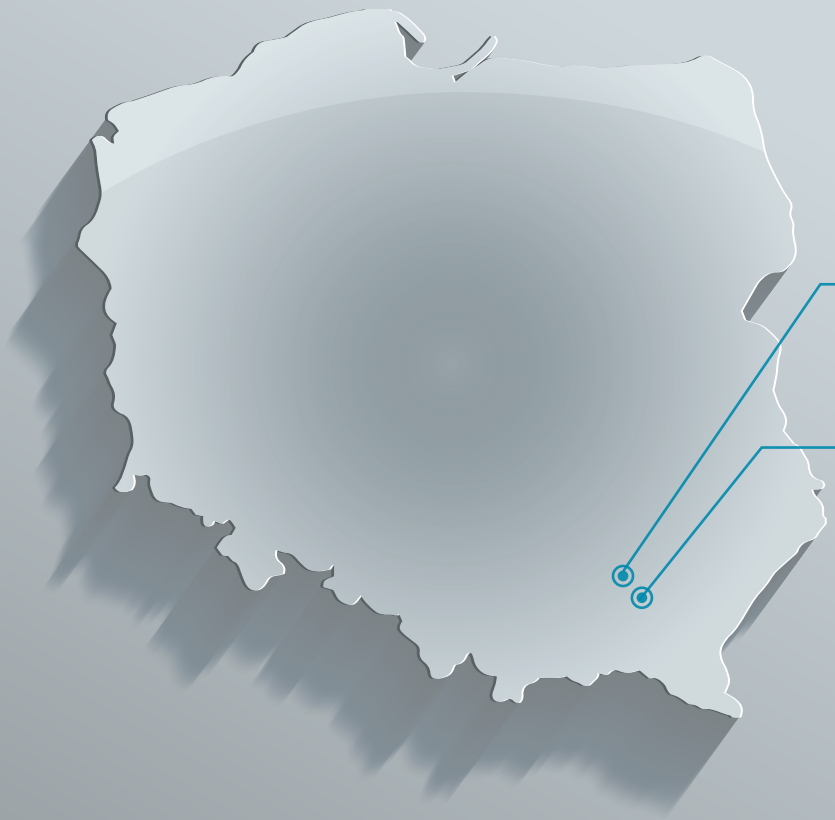


NON-DESTRUCTIVE TESTING OF STEEL STRUCTURES, WELD JOINTS AND BONDS

Non-destructive testing is used to evaluate the technical condition of a steel structure and possible detection of any faults and failures in its construction and joints.

We have at our disposal an advanced ultrasound flaw detector, allowing the inspection of components of various shapes, and we employ specialists with experience in the inspection of steel structures, as well as welded, bonded, rolled, cast and wrought components.

We utilise the ultrasonic method, allowing the analysis of components made of steel, non-ferrous metals as well as other materials. The use of ultrasound greatly reduces and simplifies the inspection, and it can be conducted at any manufacture stage; it is characterised by high efficiency in the detection of any shorts of material failures, both on the surface as well as within the component. The analysis allows a precise determination of the type, placement and size of the flaw in the analysed component.



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Galvanising plant

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