



ADOZ, s.r.o.
PRODUCTION TECHNOLOGY



ADOZ PRODUCTION DIVISION



We operate
a quality,
flexible and
efficient
machining.

WE OFFER:

High-Quality Technology

Skilled Staff

Flexible Productive Manufacturing

Professional Metrology

Progressive Trends in Machining

WE OFFER:

CNC Milling, Turning, Drilling

Turning diameters from 5 to 280 mm

Maximal Machined Length 800 mm

Machined Surfaces 1016x610x760 mm

Welding of assemblies up to 3.2 tons

Laser marking

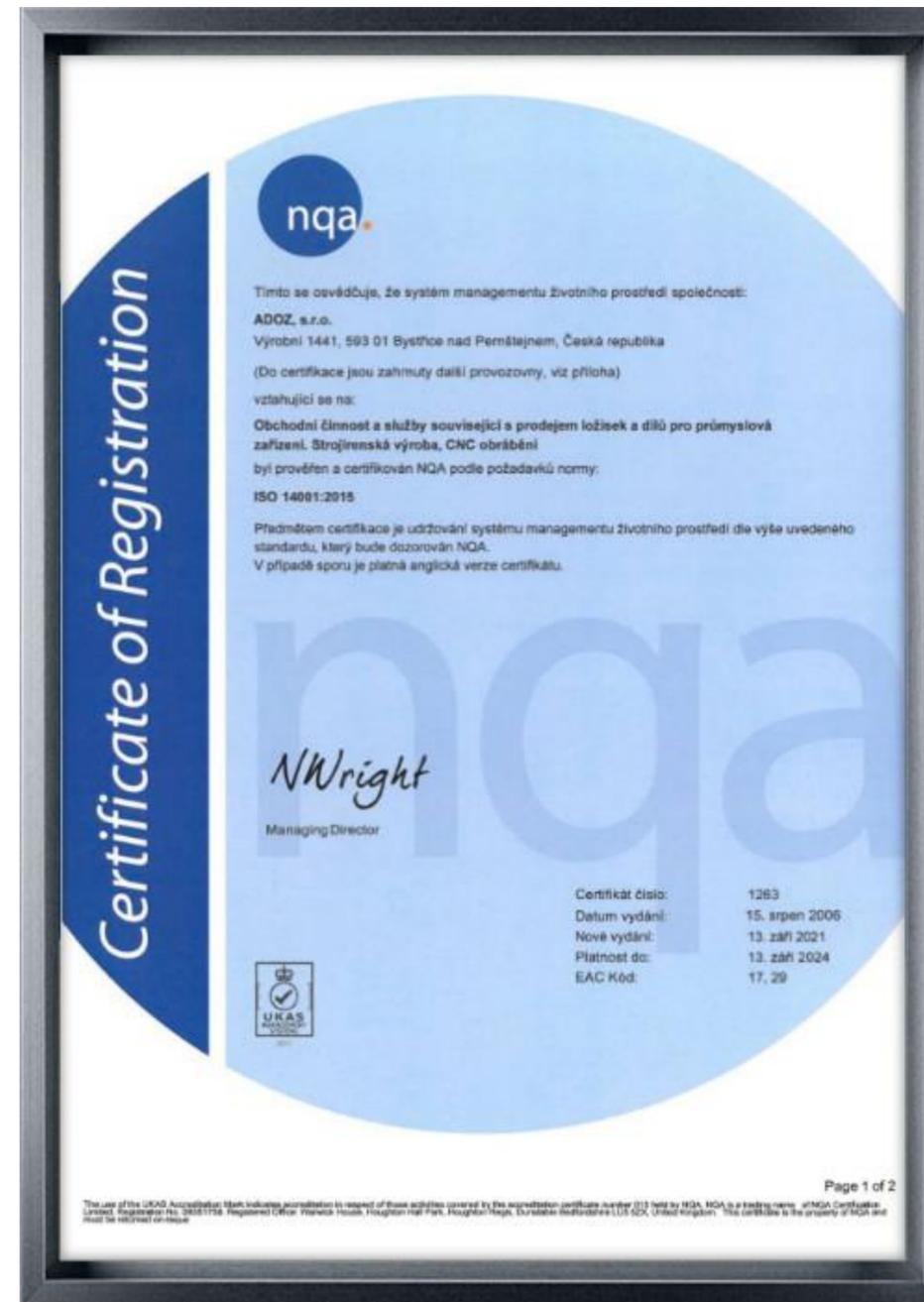
WEB

ESHOP

YOUTUBE

FACEBOOK

INTEGRATED QUALITY MANAGEMENT SYSTEM - ISO 9001, ISO 14001



MACHINE FLEET - ADOZ



TWO-PALLET MACHINING CENTRE - Brother R450X1



PRODUCTIVE PILLAR HIGH SPEED DRILLING, MILLING AND THREADING CNC MACHINING CENTRE WITH TWO-PALLET CHANGER.

PARAMETRES:

- spindle rotation speed 16 000 rpm,
- high-pressure cooling max. 35 bar,
- changer for 22 tools,
- two revolving tables with inbuilt rotary clutch,
- laser contactless probe detecting tools damage,
- contact probe,
- workpiece touch-down pneumatic control,
- dimensions of clamping area 600 x 300 mm,
- travel range of axis X/Y/Z - 450/320/305,
- positioning accuracy 0,006 - 0,020 mm,
- repeatability of positioning +/- 0,002 mm,
- table load capacity - 120 kg.



CNC MILLING CENTRE - MCFV 1060

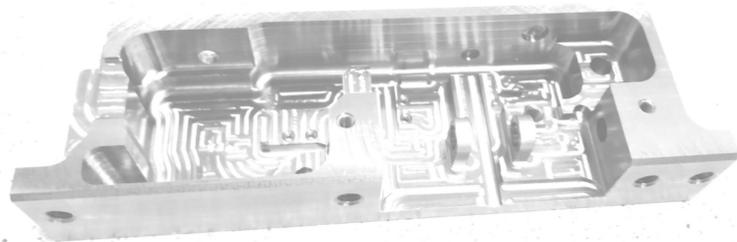
MASSIVE, PRODUCTIVE AND RIGID VERTICAL MILLING CENTRE WITH 4 PROGRAM-CONTROLLED AXES AND A 5TH MANUALLY CONTROLLED AXLE.



PARAMETRES:

- X-axis travel 1060 mm,
- Y-axis travel 610 mm,
- Z-axis travel 760 mm,
- chucking table dimensions 1270 x 590 mm,
- maximum weight of workpiece 1350 kg,
- diameter of manually tilting rotary table 250 mm.

Massive and rigid milling centre with 4 program-controlled axes and 5th manually controlled axis. The milling centre is equipped with a tool setting probe for fast and effective adjustment of the machine and a workpiece probe for fast and effective fastening of workpieces that are complicated in shape.



TURNING CENTRE - TAKISAWA TM-4000Y2, BAR FEEDER 1.5 m

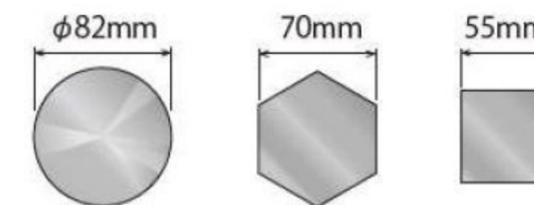
EFFICIENT AND SOLID, 4 - AXES, TURNING CENTRE WITH BAR FEEDER, Y AXE, 2 SPINDLES A 2 REVOLVERS



PARAMETRES:

- max. machined diameter \varnothing 280 mm,
- max. pass-through diameter of bars/pipes \varnothing 82 mm,
- max. machined length 800 mm,
- automatic bar feeder enabling serial production of machined parts till the diameter 82 mm.

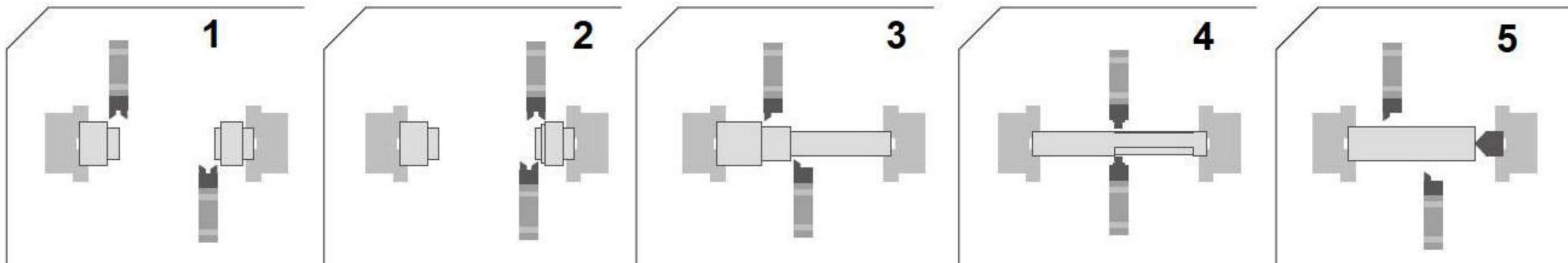
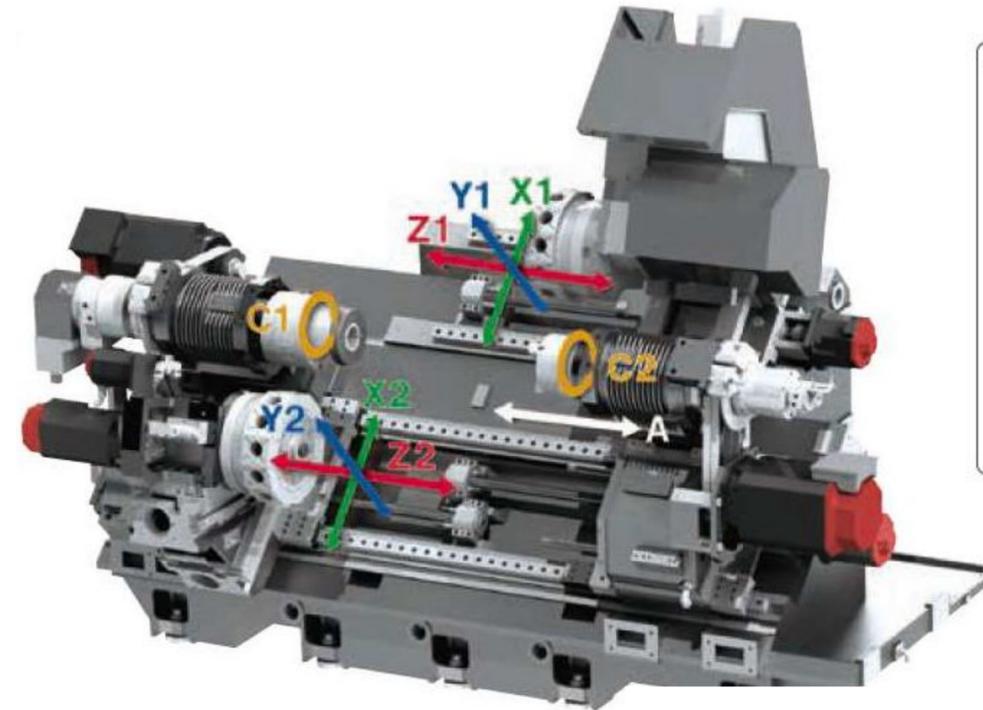
NEWS
EFFICIENT
MACHINING
OF LARGER
DIAMETERS



Průchod vřetenem

MACHINING OPTIONS

1. Productive machining on both spindles simultaneously.
2. Highly efficient machining with simultaneous machining of multiple tools on one spindle.
3. Highly efficient machining of a bar clamped between two spindles by simultaneous multi-tool machining.
4. Simultaneous milling and drilling in one operation.
5. Machining of semi-finished products (up to 800 mm) with the use of the second spindle as a support, while simultaneously machining two tools at once.
6. Machining of bars up to the diameter of 82 mm length 1,500 mm with feeder.



CNC LATHE WITH LINEAR TOOL BENCH FOR PRODUCTIVE MACHINING WITHOUT LENGTHY DRIVES.



PARAMETRES:

- max. machined diameter 170 mm (for chuck-fastened material),
- max. pass-through diameter of bars/pipes 44 mm,
- max. machined length 190 mm,
- automatic bar feeder for series production of machined parts with max. diameter 44 mm,
- machine enabling longitudinal/front, outer/inner turning, axis drilling (rough hole drilling, reaming) and making axis threads.



CNC LATHE WITH LINEAR TOOL BENCH FOR PRODUCTIVE MACHINING WITHOUT LENGTHY DRIVES.



PARAMETRES:

- max. machined diameter 250 mm (for chuck-fastened material),
- max. pass-through diameter of bars/pipes 65 mm,
- max. machined length 530 mm,
- automatic bar feeder for series production of machined parts with max. diameter 65 mm,
- machine enabling longitudinal/front, outer/inner turning, axis drilling (rough hole drilling, reaming) and making axis threads.



PRODUCTIVE MACHINING OF COMPLICATED SHAPE PARTS PROVIDED BY TWO SPINDLES AND TURRET TOOL HEAD.



PARAMETRES:

- max. machined diameter 255 mm (for chuck-fastened material),
- max. pass-through diameter of bars/pipes 65 mm,
- max. machined length 530 mm,
- turning, milling, drilling, threading,
- machine enabling longitudinal/front, outer/inner turning, axis drilling (rough hole drilling, reaming) and making axes threads, and, with the use of driven tools, milling, drilling (max. diameter 16mm) and threading perpendicularly to the axis.

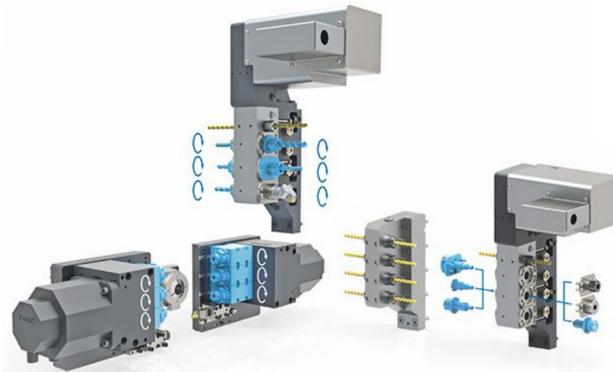
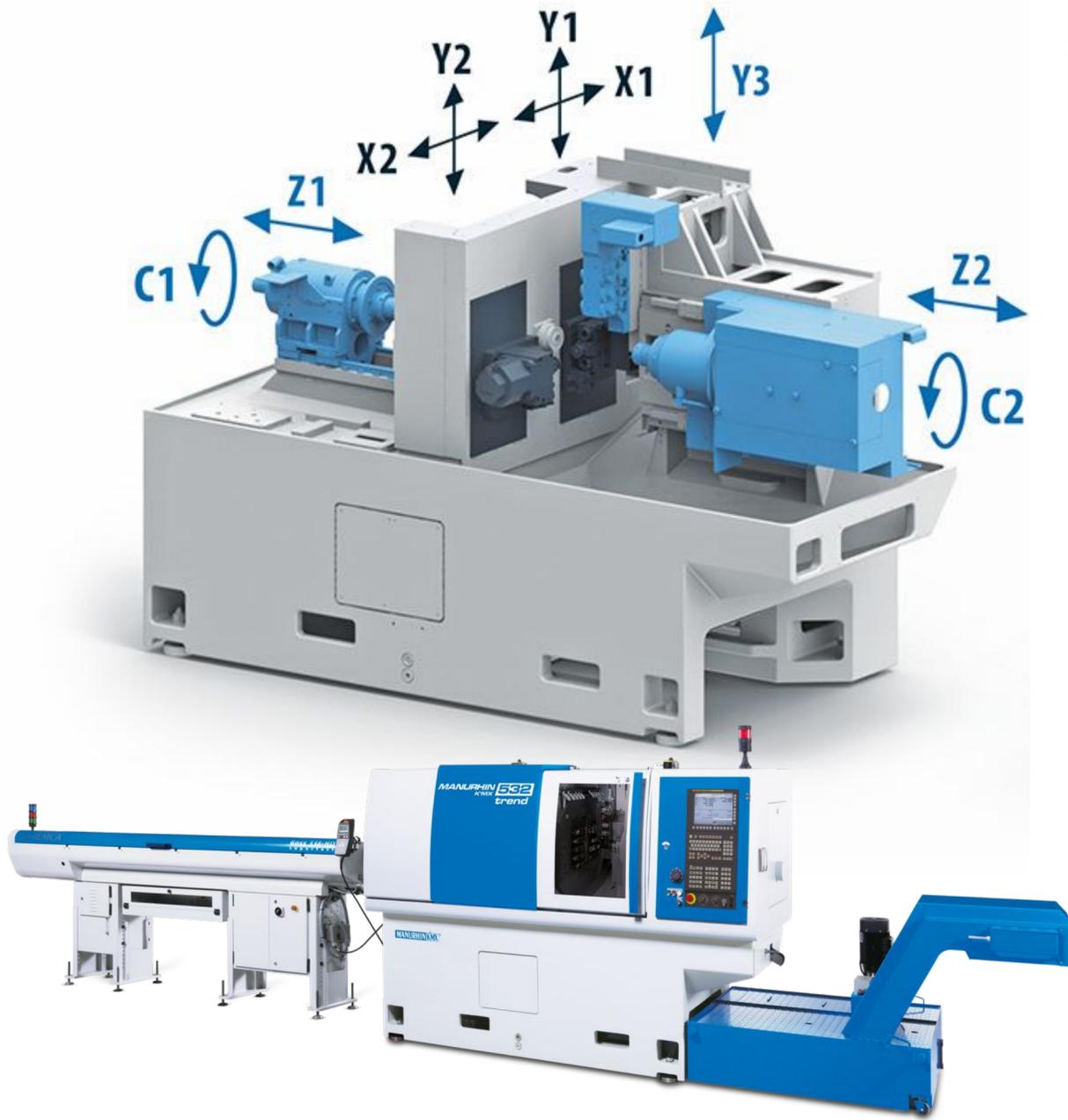


SWISS-TYPE LATHES - HANWHA 32, KMX 732 EVO, KMX 532 TREND

PRODUCTIVE MACHINING OF WORK PIECES THAT ARE COMPLICATED IN SHAPE FROM 3 AND 4 METRE BARS WITHOUT NEED OF MATERIAL CUTTING.

PARAMETRES:

- max. pass-through diameter of bars/pipes 32 mm,
- max. machining length for one stroke 400 mm,
- automatic bar feeder (3 metres/4 metres) enabling series production of machined parts to max. diameter 32 mm,
- machine enabling longitudinal/front, outer/inner turning, axis drilling (rough hole drilling, reaming) and making axes threads, and, with the use of driven tools, milling drilling and threading perpendicularly to the axis.
- machining with as much as three driven tools at the same time - roughing and clear turning + axial operations.



SWISS-TYPE LATHES - K'MX 1032

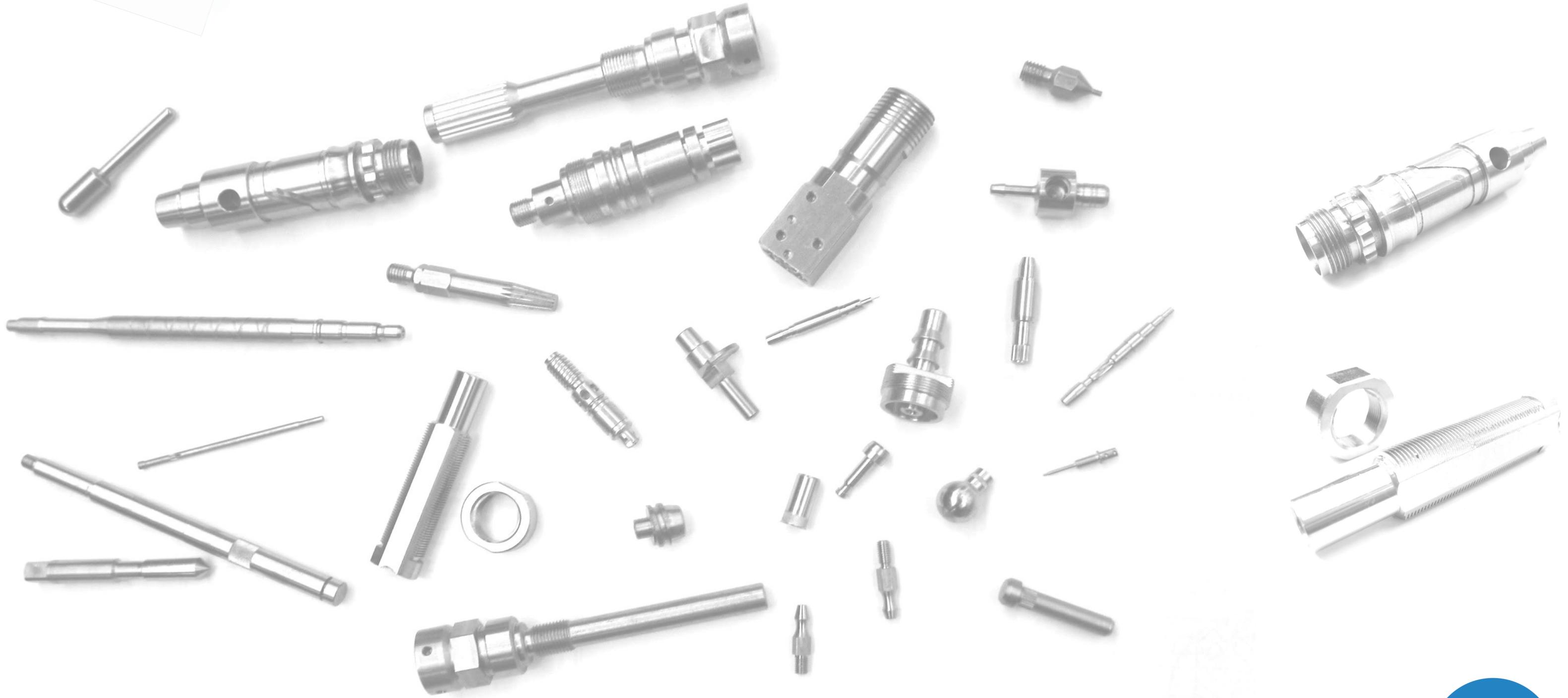


HIGH PRODUCTIVITY DUE TO UP TO 25 TOOLS, INCLUDING UP TO 17 DRIVEN ONES. 10 LINEAR CNC AXES (X1, X2, X4, Y1, Y2, Y3, Y4, Z1, Z2, Z3) AND TWO ROTARY AXES (C1, C2) ENABLE THE USE OF 4 TOOLS IN CUTTING AT THE SAME TIME.

PARAMETRES:

- max. pass-through diameter of bars/pipes 32 mm,
- max. machining length for one stroke 400 mm,
- automatic bar feeder 3 metres enabling series production of machined parts to max. diameter 32 mm,
- up to 4 tools simultaneously in a cut,
- number of controlled CNC axes 10+2,
- easy and quick tool change with a compatible tool holder system,
- ergonomic and easy access with a large door opening.



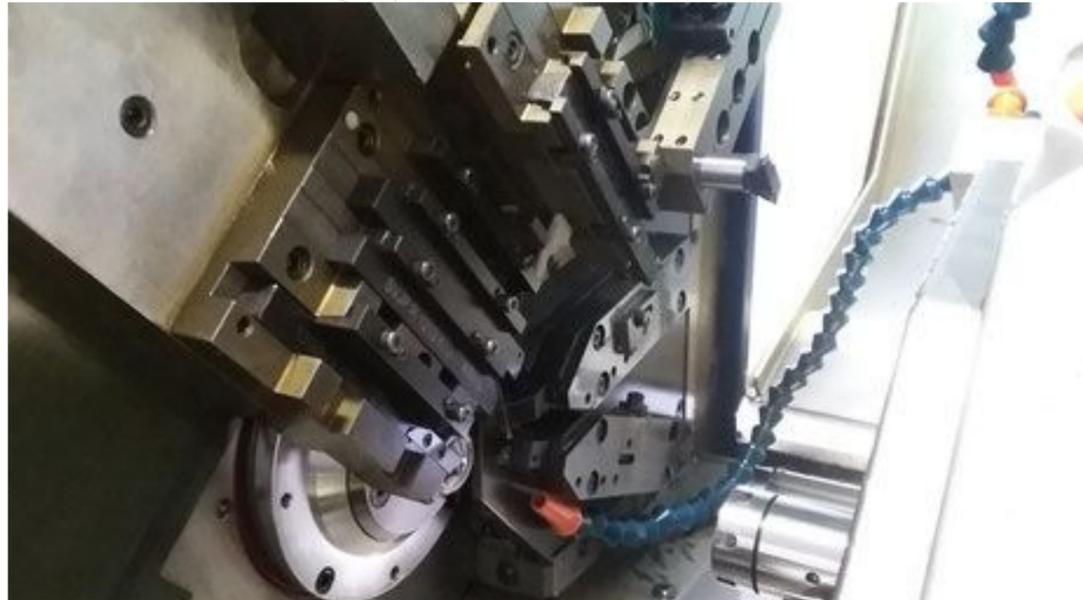


SIX-SPINDLE AUTOMATIC TURNING MACHINE - WICKMAN 1"-6

HIGHLY PRODUCTIVE SIX-SPINDLE CAM MACHINE FOR THE PRODUCTION TO THE DIAMETER 18 mm.

PARAMETERS:

- machining to the diameter 18 mm,
- 6 highly productive spindles,
- threading and drilling cycle,
- outer machining,
- length of a part max. 50 mm,
- length of feeder 5 meters.



Economical for production series > 500.000 pieces/year

MOQ = 100.000 pieces

Various types of products:

- washers, nuts, screws,
- rollers, pins, shafts,
- hydraulic end caps etc.

SIX-SPINDLE AUTOMATIC TURNING MACHINE - WICKMAN 1"-6 PRODUCT EXAMPLES



WELDING PRODUCTION - Precise welding of product assemblies



MODERN WELDING PRODUCTION ACCORDING TO EUROPEAN STANDARDS FOR WELDING OF HIGHLY PRECISE PRODUCT ASSEMBLIES.

We are able to carry out **welding** and **soldering** in a modern welding room of ferritic, austenitic, high-alloy steels and non-ferrous metals including individual combinations.

NEWS
PRECISE
WELDING OF
PRODUCT
ASSEMBLIES

Together with parts distribution and CNC production, our specialty is the supply of precise units assembled from distributed industrial parts, CNC machined drawing parts, blanks and metallurgical material.



Welding methods:

- **MIG (MAG)**
 - 131 (135) according to EN ISO 4063: Welding with a melting electrode in inert gas (MIG 131) /active gas /MAG 135)
- **TIG (WIG)**
 - 141 according to EN ISO 4063: Welding non-melting tungsten electrode in inert gas.



Welding system TPS400i Fronius

Laser workplace with a fiber laser with a power of 31W

CUSTOM LASER WORKPLACE WITH A FIBER LASER WITH A POWER OF 31W

PARAMETRES:

- Laser source 31W,
- The size of the marking field 310 x 310 mm,
- Maximum dimensions of the part w x d x h 490 x 490 X 320 mm.

MARKING MATERIALS:

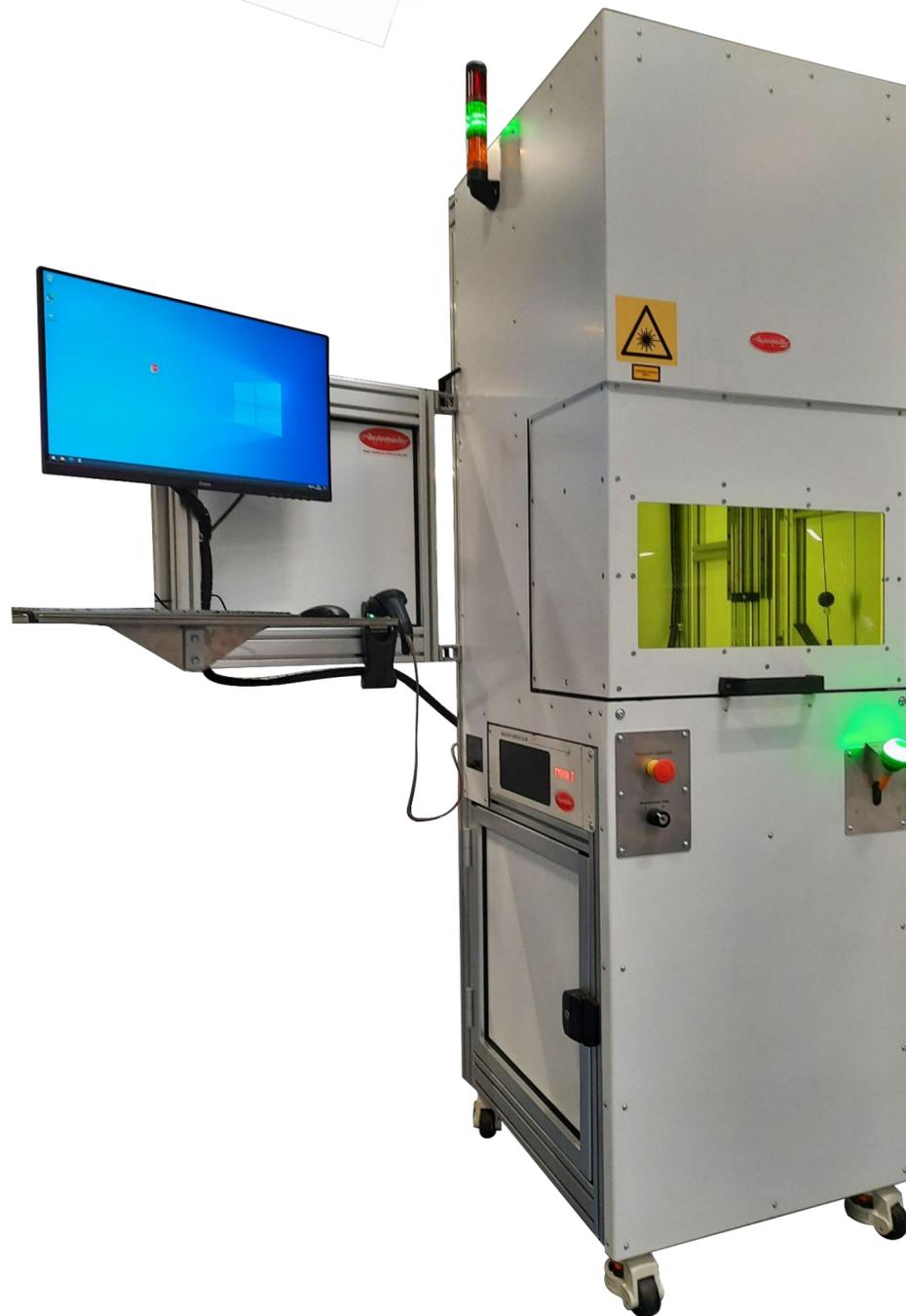
- all ferrous and non-ferrous metals,
- most plastic materials.
(*in the case of plastic marking, it is always a good to discuss marking with the ADOZ staff)

APPLICATIONS PRIORITY INTENDED FOR:

- identification of parts according to the customer's wishes,
- ensuring the traceability of parts according to the customer's wishes,
- marketing purposes.

MARKING METHODS:

- marking of parts - numbers, characters according to customer specifications,
- marking of parts using 2D codes such as Datamatrix, QR codes,
- engraving of parts - marking, logo, picture.



NEW
INDUSTRIAL
LASER MARKING
OF PARTS



**AUTOMATIC BANDSAW Pro-Line
FOR PRODUCTIVE CUTTING OF ALL KINDS OF MATERIALS TILL THE
DIAMETER 450 mm.**

PARAMETRES:

- **section:**

- rod 400 mm,
- pipe 450 mm,
- full square with sides of 400 mm,
- hollow square with sides of 450 mm,
- hollow rectangle with dimensions 520 x 450 mm,
- faggots of material may also be divided - maximum dimensions of the faggot are 500x225 mm.

- **divided material:**

- mild steel (of various sections),
- stainless and alloy steels,
- not-ferrous metals,
- hardened materials.



TECHNICAL WASHING OF PARTS - PRODUCTIVE WASHING AS WELL AS RINSING IN ONE CLOSED TIME CYCLE.



PARAMETRES:

- basked diameter: 800 mm,
- basked depth: 170 mm,
- weight of washing parts: max. 200 kg,
- bath temperature: max.65 °C.

The machine is used for technical washing of components, parts or machine units. The washing is carried out from two opposite directions by pressure spraying on parts placed in a rotating washing basket. To remove contaminated washing fluid residues, the washed parts are then rinsed with heated rinse fluid.

BLASTING OF PARTS - RUST REMOVAL, DEBURRING AS WELL AS SURFACE STRENGTHENING.

PARAMETRES:

- batch, max. weight: 350 kg,
- batch, max. volume: 165 dm³,
- 1 piece, max. weight: 15 kg.
- max. workpiece size (spatial diagonal): 345 mm.

The equipment is designed for blasting steel, cast iron or stainless steel castings, forgings, heat-treated steel parts, weldments, rust removal, deburring, surface strengthening etc. Used blasting principle: throwing metal blasting material on blasted work-pieces, blasting material is carried by blades (turbines).



PRECISION LATHE WITH INDICATION OF THREE AXES POSITIONS.



PARAMETRES:

- max. workpiece length 2000 mm,
- turning diameter over bed 660 mm,
- turning diameter over support 440 mm,
- turning diameter without bridge 900 mm,
- Z1-axis travel 230 mm,
- bridge length 320 mm,
- bed width 400 mm,
- thread cutting, metric 0,45-120 mm,
- thread cutting, diametrical 0,88-160 DP.

UNIVERSAL TOOLROOM MILLING MACHINE WITH SWIVELING CUTTER HEAD AND NUMBERING ADMEASUREMENT.



PARAMETRES

- X-axis travel 1000 mm,
- Y-axis travel 245 mm,
- Z-axis travel 450 mm,
- dimensions of clamping table 1320 x 320 mm,
- table load capacity max. 260 kg.

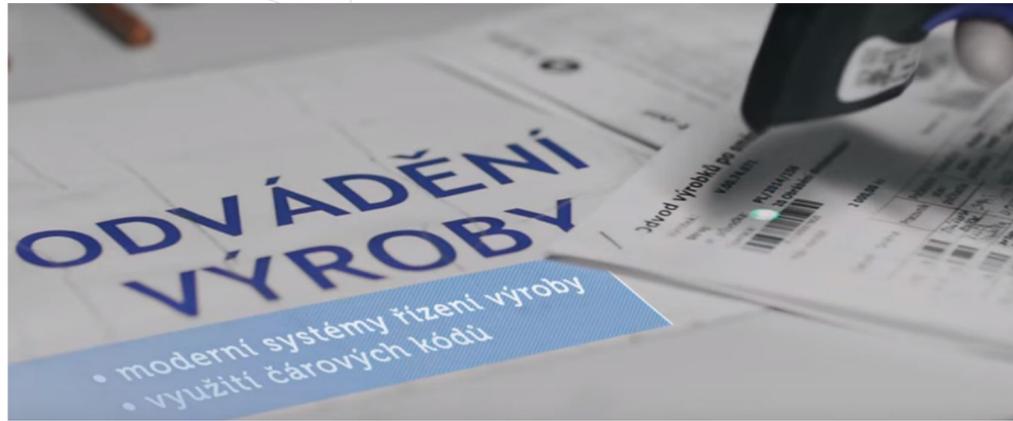
AIR-CONDITIONED MEASURING ROOM - high-quality measuring workplace



AIR-CONDITIONED MEASURING WORKPLACE WITH SKILLED STAFF AND PROGRESSIVE MEASURING TECHNOLOGIES.

- **KEYENCE IM 7030** Automatic optical measuring device capable fast measuring of hundreds of parts with precision +/-2 micrometres in a few seconds.
- **3D COORD+PH20 RENISHAW** Progressive CNC coordinate device COORD, equipped with continual dynamic scanning five-axle measuring head PH20 Renishaw.
- **CV 2000 MITUTOYO** Productive profile measuring device.
- **SJ 410 MITUTOYO** Semi-automatic device for measuring roughness enabling even measuring of spherical profiles.
- **SPECIAL GAUGES FOR INSPECTION OF BEARINGS**
- **CONVENTIONAL GAUGES** MICROMETRICAL GAUGES, DIAL DEVIATION METERS, UNIVERSAL WORKSHOP GAUGES, ...





PARTICULAR PRODUCTION OPERATIONS ARE SETTED INTO COMPANY ERP SYSTEM AFTER WORKING SHIFT WITH USE OF BARCODE READER.

PARAMETRES OF ON-LINE MONITORING:

- WORKER,
- WORK SHIFT,
- NUMBER OF OK PIECES,
- NUMBER OF NOK PIECES,
- MATERIAL BATCH
(consistent monitoring of for instance material meltage),
- OPERATION ENTERING EXPENSES
(tools, materials).

160PL1190000328		Průvodka		
Výrobek:	00.93.539	V.00.93.539 reklamní šroubovák 1 (vršek)		
Výkres:	Zátka reklamní šroubovák	Popis:	Zátka	
Varianta:	-	Plán:	500,00 ks	
Plán od:	30.5.2019	Plán do:	30.5.2019	
Šarže:	-	Kód zakázky:	-	
Strana: 1/1		Průvodka: PL/2019/328		
Operace	Komponenta	Šarže	Množ. plán.	Umístění
20	Výroba dle výkresu Výroba dle výkresu		530,000 min	
160PL119000032820		Seřizovač: odvádějí přípravu		
Stroj: KMX 732 EVO 2A.06				
VN	ZDROJ OPERÁTOR		0,500 min	
VN	ZDROJ STROJ CNC		1,000 min	
VN	ZDROJ SEŘIZOVAČ		1,000 min	
VM	JZ Tyč d 18 h9 CuZn39Pb3 (Pb3-3,		7,500 m	KMX 732 EVO 2A.06
Z	CTD TDC 2 TT 9080		1,000 ks	BOX01
Z	CTD DCGT 11T304F-AL KX		1,000 ks	BOX01
Z	CTD DCGT 11T304F-AL KX		1,000 ks	BOX01
Z	CTD 16ER1,75ISO H15		1,000 ks	BOX01
VMPZ	CTV 4,2mm 5515		1,000 ks	KMX 732 EVO 2A.06
VMPZ	CTV 8,0mm SK 90°		1,000 ks	KMX 732 EVO 2A.06
VMPN	CTT TTEL 1616-2		1,000 ks	KMX 732 EVO 2A.06
VMPN	CTT SDJCR 1616 H11		1,000 ks	KMX 732 EVO 2A.06
VMPN	CTT SER 1616 H16C		1,000 ks	KMX 732 EVO 2A.06
VMPN	CTT S20R SDUCL 11		1,000 ks	KMX 732 EVO 2A.06
H	V.00.93.539 reklamní šroubovák 1		0,000 ks	
30	Praní v průmyslové pračce Praní v průmyslové pračce		15,850 min	
160PL119000032830		Stroj: PRACKA ADS 200R 2D.07		
VN	ZDROJ OPERÁTOR		1,000 min	



Contact us ...

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