

MACHINE LIST**Mechanical operations**

CNC Punching	Punch force F(kN)	Table size	Steel, Al	Stainless Steel	Year
Trumatic 5000R	220	1500x3000 mm	up to 4mm	up to 1,5 mm	2005
Trumatic 5000R	220	1500x3000 mm	up to 4mm	up to 1,5 mm	2006
TruPunch 5000R	220	1500x3000 mm	up to 4mm	up to 1,5 mm	2008

CNC Bending	Length (mm)	F(kN)		Year
LVD PPEB 170/30	3000	1700		1996
LVD PPEB 80/25	2500	800		2003
LVD PPEB 135/25	2500	1350		2005
LVD PPRM 35/1250	1250	350		2005
LVD PPEB 35/1250	1250	350		2006
Trumpf V850	2500	850		2006

Inserting	Feeding	Press force (kN)	Inserts	Year
PEM SERTER 2000	single	72	nuts/screws/standoffs	1996
PEM SERTER 2000	single	72	nuts/screws/standoffs	2000
PEM SERTER 2000	single	72	nuts/screws/standoffs	2005
PEM SERTER 2000	double	72	nuts/screws/standoffs	2007

Stamping		Feed width	Force(kN)	Year
Excenter press			150,250,750,1000,1500	
Hydraulic Press			250,750,2000	
Fast running presses				
Bruderer				
Raster				
Colombo				
Excenter press line		750 mm	4000	2007

Welding			No. Workplaces	
Spot welding			3	
Welding(MIG/MAG, TIG)			2	
Bolt welding			2	

Handworks		No. Workplaces	
Deburring, Grinding, Drilling, Thread tapping		3	

Surface treatments

Cleaning	Type od cleaning	Basket size	Year
DURR Special 95C	Closed solvent based system	1200x800x600	2008

painting	Max. size (mm)		
Powder	3000x1000x600		

Zinc plating	Galvanic line		
clear	Max. size- housings	Max. Size - flat parts	
black	1450x300x500	1900x900x300 mm	

Other surface treatments		
Tin plating		
Nichel plating		
Alluminium anodising		
KTL – dip coating		
Silk sreening		

Assembling	No. Workplaces	
	5	

Toolshop

Toolshop machinery	technology	Working range	Year
FANUC ROBOCUT α0c	Wire EDM	320x220 mm	2007
FANUC ROBOCUT α1c	Wire EDM	520x370 mm	2005
HANSEN	Cavity sinking EDM		1990
OMEGA EDM CM800	Star hole drill EDM	350x250 mm	2006
HAAS VF-3BHE	CNC Vertical machining centre	1000x500 mm	2003
MAZAK NEXUS II 5000	CNC Horizontal machining centre	730x730x740 mm	2009
Grinding machines	Grinding - flat	620x300 mm	
Milling machines	Milling		
Turning machines	Turning		

Measurement equipment	Type of equipment	Working range	Year
Zeiss Contura	3 D Measuring system	1000x700x600	2009

Software	Application		
TruTops punch	Programming of punching		
TrumaBend	Programming of bending		
Mastercam	Programming of machining centre		
AutoCad	General construction		
CadMan	Programming of bending		
Mazatrol	Programming of machining centre		
LARGO	Integral information system (ERP)		