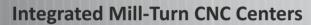
Machining processes

Milling

CNC processing centers

- 5-axis usable area: X=1135mm, Y=1050mm, Z=750mm, rotary swivel table dimensions: 1050x850, the maximum weight of milled detail: 2000 kg,
- 4-axis usable area: X=1035mm, Y=560mm, Z=510mm, the maximum weight of milled detail: 125 kg using dividing head and 255 kg using dividing head and loose headstock,
- **2-axis** usable area: X=1000mm, Y=540mm, Z=620mm, the maximum weight of milled detail: 1000 kg.
- Conventional milling machine swivel table dimensions: 400x1000 mm.





- 5-axis OKUMA using intercepting spindle and milling swivel head, the maximum turning diameter: Ø 630mm, usable area Z=900mm, Y=160 mm
- 5-axis DMG the maximum turning diameter: Ø 500 mm, usable area: Z=3000 mm, Y=400 mm, the loose headstock is controlled through software, it is equipped with two steady rests and the scope of their grip equals Ø 30÷253 mm.

Turning

- CNC turning lathes the maximum turning diameter: Ø 560 mm, spindle clearance: Ø 100 mm, the maximum length of turned component: 1500 mm, axis displacement: X=230 mm, Y=100 mm
- universal turning lathes the maximum turning diameter/length Ø 520 mm/2500 mm, Ø 560 mm/2000 mm, Ø 165 mm/3000 mm,
- boring and turning lathe the maximum turning diameter Ø 2000 mm,
- facing lathe the maximum turning diameter Ø 1620 mm.



Boring

- WK130/2 boring machine usable area 2000 x 2000 x 1800 mm, the maximum weight of treated detail: 1000 kg,
- SIP boring machine usable area 1400 x 950 x 800 mm

Machining processes

Drilling

- DIXI coordinate jig drilling machine usable machining area 780x650x70 mm
- drill lathe (horizontal drilling) for long hole drilling the maximum diameter: Ø 120/the maximum length 4000 mm; the drill lathe is equipped with tools for holes of the following diameters: Ø 7.6 mm, Ø 10 mm, Ø 11.1 mm, Ø 11.7 mm, Ø 13.25 mm, Ø 16 mm, Ø 20 mm, Ø 22 mm, Ø 29.3 mm, Ø 32.5 mm, Ø 33.6 mm, Ø 3 5 . 5 m m, Ø 3 8 m m, Ø 4 9 m m, Ø 5 8 m m, Ø 60 mm, Ø 61 mm, Ø 64.9 mm, Ø 86 mm, Ø 120 mm

Honing

- SUNEN HTC 4132 CNC honing machine for long hole honing – the scope of honed diameter is equal to Ø 7.5÷60 mm, the maximum length of honed detail cannot exceed 3000 mm, the honing machine is equipped with heads for machining of full-ended holes in the following diameters: Ø7.6÷7.8 mm, Ø8.1 mm, Ø12.7 mm, Ø21.3÷30.2 mm, Ø40 mm, Ø48.5÷63.5, and grooved holes in the following diameters: Ø7,62 mm, Ø12.5 mm, the grooves can be profiled in the following diameters:Ø7.82 mm,Ø12.96 mm,
- horizontal honing machine the scope of honed diameters: Ø 50÷112 mm, the maximum length: 2200 mm,
- vertical honing machine the scope of honed diameters: Ø7÷50 mm, the maximum length: 1000 mm

Grinding

- CNC grinding machine manufactured by Jonses & Shipman 524 EASY, grinder table dimensions: 500x200 mm,
- surface grinder grinder table dimensions: 320x1000 mm,
- cylindrical grinder the maximum grinding diameter/length: Ø400/1650 mm, Ø315/2000 mm,
- internal grinder grinding diameter/length: Ø40-400/250 mm,Ø10-165/175 mm,
- centerless grinder the maximum grinding diameter/lengthØ125/200 mm

Other machines

- **broaching machines** pull broaching length: 750 mm/force: 10T,
- thread-rolling machines the scope of diameter: 3÷70, the maximum length: 125 mm





