



Machine list



Painting box

Costplace:

6441



2 painting boxes with airless technology

- Built in: 2009
- Dimension: 15*8*8 m
- Dimension: 9*9*8 m
- Heatable: till 40 °C

Shot-blasting shop

Costplace:

6440



Shot blasting shop

3 shot blasting shops

- 2 compartments built in: 2000
- Dimension: 15 * 8 * 8 m / compartment
- 1 compartment built in: 2009
- Dimension: 15*8*8 m
- Shot blasting with sand and steelshot

Heat treatment shop

Costplace:

6104



2 heat treatment furnaces

- Dimension of 1. furnace: 5*5*10 m
- Dimension of 2. furnace: 1,5*1,5*2 m
- Temperature: Max. 1100 °C
- Crane capacity: 40 tons
- Max. height: 10000 mm

CNC-controlled HBM

SKODA 250

Costplace:

6307



CNC controlled NCT

- Horizontal movement of stand (X): 9009 mm
- Vertical movement of spindle carrier (Y): 4064 mm
- Max. boring depth (Z): 1970 mm
- Max. machining length (W): 1200 mm
- Max. machining length (Z+W): 1970 mm
- Smallest height between bed surface and spindle center: 720 mm
- Spindle diameter: 250
- Spindle revolution: 650 1/min
- Motorcapacity: 120kW
- Crane capacity: 120 tons
- Turning table: No
- Angle: Yes, mechanic

Costplace: 6307

FRORIEP FBT 160/260



CNC controlled NCT

- Horizontal movement of stand (X): 9998 mm
- Vertical movement of spindle carrier (Y): 4388 mm
- Max. boring depth (Z): 1553 mm
- Max. machining length (W): 600 mm
- Max. machining length (Z+W): 1200 mm
- Smallest height between bed surface and spindle center: 950 mm
- Spindle diameter: 260
- Spindle revolution: 600 1/min
- Motorcapacity: 95 kW
- Crane capacity: 100 tons
- Turning table: no
- Angle: no

Costplace:

6307

SKODA 200



CNC controlled NCT

- Horizontal movement of stand (X): 5723 mm
- Vertical movement of spindle carrier (Y): 4100 mm
- Max. boring depth (Z): 1500 mm
- Max. machining length (W): 700 mm
- Max. machining length (Z+W): 1500 mm
- Smallest height between bed surface and spindle center: 575 mm
- Spindle diameter: 200
- Spindle revolution: 600 1/min
- Motorcapacity: 90 kw
- Crane capacity: 100 tons
- Turning table: no
- Angle: yes, manual

SKODA 250

Costplace: 6307



CNC controlled NCT

- Horizontal movement of stand (X): 6086 mm
- Vertical movement of spindle carrier (Y): 4064 mm
- Max. boring depth (Z): 1970 mm
- Max. machining length (W): 1200 mm
- Max. machining length (Z+W): 1970 mm
- Smallest height between bed surface and spindle center: 710 mm
- Spindle diameter: 250
- Spindle revolution: 650 1/min
- Motorcapacity: 120 kW
- Crane capacity: 50 tons
- Turning table: no
- Angle: yes, manual

Pegard

Costplace: 6307



CNC controlled NCT

- Horizontal movement of stand (X): 2200 mm
- Vertical movement of spindle carrier (Y): 1800 mm
- Max. boring depth (Z): 1200 mm
- Max. machining length (W): 1800 mm
- Max. machining length (Z+W): 1800 mm
- Smallest height between bed surface and spindle center: 0 mm
- Spindle diameter: 130 mm
- Spindle revolution: 0-900 (1/min)
- Motorcapacity: 75 kW
- Crane capacity: 100 tons
- Turning table: yes
- Table load capacity: 10 tons
- Table size: 2200 x 1800 mm
- Angle: no

CNC-controlled VTL

Costplace: 6310

1540/4000



CNC controlled NCT

- Maximum allowable product weight on rotating table 63000 kg
- Diameter from rotating table 4000 mm
- Max. machining diameter: 4500 mm
- Max. machining height: 2000 mm
- Max. movement of cutting tool supports: 1250 mm
- Crane capacity: 100 tons
- Revolution: 35 1/min
- Cutter holder: 2
- Driven tools: no

Costplace:

6310

1550/5000

CNC controlled NCT

- Maximum allowable product weight on rotating table 100 000 kg
- Diameter from rotating table 4500 mm
- Max. machining diameter: 5000 mm
- Max. machining height: 2500 mm
- Max. movement of cutting tool supports: 1600 mm
- Crane capacity: 100 tons
- Revolution: 30 1/ min
- Cutter holder: 2
- Driven tools: no

Costplace:

6311

1563/6300

CNC controlled Siemens

- Maximum allowable product weight on rotating table 160 000 kg
- Diameter from rotating table 6300 mm
- Max. machining diameter: 6300 mm
- Max. machining height: 4500 mm
- Max. movement of cutting tool supports: 2000 mm
- Crane capacity: 100 tons
- Revolution: 30 1/min
- Cutter holder: 2
- Driven tools: yes

Costplace:

6310

KY-428 F1/5000



CNC controlled NCT

- Maximum allowable product weight on rotating table 125 000 kg
- Diameter from rotating table 4500 mm
- Max. machining diameter: 5000 mm
- Max. machining height: 3200 mm
- Max. movement of cutting tool supports: 2000 mm
- Crane capacity: 50 tons
- Revolution: 30 1/min
- Cutter holder: 2
- Driven tools: no

Radial boring machine

HFR 100/3000

Costplace: 6309



- Max. radial overhang of drilling spindle: 3000 mm
- Min. radial overhang of drilling spindle: 520 mm
- Revolution: 5-1600 1/min
- Clamping surface of table: 1520 x 3150 mm
- Crane capacity: 120 tons

HFR 100/3000

Costplace: 6309



- Max. radial overhang of drilling spindle: 3000 mm
- Min. radial overhang of drilling spindle: 520 mm
- Revolution: 5-1600 1/min
- Clamping surface of table: 1520 x 3150 mm
- Crane capacity: 100 tons



Costplace: 6309

RFM 75/4000



- Max. radial overhang of drilling spindle: 2000 mm
- Min. radial overhang of drilling spindle: 430 mm
- Revolution: 5-2000 1/min
- Crane capacity: 100 tons

MCFV 2080 Standard Vertical Machining Center

Costplace: 6451



- X-axis: 2030 mm
- Y-axis: 810 mm
- Z-axis: 810 mm
- Max. feed X, Y, Z: 15000 mm/min
- Table working surface: 2200 x 780 mm
- Max. load capacity of table: 3000 kg
- Crane capacity: 3 tons



ASTURN 70/2000 CNC CENTRE LATHE

Costplace: 6451



- Swivelling diameter above bed: 820 mm
- Swivelling diameter above cross slide: 530 mm
- Distance between centres: 2000 mm
- Max. weight of workpieces: 1500 kg
- Revolution range of main spindle: 0-1800 1/min
- Crane capacity: 3 tons



CNC Milling machine

Deckel Maho DMU 125 P hi-dyn

Costplace: 6451



- X Axis: 1250 mm
- Y Axis: 880 mm
- Z Axis: 800 mm
- Dimension of table: 1250* 1000 mm
- Load of table: 2000 kp
- Motorcapacity: 28 kW
- Revolution: 20-18000 1/min
- Crane capacity: 3 tons

DMG Turning lathe CTX 510 ECO V3

Costplace: 6451



- X-axis: 300 mm
- Z-axis 1050 mm
- Max machining diameter: 465 mm
- Max. rotating diameter : 680 mm
- Spindel diameter: 140 mm
- Max revolution of spindle: 3250 1/min
- Crane capacity: 3 tons

Edge and bevel grinder

KF IV N-6100 S

Costplace: 6449



- Stroke: 6100 mm
- Load of table: 1000 kg/m²
- Total dimension: 9310 * 5000 * 3300 mm
- Dimension of grinder band: 150 * 3000 mm
- Motorcapacity: 18,5 kW
- Crane capacity: 100 tons

Flame cutter

Costplace:

6442

MESSER OMNIMAT L 7000 CNC



- Max. width of plate to be cut: 6000 mm
- Max.length of plate to be cut: 16000 mm
- 2 bridges:
- 1. bridge: max. thickness of plate to be cut (CS) flame cutting: 300 mm
- 2. bridge: max. thickness of plate to be cut (SS) plasma cutting: 50 mm
- Crane capacity: 100 tons

Hydraulic break press

Costplace: 6444



2 Break presses

- Max. bending length 5500 mm
- Max. bending force: 6300 kN
- Stroke: 500 mm

- Max. bending length 5100 mm
- Max. bending force: 2000 kN
- Stroke: 300 mm
- Crane capacity: 15 tons

UBBDA 60x4500 Rolling machine

Costplace: 6443



- Max. rolling width: 4500 mm
- Max. rolling plate thickness: 60 mm
- Smallest rolling diameter: 600 mm
- Max. rolling diameter: 8000 mm
- Number of rolls: 3
- Allowance: 350 mm/ site
- Crane capacity: 100 to

Costplace:

6443

SRMVQ V-47 Rolling machine



Rubber coating for SS material

- Max. rolling width: 4500 mm
- Max. rolling plate thickness: 9 mm
- Max. rolling diameter: 4000 mm
- Smallest rolling diameter: 400 mm
- Number of rolls: 3
- Allowance: 150 mm/ site
- Crane capacity: 30 tons

Alliko Water Cutter Machine

Costplace: 8003



- Max. width of plate to be cut: 2000 mm
- Max. length of plate to be cut: 11000 mm, in this case not wider, than 1100 mm
- Max. thickness of plate to be cut: 100 mm
- Crane capacity: 20 tons

Costplace:

8004

Omega Laser Welding System



The maximum dimensions that can be welded by Omega Laser Products:

Length: 12000 mm
Width: 2000 mm
Crane capacity: 20 tons

Examples of materials that can be welded:

1.4301 - 304
1.4306 - 304L
1.4401 - 316
1.4404 - 316L
1.4438 - 317L
1.4439 - 904L
1.4541 - 321
1.4571 - 316 TI
1.4547 - 254 SMO
1.4652 - 654 SMO
1.4610 - HASTELLOY C4
1.4602 - HASTELLOY C22
1.4605 - ALLOY 59
1.4539 - 904L
1.4162 - S32101 (LDX2101)
1.4362 - S32304
1.4462 - S31803/S32205

Common used thickness:

1,0 mm + 1,0 mm
1,2 mm + 1,2 mm
1,5 mm + 1,5 mm
2,0 mm + 0,8 mm
2,5 mm + 0,8 mm
3,0 mm + 1,0 mm

Band-saw

PILOUS ARG-400 SAF PLUS



- Circumferential speed of band-saw: 15 – 90 m/min
- Maximum cutting diameter, circular 400 mm
- Maximum cutting diameter, square 390 mm

PILOUS ARG-400 SAF PLUS



- Circumferential speed of band- 15 – 90 m/min
- Maximum cutting diameter, 400 mm
- Maximum cutting diameter, 390 mm

Hydraulic plate shears

DLB 16/3100



- Max cutting length: 3000 mm
- Max. cutting thickness: 16mm
- Crane capacity: 30 tons

Welding machines

AFI welding machines	Fronius Transpuls synergic 5000	9 pcs
	Fronius Transpuls synergic 5000 imp	10 pcs
	Fronius TransSteel 5000	9 pcs
	Fronius Transpuls-synergic 4000 imp	2 pcs
	Messer MIG 500 imp	12 pcs
	Merkle M-451DW	10pcs
AWI welding machines	EWM TETRIX-500	3 pcs
	Messer TIG 450	4 pcs
	Fronius Transtig 5000	12 pcs
	Fronius Transtig 3000	9 pcs
Plasma cutter	Hypertherm Powemax 1650	3 pcs
Submerged arc welding machine	ESAB LAF 1000	7 pcs

Flux-cored arc welding



Specific data:

- Y: 4 300 mm
- X: 3 000 mm

Welding power source

<i>Machine type</i>	<i>Esab LAF 1000</i>
<i>Technical data</i>	<i>Value</i>
Current range (A)	800
BKI 60% ED (A) / (V)	1000 / 44
BKI 100% ED (A) / (V)	800 / 44
Idle voltage (V)	52



Specific data:

- Y: 3 900 mm
- X: 2 900 mm

Welding power source

<i>Machine type</i>	<i>Esab LAF 1000</i>
<i>Technical data</i>	<i>Value</i>
Current range (A)	800
BKI 60% ED (A) / (V)	1000 / 44
BKI 100% ED (A) / (V)	800 / 44
Idle voltage (V)	52



Specific data:

- Y: 6 900 mm
- X: 5 500 mm

Welding power source

<i>Machine type</i>	<i>Esab LAF 1000</i>
Technical data	Value
Current range (A)	800
BKI 60% ED (A) / (V)	1000 / 44
BKI 100% ED (A) / (V)	800 / 44
Idle voltage (V)	52

Rotary equipment and positioners



Specific data:

- Carrying capacity: 100t
- Quantity: 11 pair



Positioner SD-25.000

- Max. weight to be rotated: 25 t
- Diameter of setting-up table: 4000 mm



Positioner SDT-100.000

- Max. weight to be rotated: 100 t
- Diameter of setting-up table: 6500 mm