

Machine type	Machine parameters	Max size of a part	Toler. grade	Accuracy of processing parameters		
				Min tolerance, mm	Max tolerance, mm	Surface roughness, Ra (µm)
CNC horizontal turning centre DOOSAN Lynx 220LM 	19 kW Spindle rotation frequency – 4500 rpm Instrument qty in turret – 12 pcs	∅320x510 mm	7	∅16 mm: 0,018	∅320 mm: 0,057	0.8
CNC horizontal turning centre DOOSAN PUMA 280 LM 	27,5 kW Spindle rotation frequency - 3500 rpm Instrument quantity in turret - 12 pcs	∅410x1030 mm	7	∅16 mm: 0,018	∅410 mm: 0,063	0.8
CNC horizontal turning centre DOOSAN PUMA 3100 LM/LY 	37,5 kW Holder - 380 mm Spindle rotation frequency - 3000 rpm Y axle - 130 (+/-65 mm) Instrument quantity in turret - 12 pcs	LM: ∅450x1280 mm LY : ∅480x1300 mm	7	∅16 mm: 0,018	∅410 mm: 0,063	0.8
CNC horizontal turning centre DOOSAN PUMA 400XLC 	37 kW Spindle rotation frequency - 1500 rpm Instrument quantity in turret - 10 pcs	∅590x3095 mm	7	∅16 mm: 0,018	∅590 mm: 0,070	0.8
CNC horizontal lathe processing centre MAZAK NEXUS 6800II 	37 kW Rapid speed - 60000 mm/min Maximum spindle speed - 10000 rpm Turret - Number of instruments - 43 pcs. Table sizes - 630 x 630 mm Axis movement (X / Y / Z) - 1050 / 900 / 980 mm	1050x900x1300 mm	7	0.01	0.125	0.8

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CNC vertical turning centre - SnowLion Machines VL1200M	 <p>52,5 kW Max. table load - 2000 kg Table rotation frequency - 800 rpm Spindle rotation frequency - 3000 rpm Axis movement (X / Z) - 620 / 1000 mm Rapid speed - 24000 mm/min Rotation axis C - 360° (step 0,001)</p>	∅1160x1000 mm	7	∅100 mm: 0,035	∅1160 mm: 0,125	0.8
CNC vertical machining centre HARTFORD HSA – 423	 <p>26 kW Working area- 4000 x 2200 mm Spindle speed - 8000 rpm - (gear) Spindle speed - 10000 rpm - (direct drive) Maximum load - 5 000 kg</p>	4000x2300x780 mm	7	0.01	0.21	0.8
CNC surface grinding machine PSGP 1015AHR	 <p>7,5 kW Max. cross travel - 1200mm Max. longitudinal travel - 1650mm (vertical head) - L20 - 670mm (horizontal head) - 850mm Grinding surface of table - 1000 x 1500 mm</p>	1000x1500x700 mm	6	min. thickness. 1 mm: 0,006	max. thickness. 700 mm	0.4
CNC gear profile grinding machine NILES ZE 800	 <p>62 kW Centre distance rotary table / grinding wheel - min. / max. - 125 / 560 mm Grinding wheel diameter - min. / max. - 300/350 mm Grinding wheel width - min./max. - 63/80mm Tip diameter - 800 mm Helix angle of the tooth - 45° Stroke length - 600 mm Rotary table diameter - 650 mm Profile depth - 35 mm Rotary table load - 1500 kg</p>	∅800 mm	6	0.005	0.005	0.4

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CNC cylindrical grinding machine TOS BUB 50B NC/1500 Practic	 <p>31 kW Max. piece \varnothing - 500 mm Max. work length - 1200 mm</p>	\varnothing 500x1200 mm	6	\varnothing 16 mm: 0,006	\varnothing 500 mm: 0,063	0.4
CNC deep rolling and threading machine ROLLER 2800	 <p>Max. \varnothing without the use of tilting axis B - 300 mm Max. \varnothing with the use of tilting axis B \pm 30° - 280 mm Max. \varnothing with the use of tilting axis B \pm 35° - 250 mm Maximum lift of the rolling head - 112 mm Range of rolling force - 2,5-50 kN Max. force of rolling without the use of tilting axis B - 50 kN Max. force of rolling with the use of tilting axis B-20 kN Max. piece weight - 1000 kg Control system - SIEMENS SINUMERIK 840D</p>					
Automatic CNC bandsaw BOMAR Individual 620.460 GANC	 <p>Round profile: 0° - 460 mm; 45° - 405 mm; 60° - 260 mm Rectangular profile: 0° - 620x460 mm; 45° - 410x280 mm; 60° - 265x320 mm Square profile: 0° - 460x460mm; 45° - 405x405 mm; 60° - 265x265 mm Round rod: 350 mm Square rod: 350 mm</p>	620 x 460 mm	12	0.1	0.1	12.5