

# OUR MACHINES AND CAPACITY



## OUR SERVICES:

- Laser cutting
- Thermal cutting of metal sheets and metal sections
- Mechanical cutting of metal sheets and metal sections
- Mechanical cutting using guillotine cutters
- Drilling and cutting holes in metal sheets and metal sections
- Bending and straightening on hydraulically-operated vertical press brakes
- Straightening of metal sheets (up to 20 mm in thickness)
- Mechanical pressing
- Machining
- Blast cleaning of materials and products using abrasive blast cabinets and continuous shot blasting machine
- Hot-dip galvanizing
- Powder coating and wet painting
- Welding using Lorch welding unit with COBOT Universal Robots UR10 cooperating robot

## WELDING

- Modern welding machines: MAG (135), TIG (141) made by FRONIUS, EWM AG and LINCOLN ELECTRIC
- MSR-20 MOST self-adjustable welding rotator with a carrying capacity of up to 20 MT
- MCP-1 MOST conventional welding positioner with a carrying capacity of up to 1 MT
- Welding methods: 111, 135, 136, 141
- For material groups: 1.1, 1.2, 7.1, 8.1, 8.2, 43, 1.2+8.1

## Team

- an in-house team of qualified welding supervisors as required by the PN-EN ISO 14731 standard
- specialists include international welding engineers (IWE's) and international welding inspectors (IWI's)
- personnel qualified to perform non-destructive tests of welded joints using surface methods, are certified according to the PN-EN ISO 9712 standard
- a certified inspector for anti-corrosion protection namely a Frosio Inspector, level 3

In volumetric non-destructive testing of welds, the methods we use include UT and RT. For such tests, we rely on the support of reputable and experienced laboratories, such as WELD-TEST Sp. z o.o., and SOLDAR.

The methods we use in such testing include:

- visual testing (VT) level 2
- penetrant testing (PT) level 2
- magnetic particle testing (MT) level 2



# MACHINERY AND PRODUCTION CAPACITY

## CUTTING

### Laser cutting

- BYSTRONIC CNC Fiber Laser cutting machine
  - ➔ Maximum sheet size: 1,500 x 3,000 mm
  - ➔ Maximum metal sheet thickness: 25 mm (35 mm for stainless steel)
  - ➔ Cutting speed: 60 m/min
- TRUMPF TruLaser3060 Laser cutting machine
  - ➔ Maximum sheet size: 2,000 x 6,000 mm
  - ➔ Maximum metal sheet thickness: 20 mm
  - ➔ Cutting speed: 6 m/min

### Gas and plasma cutting

- Eckert gas and plasma cutting machine
  - ➔ Maximum sheet size: 2,000 x 12,000 mm
  - ➔ Maximum metal sheet thickness: 100 mm

### Others

- CNC band saws
- Hydraulically-operated CNC guillotine shearing machine
  - ➔ Maximum metal sheet thickness: 13 mm
  - ➔ Cutting length: 4,080 mm

## HEAT TREATMENT

- Induction hardening machines
- Resistance hardening furnaces

## MACHINING

- Engine lathes
  - ➔ Maximum workpiece diameter: 650 mm
  - ➔ Maximum workpiece length: 6,000 mm
- Turning lathes
  - ➔ Table diameter: 1,125 mm
  - ➔ Maximum workpiece diameter: 1,000 mm
- CNC lathes
  - ➔ Workpiece diameter: 600 mm
  - ➔ Workpiece length: 1,500 mm
- Milling machines
  - ➔ vertical milling machines with a table working area of up to 2,000 mm
  - ➔ horizontal milling machines with a table working area of up to 2,000 mm
- CNC machining centre
  - ➔ x=3,900 mm, y= 1,950 mm, z=1,250 mm
  - ➔ Maximum load capacity of table: 2 MT

- Radial drilling machines
  - ➔ Maximum diameter of drilling: 63 mm
  - ➔ Arm length: 1,600 mm
- Automatic lathes
  - ➔ Turning diameter: 50 mm
  - ➔ Length: 1,000 mm
- Grinding machines:
  - ➔ for rollers: maximum diameter: 120 mm, length: 1,450 mm
  - ➔ for holes: maximum diameter: 200 mm, length: 200 mm
  - ➔ for surfaces: maximum width: 350 mm, length: 1,050 mm

## METAL FORMING

- Cold forming
- Metal sheet rollers
  - ➔ Maximum metal sheet thickness: 18 mm
  - ➔ Maximum metal sheet length: 3,000 mm
- CNC brake press
  - ➔ Press force: 225 MT
  - ➔ Maximum cutting length: 4,050 mm
- CNC brake press
  - ➔ Press force: 80 MT
  - ➔ Maximum cutting length: 2,500 mm
- Mechanical and hydraulic presses
  - ➔ GEKA multi-purpose hydraulic press
- Wire bending machine

## ANTI-CORROSION PROTECTION

- Shot blasting room: 15 x 6 x 6 m
- Paint drying cabinet: 15 x 6 x 6 m
- Shot blast cleaning machine, width: 2,000 mm
- Pint room for large-format items:
  - ➔ powder coating and wet painting
  - ➔ dimensions: 60 m x 14 m
  - ➔ Maximum dimensions of the painted item:
    - door dimensions: 5,600 mm x 6,000 mm
    - Maximum length: 60 m

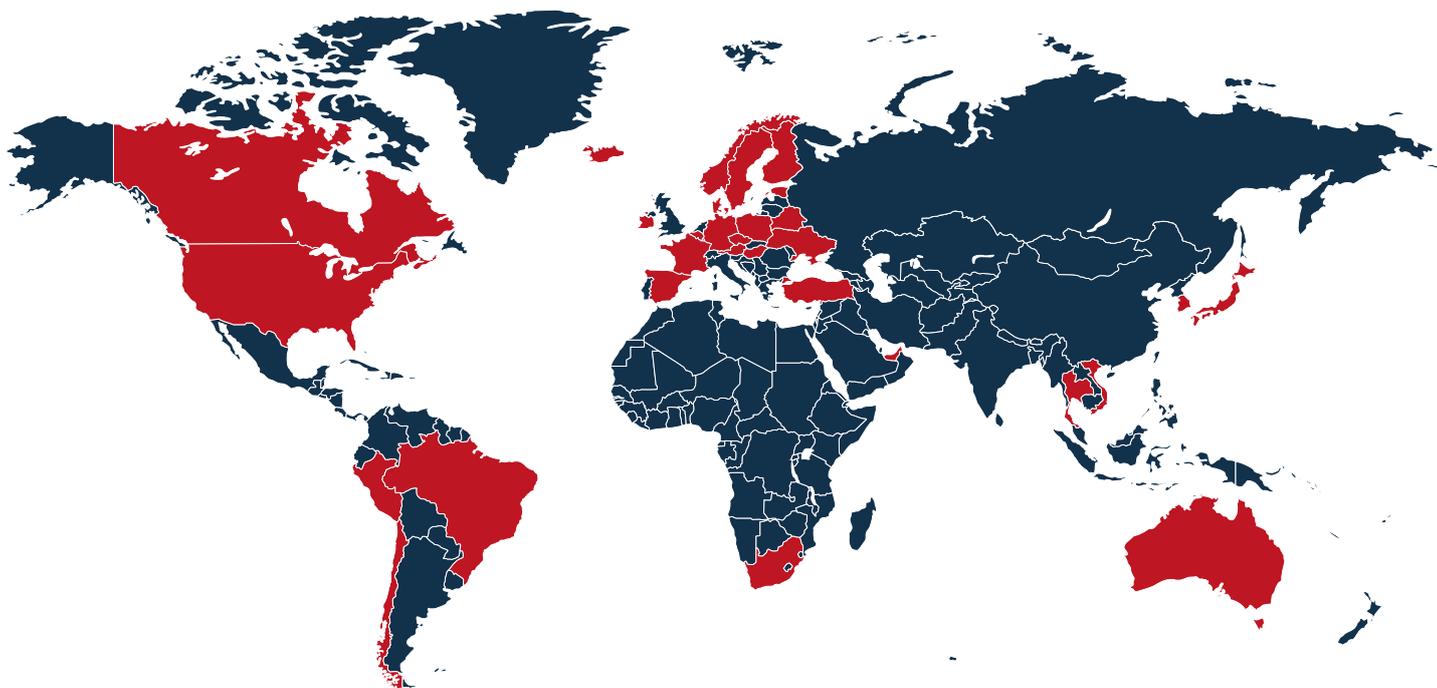
## OVERHEAD CRANES

3,2 MT, 5 MT, 6,3 MT, 8 MT, 10 MT, 12,5 MT.

## AUTOMATION

ZLorch welding unit with COBOT Universal Robots UR10 cooperating robot.

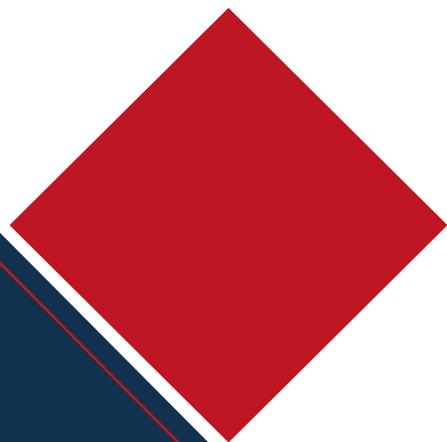




**ZUK Stąporków S.A.**  
ul. Górnicza 3, 26-220 Stąporków

+48 (41) 230 67 76

zuk@zuk.com.pl



**[www.zuk.com.pl](http://www.zuk.com.pl)**

