

List of machinery and technological possibilities of CHEMOSVIT STROJCHEM

NC and CNC machines

CNC machining centres - horizontal

TYC FPPC 400/11

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Pallet size	10 000 x 3000 mm
Axes	x = 11 000 mm y = 4 000 mm z = 1 500 mm
Number of machines	1

Vison Wide SF-4127

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Pallet size	4 000 x 1800 mm
Axes	x = 4 100 mm y = 1870 mm z = 1 020 mm
Number of machines	1

TOS WHQ 13 NC

Positioning accuracy	0,01 mm
Accuracy of machining	IT7 and higher
Table dimensions	2 200 x 1 800 mm
Axes	x = 3500mm/4000mm y = 2000mm/2200mm z = 1250mm
Number of machines	2

TAJMAC - ZPS H 63 / H800

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Pallet size	800 x 630 mm
Axes	x = 1 010 mm y = 800 mm z = 1 010 mm
Loading mechanism	Pallet changer (2 pallets)
Number of machines	2

Buckhard & Weber MC60H

Positioning accuracy	0,01 mm
Accuracy of machining	IT7 and higher
Pallet size	630 x 630 mm
Axes	x = 800 mm y = 600 mm z = 600 mm
Loading mechanism	Pallet changer (8 and 10 pallets)
Number of machines	2

Hyundai - Kia HX630

Positioning accuracy	0,008 mm
Accuracy of machining	IT6 and higher
Table dimensions	630 x 630 mm
Axes	x = 1 085mm y = 850mm z = 850mm
Number of machines	1

DAEWOO HP500

Positioning accuracy	0,008 mm
Accuracy of machining	IT6 and higher
Table dimensions	500 x 500 mm
Axes	x = 800mm y = 700mm z = 750mm
Number of machines	1

CNC machining centres - vertical**DECKEL-MAHO C100V**

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Table dimensions	1 250 x 800 mm
Pallet size	760 x 460 mm
Axes	x = 1 000 mm y = 800 mm z = 600 mm
Loading mechanism	Pallet changer (2 pallets)
Number of machines	1

MATEC 30L

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Table dimensions	2 500 x 1 050 mm
Pallet size	760 x 460 mm
Axes	x = 2 000 mm y = 1 000 mm z = 600 mm
Loading mechanism	Table; can be divided into two working areas
Number of machines	1

MCV 1000 -Power

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Table dimensions	1 300 x 670 mm
Pallet size	760 x 460 mm
Axes	x = 1 016 mm y = 610 mm z = 720 mm
Number of machines	1

Feeler 2215

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Table dimensions	2 100 x1 400mm
Axes	x = 2 150 mm y = 1 400 mm z = 750 mm
Number of machines	1

CNC milling machines

FGS 40CNC

Positioning accuracy	0,01 mm
Accuracy of machining	IT8 and higher
Axes	x = 800 mm y = 400 mm z = 500 mm
Number of machines	1

NC boring machines

WHN9B

Positioning accuracy	0,05 mm
Accuracy of machining	IT8 and higher
Table dimensions	1 120 x 990 mm
Axes	x = 1 200 mm y = 900 mm z = 650 mm
Number of machines	1

WHN10 NC

Positioning accuracy	0,03 mm
Accuracy of machining	IT8 and higher
Table dimensions	1 100 x1 100 mm
Axes	x = 1 200 mm y = 900 mm z = 650 mm
Number of machines	2

WD130

Positioning accuracy	0,03 mm
Accuracy of machining	IT8 and higher
Rotating table size	2 000 x 2 000 mm
Axes	x = 3 200mm y = 1 250mm z = 1 000mm
Loading mechanism	Rotating table
Number of machines	1

NC and CNC drilling machines

VXR 50 NS632A

Positioning accuracy	0,02 mm
Accuracy of machining	IT7 and higher
Axes	x = 1 250 mm y = 1 000 mm z = 800 mm
Number of machines	1

VXR 50 NS316

Positioning accuracy	0,02 mm
Accuracy of machining	IT7 and higher
Axes	x = 600 mm y = 400 mm z = 400 mm
Number of machines	1

NC and CNC lathes - horizontal**SPR 63 NC**

Positioning accuracy	0,01 mm
Accuracy of machining	IT7 and higher
Max part size	D max= 320 mm, L max= 350 mm
Other functions	Automatic bar feed (up to D max = 63 mm)
Number of machines	2

MASTURN 70 CNC

Positioning accuracy	0,01 mm
Accuracy of machining	IT7 and higher
Max part size	D max= 720 mm, L max= 3 000 mm
Number of machines	1

SKT 28LM

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Max part size	D max= 415 mm, L max= 1 070 mm
Other functions	Driver tools "C" axis
Number of machines	1

SKT 400

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Max part size	D max= 535 mm, L max= 1 200 mm
Number of machines	1

Weiler 1000

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Max. part size	D max= 730 mm, L max= 2 500mm
Number of machines	1

UD 802 CNC - Schaerer

Positioning accuracy	0,01 mm
Accuracy of machining	IT7 and higher
Max. part size	D max= 520 mm, L max= 4000 mm
Number of machines	1

MD5 SS CNC

Positioning accuracy	0,01 mm
Accuracy of machining	IT6 and higher
Max. part size	D max= 400 mm, L max= 1100 mm
Other functions	Driver tools "C" axis
Number of machines	1

NC and CNC lathes - vertical

SKJ 10CNC

Positioning accuracy	0,01 mm
Accuracy of machining	IT7 and higher
Max. part size	D max= 1 000 mm, L max=1 000 mm
Number of machines	1

CNC Cylindrical grinders

BUC 63-3000 CNC

Accuracy of machining	IT5 and higher
Max. part size	D max= 630mm, L max=3 000 mm
Number of machines	1

Conventional machines (without NC or CNC)

Lathes – horizontal

Max. part size	D max= 530 mm, L max= 6 000 mm
Accuracy of machining	IT9 and higher
Machine models	RM25, SUI40, SUI50, SN50, SUI63, SUI 80RP, SUS 80, UD 801 DE
Number of machines	9

Lathes – vertical

Max. part size	D max=1 250 mm, L max= 710 mm
Accuracy of machining	IT9 and higher
Machine models	SKJ 12A
Number of machines	1

Milling machines

Max. part size	x = 1 600mm, y= 400mm
Accuracy of machining	IT9 and higher
Machine models	FGU32, FGS25/32, FA4AU, FGSH40
Number of machines	4

Drilling machines

Max. part size	x = 1 600mm, y = 600mm z = 1 400mm
Accuracy of machining	IT11 and higher
Machine models	VR4A, VR6A, VO50
Number of machines	3

Surface grinders

Max. part size	x = 1 000 mm, y= 300mm z= 250mm
Accuracy of machining	IT5 and higher
Machine models	BPH 320 A, BPV 300, BRH 20.05
Number of machines	3

Cylindrical grinders

Internal

Dimensions of parts	D min=10mm, D max=250mm, L max=150mm
Accuracy of machining	IT5 and higher
Machine models	BDU 250A
Number of machines	1

External

Max. part size	D max = 630 mm D max = 4 000 mm
Accuracy of machining	IT5 and higher
Machine models	BHU 32A, BUC63B, BHV50A, BU28
Number of machines	4

Hobbing and gearcutting

Gears:	Cylindrical, bevel and worm
Teeth:	Straight, angled, shaped (band wheel for pulley)

Exterior teeth

Size	D max = 1 200 mm, m _{max} =10mm
Accuracy of machining	From St. 7

Interior teeth

Size	D max = 400 mm, m _{max} =6mm
Accuracy of machining	From St. 7

Machine models	FO-6, FO-10, OHO20, OH6, MAAG, PFAUTER, ZSTWK.
Number of machines	7

Planers, slotters and broaching

Size	x = 3 500, y = 1 000, z = 300mm
Accuracy of machining	IT12 and higher
Machine models	HD12, 5-16-20A
Number of machines	1

Slotting

Size	D max = 650 mm z =450
Accuracy of machining	IT9 and higher
Machine models	HOV 25, STANKOIMPORT 7D430
Number of machines	2

Broaching

Size	D max= 500 mm, L max=300mm
Accuracy of machining	IT8 and higher
Machine models	STANKOIMPORT
Number of machines	1

Dynamic balancing

Size	D max= 700 mm, L max= 3400 mm,
M _{max}	350kg
Machine models	TIRARAVENSTEIN
Number of machines	1

Welding

What are we welding:

- Weldments according to customer's documentation
- Rotating, flat, cubical parts and welded constructions

Types of welding processes:

- MAG, MIG, TIG, MMA, Gas welding, cold micro-welding

What materials are we welding:

- Non-alloy and Alloy steels, Aluminium and Copper alloys, Steel castings

Maximum measurements for welded part:

- 15 000 x 4 000 x 3 500
- 20 tons

Personnel:

- 11 welders
- 1 welding engineer

Certificates:

- ISO 3834-2, EN1090-EXC3

Painting

What are we painting:

- Parts according to customer's specification

Types of painting processes:

- Spray painting with compressed air

Maximum measurements for painted part:

- 10 000 x 3 500 x 4 000
- 20 tons

Assembly

What are we assembling:

- Assemblies, sub-assemblies and complete machines according to customer's documentation
- Mechanical assembly with hydraulic, pneumatic and electric systems

Maximum measurements for assemblies:

- 15 000 x 4 000 x 3 500
- 20 tons

Other services

Cranes capacity

Machinery

- Main passages 5t, 3t
- Jib cranes 250-1000kg

Main assembly area

20t

Subassembly area

8t, 3t

Heat treatment

- Stress relieving
- Annealing
- Normalising
- Re-crystallisation
- Hardening
 - o In water
 - o In oil
 - o In air ('self-hardening' materials)

Heat treatment ovens

Box furnace

Max. part size	1 100 x 600 x 500 mm
Sampling of temperature and time	digital with log
Quantity	1

Pit furnace

Max. part size	d800 x 1 400 mm
Quantity	1

Pit furnace

Max. part size	d850 x 1 000 mm
Quantity	1

Other services

- Anti-rust surface treatment
- Construction and repair of production fixtures
- Tools repairs and sharpening
- 3D measurement and measurement reports
- Repair of parts using welding and microwelding with spray deposit