

machine description	material	permissible workpiece dimensions				other technical data
		∅	thickness	width	length	
		mm	mm	mm	mm	
Continuous blasting machine			500	2550		
Continuous blasting machine			700	1500		
CNC cutting machine	St		100	2600	12,000	
CNC cutting machine	St		100	5000	22,000	
Plasma cutting system mobile	St, VA		25			power: 100A
CNC cutting machine Trulaser 5060	St, VA		25	2000	6000	laser
Bore-flame system (2 pcs)	St		8 till 60	80 till 600 resp. 1000		drilling diameter: 8 till 40mm
Bore-saw system	St		400	1000		drilling diameter: 8 till 40mm
Long cut band saw			410	850		with miter cut 45°
Automatic band saw			320	320		
Hydraulic shears	S355		10	3000		S235JRG2 till 12
Profile shears KBL 13 (500 kN)		max. 20	max. 20			with punch
Notchers		¾ - 2inch	5			notch: ∅ 27 - 60mm
Hole punch KL110 (1100 kN)		max. 50	max. 20	1200	2000	with coordinate table and scissors
Hole punch KBLH 700 (700 kN)		max. 30	max. 20			
Hole punch KL350 (350 kN)		max. 20	max. 20			
Wheels up / down press (2000 kN)						pressing direction horizontal
Press brake (5000 kN)			max. 20	4500		sidewall sieves max. till 4600; min. 1200
Press brake (4000 kN)			max. 12	4000		
Double straightening press (up to 2000kN)			500			
Swivel bending machine	St		8	3000		
Profile bending machine			20	80		material size depends on the profile

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Profile bending machine		50				
Round roller (Rollers-∅ 1030)			till 280	3500		conical
Round roller (Rollers-∅ 450)			till 40	3000		conical
Round roller (Rollers-∅ 320)			till 20	3100		conical
Round roller (Rollers-∅ 280)			till 10	2500		
Round roller (Rollers-∅ 220)	S355		till 10	3000		conical
Round roller (Rollers-∅ 120)			till 40	2000		
L + Z Lathe		400			2000	largest turning diameter: over support 250mm
L + Z Lathe		700			2000	largest turning diameter: over support 440mm
L + Z Lathe		1015			9000	∅ 1015, turning length. 330mm wenn inside kann be stretched
						largest turning diameter: over support 570mm
NC-lathe		450			2000	largest turning diameter: over support 410mm
						tool changer
Face lathe	St	2500			3500	turning length 3.500mm at ∅ 2500
		4000			500	turning length 500mm at ∅ 4000
CNC-vertical lathe		12,500			5500	turning length 3500mm workpiece weight up to 250t 2 supports, one of them 1x with powered tool C-axes-control of positioning faceplate
CNC- horizontal lathe		6500			20,000	workpiece weight up to 250t 1 support
CNC-universal milling machine			500	1150	500	table size 400 x 1400mm travel: y = 500 / x = 1150 / z = 500

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CNC-universal milling machine			600	850	625	table size: 650 x 1000mm Movement: y = 600 / x = 850 / z = 625
Milling machine	St		370	880	300	table size: 330 x 1000mm travel: y = 370 / x = 880 / z = 300
Round seam milling machine (Graebener)		1500-5500				max. milling depth: 100mm max. milling depth during step 1: 30mm
CNC-universal machining center	St		2600	5000	15,000	table size: 2 pieces 4500 x 3300mm travel: x = 15,000 / y = 5000 / z = 1300, V- axis = 2500, W- axis = 1300, B- axis = 360° work spindle diameter: 200mm clamping surface: approx. 11,000 x 3300mm tool holder: SK 50/ SK 60 automatical tool changer for 60 tools speed range spindle 2.5 - 1250 U/min max. feed: 10,000mm/min. workpiece weight: max. 150t
CNC horizontal drilling and milling machine			1250	1250	1800	Table size/clamping surface: 1400 x 1400mm Working spindle diameter: 120mm table movement transverse: 1800mm Working spindle direction: 630mm Maximum height of working spindle centre: 1200mm Tool holder: SK-50 Max rotation: 4000 rpm. Workpiece weight: 5 tons
Table boring mill 1			1000	1200	1450	table size: 1200 x 1000mm workpiece weight: 3t
Mobile boring machine for mechanical processing of components on site	St		1650	1650	>/<	table size: 3000 x 1600mm weight and dimensions are secondary

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Radial drilling machine		500	1300	500	H=570	largest drill diameter: 100mm boring spindle display: 1200mm largest boring spindle stroke: 420mm clamping surface: 700m 1500mm
Keyseating machine		13-230	390	300		table size: 120 x 460mm slot width: 5 - 50mm slot depth: 2.2 - 14.3mm
Flatbed grinding machine			425	700	300	table size: 300 x 700 travel: y = 425 / x = 700 / z = 300
Mobile inert gas welding system up to 500 amps						welding processes: E-Hand, MAG (pulse), MIG, TIG gas fusion welding (G-welding) stud welding: till ∅ 22mm materials: structurale steels, rust and scale resistant steels, casting / gray cast iron, high strength steels, wear resistant steels, composite armor plates, hardfacing, high alloy steels
UP welding portal up to 1400 Amp.			26,000	6700	6000	wire feed up to max. tandem 2 x ∅ 4mm
UP welding portal up to 1250 Amp.						
Mobile UP system up to 1200 Amp.						
Positioner		800-8000			H= 3000	workpiece weight: up to 150t turning speed: stepless 300 - 1000mm/min
Positioner, swivelling		6000				workpiece weight: up to 65 to pivotable till 135° turning speed: stepless 0.02 – 0.8 U/min
Pullmax welling phase cutting			50			chamfering width: 25mm
CHP 12 welding phase cutting			25			chamfering width: 12mm
Heating hall		hall dimensions		10.5m	20.7m	height (inside): 9m, weights: hall can be loaded by Straddler Carrier or mobile crane

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Blast hall with mobile blasting equipment		hall dimensions		9m	26m	height (inside): 10m
Painting hall		hall dimensions		20m	100m	painting surface with suction: 20m x 25m
Portal resp. Overhead cranes						max. lifting capacity: up to 150t per crane; 300t double stroke, hook height: up to 12.5m
Straddle Carrier				approx. 10m	approx. 8.5m	max. lifting capacity: 260t hook height: up to 9.3m suitable for ship loading in own harbor basin