Technological Machining
ACEBRON GROUP

Mecace Acemetal Acesan Acecal

ACEBRÓN MACHINERY

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MACHINING SECTION MACHINERY AND EQUIPMENT

1. LATHES

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
1.1. CNC HORIZONTAL LATHES		
1.1.1 ECHEA BRN HORIZONTAL LATHE	1100 x 8000 130422230	
Max. weight of workpiece between centres	12000 kg.	
Distance between centres	8000 mm	
Swing over carriage	1940 mm	
Swing over bed	2200 mm	
Main shaft hole	80 mm	
Maximum spindle speed	400 rpm	
Main head power	104.76 HP	
1.1.2. GURUZPE LATHE	A-1000/2	
Max. weight of workpiece between centres	10000 kg	
Distance between centres	4000 mm	
Swing over carriage	1100 mm	
Swing over bed	1800 mm	
Main shaft hole	105 mm	
Maximum spindle speed	1000 rpm	
Power	48 kW	
1.1.3. SAFOP HORIZONTAL LATHE	LEONARD 80/3000 CNC	
· CNC FAPUC OT-C		
· C axis with driven tools, spindle power 20 hp		
TECHNICAL SPECIFICATIONS		
Swing over bed	3500 mm	
Swing over carriage	3000 mm	
Distance between centres	7650 mm	
Maximum weight between centres 30 tn	30 tonne	
1.1.4. DAEWOO PUMA 400M LATHE	400 MA	
〈 CNC Fanuc 18i-T		
〈 VDI-50 lathe with driven tools		
TECHNICAL SPECIFICATIONS		
Z axis travel	1105 mm	
X axis travel	363 mm	
Distance between centres	1000 mm	
swing over carriage	450 mm	
Swing over bed	711 mm	
Main shaft hole	85 mm	
Maximum spindle speed	2000 rpm	
1.1.5. GURUZPE LATHE	A2000 4G CNC	
Maximum weight	20000 kg.	
Distance between centres	5000 mm	
Swing over carriage	1700 mm	
Swing over bed	2050 mm	
Main shaft hole	110 mm	
Maximum spindle speed	1000 rpm	

1. LATHES

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
1.2. CONVENTIONAL HORIZONTAL LATHES		
1.2.1. TRENS TRENCIM LATHE	SN500S /2000	
Distance between centres	1000 mm	
Swing over carriage	270 mm	
Swing over bed	505 mm	
Swing over gap	700 mm	
Main shaft hole	77 mm	
1.2.2. GEMINIS LATHE	GE-650	
Swing over bed	660 mm	
Swing over gap	830 mm	
1.2.3. NERVION LATHE	315	
Distance between centres	2000 mm	
Swing over bed	645 mm	
Swing over carriage	400 mm	
Swing over gap	865 mm	
Main shaft hole	71.5 mm	
1.2.4. GURUTZPE LATHE	SUPER-BT	
Distance between centres	8000 mm	
Swing over bed	1400 mm	
Swing over carriage	1045 mm	
Swing over gap	1770 mm	
Main spindle hole	102 mm	
1.2.5. COER GE-650 LATHE	GE-650	
Swing over bed 660 mm	660 mm	
Swing over gap 830 mm	830 mm	
1.3. VERTICAL LATHES		
1.3.1. NESTOR VERTICAL LATHE	631-631	
〈 CNC Fagor 8055		
TECHNICAL SPECIFICATIONS		
Maximum weight on table	8000 kg.	
Swing diameter	1,800 mm	
Height	800 mm	
Ram travel	480 mm	

1. LATHES

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
1.3.2. TOSHULIN VERTICAL LATHE	SKIQ 16	
〈 CNC FAGOR 8055		
〈 C axis		
TECHNICAL SPECIFICATIONS		
Table diameter	1,600 mm	
Maximum swing diameter	2,000 mm	
Maximum permitted weight	12 tonne	
Maximum working height	2,000 mm	
Ram travel	1,000 mm	
C axis	3,312 rpm	
1.3.3. SCHIESS-FRORIEP VERTICAL LATHE	32DV-700-350	
〈 CNC FAGOR 8055		
TECHNICAL SPECIFICATIONS		
Table diameter	4,000 mm	
Turning height	3,500 mm	
Maximum swing diameter	11,000 mm	
Maximum permitted weight	40 tonne	
Ram travel (ram cross section 240 X 240)	1,500 mm	
Rpm	71 rev/min	
1.3.4. HONOR SEIKI VERTICAL LATHE	VL 160 CM	
〈 CNC FAGOR 8055		
TECHNICAL SPECIFICATIONS		
Maximum turning diameter	2,000 mm	
Maximum turning height	1,250 mm	
Max. workpiece weight	8,000 kg.	
Table diameter	1,600 mm	
Spindle speed	250 rpm	
C axis	0.001º	
Ram travel (220 x 220)	900 mm	
X axis horizontal travel	-200+1150 mm	
1.3. VERTICAL LATHES		
1.3.5. HONOR SEIKI VERTICAL LATHE	VL 250CM	
〈 CNC FAGOR 8055		
TECHNICAL SPECIFICATIONS		
Maximum turning diameter	3,000 mm	
Maximum turning height	2,100 mm	
Max. workpiece weight	15,000 kg.	
Table diameter	2,500 mm	
Spindle speed	250 rpm	
C axis	0.001º	
Ram travel (220 x 220)	1,500 mm	
X axis horizontal travel	-300+1,650 mm	

2. LINE BORING UNITS

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
2.1. TOS VARNSDORF HORIZONTAL COLUMN BORING UNIT	WHQ105CNC	
〈 CNC Heidenhain TNC 430		
〈 40-tool magazine		
〈 Internal cooling		
〈 Universal milling head		
TECHNICAL SPECIFICATIONS		
Spindle diameter	105 mm	
Spindle speed	3300 rpm	
Spindle power	28 kW	
X-Y-Z travel	1900 * 1250 * 630 mm	
Spindle stroke (W axis)	630 mm	
Maximum load on table	5 tonne	
Table area	1400 x 1400 mm	
2.2. & 2.3. TWO TOS VARNSDORF HORIZONTAL LINE BORING MILLS	WHN13CNC	
〈 CNC Heidenhain TNC 426		
〈 Universal milling head		
TECHNICAL SPECIFICATIONS		
Spindle diameter	130 mm	
Spindle speed	2500 rpm	
Spindle power	37 kW	
X-Y-Z travel	3500 * 2500 * 1250 mm	
Spindle stroke (W axis)	800 mm	
Maximum permitted weight	12 tonne	
Table dimensions	1800 x 2000 mm	
2.4. & 2.5. TWO TOS VARNSDORF HORIZONTAL LINE BORING MILLS	WH(Q)13CNC	
〈 CNC Heidenhain TNC 430		
〈 80-tool automatic magazine		
〈 Through-spindle cooling		
〈 D'Andrea UT 5 630S boring head		
〈 Universal milling head		
TECHNICAL SPECIFICATIONS		
Spindle diameter	130 mm	
Spindle speed	2500 rpm	
Spindle power	37 kW	
X-Y-Z travel	4000 * 3000 * 2000 mm	
Spindle stroke (W axis)	800 mm	
Maximum permitted weight	20 tonne	
Turntable dimensions	1800 x 2200 mm	

2. LINE BORING MILLS

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
2.6. & 2.7. TWO TOS VARNSDORF TRAVELLING COLUMN BORING MILLS 〈 CNC Heidenhain TNC 430 (X, Y, Z, W axis control) Z, W) 〈 60-tool magazine 〈 Universal milling head 〈 Through-spindle cooling TECHNICAL SPECIFICATIONS Spindle diameter Spindle speed Spindle power Maximum torque Ram dimensions Turntable horizontal cross travel (X axis) Head vertical travel (Y axis) Ram travel (Z axis) Spindle stroke (W axis) Fixed table dimensions Maximum weight on fixed table Turntable dimensions Maximum weight on turntable	WRD150Q 150 mm 2500 mm 60 kW 2290 Nm 450 x 450 mm 1 8000 mm and 2 10,000 mm 4000 mm 1000 mm 800 mm 3600 x 4000 mm 80 tonne 3000 x 2500 mm 25 tonne	 
2.8. TOS VARNSDORF TRAVELLING COLUMN BORING MILL 〈 CNC Heidenhain iTNC 530 (X, Y, Z, W axis control). Siemens motors 〈 80-tool automatic magazine Rocker tool holder 〈 CHOV 20-bar through-spindle tool cooling 〈 2.5º HUI 50 automatic milling head positioning TECHNICAL SPECIFICATIONS X-Y-Z travel Two CNC turntables 25,000 kg. , 2000*2000 mm table 40,000 kg. 3000*3000 mm table	WRD150 14000 * 4000 * 1000 mm	

3 DRILLS / TAPPING MACHINES

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
3.1. MAS V050 RADIAL DRILLING MACHINE Maximum distance Bit diameter Power	V050 1600 mm 50 mm 6 kW	
3.2. IBARMIA STANDING DRILL Height Maximum bit diameter	B-70 1100 mm 70 mm	
3.3. SORALUCE DRILL Maximum bit diameter Arm length Power	TR3-2500 80/100 mm 2500 mm 15	
3.4. & 3.5. TWO GAMOR HYDRAULIC HORIZONTAL/VERTICAL TAPPING MACHINES Tapping capacity Power	MTC 2-48 M2-M48 BSW 1/8-1 ¾ BSP 1/8-2 1/4” 7.5 kW	

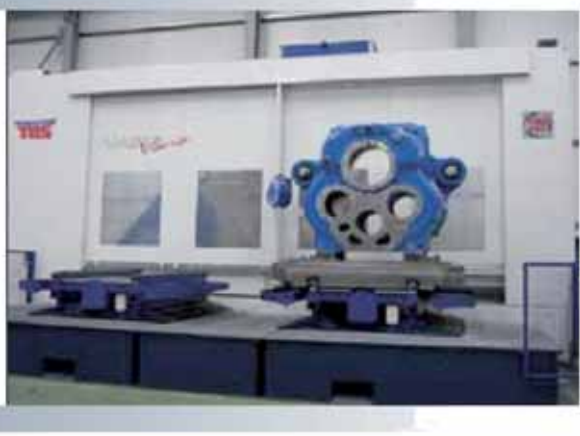
4 MILLING MACHINES

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
4.1. ANAYAK FIXED-BED MILLING MACHINE	VH 2200	
〈 CNC HEIDENHAIN TNC-426M		
〈 Spirsin 81210F/320 rotary table		
TECHNICAL SPECIFICATIONS		
Turntable	2200 x 750 mm	
X-Y-Z travel	2000 * 900 * 900 mm	
Spindle power	15 kW	
4.2. ANAYAK HVM 5000 FIXED TABLE TRAVELLING COLUMN MILLING MACHINE	HVM 5000	
〈 CNC HEIDENHAIN TNC-430		
〈 10-tool static magazine		
〈 Automatic head		
TECHNICAL SPECIFICATIONS		
Turntable	5000 x 1200 mm	
X-Y-Z travel	4300 * 1500 * 1800 mm	
Power	30 kW	
4.3. ZAYER PORTAL MILLING MACHINE	KPC-6000 AR	
〈 CNC HEIDENHAIN INC-530		
〈 2 Heads: one continuous tilting and one straight		
〈 60-tool automatic changer		
TECHNICAL SPECIFICATIONS		
Table area	6000 x 2000 mm	
Width between uprights	2800 mm	
X-Y-Z travel	6010 * 3559 * 1180 mm	
Main motor power	37 kW	
Maximum permitted weight on table	10,000 kg.	

5. MACHINING CENTRES

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
5.1. DAEWOO MACHINING CENTRE	Mynx 500	
〈 CNC FAPUC		
〈 Automatic tool change (30)		
TECHNICAL SPECIFICATIONS		
Max. height of workpiece	625 mm	
Table size	1200 x 500 mm	
Permitted load	800 kg.	
Spindle speed	10,000 rpm	
Motor power	11/15 kW	
X-Y-Z travel	1020 * 510 * 575 mm	
5.2. CORREA EXCELL MACHINING CENTRE	XB-106	
〈 CNC HEIDENHAIN		
〈 36-tool automatic changer		
〈 Dual pallet with “B” axis		
TECHNICAL SPECIFICATIONS		
X-Y-Z travel	900 * 600 * 500 mm	
Spindle speed	6000 rpm	
Head power	17 kW	
5.3. OKUMA HORIZONTAL MACHINING CENTRE	MA-500HB	
〈 CNC OSP-P200M		
〈 Automatic tool changer		
〈 NC B axis rotary table		
〈 60-tool magazine		
〈 Dual pallet		
〈 Tool breakage detection system		
TECHNICAL SPECIFICATIONS		
Table size	500 x 500 mm	
Permitted load	800 kg.	
Spindle speed	25,000 rpm	
Motor power	30 kW	
X-Y-Z travel	700 * 900 * 780 mm	
Y axis travel	900 mm	
Z axis travel	780 mm	
5.4. UARISTI PALLETISED MACHINING CENTRE	T1	
〈 60-tool automatic changer		
〈 2 pallet automatic changer		
TECHNICAL SPECIFICATIONS		
Maximum power	37 kW	
Maximum torque	1210 Nm	
X-Y-Z travel	3000 * 1600 * 1100 mm	
Pallet area	1,200 x 1,500 mm	
Maximum load permitted on pallet	5,000 kg.	

5. MACHINING CENTRES

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
5.5. TOS VARNSDORF VARIA MACHINING CENTRE 〈 CNC HEIDENHAIN 〈 Heidenhain self-correction sensor 〈 TECHNICAL SPECIFICATIONS		
Two allets	1.600 x 2.000 mm	
Useful load	16,000 kg.	
Motor power	37 kW	
X-Y-Z travel	3000 * 2000 * 2000 mm	
Shaft diameter	130	

6. OTHER UNITS

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
6.1. SACEM MORTISER	SCV-600	
TECHNICAL SPECIFICATIONS		
Vertical travel	600 mm	
Diameter	1200 mm	
6.2. DANOBAT FLAT RECTIFIER	RT 1200	
TECHNICAL SPECIFICATIONS		
Rectifiable length	1200 mm	
Rectifiable width	450 mm	
Magnetic plate dimensions	1000 x 400 mm	
Rectified height	450 mm	
Power	7.5 kW	

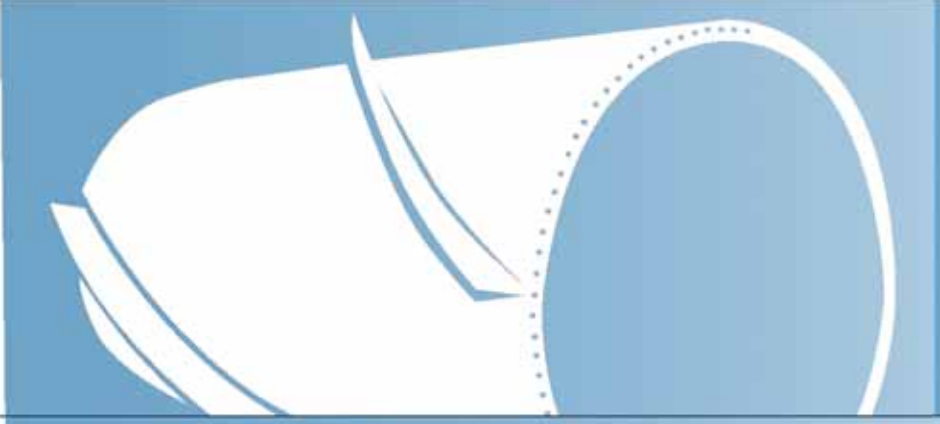
METROLOGY SECTION MACHINERY AND EQUIPMENT

7. MEASURING EQUIPMENT

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
7.1. LASER TRACKER (HAND-HELD)		
TECHNICAL SPECIFICATIONS		
Working range	35 m (70 m)	
Interferometer angular repeatability	3µm + 1µm/m	
Interferometer repeatability	1µm + 1µm/m	
Interferometer uncertainty	Square root of the sum of the repeatabilities	
Interferometer accuracy	10µm + 0.8µm/m	
Super ADM angular repeatability	3µm + 1µm/m	
Super ADM repeatability	7µm + 1µm/m	
Super ADM uncertainty	Square root of the sum of the repeatabilities	
Super ADM repeatability	20µm + 1.1µm/m	
7.2. HOFMANN BALANCER	PCX-25.2	
TECHNICAL SPECIFICATIONS		
Maximum permitted weight	6818 Kg (3409 per pedestal)	
Minimum weight	22.7 kg	
Maximum diameter	1753 mm	
Maximum diameter on belt	1270 mm	
Maximum length between pedestals	2692 mm	
Minimum length between pedestals	375 mm	
Power	16.1 kW	
7.3. DEA COORDINATE MEASURING MACHINE	BETA 512015	
TECHNICAL SPECIFICATIONS		
X axis (longitudinal) travel	5080 mm	
Y axis (transversal) travel	2030 mm	
Z axis (height) travel	1500 mm	
Measuring accuracy	14 + 15 L/1000 µm	
7.4 TESA MOTORISED SETTING BENCH	TPS 1000	
MEASUREMENT FIELD:		
Interior dimensions:	1 – 1016 mm	
Exterior dimensions:	40 – 1040 mm	
Measurement uncertainty	(1.5+L/300)µ L=m	
Exterior dimensions:	1320 x 340 x 300 (in mm)	

8. INSPECTION EQUIPMENT

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
NON-DESTRUCTIVE TESTING (NDT) AREA		
A8.1. ULTRASOUND UNITS 1 Unit	KRAUTKRAMER USM 35X	
8.2. MAGNETIC PARTICLE TESTER 2 YUGO Y6 units		
8.3. UV LAMP 2 units	LABINO PS 135 UV (Midlight) MAGNAFLUX	
8.4. LEVEL II QUALIFIED PERSONNEL ACCORDING TO EN473 IN THE FOLLOWING METHODS: Magnetic particles Penetrating liquids Ultrasound Visual inspection (Sectors : metallic materials and welding)		



METALWORK SECTION MACHINERY AND EQUIPMENT

9. WELDING EQUIPMENT

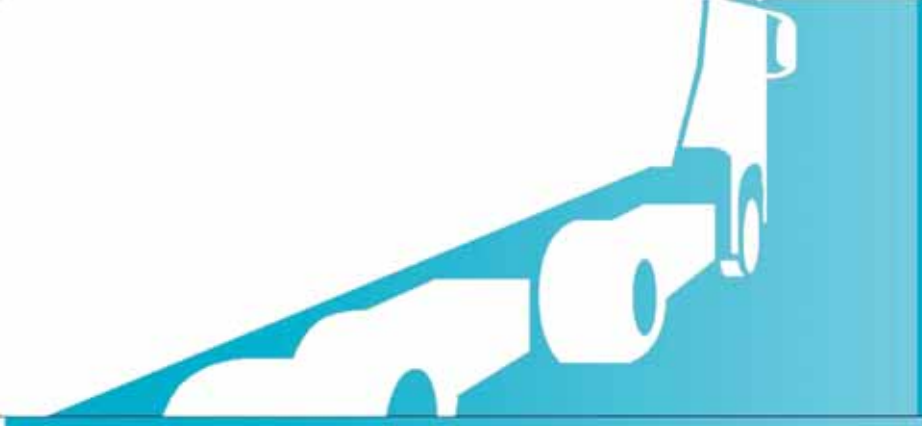
MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
9.1 Various welding units of the following types: TIG MIG-MAG STICK WELDING AIR CARBON ARC SUBMERGED ARC PULSE ARC WELDING		
9.2 ESAB PK-5 ELECTRODE DRY STORAGE OVENS		

10. METALWORK SECTION EQUIPMENT

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
10. 1. LOIRE SAFE CHVT-103 SHEAR Maximum cut (steel) Maximum cut (stainless) Maximum width	151077 Up to 10 mm thickness Up to 5 mm 3 metres	
10.2. PHSE-250/40/31 LOIRE SAFE FOLDING PRESS Force Folding length	15174 2500 TN (tonne) 4050 * 150 * 200 mm	
10.3. TMJ 5026 SAW Capacity (Height * width)	F3025 450 * 500 mm	
10.4. SUPRAREX SXE-P 4500 OXY-FUEL-CUTTER Useful cutting dimensions TWO HEADS FOR CUTTING WITH OXYGAS - Thickness - Cuts HD3070 HIGH-DEFINITION PLASMA - Thickness - Cuts ESAB ESP-200 PLASMA - Thickness - Cuts	20100536 1200 * 3300 mm 5 – 200 mm Iron 0.5 – 12 mm Steel, stainless steel, aluminium, brass 2 – 25 mm Steel, stainless steel, aluminium	
10.7. ERCOLINA TOP-BENDER PIPE BENDER	5960459	
10.9. DAVI MAS 2018 PLATE ROLLING MACHINE Work capacity: Width Thickness	 2 metres 8 mm	
10.10. GEKA HYD-110 IRONWORKER		
10.11. ELECTROMAGNETIC MILLING MACHINE	82985	
10.12. ROLLING CYLINDER		

11. SURFACE TREATMENT SECTION EQUIPMENT

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
11.1. SPRAY BOOTHS Dimensions	 12000 * 3750 * 4280	
11.2. BLASTING BOOTH Dimensions	81/EY 12000 * 4980 * 5120	
11.3. METAL SPRAY BOOTH Dimensions	HS-4400H2 10450 * 5740 * 5380	
11.4. TWO PAINTING MACHINES Flow (Q) Pressure ratio	200454 12.5 45	
11.6. M45 METAL SPRAY MACHINE Power	MZ08 13.5 kW	



LOGISTICS SECTION MACHINERY AND EQUIPMENT

12. LIFTING AND TRANSPORT EQUIPMENT

MODEL	TECHNICAL SPECIFICATIONS	PHOTOGRAPH
12.1. Maximum gantry crane capacity 32-tonne crane 20-tonne crane 16-tonne crane	50-tonne 9 25-tonne cranes 5 10-tonne cranes 2 5-tonne cranes	
12.2. Transport equipment CATERPILLAR forklift	5 tonne DP 50K	
LINDE H16D-1200 heavy duty forklift LINDE H80 D353 diesel forklift	16-tonne 16-tonne	
OMG 2t electric pallet truck OMG electric pallet truck	2 tonne 320 kN 1.5 tonne 320 KEG	
2 Mercedes Benz trucks