

CNC MILLING

Quaser MV204 IIU/15 – 1off	Quaser MK603 HE/10 – 1 off	Quaser MV205 CPL
Vertical 5 axis machining center , 500 x 500mm pallet size table, Max load 200kg, dia600 x 500mm, 40m/min rapids, BT40 Big-Plus 15000RPM spindle, 32 tools, 50 bar T/C, Heidenhain TNCi530 Control	Horizontal 2 pallet machining center, 500 x 500 pallet size table, 610 x 610 x 710mm 500kg, full C axis, BT40 Big-Plus, 18kW Spindle, 10000RPM, 60 tools, through coolant 20 bar, Fanuc Oi Mate control	Vertical machining center; 1700 x 700 table size, Max load 2000kg; 36m/min rapids, BT50 Big-Plus; 7500RPM spindle, 30 tools, 20 bar T/C, Heidenhain iTNC530 control
Fadal VMC 6535 HTX – 1 off	Fadal 4525 – 1 off	Fadal VMC 6535 – 3off
Vertical machining center, 1651 x 889 x 710, 1500kg load, CAT 50, 6000RPM, 30kW high torque spindle, 30 tools. Fanuc 18i MB control	Vertical machining center, 1143 x 635 x 520, 500kg load, BT40, 8000RPM, 18kW spindle, 30 tools. Nikken 202B rotary 4 th axis, Sinumerik 840D control	Vertical machining center, 1651 x 889 x 710, 1500kg load, CAT 50 & BT50, 7500RPM, 30kW spindle, 30 tools. Fadal V400 rotary 4 th axis & Fadal VH275 4 th rotary axis, Sinumerik 840D control or Fanuc 18i
Mori Seiki DuraVertical 5080 – 2 off	Fanuc Robodrill α-T21iFla – 1 off	HP 5-29 – 1 off
Vertical machining center, 800 x 530 x 510, 800kg load, BT40, 10000RPM, 18kW spindle, 30 tools. Nikken 202B rotary 4 th axis. Mitsubishi MSC-504	Vertical machining center, 700 x 400 x 330, 300kg load, BT30, 10000RPM, 3.5kW spindle, 21 tools. 4 th axis DDR 260iB (direct drive motor), Fanuc 31i-A5 control	Horizontal 1 pallet machining center, 630 x 630 pallet size table, 610 x 760 x 600mm 500kg, full C axis, BT50, 18kW Spindle, 3000RPM, 32 tools, through coolant 8 bar, Sinumerik 810 control
WHN 13.8 – 1 off	Okuma MCR-30 B II – 1off	
Horizontal 1 pallet boring machine, 1800 x 1600 pallet size table, axis travel (x,y,z, w) 3500 x 2000 x 1250 x 800mm 12000kg load, C axis, ISO50, 37kW Spindle, 1600RPM, Engelhardt 2004 control	Vertical gantry type CNC machine, 4800 x 2500 table size, axis travel (x,y,z, w) 5000 x 3700 x 800 x 1300mm 33000kg load, additional 5 sided head with C and B axis, BT50, 30kW Spindle, 6000RPM, Okuma OSP 5020M control	

CNC TURNING

Gildemeister CTX-410 V1 – 1 off	Gildemeister CTX-400 S2 – 1 off	Gildemeister CTX-210 V2 – 1 off
320mm diameter x 550mm capacity, spindle bore diameter 45mm, Fanuc 32i control	280mm diameter x 500mm capacity, live tools, spindle bore diameter 40mm, C-axis, Fanuc 21i control	210mm diameter x 330mm capacity, spindle bore diameter 35mm, live tools, C-axis, Fanuc 32i control
Gildemeister CTX-410 V2 – 1 off	Gildemeister CTX-210 V2 – 1 off	ZERBST DP-1 – 1 off
320mm diameter x 550mm capacity, live tools, spindle bore diameter 45mm C- axis, Fanuc 32i control	210mm diameter x 330mm capacity, spindle bore diameter 35mm, live tools, C-axis, Fanuc 32i control	1300mm diameter x 500mm capacity, Sinumerik H-645
DF-4 – 1off	DF-2/3 – 2 off	SEDIN 1525 – 1 off
850mm diameter x 500mm capacity, spindle bore diameter 95mm, Pronum-T	320mm diameter x 550mm capacity, spindle bore diameter 45mm, Pronum-T control	Vertical lathe, max turning diameter 2500mm, table dia 2250mm 11400kg load, max height of machined part 1600mm

BEND SAW

TMJ PP 302 GA/NC	TMJ PP 362 GA/NC	Beka-Mak 1100
Max cutting diameter 320mm, automatic bar feeder. Cutting edge 27mm.	Max cutting diameter 420mm, automatic bar feeder. Cutting edge 34mm.	Max cutting diameter 1100mm, motorized feeder. Cutting edge 67mm.

CNC MILL-TURN

Mori Seiki NL2500/700Y – 3off	Mori Seiki NL2500/700Y – 2off	Daewoo Puma 700LM 1 off
10" chuck, max diameter 320mm, spindle bore diameter 85mm, maximum bar length 700mm, 12 bar pressure coolant, Y-axis travel +/- 50mm, Main spindle speed 35-4000RPM, 12 position turret with 8kW live tool spindle, Mitsubishi MSX-850 control with MAPPS II interface.	12" chuck, max diameter 340mm, spindle bore diameter 85mm, maximum bar length 700mm, 12 bar pressure coolant, Y-axis travel +/- 50mm, Main spindle speed 35-4000RPM, 12 position turret with 8kW live tool spindle, Mitsubishi MSX-850 control with MAPPS III interface.	19" chuck, max diameter 900mm, spindle bore diameter 125mm, maximum bar length 3200mm, max load 5000kg, SLU hydraulic 5.2 steady rest, 12 bar pressure coolant, full C- axis. Main spindle speed 12-1500RPM, 12 position turret with 8kW live tool spindle, Fanuc 18i-T control.
Mori Seiki NL2500/1250MC – 1 off	Mori Seiki NL2500/1250Y – 1 off	Daewoo Puma 700LY 1 off
10" chuck, max diameter 320mm, spindle bore diameter 85mm, maximum bar length 1250mm, 12 bar pressure coolant. Main spindle speed 35-4000RPM, 12 position turret with 8kW live tool spindle, Mitsubishi MSX-850 control with MAPPS III interface.	12" chuck, max diameter 320mm, spindle bore diameter 85mm, maximum bar length 1250mm, Y-axis travel +/-50mm, 20 bar pressure coolant. Main spindle speed 35-4000RPM, 12 position turret with 8kW live tool spindle, Mitsubishi MSX-850 control with MAPPS III interface.	19" chuck, max diameter 750mm, spindle bore diameter 164mm, maximum bar length 3200mm, Y-axis travel +/-100mm, max load 5000kg, SLU hydraulic 5.2 steady rest, 12 bar pressure coolant, full C- axis. Main spindle speed 12-1500RPM, 12 position turret with 8kW live tool spindle, Fanuc 32i
Mori Seiki NLX2500/700Y – 1off	Mori Seiki NLX2500/1250Y – 1off	Mori Seiki NLX2500/700Y – 2off
12" chuck, max diameter 320mm, spindle bore diameter 85mm, maximum bar length 700mm, 12 bar pressure coolant, Y-axis travel +/- 50mm, Main spindle speed 35-4000RPM, 12 position turret with 8kW live tool spindle, Mitsubishi MSX-850 control with MAPPS IV interface.	12" chuck, max diameter 320mm, spindle bore diameter 85mm, maximum bar length 1250mm, 30 bar pressure coolant, Y-axis travel +/- 50mm, Main spindle speed 35-4000RPM, 12 position turret with 8kW live tool spindle, Mitsubishi MSX-850 control with MAPPS IV interface;	12" chuck, max diameter 320mm, spindle bore diameter 85mm, maximum bar length 700mm, Y-axis travel +/- 50mm, Main spindle speed 35-4000RPM, 12 position turret with 8kW live tool spindle, Mitsubishi MSX-850 control with MAPPS IV interface; High pressure coolant 70 bar.

EDM

AccuteX AMNC 50 Sinking EDM	AccuteX AU-500i Wire EDM
X/Y/Z travel: 500 x 400 x 350mm, Table size: 750 x 520mm, Max electrode weight: 150kg ,Max part weight: 1200kg ,Heidenhain TNC416 control.	X/Y/Z travel: 560 x 360 x 300mm, U/V travel +/- 50mm Cut angle on 100mm: 22.5 deg. ,Max. part dimensions: 990 x 560 x 265mm, Max part weight: 400kg

Waterjet

Bystronic ByJet Classic L 6030	
Cutting area X/Y/Z : 6074 x 3068 x 250mm Nominal sheet metal size: 6x3m Max material thickness: 200mm	Max plate weight: 790kg/m2 Area load: 2-4N/cm2 Point load (dia150mm): 25kN
Additional equipment: automatic cleaning system, two cutting heads, drilling head for pre-drill hole technology (allows to cut composite material)	

INSPECTION

CMM Aberlink 3D	CMM ZEISS	DIGITAL HIGHTS
Model ZENITH – 1200 x 800 x 700 mm bed size with PH-10 Renishaw probe. Software: ABERLINK 3D. CMM generates reports either PDF or XLS format.	Model CONTURA G2 – 2100 x 1000 x 800 mm bed size, articulating motorized head ZEISS RDS-P and ZEISS VAST XXT scanning probe. Software: CALYPSO ver. 4.6. Capability to import IGES or SAT 3D files. CAD based programming.	TESA Micro-hite 600, TESA Micro-hite M600 plus, TESA Micro-hite 350
		Comprehensive inventory of manual inspection equipment including Mitutoyo roughness meter

CAD/CAM Systems

Mastercam X – 1 seat	Siemens NX 7.5 – 4 seats
IGES, X-T, DXF, DWG, STEP, STL, IDW, SLDPRT, CADPRT.	IGES, X-T, DXF, DWG, STEP, STL, SLDPRT, CADPRT.

Services

Painting		Pre-painting
Two-epoxy painting according to Norsok M-501 System 7 and client spec.;		Degreasing with solvents, water cleaning, blast cleaning to clean class Sa3
Powder painting		
Coatings		Assembly
PTFE based coating (Xylan)	Manganese phosphating	Assembly and sub-assembly up to 20 ton
Mo ₂ S based coatings (Molykote)	Zinc phosphating	
Welding Mig/Mag / TIG		Pressure testing
6 axis Motoman HP-20D robot with capacity of 20kg and YASNAC DX100 controller, positioned with rotary-tilted table diameter 1000mm and capacity 1.5 ton, power source KEMPII		Pressure testing with water up to 2000 bar; gas testing upon customer request.

Buildings

Location – Piaskowiec / near Gdansk	Location – Male Walichnowy
2 workshops (800 sq. m. and 600 sq. m.) 3 warehouses with total area of 300 sq. m.	Number of buildings with total area of 1.300 sq. m. Completely new assembly and test facility built Summer 2011 Area: 800 sq. m., height: 9m (7m to the hook), 2 overhead cranes: 20 + 5 ton on the one rail + 12.5 ton Gas test pit (5x5m, 5 m deep) for gas testing sink in a water. Medium for gas testing: nitrogen.

New Investments

Location – Piaskowiec	Location – Male Walichnowy
New facility – a 2.000 sq.m. building with 1.500 sq.m. machine shop and 1.000 sq.m. office and social area. End of investment: Beginning Sept. 2013.	New welding facility – 600 sq.m. for Inconel overlay welding and welding application for the subsea market.
New machines	
Matsuura RA-4G – 2off Vertical machining center with the pallet changer. 1000 x 490 table size, max load 500kg, Bt50, 8.000RPM, 30m/min rapid, 30 position ATC, Fanuc 16iMB control	
Matsuura H.Plus-630/800(N)-50 – 1off Horizontal machining center with the pallet changer; 800 x 600 table size; max load 1.200kg; max size: Ø1050 x 1115mm; BT50; 10.000RPM; 60m/min rapid; 50 bar CTS; G-Tech 30i Control	