

2.1. Steel Structures – Material Preparation

Cutting of Plates



Technology	Machine	Max. Width (mm)	Max. Length (mm)	Max. Thickness (mm)
Flame cutting	Oxy cutters, 2 Pcs	2500	6000	300
Laser cutting	Bystronic ByLaser 6000 (6 kW)	2500	6000	30
	Bystronic ByStar 4020 (4 kW)	2000	4000	30
Waterjet cutting	Bystronic ByJet 3015	1500	3000	200

Bending



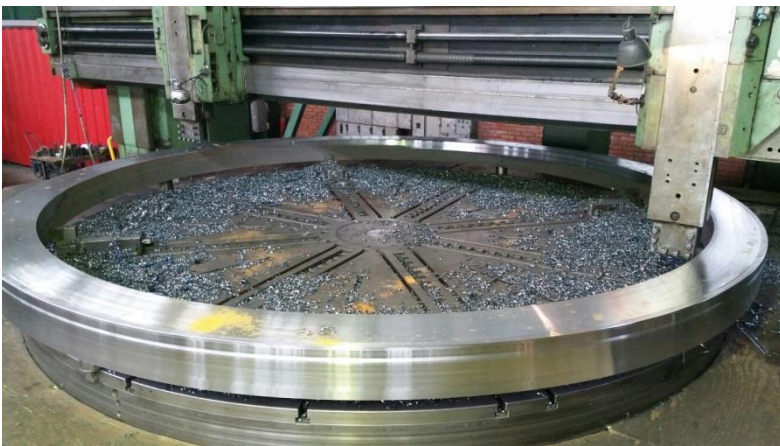
Type	Tonnage (kN)	Bending length (mm)	Open height (mm)	Standard stroke (mm)
Bystronic Xpert 800	8000	6200	650	365
Bystronic Beyeler PR 150	1500	4100	500	215

2.2. Machining



Equipment	Hmax	Bmax	Lmax	Weight
Boring mill - Škoda Tandem	4100mm	2000mm	26000mm	110t

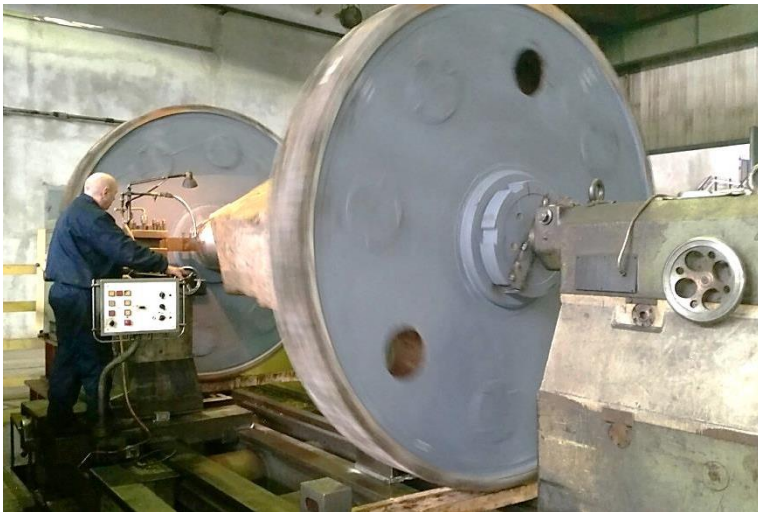
Spindle size



Equipment	Hmax	Diameter	Weight
Lathe - Rafamet	4150mm	8080mm	110t



Equipment	Hmax	Diameter	Weight
Turning table + Škoda Tandem	3000mm	15000mm	110t



Equipment	Diameter (mm)	Length (mm)	Weight (t)
Horizontal lathe	2000	10500	15



No.	Machine type	Machine designation	Operation	Module min.	Module max.	Diameter (mm)		Max. width (mm)	Surface quality	
						Min	Max		DIN	AGMA
1	Pfauter	TOS-F0116	Gearing	4	16	120	1600	500	N8	Q10
2	Pfauter	ZTSF5A342P	Gearing	4	20	300	2000	560	N8	Q10
3	Pfauter	ZTS5343P	Gearing	6	30	500	4315	1200	N9	Q9
4	Pfauter	ZTS5346	Gearing	8	30 (70)	800	8000	2000	N9	Q9
5	Wanderer	GF 324	Gearing	0,75	8	10	320	4000	N8	Q10
6	Wanderer	ZTS5V373P	Gearing	8	30 (50)	150	800	3500	N9	Q9
7	Niles	ZTS 315C	Gear grinding	1	10	30	315	210	N6	Q12
8	Niles	ZTS 500C	Gear grinding	1	14	50	630	215	N6	Q12
9	Niles	ZSTS35	Gear grinding	4	25 (34)	350	3500	710 (1200)	N6	Q12