

MECHANICAL PROCESSING SERVICES

The engineering park Machinery Factory Tarnow allows customers to meet the needs of industrial services in the field of machining, metalwork and welding.

Range of machining services include:

■ turning

max. turning length 3000 mm
max. turning diameter over bed \varnothing 1200 mm
max. turning diameter over support \varnothing 550 mm

■ surface milling

max. machining length 3000 mm
max. milling width 400 mm
max. milling height 500 mm

■ machining of gears, toothed racks, call involute

execution by a perimeter of teeth ranges from module 0,5 to 5,0 mm
of 8-7 class, the maximum diameter of the pinion \varnothing 300 mm
teeth grinding (grinder RAISHAUER) module ranges from 0,5 to 6,0 mm
of 7-6 class, the maximum diameter of the gear \varnothing 315 mm
performing internal tooth using the "Fellows"
execution of toothed racks

calls involute

perform sprockets

exercise pulleys

■ grinding holes

max. diameter of the polished bore \varnothing 250 mm
max. length of the polished bore 250 mm
max. diameter of the workpiece 400 mm
max. polished cone angle 60°

■ grinding rollers

max. diameter of grinding 317 mm
max. length of polished object 2000 mm

■ ribbed cylindrical grinding

max. length of 1200 mm with diameters ranging from \varnothing 11 to \varnothing 100 mm

■ surface grinding

max. grinding length 3000mm
max. grinding width of 600mm
max. grinding height of 800 mm

■ drilling holes for drilling Jig (SIP)

max. length of the workpiece 1000mm
max. width of the workpiece 600mm
max. workpiece height 500 mm

■ drag holes

perform keyways,
making holes spline
making holes hexagonal, square

Machining on CNC machine tools:

■ lathe

max. turning diameter \varnothing 400 mm;
max. turning length of 1500mm

■ machining centers 3 and 5 axis

max. workpiece dimensions:
- length 1200 mm - width 750 mm - height 750 mm

Range of machining also includes:

- the performance spindles,
- production of spare parts for machine tools,
- grinding and regeneration cradles, slides,
- turning discs and drums for all makes of vehicles,
- the regeneration of other auto parts



Table of maximum dimensions of workpieces

| TYPE OF TREATMENT | Type of machine | Length max mm | Width max mm | Height max mm | ∅ max mm | Remarks |
|----------------------|----------------------|---------------|--------------|---------------|----------|------------------|
| TURNING | Conventional | 3000 | | | 1200 | over bed |
| | | | | | 550 | over cross slide |
| MILLING | CNC | 3200 | | | 400 | |
| | conventional | 3000 | 400 | 500 | | |
| DRILLING AND MILLING | CNC | 1200 | 750 | 750 | | |
| | coordinate | 1000 | 600 | 500 | | |
| GRINDING | Cylindrical | 2000 | | | 317 | |
| | the holes | 250 | | | 250 | ∅ grinded hole |
| | | | | | 400 | ∅ grinded object |
| | for planes | 3000 | 600 | 800 | | |
| | external thread | 1000 | | | 230 | |
| | for internal threads | 100 | | | 40-80 | |
| | snails to splines | 1000 | | | 230 | |
| | | 1200 | | | 11-100 | m=6 |

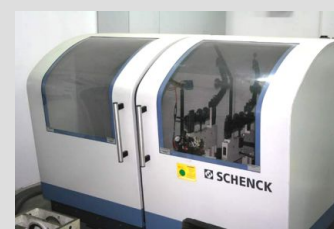
Table possibility of machining of gear

| TYPE OF TREATMENT | | Module max | ∅ max | b width of the rim | Accuracy class according to PN/M-8852201 | Remarks |
|----------------------------|----------|------------|-------|--------------------|--|----------------|
| MILLING CIRCUMFERENTIAL | gears | 0,5 - 5 | 300 | 200 | 8 - 7 | |
| | pinions | 0,5 - 5 | | 250 | 8 - 7 | |
| GRINDING | gears | 6 | 315 | 145 | 7 - 6 | |
| | pinions | 6 | 90 | 350 | 7 - 6 | |
| CIRCUMFERENTIAL CHISELLING | external | 1 - 4,5 | 300 | | 9 - 8 | method Fellows |
| | interior | 1 - 4,5 | 225 | | 9 - 8 | |
| WORM WHEELS | | 1 - 5 | 250 | | 9 - 8 | |



In addition to the above mentioned technical possibilities Machine Factory Tarnow sc we would like to offer the following services:

- **perform major repairs** and limited domestic production of machine tools, as well as domestic and foreign manufacturers with warranty made the scope of work
- **metalwork construction and welding** in the steel constructions, electric arc welding, gas welding
- **repair of industrial equipment**
- **dynamic balancing (balancing SCHENCK type HE3BU / CAB700)**
 - rotor weight for load balancing G300 kg / per support max. after 150 kg
 - max. rotor diameter over bed 1260 mm / range of diameters pivots 9-70 mm
 - spacing of the rolls from 50 mm to 1350 mm
 - threshold calibration constant of $180 \times 10^6 \text{ kg/min}^2$
 - bed length 1500mm / speed measuring range of 120 to 10 000 rpm
 - minimum achievable residual balance not according to ISO 29532.0 gmm/kg
 - the ratio imbalance reduction (URR) of 95%
- **Laser Marking (laser ELECTROX 600Group, model: MAX Box)**
- **Induction hardening bed guides**



We guarantee complete satisfaction of processed orders guaranteeing the high quality of our products and services.

NOTE: The listed parameters are only general information, so before performing any services must be checked individually optimal performance capabilities from the structural and technological



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