

TECHNOLOGY

Mechanical operations

Sheet metal forming	Specifications
Shear	Max. d = 5 mm l = 3000 mm
CNC Punching	Max. d = 4 mm 3000x1500 (mm)
Laser cutting	4,5 kW 3000x1500 (mm)
CNC Bending	F = 1700 kN l = 3000 mm
Hydraulic Presses	F = 2000 kN
Excenterpresses	F = 4000 kN
Fast running Presses	n = 1500/min
Fastener inserting (PEM)	F = 72 kN
Welding	MIG, TIG, Spot welding

Milling	Working range
Horizontal Machining Centre	Φ800x1000 (mm)
Vertical Machining Centre	1016x508x635 (mm)
Vertical Machining Centre	406x305x254 (mm)

Surface Treatments

Painting	Min. dim.	Max. dim.
Powder	50x50x20 (mm)	3000x600x1000 (mm)

Zinc plating	Coat thickness	Max. dim.
Clear, Black; Rack, Barrel	8 - 24 μ	1900x900x300 (mm)

Tin plating	Coat thickness	Max. dim.
Rack, Barrel	Up to 12 μ	800x600x200 (mm)

Nickel plating	Coat thickness	Max. dim.
Rack, Barrel	8 - 24 μ	2000x1000x300 (mm)

Anodisation	Coat thickness	Max. dim.
Transparent, Black	Up to 20 μ	500x500x200

KTL Dip painting	Coat thickness	Max. dim.
Black	Up to 20 μ	2000x1000x500 (mm)

Silk-screening		Max. dim.
Single and multicolour		500x500 (mm)

<p>INTEC MKD d.o.o. Retnje 1a, 4294 Križe SLOVENIJA</p>	<p>Tel: + 386 4 5951140 Fax: + 386 4 5951160 e-mail: mkd@intec.si Internet: http://www.intec.si</p>
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Assembling

Assembling without electrical testing

Tool shop

Tool types	Dimensions
Tool for sheet metal forming	Max. 800x500 (mm) or acc. Agreement

Tool shop technologies	Working range
Wire EDM	Max. 520x370 (mm)
Sink EDM	Max. 250x150x70 (mm)
Vertical Machining centre	Max. 1016x508x635(mm)
Start hole EDM	Max. 350x250 (mm)
Flat grinding	Max. 620x300 (mm)

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