

## Company overview / production competence Schwing St. Stefan



**SCHWING GmbH**

**A-9431 St. Stefan /Lav., Carinthia**

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**[www.Schwing-Auftragsfertigung.at](http://www.Schwing-Auftragsfertigung.at)**



## Contact details

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### Contact persons / contact details:

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## Technical details about our machinery

(just max. values are listed / Information depends on material!)

### Qualifications:

#### Welding methods

Welder's qualification ISO 9606-1

MAG – welding

Manual arc welding

(details about welding: nr. **111** / ISO 9606-1

nr. **135, 136, 138** / ISO 9606-1

nr. **135, 136, 138** / ISO 14732

nr. **141** / ISO 9606-1)

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#### Welding license

DIN EN 1090-2 EXC 3

DIN EN ISO 3834-2

DIN 2303 Q3 BK1

DIN EN 15082-2

DVS 1715

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#### Testing methods

Ultrasonic testing instruments

Magnetic powder test

Color infiltration method

Encoders for dimensional accuracy and surface quality

Spectral analysis instrument

Hardness testing

Salt spray testing (NSS, AASS)

Hydraulic cylinder testing area through 500 bar

FARO gage measuring arm: portable 3D measuring arm

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#### Max. part dimensions

Max. Length: 28000 mm

Max. Width: 2500 mm

Max. Height: 3000 mm

Max. single piece weight: 10 tons

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#### Certified

ISO 9001:2015

ISO 14001:2015

## CNC- controlled machines



CNC turning-milling-drilling machining center



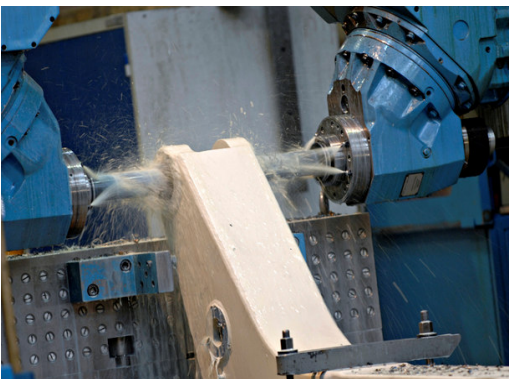
CNC palletchanging milling-drilling machining center



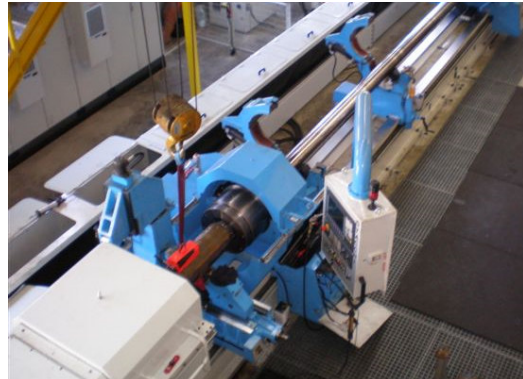
CNC Drilling and milling machining center



CNC palletchanging milling-drilling machining center



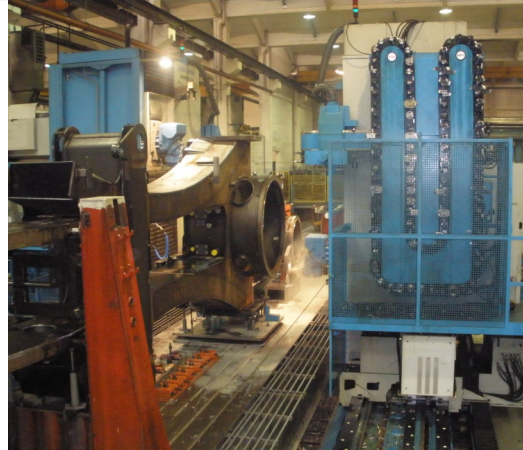
CNC travelling column milling machine center



CNC deep drill machine



CNC travelling column milling machine center



CNC travelling column milling machine center



## CNC- controlled machines

### **Fine focus plasma**

Max. sheet size: 2.500 x 12.000 mm

Max. thickness: 35 mm

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### **Autogenous**

Max. sheet size: 2.500 x 10.000 mm

Max. thickness : 250 mm

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### **Laser**

Max. sheet size : 2.500 x 12.000 mm

Max. thickness: 15 mm

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### **CNC – cylindrical grinding machine**

Diameter:  $\varnothing 20 \dots \varnothing 390$  mm

Max. grinding length : 4000 mm

Max. weight: 1 to

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### **CNC – milling machinery**

With horizontal / vertical swiveling head

NC – rotary table for 5-sided machining

Traveling distance X: 2800 mm

Traveling distance Y: 2000 mm

Traveling distance Z: 2200 mm

or with magnetic clamping table

Traveling distance X: 6500 mm

Traveling distance Y: 1600 mm

Traveling distance Z: 900 mm

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### **Machining centers**

Max. traveling distance X: 12.000 mm

Max. traveling distance Y: 3.600 mm

Max. traveling distance Z: 1.200 mm

Pallet box: 2.500 x 12.000 mm

NC - Turntable: A 1.250 x 1.250 mm

B 2.500 x 1.800 mm

Pick-up for 3 heads

5 – sided machining

pallet changer

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### Double moving column machine

Max. traveling distance X: 28.000 mm

Max. traveling distance Y: 2.500 mm

Max. traveling distance Z: 1.500 mm

Pallet range: 2.000 x 30.000 mm

5 – sided machining

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### CNC – Lathe

Small lathes

Max. height: 270 mm (Ø 540mm)

Max. turning length: 1.200 mm

Max. spindle bore: Ø 77 mm

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### CNC – Lathe

Large lathes

Max. height: 940 mm

Max. turning length : 4.000 mm

Driven tools

X,Y,Z - axis

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### CNC-turning-drilling-milling machines

Max. height: 440 mm

Max. turning length : 6.500 mm

Driven tools until 25KW

X, Y, Z, B, C – axis

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## Conventional machines:

### Sawing

Section thickness range: 0 ... 420 mm

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### Rolling machine (CNC – controlled)

Number of rolls: 4  
Max. thickness : 20 mm  
Max. sheet width: 2.000 mm  
Roller diameter: 320 mm  
Max. strength of sheets: 960 N/mm<sup>2</sup>

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### Edging – Press 400tons (NC – controlled)

Max. thickness: 20 mm  
Max. sheet width: 3.700 mm  
Max. strength of sheets: 960 N/mm<sup>2</sup>

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### Radial drilling machine

Max. drilling diameter: Ø60 mm  
Max. length: 1.500 mm  
Max. clamping area: 1.000 x 1.900 mm

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### Plate drilling machines

Spindle: Ø110 mm  
Traveling distance X: 4.200 mm  
Traveling distance Y: 1.500 mm  
Traveling distance Z: 400 mm  
Clamping range of pallet field: 1.200 x 8.000 mm  
Max. possible weight: 16 tons

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### Milling machines

Table clamping surface: 630 x 400 mm  
Traveling distance X: 1600 mm  
Traveling distance Y: 600 mm  
Traveling distance Z: 600 mm

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**Drilling and milling machine**

Spindle:  $\varnothing$ 100 mm

Traveling distance vertical: 1.200 mm

Traveling distance horizontally: 1.600 mm

Clamping surface rotary table: 1.250 x 1.250 mm

Clamping surface rotary table: 2.200 x 2.200 mm

Max. possible weight: 3 tons

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**Lathe**

Max. height: 310 mm

Max. turning length: 4.000 mm

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**Deep drilling machines**

Max. deep drilling length: 6.000 mm

Diameter:  $\varnothing$ 31,6 ...  $\varnothing$ 600 mm

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**Honing machine**

Diameter:  $\varnothing$ 20 ...  $\varnothing$ 210 mm

Max. honing length: 2.200 mm

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**Cylindrical grinding machine**

Diameter:  $\varnothing$ 30 ...  $\varnothing$ 420 mm

Max. grinding length: 2.000 mm

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***Cutting equipment / welding equipment***



CNC Fine Focus plasma machine



CNC-Laser cutting machine



Cross-seam welding system



Welding robot



Welding robot



Cylinder welding robot



## Welding systems

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### Longitudinal welding robot

Traveling distance: 15.000 mm

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### Cross-seam welding system

Traveling distance: 15.000 mm

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### Welding robot

Traveling distance: 16.000 mm

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### Portal welding robot

Double L-manipulator

Max. possible weight: 2,0 to

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### IGM Welding robot (MAG)

Max. height: 430 mm

Max. turning length: 4.000 mm

Max. possible weight: 500 kg

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## Other systems:

<b>Annealing furnace</b>	Electrically heated shaft furnace with air circulation LSU 100/200 Max. annealing temperature: 750 Grad Length: 2.000 mm Diameter: 1.000 mm Hard chrome plating plant
<b>Nitriding</b>	Nitriding oven for gas nitriding or for nitrocarburizing with the subsequent oxidation Furnace size: 900 x 900 x 1.300 [mm]
<b>Hard chrome plating plant</b>	Inside- and outside chroming Certified: RAL 6011 level for the highest quality max. chroming length: 2.500 mm max. Diameter: 300 mm Chrom repair method SELECTRON
<b>Sand blasting cabinet</b>	Width: 3,8 m Height: 4 m Length: 12 m
<b>Continuous blasting machine Rotojet</b>	Max. dimensions of piece: Width: 2.500 mm Height: 500 mm Length: 12.000 mm
<b>Painting cabins</b>	Width: 5.600 mm Height: 5.000 mm Length: 17.000 mm
<b>Hydraulic cylinder washing system</b>	Max. length of piece: 3.500 mm Max. outside diameter: 400 mm Max. possible weight : 800 kg

## Shipping options:

**In addition by train – direct connection to the factory** (train station A-9431 St. Stefan)