

Overview of Production Facilities

Prod. Group	Brand	Type	Quantity	Max Stroke rate pro min.	Draw length		Wire		Band			Processing stages/ stamping pressure (t)
					min mm	max mm	Ø		max mm	Thickness		
							min mm	max mm		min mm	max mm	
Cold headed parts (step mounting pins, etc.)	Hilgeland	HC4-15	12	850	5	39	1	4				Double strike
	National	M 3	1	300	3	12	1	2.8				Double strike
	National	M 3 1	2	550	4	26	1	3.5				Double strike
	National	FXH 1M	4	470	3	40	1.5	5				Double strike
	National	FXH 1L	1	360	12	60	2	5				Double strike
	National	M 51	3	470	10	60	2	5				Double strike
	National	M 56	2	350	5	31	2	6				Double strike
	Asahi	A OT-68	1	250	9	34	2	6				2 Matrices
	National	M 34 3B	2	200	6.5	65	2.5	6.5				2 Matrices
	Hilgeland	HC5-FT	1	400	6.5	75	2	6				2 Matrices
	National	FXP 23S	1	350	3	50	2	9				3 Matrices
	National	FXP 23M	1	330	9	75	3	9				3 Matrices
	National	FXP 34S	1	300	3	50	2	12				4 Matrices
	National	FXP 24S	1	350	2	50	2	9				4 Matrices
	National	FXP 25S	3	330	3	50	3	9				5 Matrices
	National	FXP 37S	1	255	3	50	3	12				7 Matrices
Wire stamping and bending parts	Bihler	RM 35	3	250		170	0.3	3	32	0.2	2-5	7
		RM 40	5	350		270	0.3	4	60	0.2	3	9
		MC 42	1	350		120	0.3	4	60	0.2	3	9
		GRM 50	3	130		320	0.3	5	40	0.2	4	25
		GRM 50S	1	130		1000	0.3	5	40	0.2	4	25
		GRM 80	7	250		520	0.4	6	80	0.2	4	30
		MC 82	2	250		200	0.5	6	80	0.2	4	30
		GRM 100	1	160		400	0.5	7	100	0.3	4	54
	Lafranconi	LM 400S	1	1000		Servo	0.3	4	100	0.2	3	7
Follow-on die stamped parts	Bruderer Beutler Bruderer Bruderer Bruderer Bruderer Beutler Bruderer Bruderer Bruderer Helmerding Bruderer Bruderer	BSTA 500-110B2	1	1120		120	Clamping surface(lxw) 1075 x 650		120	0,3	2,5	50
		BSTA 250 75 B	1	1500		85	730 x 530		80	0,2	2,5	25
		PDH 40	1	110		160	630 x 450		60	0,3	1,5	40
		BSTA 50L	1	1200		120	940 x 650		120	0,3	2,5	50
		BSTA 50-95B2	2	1120		120	940 x 650		120	0,3	2,5	50
		BSTA 80UL	1	750		120	1220 x 910		200	0,3	3	80
		BSTA 80 B2L	1	750		120	1220 x 910		200	0,3	3	80
		PDR 100	1	100		220	900 x 640		200	0,3	3	100
		BSTA 110H	1	850		120	1150 x 1070		200	0,3	3	110
		BSTA 125BL	1	500		200	1490 x 1070		200	0,3	3,5	125
		BSTA 1600-181B2	1	600		300	1790 x 1070		250	0,5	3,5	160
		KDH 200/2100/2	1	120		300	2000 x 1000		350	0,5	3,5	200
		BSTA 810-145B2	1	600		Servo	1490 x 910		200	0,3	3,5	80
		BSTA 510-125B2	1	950		Servo	1240 x 650		120	0,3	2,5	50
		Post-processing	<ul style="list-style-type: none"> ◆ div. eccentric presses ◆ div. rotary transfer machines (up to a max. 6 stations) ◆ div. plants for thread rolling/cutting, drilling, welding, etc. ◆ div. plants for vibratory grinding, steam de-greasing 									