



SPECIFICATIONS OPERATIONS DE CROMVOIRTSE

Lasercutting

	Stainless Steel	Aluminum	Steel
Maximum size	4000x2000mm	4000x2000mm	4000x2000mm
Thickness	25mm maximum (= contour dependent)	15mm maximum (= contour dependent)	25mm maximum
Smallest hole diameter	0.5 x thickness of plate	0.7 x thickness of plate	0.5 x thickness of plate
Tolerances	Depending from thickness and length, you can request this at your contactperson		
Indicative delivery time	2 business days; if your order is processed before 12:00u, products will be nested the same day, cutting the next day and delivery the day after.		

Plasma cutting

	Stainless Steel	Aluminum	Steel
Maximum size	6000x2000mm	6000x2000mm	6000x2000mm
Thickness	12mm up to 30mm	12mm up to 15mm	12mm up to 30mm
Smallest hole diameter	1,5x thickness of plate	1,5x thickness of plate	1,5 x thickness of plate
Tolerances	Length/width: +/- 1,5mm Squareness cutting edges: +/- 2° Pay attention: holes could be conical.		
Note	It is not possible to engrave.		
Indicative delivery time	5 business days; if your order is processed before 12:00u.		

Autogenously cutting

	Stainless Steel	Aluminum	Steel
Maximum size	Not possible	Not possible	6000x2000mm
Thickness	Idem	Idem	Minimal 12mm - Maximum 60mm
Smallest hole diameter			1,5 x thickness of plate
Tolerances	Length/width: +/- 1,5mm Squareness cutting edges: +/- 1°		
Note	It is not possible to engrave.		
Indicative delivery time	5 business days; if your order is processed before 12:00u.		

Waterjet cutting

	Stainless Steel	Aluminum	Steel
Maximum size	3000x1500mm	3000x1500mm	3000x1500mm
Thickness	20-25-30-40-50mm	12-15-20-25-30-40-50mm	20-25-30-40-50-60mm
Note	Available in 3 qualities; fine-medium-coarse. Standard cutting with medium quality		
Indicative delivery time	3 business days; if your order is processed before 12:00u.		

Cutting (scissor)

	Stainless Steel	Aluminum	Steel
Maximum size	3000x1500mm	3000x1500mm	3000x1500mm
Thickness	up to 10mm	up to 10mm	S355J2-S355MC (st.52) up to 6mm S235JR (st.37) up to 10mm
	Tear plate can be cut until this thickness (tear included)		
Tolerances	Length: +/- 1,00mm diagonally opposite angles: +/- 1,50mm Tordation: Stainless Steel: width of 30 x thickness of plate, tordation of 3°/m ¹ Aluminum : width of 25 x thickness of plate, tordation of 3°/m ¹ Steel: width of 20 x thickness of plate, tordation of 3°/m ¹		
Note	Exclusively rectangular figures.		
Indicative delivery time	1 business day.		



Bending

Thickness in mm	0,8	1	1,5	2	3	4	5	6	8	10	12
Max.length in mm S235	4000	4000	4000	4000	4000	4000	4000	2800	3100	2700	i.o.
Max.length in mm S420	4000	4000	4000	4000	4000	3400	2900	2500	2100	2000	i.o.
Max.length in mm STAINLESS STEEL	4000	4000	4000	4000	4000	3400	2700	1900	2100	1800	i.o.
Max.length in mm aluminum	4000	4000	4000	4000	4000	4000	4000	4000	4000	4000	i.o.
Tolerances	For more information please contact us, or pay a visit to our website.										
Note	Concerns corners of 90° when using standard tools. Starting from 8x plate thickness groove.										
Indicative delivery time	5 business days										

Service operations

	Material	Size	Note
Deburring	stainless steel- aluminum	thickness: min.1mm up to max.25mm Width: min. 20mm up to max.1350mm Length: min. 20mm up to max. 4000mm	If not indicated we will deburring the bottom. Maximum 45 kg.
Deburring drum	stainless steel- aluminum	Max. 200x200mm	Also suitable for products with foil.
Tapping	stainless steel-steel- aluminum	From 2mm thick	M4-M5-M6-M8-M10-M12-M14-M16-M20
Edge breaking	stainless steel-steel- aluminum	Max. hole diameter: up to 26mm from 1mm thick	Facet of approx 1mm
Countersinking	stainless steel-steel- aluminum	Max. diameter: up to 26mm at an angle of 90° from 2mm thick	
Surface treatment	stainless steel-steel- aluminum	Different sizes and possibilities	In consultation with sales.
Indicative delivery time	In consultation with sales.		

Tube laser

	Stainless Steel	Aluminum	Steel
Thickness	up to 4mm	up to 3mm (3mm in consultation)	S235JR (st.37): up to 8mm S355JZ-S355MC (st.52): up to 6mm
Size	Tube diameter: minimal Ø12,0 mm and maximum Ø152,4 mm Square tube: minimal 12,0mm and maximum 120,0mm Maximum weight from product per meter: 16kg. Supply length: till 6500mm. Maximum cutting length from 1 piece: 5800mm from 6000mm length.		
Tolerances	On cut contour: +/- 0,1mm Op centering of cut contour: +/- 0,2mm On total length: +/- 0,2mm		
Note	When there are a lot of contours in the tube, this produces a lot of heath. Therefore the tolerances could deviate. The material could also give discoloration. Inside profile will not be deburred.		
Indicative delivery time	1 week.		

Sawing

Minimale size	Round 5	
Maximum size	700x500mm	
Angles	Between 30° en 90°	
Tolerances	+/- 0,5 en +/- 1mm dependening on machine and angle	Till square 120mm and round 150mm tolerance +/- 0,5mm available on request.
Note	Odd sizes and lengths on request.	
Indicative delivery time	1-3 business days, big ammounts on request.	