

# DE CROMVOIRTSE SPECIFICATIONS OPERATIONS

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 tickness of plate	0.7 x tickness of plate	0.5 x tickness 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 tickness of plate	1,5x tickness of plate	1,5 x tickness 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 tickness 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	6000x2000mm	6000x2000mm	6000x2000mm
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	S235JR (st.37) up to 10mm
Tolerances	Tear plate can be cut until this thickness (tear included) Length: +/- 1,00mm diagonally opposite angles: +/- 1,50mm Tordation: Stainless Steel: width of 30 x thickness of plate, tordation of 3°/m <sup>1</sup> Aluminum : width of 25 x thickness of plate, tordation of 3°/m <sup>1</sup> Steel: width of 20 x thickness of plate, tordation of 3°/m <sup>1</sup>		
Note	Exclusively rectangular figures.		
Indicative delivery time	1 business day.		

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## BENDING

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

## SERVICE OPERATIONS

	<b>Material</b>	<b>Size</b>	<b>Note</b>
<b>Deburring</b>	stainless steel - aluminum	thickness: min.1mm up to max.25mm Width: min. 50mm up to max.1350mm Length: min. 50mm up to max. 4000mm Steel: max 600mm	If not indicated we will deburring the bottom. Maximum 45 kg.
<b>Deburring drum</b>	stainless steel- aluminum	Max. 200x200mm	Also suitable for products with foil.
<b>Tapping</b>	stainless steel-steel- aluminum	From 2mm thick	M4-M5-M6-M8-M10-M12-M14-M16-M20
<b>Edge breaking</b>	stainless steel-steel- aluminum	Max. hole diameter: up to 26mm from 1mm thick	Facet of approx 1mm
<b>Countersinking</b>	stainless steel-steel- aluminum	Max. diameter: up to 26mm at an angle of 90° from 2mm thick	
<b>Surface treatment</b>	stainless steel-steel- aluminum	Different sizes and possibilities	In consultation with sales.
<b>Indicative delivery time</b>	In consultation with sales.		

## TUBE LASER

	<b>Stainless Steel</b>	<b>Aluminum</b>	<b>Steel</b>
<b>Thickness</b>	up to 6mm	up to 5mm (5mm in consultation)	up to 8mm
<b>Size</b>	Tube diameter: minimal Ø12,0 mm and maximum Ø240 mm Square tube: minimal square 12,0mm and maximum 200 mm Maximum weight from product per meter: 40kg. Supply length: till 6500mm. Maximum cutting length from 1 piece: 5800mm from 6000mm length.		
<b>Tolerances</b>	On cut contour: +/- 0,1mm On centrerig of cut contour: +/- 0,2mm On total length: +/- 0,2mm		
<b>Note</b>	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.		
<b>Indicative delivery time</b>	3 business days		

## SAWING

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

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