

# DE CROMVOIRTSE SPECIFICATIONS OPERATIONS

<b>LASERCUTTING</b>	<b>Stainless Steel</b>	<b>Aluminum</b>	<b>Steel</b>
<b>Maximum size</b>	4000x2000mm	4000x2000mm	4000x2000mm
<b>Thickness</b>	25mm maximum (= contour dependent)	15mm maximum (= contour dependent)	25mm maximum
<b>Smallest hole diameter</b>	0.5 x tickness of plate	0.7 x tickness of plate	0.5 x tickness of plate
<b>Tolerances</b>	Depending from thickness and length, you can request this at your contactperson		
<b>Indicative delivery time</b>	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.		

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

<b>WATERJET CUTTING</b>	<b>Stainless Steel</b>	<b>Aluminum</b>	<b>Steel</b>
<b>Maximum size</b>	4000x2000mm	4000x2000mm	4000x2000mm
<b>Quality</b>	304	AW 6082	WGW S355MC
<b>Thickness</b>	10 Up to 60mm	8 Up to 40mm	10 Up to 25mm
<b>Quality</b>	316	AW 5083 cast 2-sided milled	WGW S355J2+N
<b>Thickness</b>	10 Up to 60mm	5 Up to 90mm	30 Up to 100mm
<b>Note</b>	Available in 3 qualities; fine-medium-coarse. Standard cutting with medium quality		
<b>Indicative delivery time</b>	3 business days; if your order is processed before 12:00u.		

<b>BENDING</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>Thickness in mm</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.										

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SERVICE OPERATIONS	Material	Size	Note
<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	Stainless Steel	Aluminum	Steel
<b>Thicknesss</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 10,0mm and maximum 200 mm Maximum weight from product per meter: 40kg. Suplly length: till 6500mm. Maximum cutting length from 1 piece: 5800mm from 6000mm length.		
<b>Tolerances</b>	On cut contour: +/- 0,1mm On centring 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.	