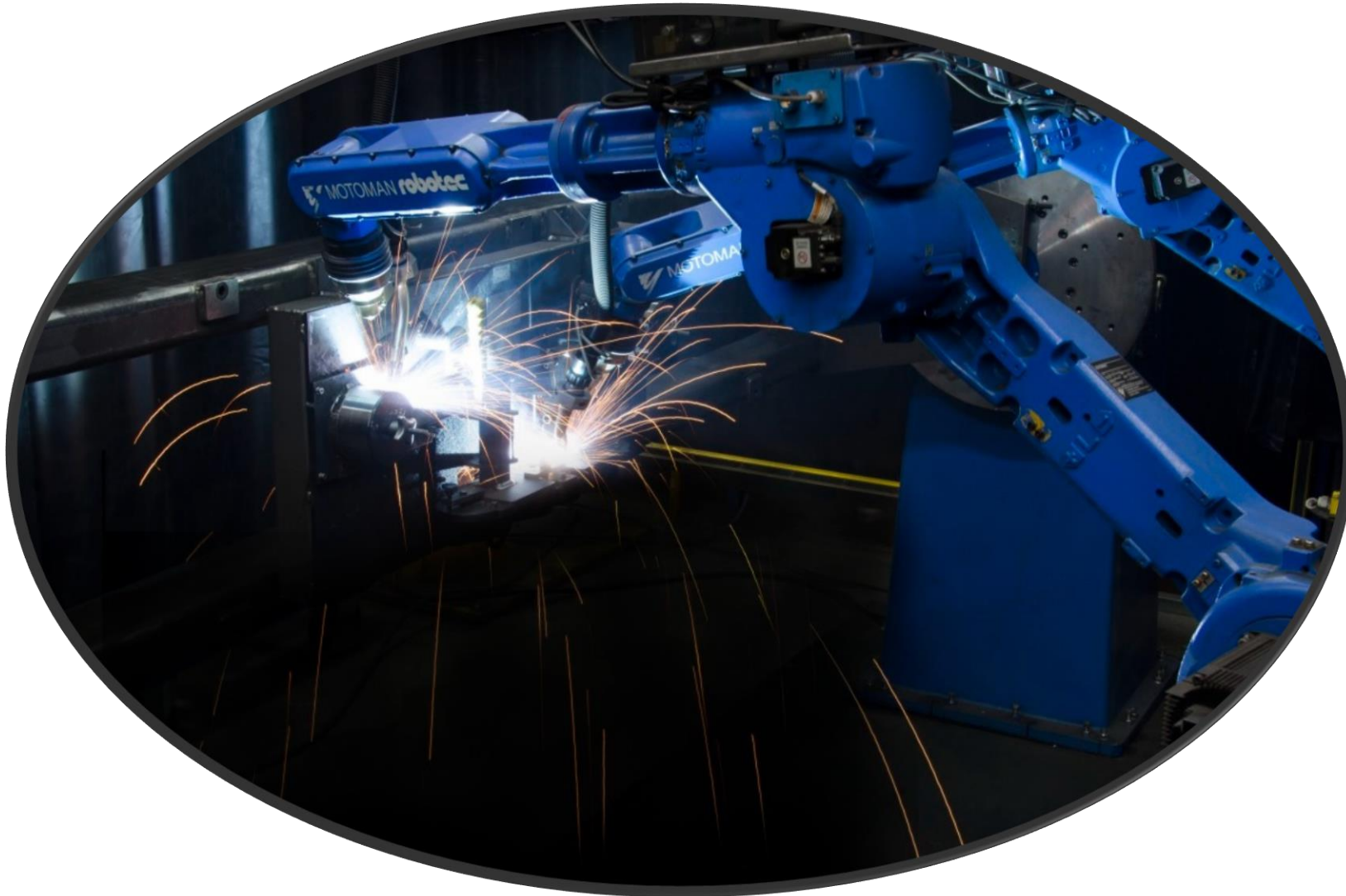


Company Presentation

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&  
BAUMRUK  
s.r.o.**

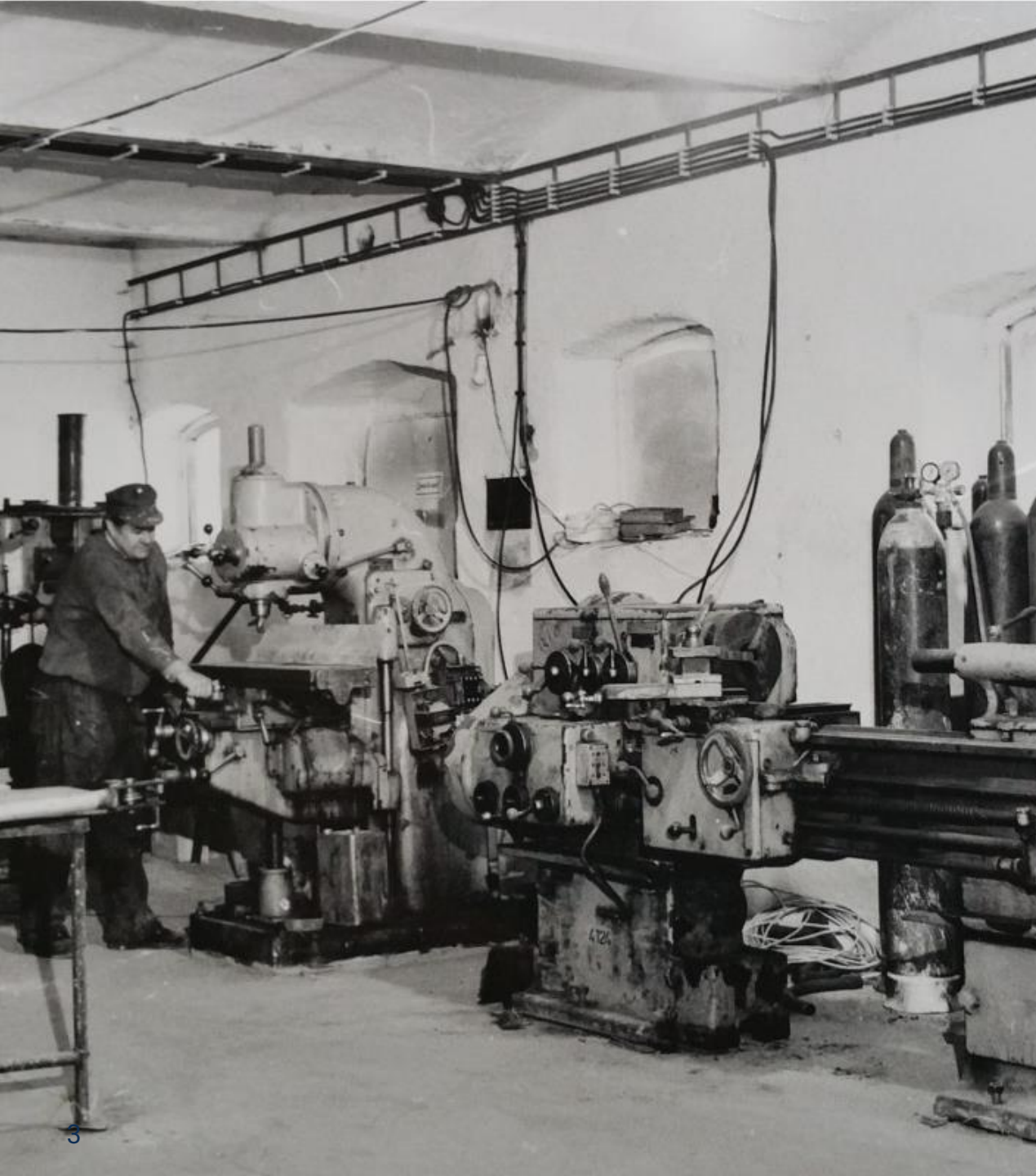




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## Company history since 1990

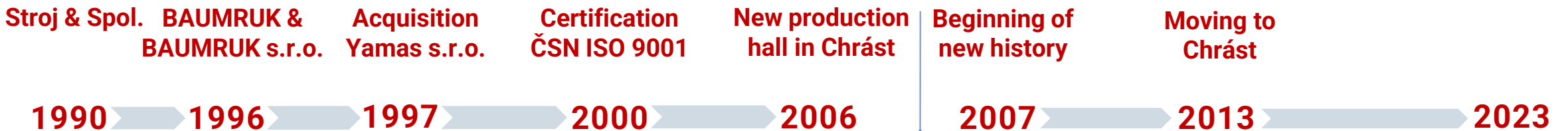
*In 1990, the Baumruk family founded the company Stroj & Spol, which was primarily focused on the custom production of steel constructions with three employees. In 2007, Mr. Martin Baumruk took over the company management. The company have invested to automation, machinery and software equipment. This year the modern history of the company began to be written.*



Martin Baumruk  
CEO BAUMRUK & BAUMRUK s.r.o.

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# History of company brand.



- Building of new production facilities, total current built-up area approx. 14.000 m<sup>2</sup> + large area for future company development
- Extensive investment in automation, machinery and software
- Welding certificates EN ISO 3834-2 and EN 15085

**AT THE FIRST SIGHT**  
Independent  
and **self-**  
**sufficient.**



**42000**  
m<sup>2</sup> area

**120**  
employees

**12,6**  
mil. € turnover  
in 2022



A blue industrial robot arm is shown in a factory setting, performing a welding task. Bright sparks are flying from the point of contact between the robot's tool and the metal workpiece. The robot arm has 'MOTOMAN robotec' and 'MOTOMA' branding on it.

**AT THE FIRST SIGHT**  
**Markets 2022**

**79%**

**turnover  
increase  
since 2019**

**90%**

**of turnover  
on German  
market**

**100%**

**focus on serial  
production and  
long-term cooperation**

**95%**

**in house  
production**

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# Production technology





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# Production technology

## Sheet Metal Processing

Laser Cutting Machines  
CNC Bending Machines  
Pressing etc.



## Bar and tube processing

CNC Cutting  
CNC Bending  
others



## Welding

9x Robotic Welding  
15x Manual Welding Machine  
2x Spot Welding machine



## Machining

Milling  
Turning  
Drilling  
Grinding and others



## Surface Treatment

Blasting  
Deburring  
Powder Coating





# Production technology

## Sheet Metal Processing

### Laser Cutting

3x Laser Mazak Optiplex

- Resonator output 6 kW
- Sheet metal format 3000 x 1500 mm
- Accuracy 0,05 mm / 500mm
- Max sheet metal thickness: Construction steel - 20mm  
Stainless steel - 15mm  
Aluminium - 15mm



### Bending with folding brake

1x CNC press brake SAFAN E-Brake 300

- Pressing force 3000 kN
  - Max size of sheet metal 4080 mm
  - Opening 615 mm
  - Accuracy of the ram 0,01 mm
- Notice: Five-axis rear stop, bending support for thin and long sheets up to a weight of 150 kg, active angle measurement of the bending

1x CNC press brake SAFAN E-Brake 100

- Pressing force 1000 kN
  - Max size of sheet metal 3060 mm
  - Opening 515 mm
  - Accuracy of the ram 0,01 mm
- Notice: Five-axis rear stop



### Pressing

Hydraulic presses, eccentric presses, presses for binding joints etc.

Pressing force up to 2500 kN.



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# Production technology

## Bar and tube processing

### Cutting

- 1x CNC fully automatic circular saw Kastoflex F
- 1x automatic band saw Kastowin A 3.3
- 2x semi-automatic NC saws, disc saws etc.



### Tube and profile bending

1x bending machine BLM E-Turn 52

- Max tube dimension 50 x 2 mm
- Bending force 4800 Nm
- Left / right bending
- Tube rolling

1x bending Tractotechnik Tubomat 642

- Max tube dimension 42 x 2,5 mm

1x three roll profile bender Amob MAH 40/3 CNC

- Capacity: tube D60x3 / R500 , rod D30 / R350

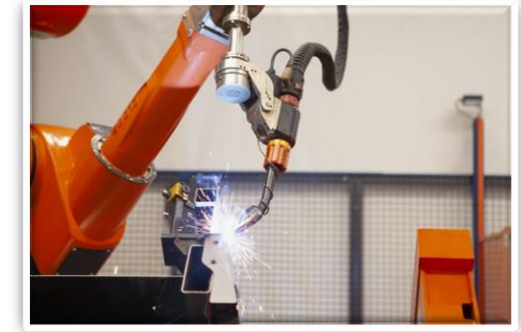
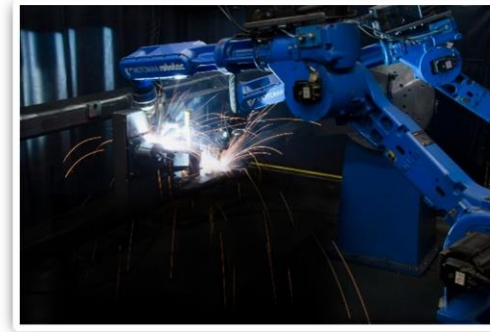




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# Production technology

## Welding



### Manual

15x welding machine MIG/MAG, WIG

- Max current load up to 420 A
- Pulse welding

2x spot welding machine CEA PPN 83

- Nominal power 80 kVA
- Maximal power 212 kVA

1x laser welding machine Herolaser

- Nominal power 1500 W
- Laser wavelength 1070 nm

### Robotic

8x welding center (Motoman / Cloos)

- MIG/MAG
- Max length up to 4000 mm
- Max rotational diameter 1600 mm
- Max weight 3000 kg

1x welding center Cloos

- MIG/MAG, WIG
- Max length up to 1000 mm
- Max rotational diameter 800 mm
- Max weight 250 kg



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# Production technology

## Machining

### Milling

- 2x 5-axis vertical CNC center HAAS UMC 750  
(up to X/Y/Z dimensions 762/508/508mm, weight 1360 kg)
- 1x 4-axis horizontal CNC center HAAS EC-1600  
(up to X/Y/Z dimensions 1626/1016/813mm, weight 4536 kg)
- 1x 3-axis vertical center HAAS VF-5  
(up to X/Y/Z dimensions 1270/660/635mm, weight 1814 kg)
- 1x 3-axis vertical center HAAS VF-3  
(up to X/Y/Z dimensions 1016/660/635mm, weight 1588 kg)
- 3x 3-axis vertical center HAAS VF-2  
(up to X/Y/Z dimensions 762/508/508mm, weight 1360 kg)
- 1x vertical NC milling machine FTU 1250  
(up to X/Y/Z dimensions 1500/540/550mm, weight 1000 kg)
- 1x horizontal milling machine WH 10 CNC  
(up to X/Y/Z dimensions 1250/1120/1000mm, weight 3000 kg)





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# Production technology

## Machining

### Turning

2x CNC lathe HAAS DS-30Y

*(max cutting dimension  $\varnothing$  405x660mm, C-axis, Y-axis, second. spindle)*

2x CNC lathe HAAS ST 30

*(max cutting dimension  $\varnothing$  533x826mm)*

2x CNC lathe HAAS SL 30

*(max cutting dimension  $\varnothing$  432x864mm, C-axis)*

1x CNC lathe HAAS ST 10

*(max cutting dimension  $\varnothing$  220x356mm, second. spindle)*

1x CNC lathe NAKAMURA AS200LMYS

*(max cutting dimension  $\varnothing$  340x530mm, C-axis, Y-axis, second. spindle)*

1x CNC lathe GOODWAY GS2600YS

*(max cutting dimension  $\varnothing$  400x779mm, C-axis, Y-axis, second. spindle)*

1x CNC lathe HAAS TL-3

*(max cutting dimension  $\varnothing$  508x1524mm)*



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# Production technology

## Machining

### Drilling and grinding

1x drilling machine VO-32

*(max drilling  $\varnothing$  32mm, rotary arm 250-1000mm)*

1x rotary grinding machine BUB 50/1000

*(max grinding dimension  $\varnothing$  500x1000mm, weight 350kg)*





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# Production technology

## Surface treatment

### Blasting and deburring

1x automatic hook-type blasting machine TZNZ4

*(max size of product 1800x1800x2800mm, weight 1000kg hanged, 2000kg laid)*

1x automatic hook-type blasting machine TZNZ3

*(max size of product 1200x1200x2300mm, weight 500kg)*

1x automatic hook-type blasting machine TZNZ2

*(max size of product 1100x1100x1600mm, weight 500kg - only for stainless steel)*

1x automatic tumbling blasting machine TZNZ1

*(max volume of charge 165 dm<sup>3</sup>, max part's weight 15kg, charge's weight 350kg)*

1x conventional chambre blaster PK-SBC420

*(max size of product 1200x900mm, only for stainless steel)*

1x vibratory finishing machine XINGXING Abrasive AB180

*(volume 180 l, automatic 200 l vibratory drying machine – only for stainless steel)*

1x deburring machine Lissmac SBM-S 1500

*(deburring of parts up to width 1500mm – only for stainless steel)*

+ Marking laser and other equipment

### Powder coating

1x automatic painting line Surfin

- Max product size 1000x2000x2500mm
- Max weight of the product 600kg
- Cyclone and powder recuperation, chemical pre-treatment (Phosphate), robotic cabin with 2 ABB robots + manual cabin

1x painting line Surfin

- Max product size 1500x2000x6000mm
- Max weight of the product 1500kg
- Cyclone and powder recuperation

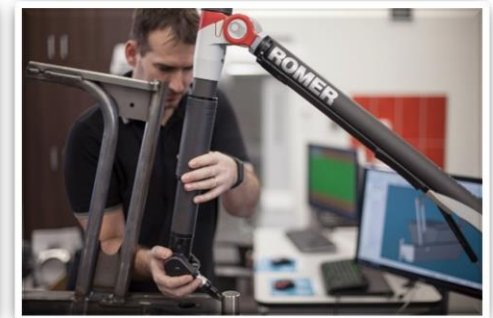


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## Quality assurance

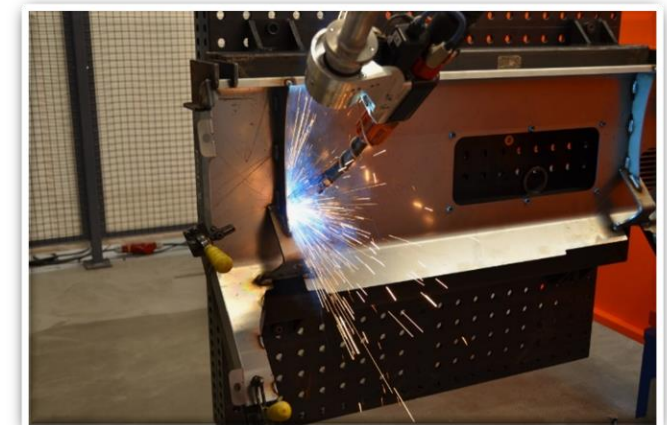
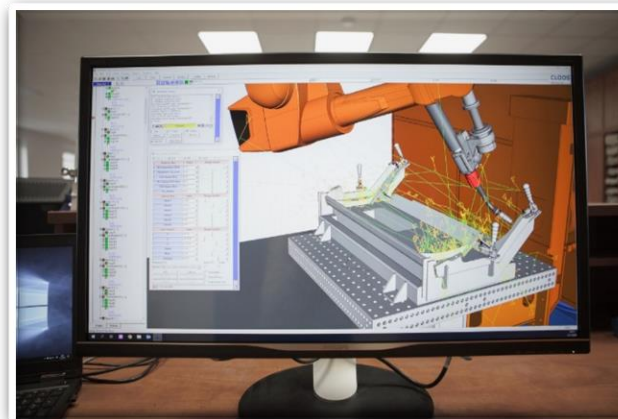
### Measuring devices

- 3D measuring device Global Performance
- 3D measuring arm Romer RA-7525
- Contour measuring device Mitutoyo Formtracer Avant FTA – H4 3000-D
- + many other conventional measuring tools



### Design & Technology dpt.

- Preparation of production documentation
- Design of jigs
- Continuous improvement





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# Products





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# Products



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# Certification



## Quality Management

ISO 9001:2015

## Welding

Welding certificates for railway carriages acc. to EN ISO 3834-2, EN 15085 and ČD V 95/5

## Others

- Certificate for Supplier to Czech Railways
- NDT for visual inspection, PT and MPT acc. to ISO 9712
- others

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# Selected references.





**BAUMRUK & BAUMRUK s.r.o.**

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