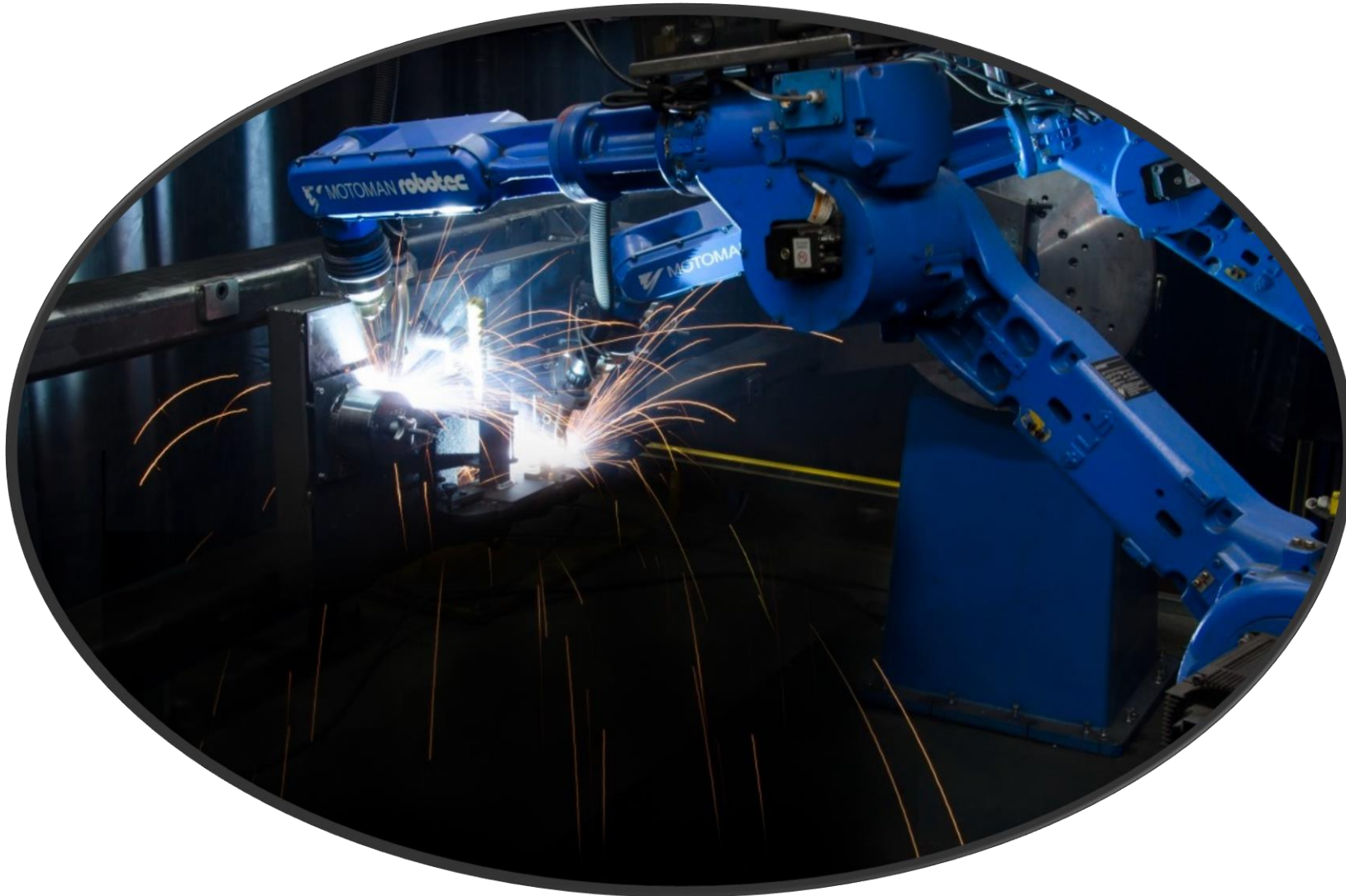


Company Presentation

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

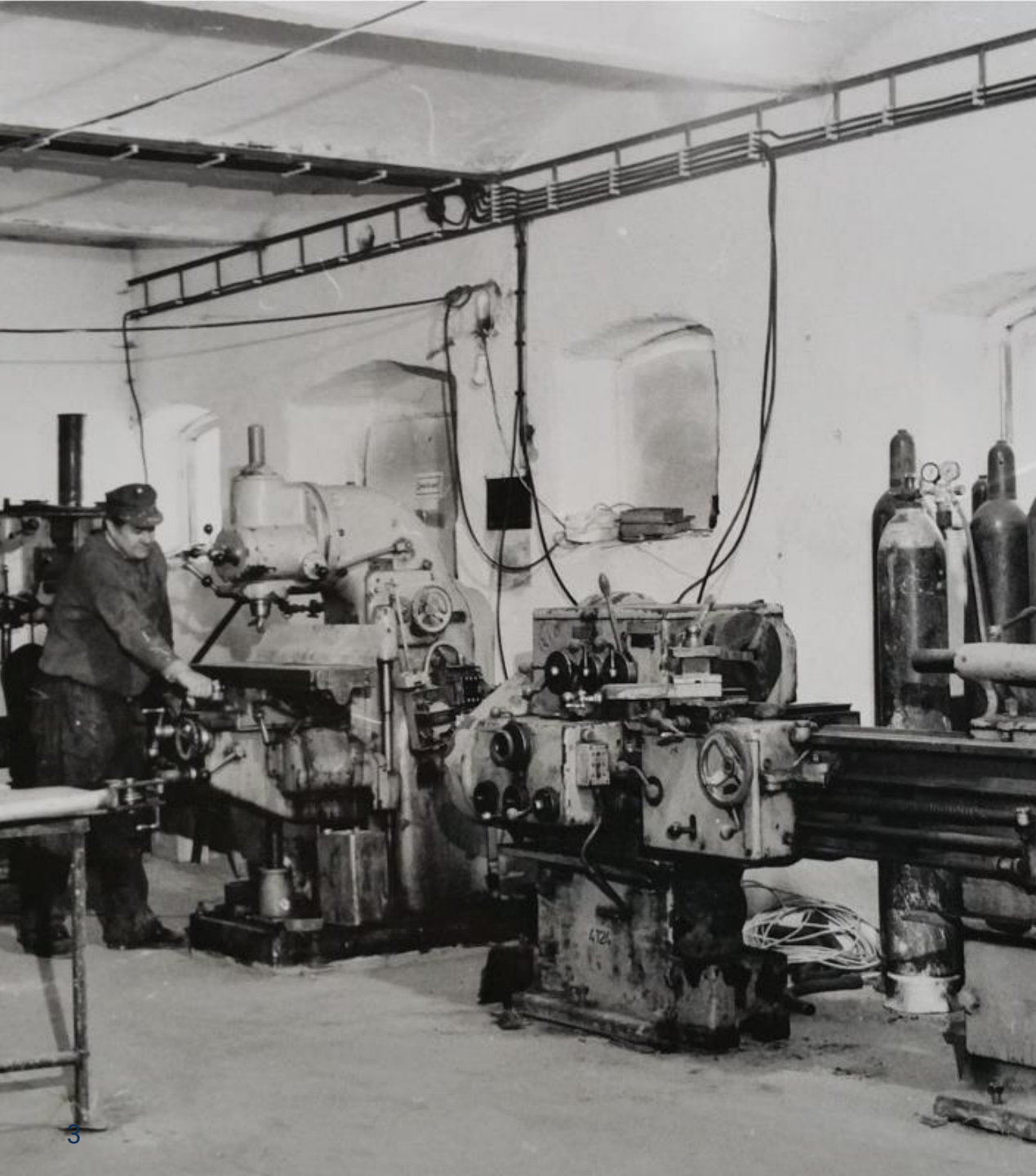
PRESENTED BY
Petr Matějka





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Company history since 1990

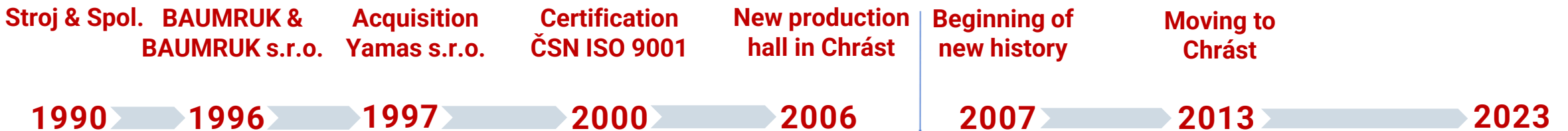
In 1990, the Baumruk family founded the company Stroj & Spol, which was primarily focused on the custom production of steel constructions with three employees. In 2007, Mr. Martin Baumruk took over the company management. The company have invested to automation, machinery and software equipment. This 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 m² + 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
m² area

120
employees

12,6
mil. € turnover
in 2022



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



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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 moment 4,8 kNm
- 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

1x bending machine MEWAG Telarus 170 S

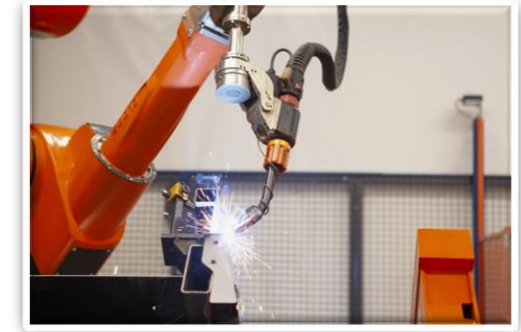
- Max tube dimension 168 x 3mm
- Bending moment 127 kNm
- Tube rolling - force 120 kN
- Max bending radius 500mm



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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 dm³, 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

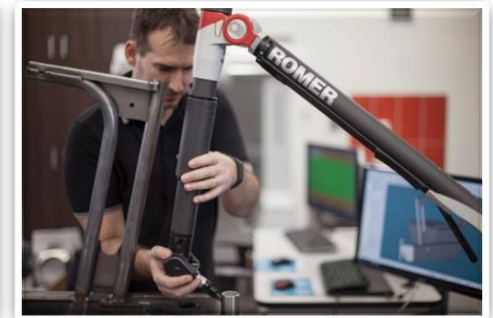


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Quality assurance

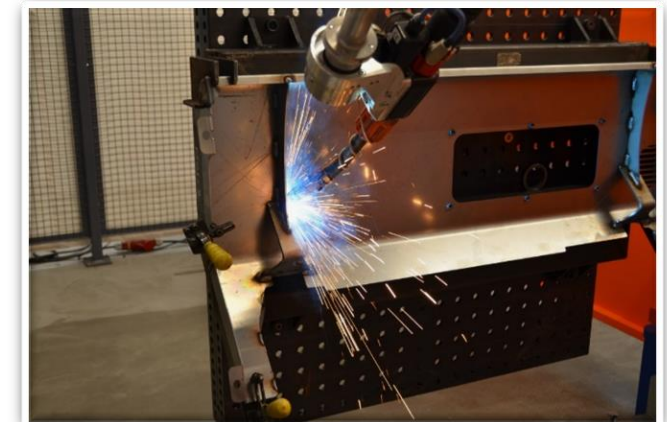
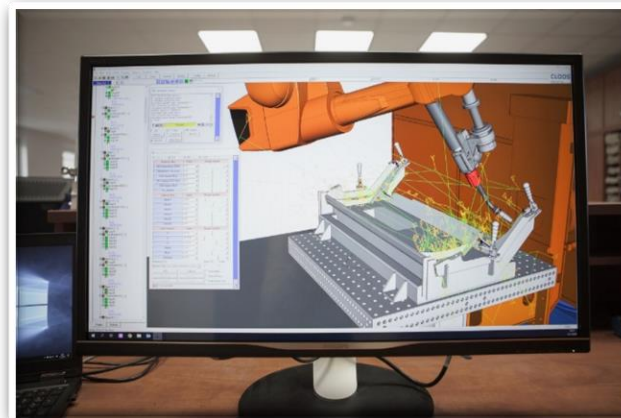
Measuring devices

- 3D measuring device Global Performance
- 3D measuring arm Romer RA-7525
- Contour measuring device Mitutoyo Formtracer Avant FTA – H4 3000-D
- Visometry Twyn
- + 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

BAUMRUK & BAUMRUK s.r.o.

Selected references.



BAUMRUK & BAUMRUK s.r.o.

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