



Production options

Bending on CNC presses

Adira QHD-250400B - a robust press used for bending materials with a thickness of up to 20 mm. It is possible to bend sheet metal with a width of up to 4,000 mm (the bending width depends on the thickness of the material and shape of product). The working pressure of the press is 250 t.

Ursviken Optiflex 130 - a numerically controlled machine for precise bending of sheet metal in widths of up to 3,000 mm and thickness of materials of up to 6 mm. The working pressure of the press is 130 t.

Trumpf TrumaBend V50 – a numerically controlled press for precise bending of sheet metal in widths of up to 1,200 mm and thickness of materials of up to 6 mm. We can also bend 8 mm sheet metal on this press but only with a bending width of up to 100 mm. The working pressure of the press is 50 t.

Machine cutting

Is carried out using a Bianco 270 saw. Materials of up to 200 mm in size can be clamped under the cutting angle of up to 60°, the lift of the saw is 500 mm. The FMB Jupiter band saw with automatic material feed is used for cutting materials with a clamping width of up to 350 mm and the under the angle of up to 45°. The lift of the saw is 500 mm, the maximum length of cut rods is 8 m.

Sheet metal coiling

is offered for a thickness of up to 3 mm, a width of up to 1,000 mm and a minimum coil diameter of 150 mm. A larger machine enables the coiling of sheet metal with a thickness of up to 6 mm and a width of 1,200 mm.

Cutting sheet metal

is carried out using TNC 2500/4 guillotine shears. The maximum width of sheet metal is 2,500 mm, and thickness of 4 mm.

Drilling, milling and threading

is carried out using a drill with a stand height of 1,300 mm with a diameter of up to 55 mm, a milling machine with a table 800 x 700 x 500 mm in size and using a CMA mobile threading machine with a thread size ranging from M3 to M24

Shot-peening

of parts is carried out in continuous blasting of parts up to 6,000 mm in length and 1,000 mm in width. The maximum height of the shot-peened part is 500 mm and the maximum weight is 1,000 kg.

Surface finish

wet painting in the painting cabin, which is 8 x 5 m in size, is carried out base on customer requirements in case or top coat. Before surface treatment it is possible to provide degreasing using high-pressure washing (WAP) in a washing box 4 x 4 m in size. In cooperation, we provide surface finish using powder coating, painting using the KTL method, and for small parts we use galvanisation, phosphating and Teflon coating.



Production of cut parts

TMW, a.s. produces cut parts of various sizes and uses. The thickness of the cut material can range from 0.5 mm to 150 mm depending on the material and cutting technology. The selected technology is also a determining factor in the maximum size of cut sheets. Laser cutting is recommended for precise cutting up to a thickness of 20 mm, or plasma cutting and oxy-acetylene cutting for thicker materials.

Laser cutting

TMW, a.s. carries out metal sheet cutting for the needs of its own production, as well as for ordering using the TRUMPF 3030 laser cutting machine. This modern device, which works on the principle of flying optics, processes a variety of materials in the field of thin and thick sheet metal, up to the state of mounting readiness. Moreover, it can carry out marking of parts for identification purposes, create dimples in materials and process metal sheets covered with film.

Format and types of cut materials

- Format of material max. 3,000 mm x 1,500 mm
- Black material from 0.5 mm to 20 mm
- Aluminium from 1 mm to 6 mm
- Stainless material from 0.5 mm to 8 mm (thicker sheets 6 – 8 mm only in small piece batches)
- Cutting accuracy 0.04 mm, 3 kW

Plasma cutting

Cutting sheet metal with a thickness of up to 25 mm is ensured by the powerful MGM Omnicut 3100 cutting machine. The cutting machine allows us to cut both regular and shaped parts. We program cutting plans on the computer according to provided printed or electronic drawings (in formats DXF, DWG, etc.) and transfer them into the machine via a computer network or USB interface from a flash drive.

Format and types of cut materials

- Maximum size of cut material is 2,000 x 8,000 mm
- Maximum thickness of steel plates is 25 mm
- We cut steel of various grades with plasma, however, most often 11 375 or 11 523
- We can also cut aluminium materials

Oxy-acetylene cutting

Format and types of cut materials

- Maximum size of cut material is 2,000 x 8,000 mm
- Maximum thickness of steel plates is 150 mm
- We cut steel of various grades with plasma, however, most often 11 375 or 11 523
- We can also cut stainless materials



Production of weldments

TMW, a.s. offers its customers the production of weldments for various applications. Weldments are made based on drawings provided by the customer or they can be projected by the Design Department of the company.

Robotic welding

Given the continuous improvement in the quality of welding, a robotic workplace is established at TMW, a.s., that is equipped with a CLOOS ROMAT@350 welding robot. This robust industrial robot with a large working range and structure based on the principle of a folding arm with a large working range of all axes meets the highest demands on the quality and strength of welds. The freely programmable positioner enables the installation of fixtures with a clamping length of up to 2,500 mm. Weldments weighing up to 500 kg, including the fixture, can be produced using the robotised unit.

Manual welding

TMW, a.s. has 12 welding workplaces set-up for manual welding using the MIG/MAG method, equipped with REHM RD 250, RD 320, RD 254 Synergic, RD 324 Synergic welding power supplies with an output of 250 A to 300 A, air-cooled. More powerful, liquid - cooled welding power supplies are also available - Synergic 3400, FRONIUS Synergic 4000 and FRONIUS Synergic 5000 with a welding performance ranging from 340 A to 500 A. Three workplaces for manual welding are equipped with the latest welding power supplies for pulse welding - FRONIUS TRANS PUL S Synergic 4000 and CLOOS QINEO PULSE 450 C, which meet the most stringent requirements for quality penetrations and very massive weldments.

We also have a Köco 1002 welding machine for stud welding (stud diameter of up to 20 mm) and a FRONIUS TRANSTIG MAGIC WAVE 2200 welding power supply with an output of up to 220 A for TIG welding with the option of welding steel, stainless steel or aluminium.



Safety cabs for forklift trucks

TMW, a.s. manufactures modern all-metal cabs for forklift trucks. Cabs are manufactured according to type series of forklift trucks and fitted to the original protective frame of the trucks or they are delivered to the customer as a whole including the protective frame. Forklift truck cabs are designed to meet safety during operation, protect the truck operator from the adverse effects of the external environment and meet the requirements of ease of use and reliability. Cabs are equipped with lockable doors with opening windows, and depending on the type of truck either with hot water or electric heating. Approved tempered safety glass is used for the windshields. Modern technology is applied in the manufacture of cabs – cutting sheet metal with a laser beam, bending sheet metal on CNC press brakes, welding on a robotic unit, and bonding glass in the assembly of cabs.

The company currently offers more than 20 models of cabs for trucks with a capacity of 1.5 to 7 tons, both its own design and the design based on customer requirements. All products undergo continuous modernisation and meet the most stringent requirements on safety. Monitoring and implementation of the latest technology is ensured separately by the Development and Design Department. Materials and components of leading European companies with a guarantee of the highest quality and reliability are applied in the production of cabs.

Example of a cab for the following truck brands:

Hyster
Yale
Miag
Desta
Linde
Jungheinrich