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ONE-STOP SHOP FOR HEAVY INDUSTRIES

ON-SITE MACHINING SERVICES

- Portable circular milling machine
- Laser tracker
- Compact heavy drilling machine

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Project nr: 14-1072
Customer: NOV
Date: Feb 2015
Pedestal machining

Scope of work

- Flange machining OD-ID Ø4045 – Ø3640
- Flange thikness 105mm
- Thruholes 108 x Ø55
- Machining allowance 10mm

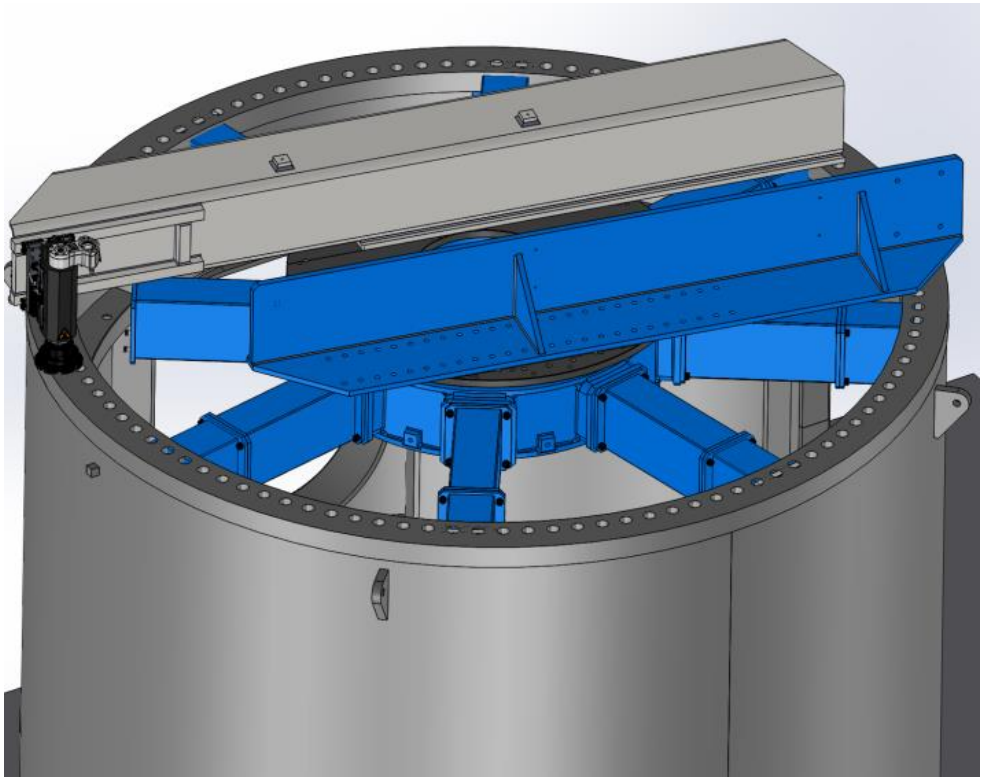
Requirements for machining:

- Flange flatness after machining - max 0,2mm
- Ra 6,3
- Holes positioning deviation from the center of the flange - max 1,0 mm

Result:

- Flatness after machining 0,11mm
- Ra 3,1
- Holes positioning deviation after drilling – max 0,5mm

References:



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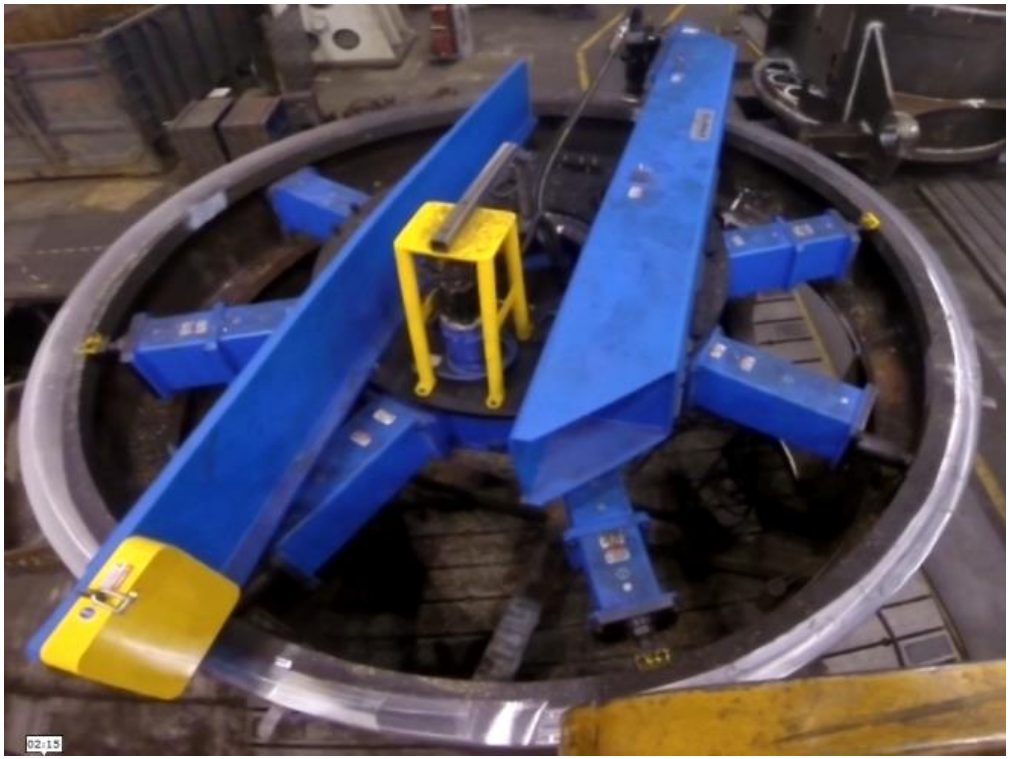
Pedestal rough machining



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Pedestal final machining

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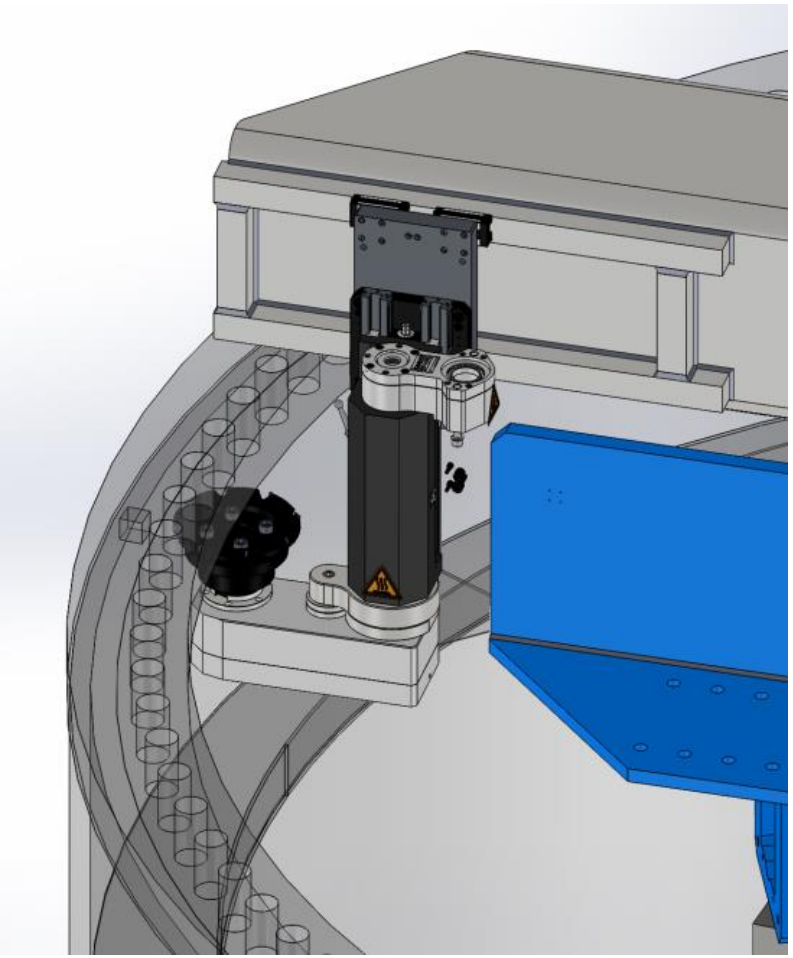
Pedestal backside machining



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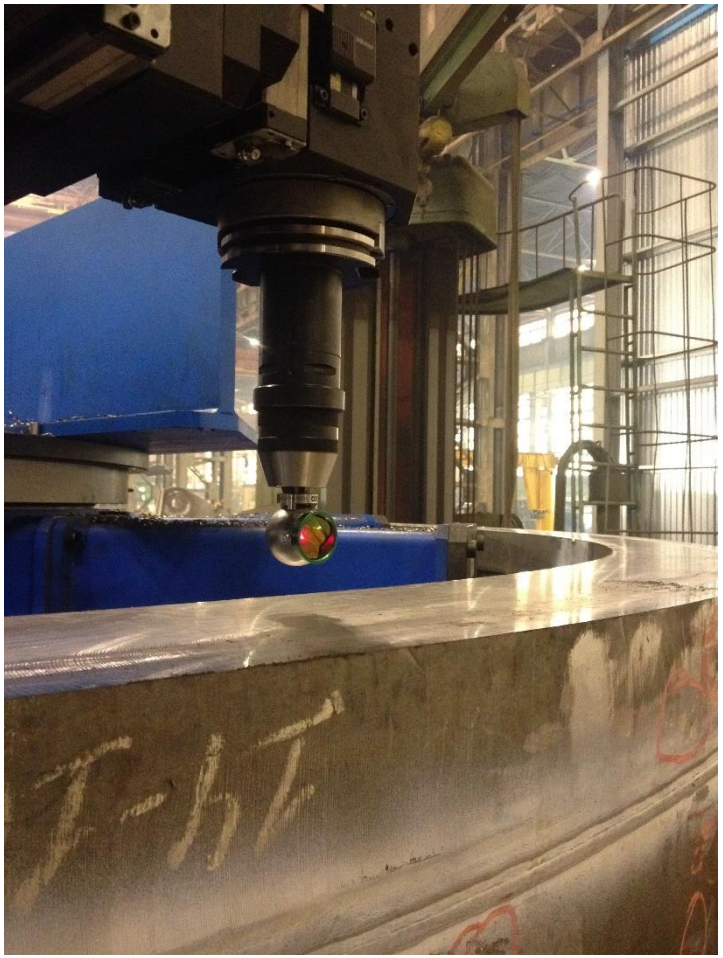
Pedestal holes marking



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Pedestal holes drilling

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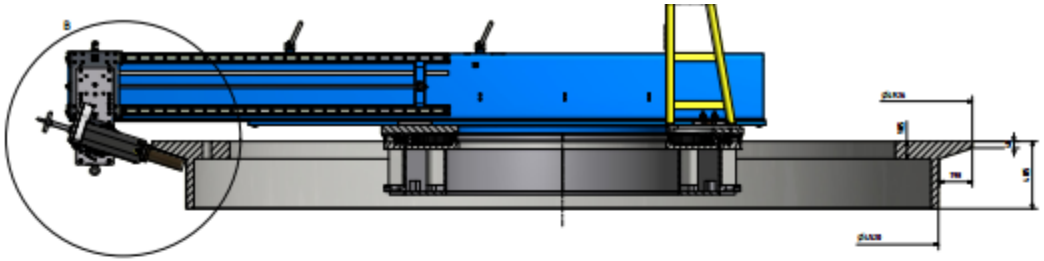
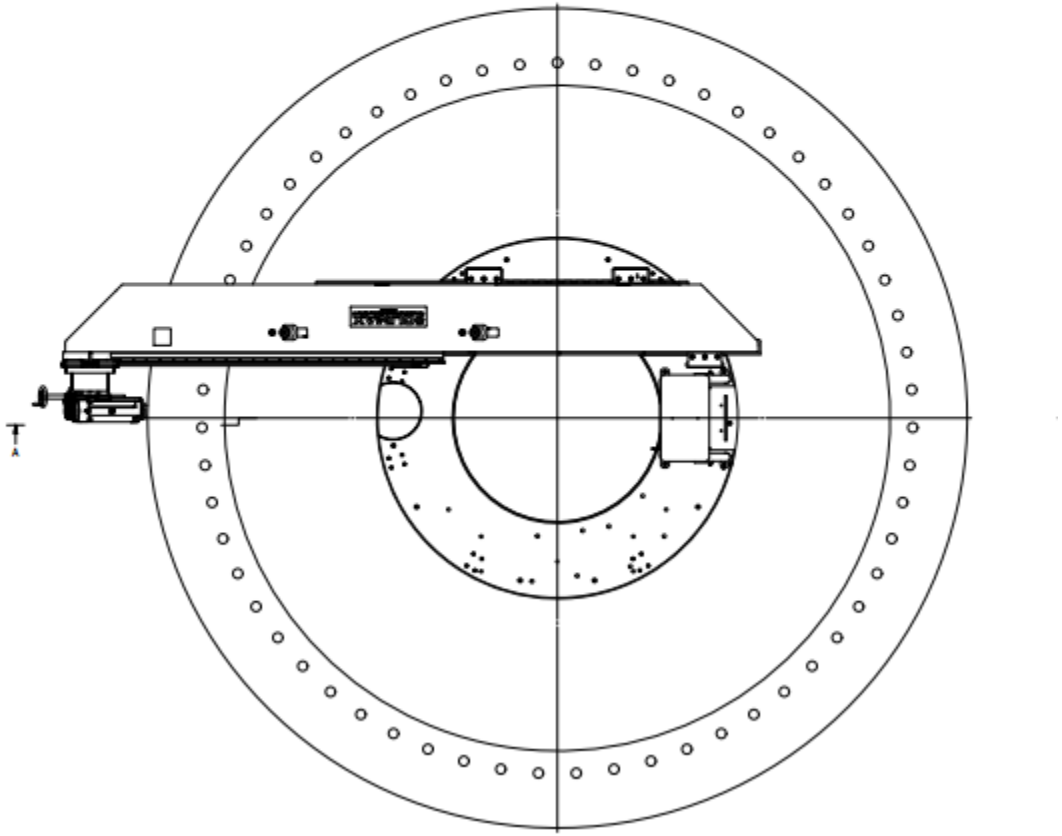
Project nr: 15-1033
Customer: NOV
Date: Jul 2015
Bottom flange machining





Scope of work

- Flange machining OD-ID Ø4926 - Ø4080
- Flange thikness 105mm
- Machining allowance 10mm

Requirements for machining:

- Flange flatness after machining - max 0,5mm
- Ra 6,3

Result:

- Flatness after machining 0,2mm
- Ra 2,9

References:

NOV

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Flange rough machining

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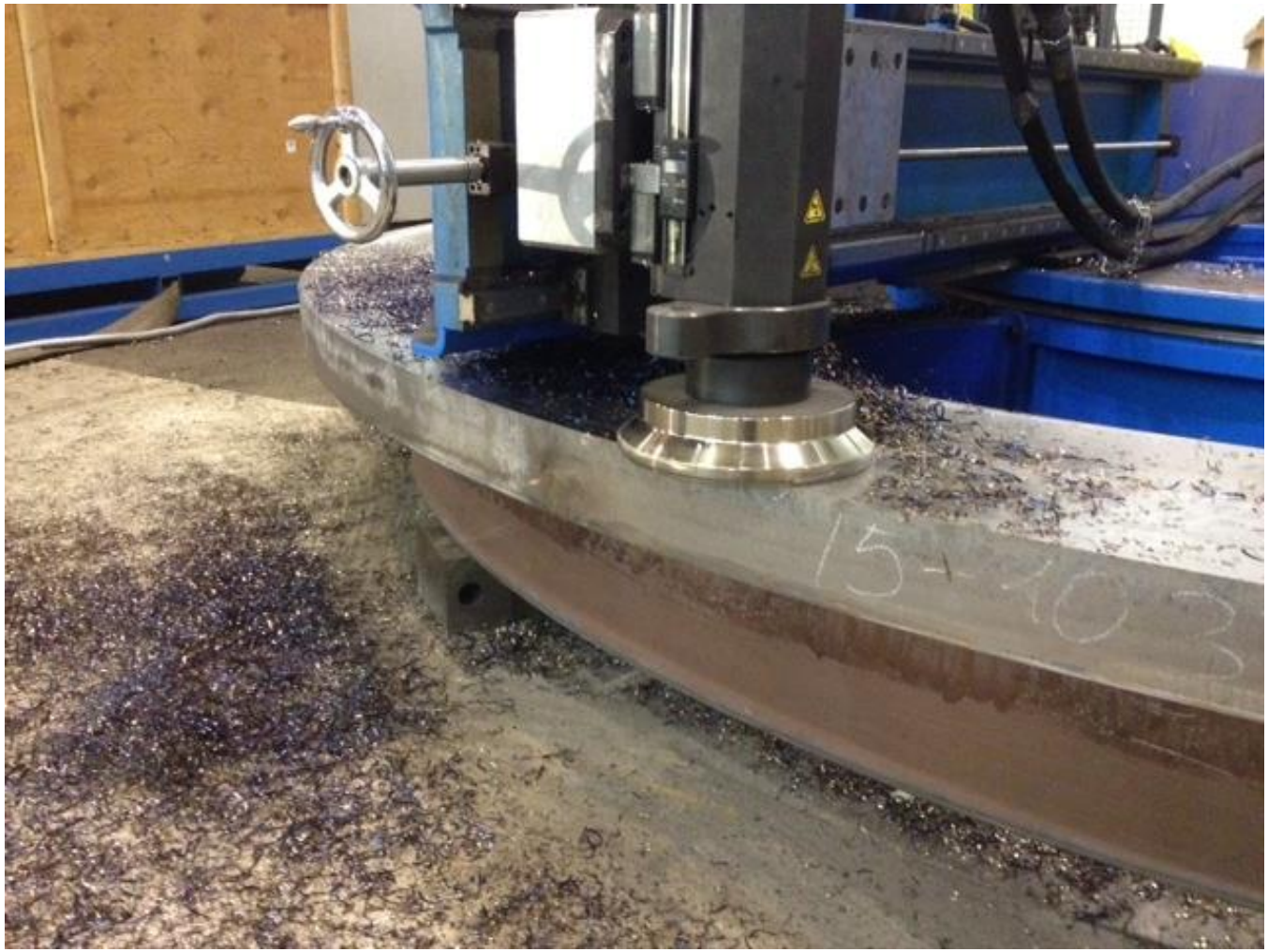
Flange final machining



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Flange after machining

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Project nr: 15-1069,15-1072
Customer: ANDRITZ OY
Date: Jun 2016
Column flanges machining

Scope of work

- Upper and bottom flange machining OD-ID Ø3490 – Ø3000
- Outside Ø3490 machining
- Flange thikness 110mm and 55mm
- Machining allowance 10mm

Requirements for machining:

- Flange flatness after machining - max 0,4mm
- Ra 12,5

Result:

- Upper flange flatness after machining 0,32mm
- Bottom flange flatness after machining 0,28mm
- Ra 6,3

References:

ANDRITZ

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Upper flange machining on 5 m height

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Bottom flange after machining

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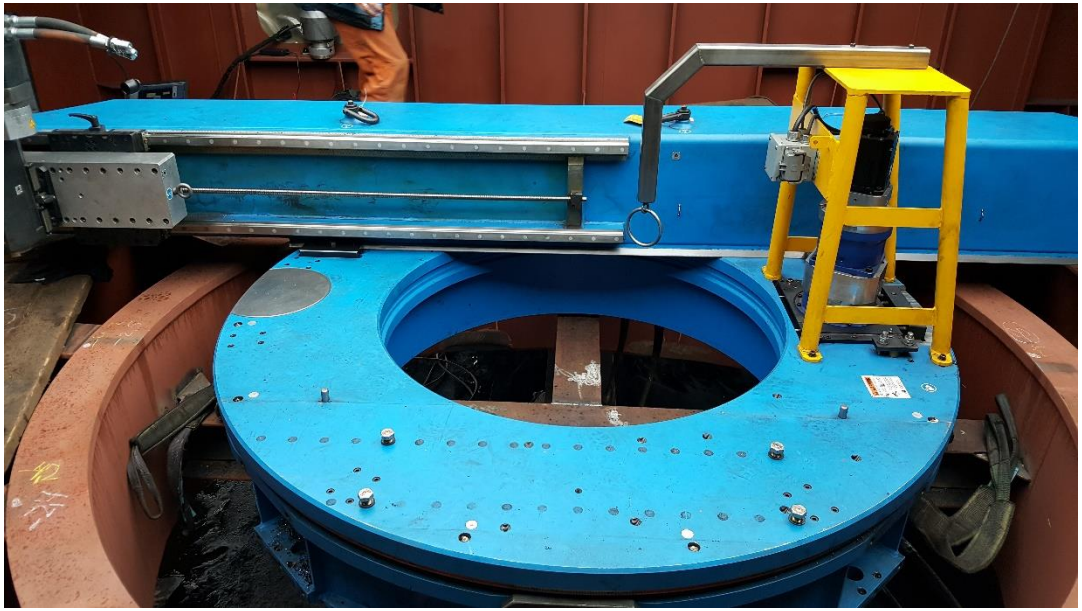
Project nr: 16-1090
Customer: Baltic Workboats
Date: Nov 2016
Azipod machining

Scope of work

- Azipod flanges machining OD-ID Ø3220 – Ø2860
- O-ring groove machnining
- Thread holes M24 x 48pcs
- Machining allowance 10mm



Requirements for machining:

- Flange flatness after machining - max 1,0 mm
- Ra 6,3

Result:

- Flange flatness after machining 0,25mm
- Ra 3,2

References:

Baltic Workboats shipyard

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Jigs for machine setup

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Azipod flange rough machining

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Azipod flange final machining

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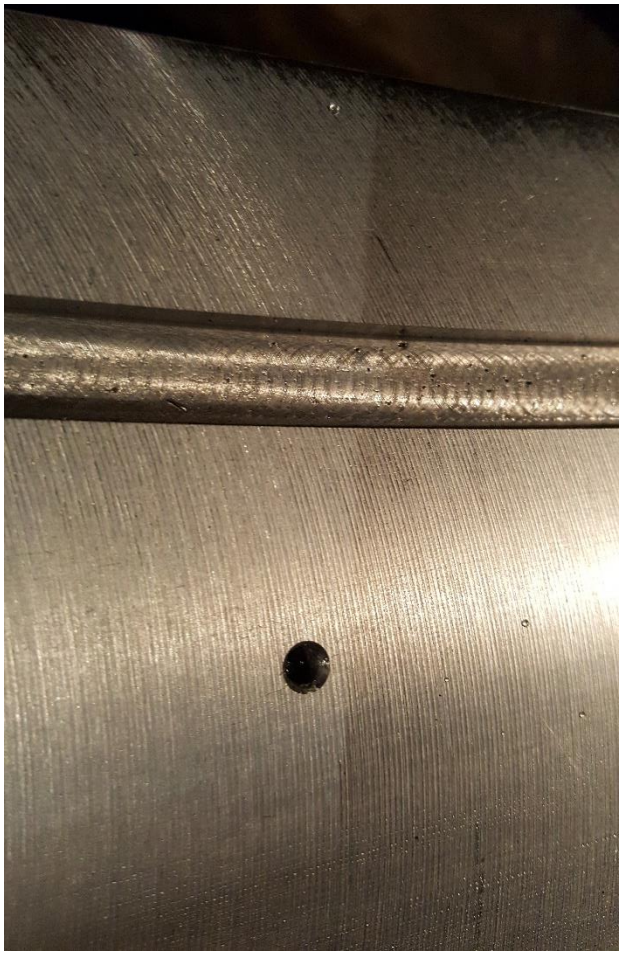
O-ring groove machining



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Thruholes marking and drilling

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Azipod flange after machining

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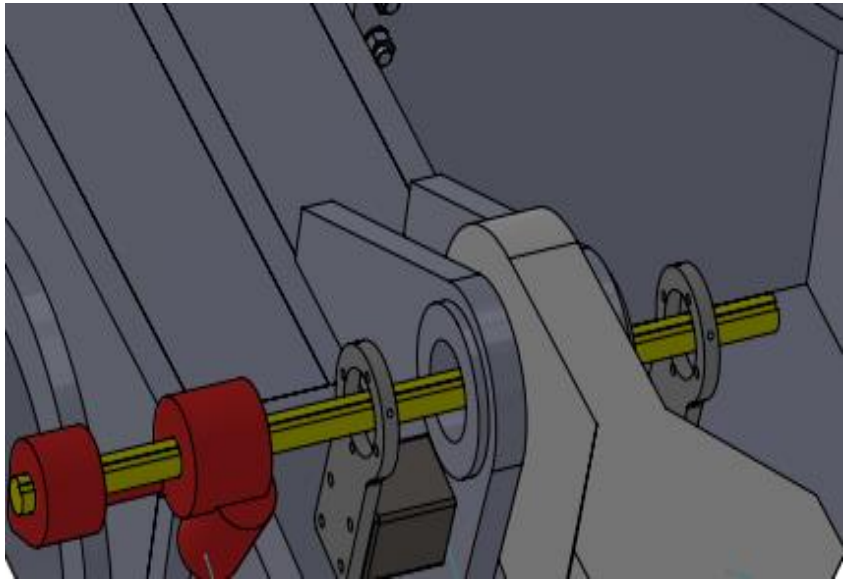
Project nr: 13-1049
Customer: MacGregor Norway
Date: Mai 2013
A-frame in-line boring

Scope of work

- Facing of frame cheeks
- Line boring of frame axis in top beam assembly
- Machnining diameter is Ø150mm
- Machining allowance 5mm



Requirements for machining:

- Ra 6,3
- Alignment of the holes and axis

Result:

- Ra 3,2
- Machined axis and holes are aligned

References:

MACGREGOR

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Facing of frame cheeks

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Line boring of frame axis in top beam assembly

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