

1. Automated 5-axis CNC Milling		
# Machine	Working Range	Remarks
1 Willem Macodel 508MT		8-axis machine with CNC turning and milling capability's. Control: Fanuc 31iB5. 30.000 RPM, tool magazine 72 pockets.
1 DMU - 100U duoBlock	450x200x425	Automatic machine loading with Bar-feeder IRCO ILS-MUK-7012 5-axis machining, control: Heidenhain iTNC 530. 12.000 RPM, tool magazine 120 pockets.
1 DMU - 70 eVo	1.000x1.000x1.000	Automatic machine loading/unloading with: Fastems FPC1150 (10 pallets) 5-axis machining, control: Heidenhain iTNC 530. 18.000 RPM, tool magazine with 92 pockets.
1 max. dimensions for automation:	750x600x520	Automatic machine loading/unloading with: for automation: System 3R WorkMaster robot (44 pallets).
1 DMU – 80 eVo	530x410x350	5-axis machining, control: Heidenhain iTNC 530. 18.000 RPM, tool magazine with 120 pockets.
1 Mikron HPM1150U	800x650x550	Automatic machine loading/unloading with: Cellro Round 2000-165 Advanced (61 pallets) 5-axis machining, control: Heidenhain iTNC530, 24000 RPM, tool magazine with 120 pockets.
max. dimensions for automation:	1.150x1.000x895	Automatic machine loading/unloading with: System 3R WorkMaster robot (15 pallets).
2 Hermle C40U	700x480	5-axis machining, control: Heidenhain iTNC 530, 28000 RPM, tool magazine with 125 pockets.
	850x700x500	Automatic machine loading/unloading with: System 3R WorkMaster robot (44 pallets).
2. Direct CNC supporting software		
# Software		
1 SolidEdge		CAD software.
2 EdgeCAM		CAM software.
1 Vericut		CAM/Optimization software.
3. Milling (CNC & conventional)		
All CNC machines are equipped with: STARK ZERO POINT MOUNTING SYSTEM		
# Machine	Working Range	Remarks
2 DMG-DMC 65V	650x500x500	18000 RPM, rapid traverse 60m/min, Heidenhain TNC 430. 30 pockets.
1 DMG-DMC 70V	700x550x500	With 4th axis, control: Heidenhain TNC 426. 30 pockets.
1 Hermle C600U	600x450x450	5-axis machining, control: Heidenhain TNC 430. 30 pockets.
1 Leadwell MV50-i	1270x635x610	3-axis machining, control: Fanuc Oi-MC. 24 pockets
1 Deckel FP4CC	600x500x500	High-frequency milling (24000 RPM), control: Grundig Dialog 11.
1 Deckel FP1	350x150x200	Conventional milling.
4. Turning (CNC & conventional)		
# Machine	Working Range	Remarks
1 Gildemeister CTX 400 / S2		With driven tools, no Y-axis. Bar capacity \varnothing 65mm. Bar loader: LNS Quick-Servo II; \varnothing 6- \varnothing 120. Length 130-1600mm.
1 Gildemeister CTX 320 V6 linear	\varnothing 305x600	With driven tools and Y-axis (64mm). Bar capacity \varnothing 65mm. Bar loader: LNS Quickload Servo III; \varnothing 33- \varnothing 65. L. max 1200mm.
1 Hitachi Seiki CS 20	\varnothing 240x450	Vertical CNC-lathe with 14 pallets.
1 Schaublin 110 CNC-R	\varnothing 150x150	With driven tools.
1 Schaublin 125	\varnothing 25x200	
1 Ursus 225	\varnothing 240x500	
	\varnothing 270x1500	
5. Jig boring / milling / tapping (CNC & conventional)		
# Machine	Working Range	Remarks
1 Brother TC 324	420x300x250	CNC with 2 pallets.
1 Fehlman P18		

6. Surface grinding / lapping / honing (conventional)

#	Machine	Working Range	Remarks
1	Jung F50-2632	500x200	
1	Kemet LA230 F	Ø230	Lapping.
1	Sunnen BC 1804G		Honing.

7. Measuring

#	Machine	Working Range	Remarks
1	Mitutoyo Crysta Apex C9166	1600x900x600	CNC measuring with Renishaw CNC probe system.
1	Mitutoyo Crysta Apex S9106	900x1000x800	CNC measuring with Renishaw CNC probe system.
1	Mitutoyo Cosmos		CMM software.
1	Mitutoyo CAT 1000S		CMM software.
2	Metrolog XG		CMM software.
1	Trimos 600	600mm	Digital height gauge.
1	Trimos 600+	600mm	Digital height gauge.
1	Mitutoyo surftest 201		Surface roughness measuring gauge.
1	Zeiss handsurf E35A		Surface roughness measuring gauge.
1	Minitest 3001		Micro processor coating thickness gauge.
1	Saroy		Rockwell hardness testing gauge.
1	Mitutoyo PJ 300	50x50	Profile Projector.
1	Trimos calibrating gauge with Silvac-reading		Accuracy 1µm (reading 0,1 µm).
1	Penetrant inspection		Red/white and fluorescent.
	Miscellaneous gauges		Plug, snap, ring and screw gauges, gauge blocks, precision pins. Carbide and/or ceramic.
	Miscellaneous inside- outside micrometers		Two-point and three-point.

All equipment stored/positioned in a climatized measuring room (20°C) with Thermo-hygrograph registration.

8. Miscellaneous

#	Machine	Working Range	Remarks
1	Hurth KF32A		Splineshaft milling
1	JTC VT6 1350		Broaching
1	Ravensburg S250		Slotting
1	Amada CNC HFA 250 W	Ø250	NC controlled automatic bandsaw.
1	Bewo 315	Ø150	Circular saw.
1	Bauer 400V		Vertical bandsaw.
1	Zoller Redomatic 600		CNC controlled presetting and measuring device.
1	Zoller Bravo 2		Presetting device
1	Laborex	300x400x400	Blasting cabinet (glass beads).
1	Walter Trowal CVE 125		Circular vibrating machine (surface finish).
1	Walter Trowal TFM 120/91		Through vibrating machine (surface finish).
1	Micro-tap 9011-G5	M1 - M6	Micro processor controlled tapping device.
1	Micro-tap II-G8	M2,5 - M12	Micro processor controlled tapping device.
1	APM		Production Management Software.
1	MKG		ERP software.

Landes
HIGH END MACHINING

Magelheanstraat 15
7825 VL Emmen
P.O. Box 2062
7801 CB Emmen
The Netherlands

T +31 (0) 591 63 22 05
F + 31 (0) 591 63 22 95
info@landes.nl

www.landes.nl
www.landeshighendmachining.de
www.landeshighendmachining.co.uk

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