



KENTAUR IMPEX
ISKRA KUMANOVO

FABRICATION AND TRADE
Equipment Catalogue

Welcome to Iskra Kumanovo



Source: <https://www.youtube.com/watch?v=HTdJuH6F29A&t=69s>

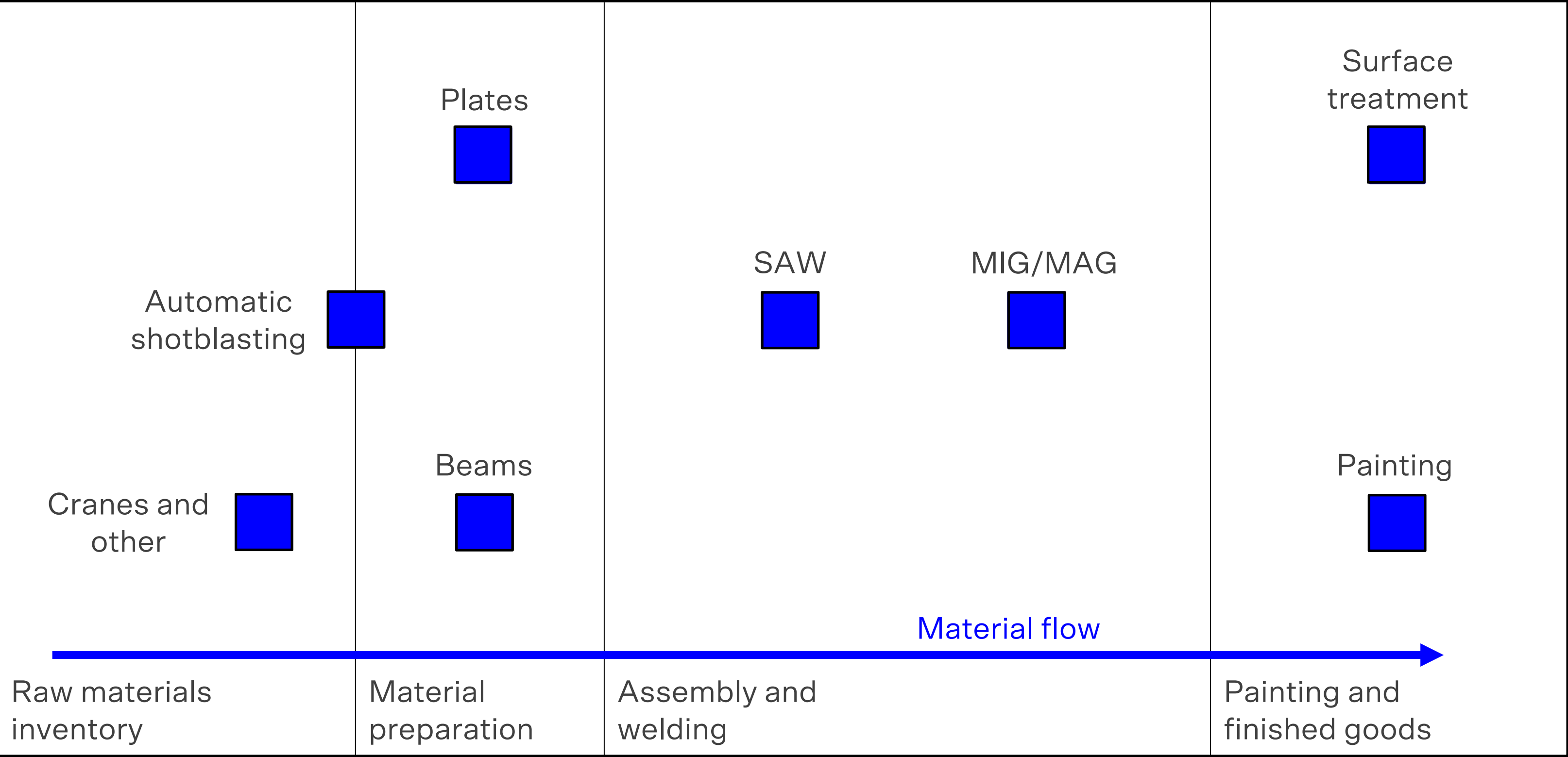
Covered area: **33,000 m²**

Overhead cranes: **32**

Lifting capacity: **5 to 40 t**

Theoretical capacity: **1000 t/month**

Manufacturing process



Automatic shotblasting

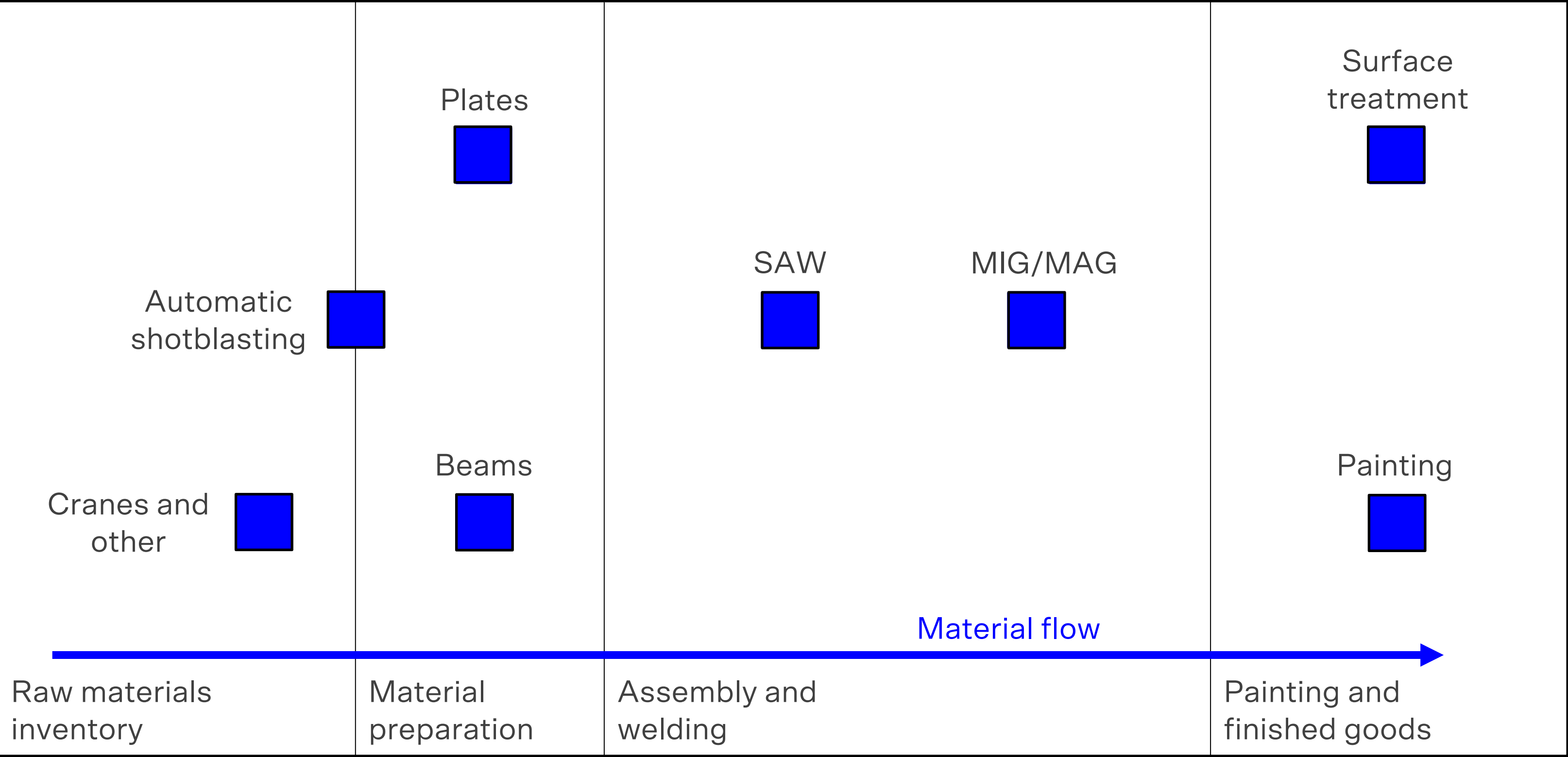


Manufacturer: OMSG Villa Cortese, Italy
Plate working space: 600/3000 mm
Beam working space: 590/2200 mm
Maximum speed: 2.4 m/min
Sand blasting standard: SA 2.5 (Very thorough blast cleaning)

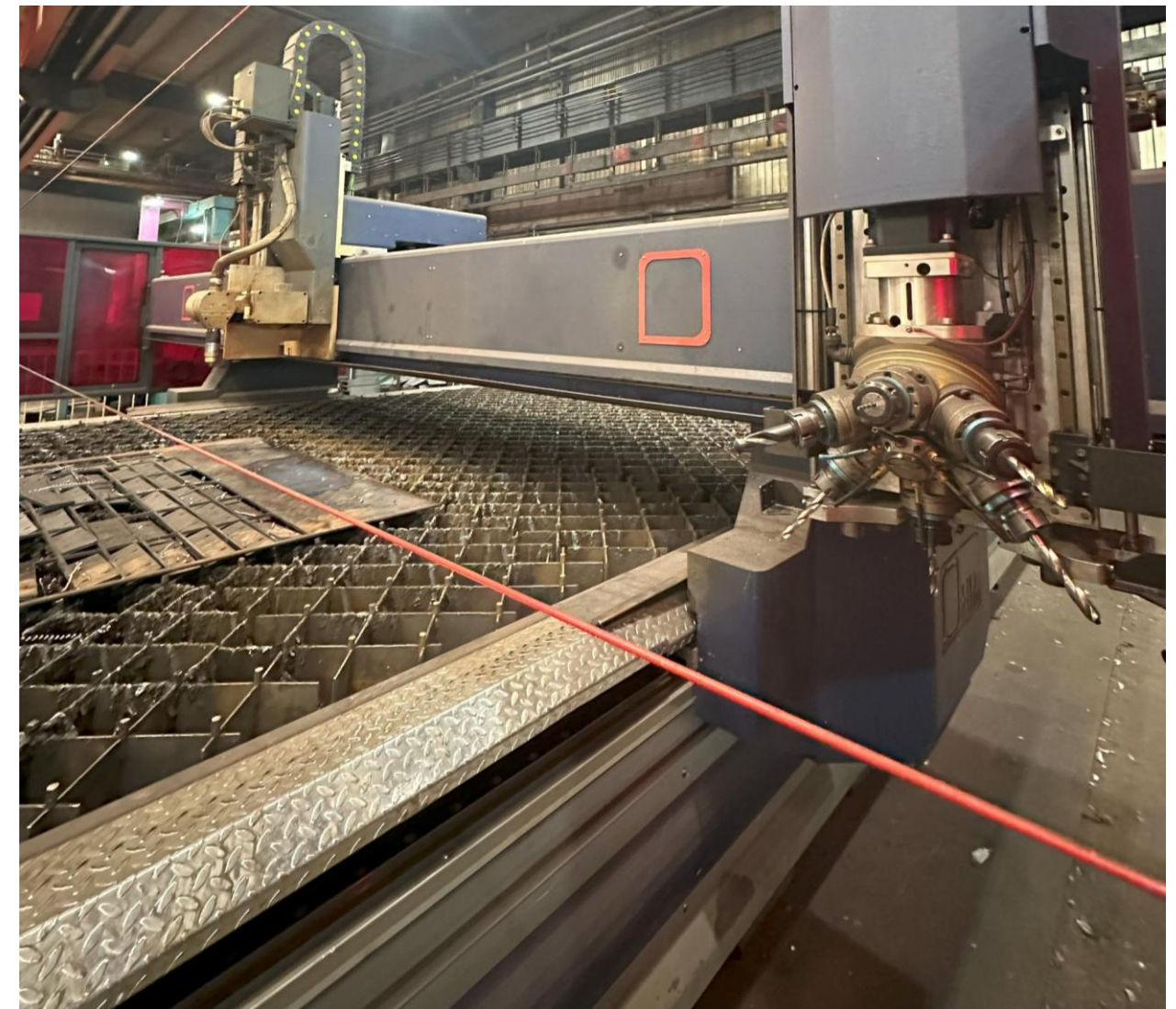
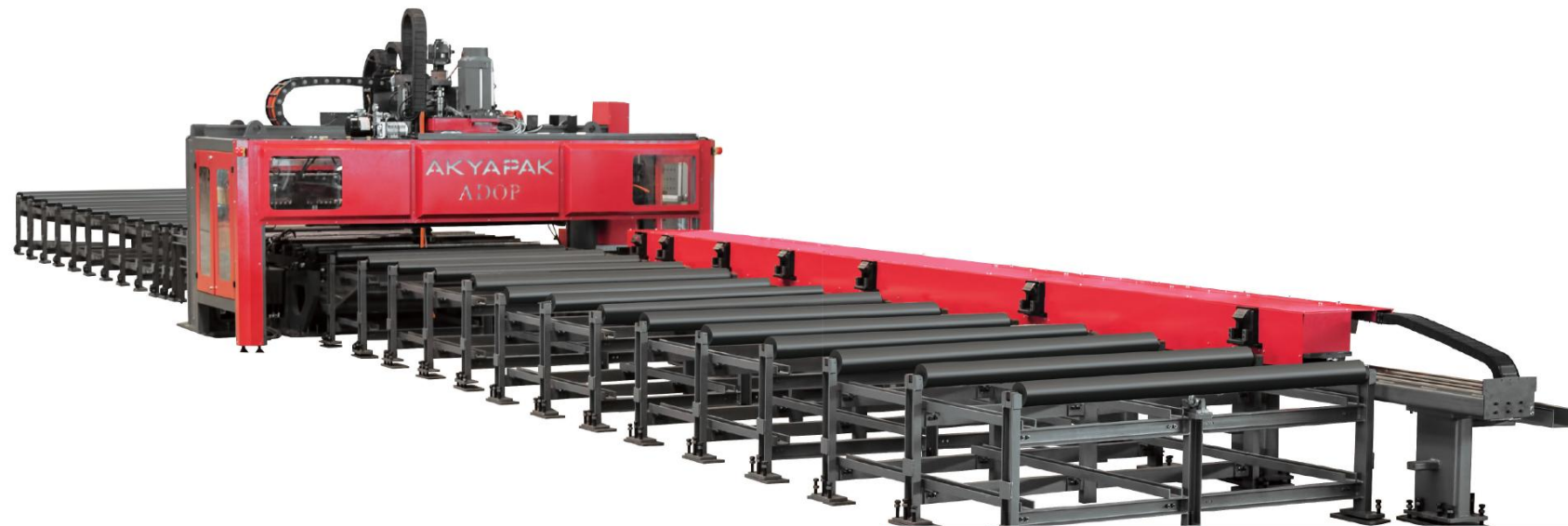


Manufacturer: Gostol, Slovenia
Plate working space: 1500 mm
Beam working space: 800/1600 mm
Maximum speed: 0.3-2.4 m/min

Manufacturing process



Material preparation - Plates



Source: Akyapak

Type: CNC plate cutting and drilling machine

Manufacturer: Akyapak, Turkiye

Number of tools: 6

Limits: drilling: 10 - 40 mm (inner cooling); tapping: M12 - M24

Max. thickness: plasma: max. 30mm; oxy: max. 100mm

Maximum weight: 7.5 t

Type: CNC plate cutting and drilling machines

Manufacturer: HPM, Italy

Cutting dimensions: 14 x 3 m

Maximum plasma cutting thickness: 80 mm

Maximum oxy fuel cutting thickness: 120 mm

Mechanical/electronic precision: 0.05 mm

Material preparation - Plates



Type: CNC plate cutting and drilling machines

Manufacturer: HPM, Italy

Cutting dimensions: 18 x 3 m

Maximum plasma cutting thickness: 80 mm

Maximum oxy fuel cutting thickness: 120 mm

Mechanical/electronic precision: 0.05 mm



Type: Automatic gas cutting

Manufacturer: Messer, Germany

Number of machines: 2

Burners: number: 8; min. distance between them: 40 mm

Max. plate dimensions: 26 x 4 m

Average cutting speed: 0.34 m/min

Material preparation - Plates



Type: Bending machine with conical bending device
Manufacturer: Sahinler, Turkey
Useful length: 3100 mm
Maximum thickness: 40 mm



Type: Bending machine
Manufacturer: Le Mense, Belgium
Dimensions: 4000 x 160 mm
Maximum thickness: 32 mm

Material preparation - Plates



Type: Predeformation- plate straightening

Manufacturer: Di Parmigiari, Italy

Max. plate width: 2000 mm

Max. plate thickness: 30 mm



Type: Predeformation- plate prestressing (IP 700x35)

Manufacturer: Di Parmigiari, Italy

Max. plate width: 700 mm

Max. plate thickness: 35 mm

Speed: 14 m/min

Material preparation - Plates



Type: Drilling and cutting (HYD 110)
Manufacturer: GEKA, Spain
Max. diameter: 40 mm
Max. plate thickness: 35 mm
Max. hole diameter: M 16



Type: CNC Punching (PAXY 1500, PUMA 110)
Manufacturer: GEKA, Spain
Workspace: 750 x 1515 mm
Max. thickness: 28 mm (diameter 28 mm)

Material preparation - Plates



Type: Press brake (QHD-20040/60)
Manufacturer: ADIRA, Portugal
Maximum capacity: 2000kN
Max. working length: 6.1 m
Stroke: max- 200 mm; min- 15 mm
Max. working speed: 7.9 mm/s



Type: Press brake (APHS HYBRID 61600)
Manufacturer: Baykal, Turkey
Bending force: 600 t
Max. bending length: 6.1 m
Stroke: 625 mm
CNC controller

Material preparation - Plates



Type: Press brake (PI 175)
Manufacturer: SIMEROM, Romania
Max. plate length: 4050 mm
Max. plate thickness: 8 mm

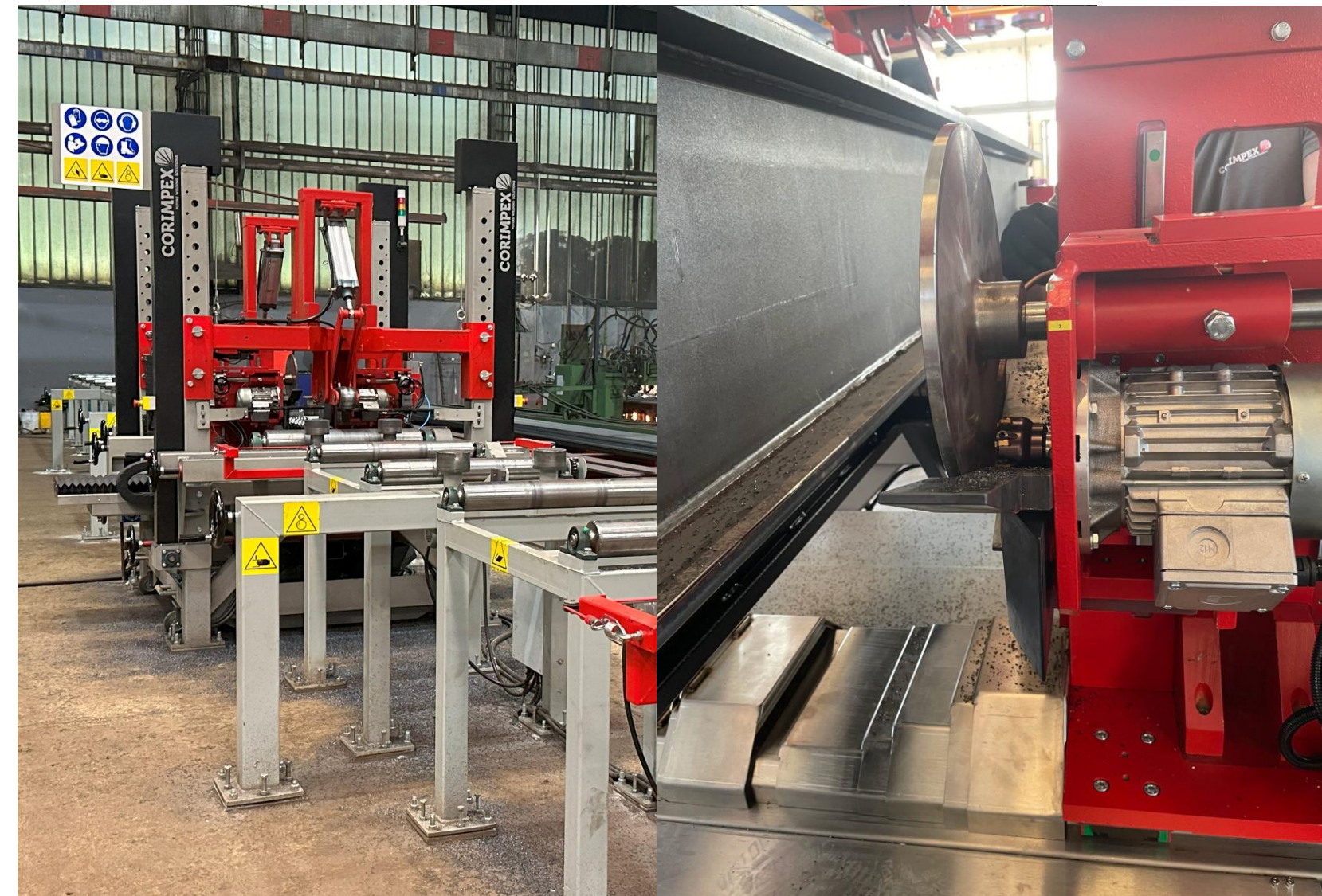


Type: Press brake (MG 31/ 16-20)
Manufacturer: JELSINGRAD
Max. plate width: 3100 mm
Max. plate thickness: 12 mm

Material preparation - Plates



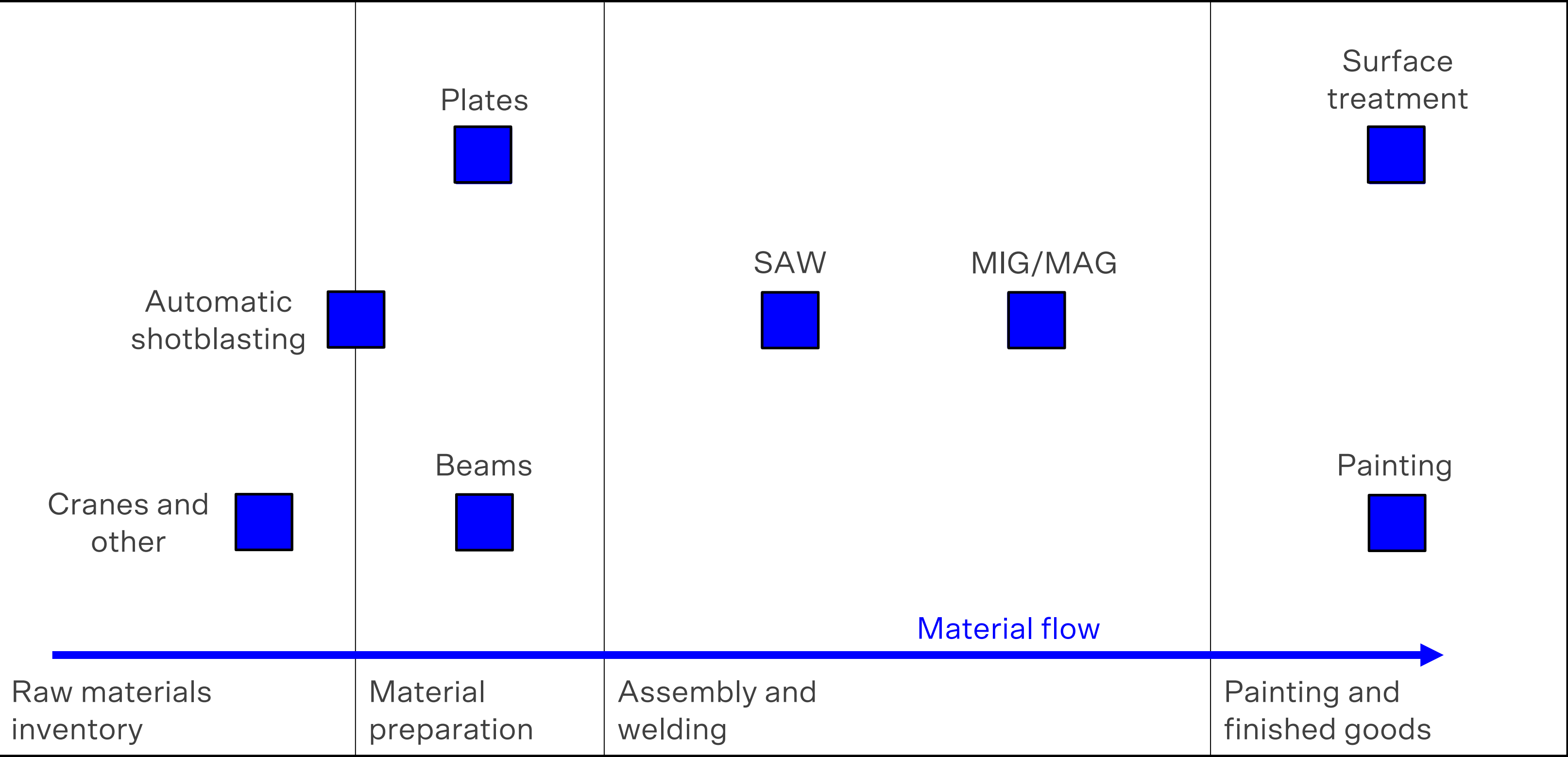
Type: Plate bevelling machine
Manufacturer: HULIN TOS, Czechoslovakia
Max. plate length: 14 m
Max. plate thickness: 80 mm
Max. speed: 12 m/min



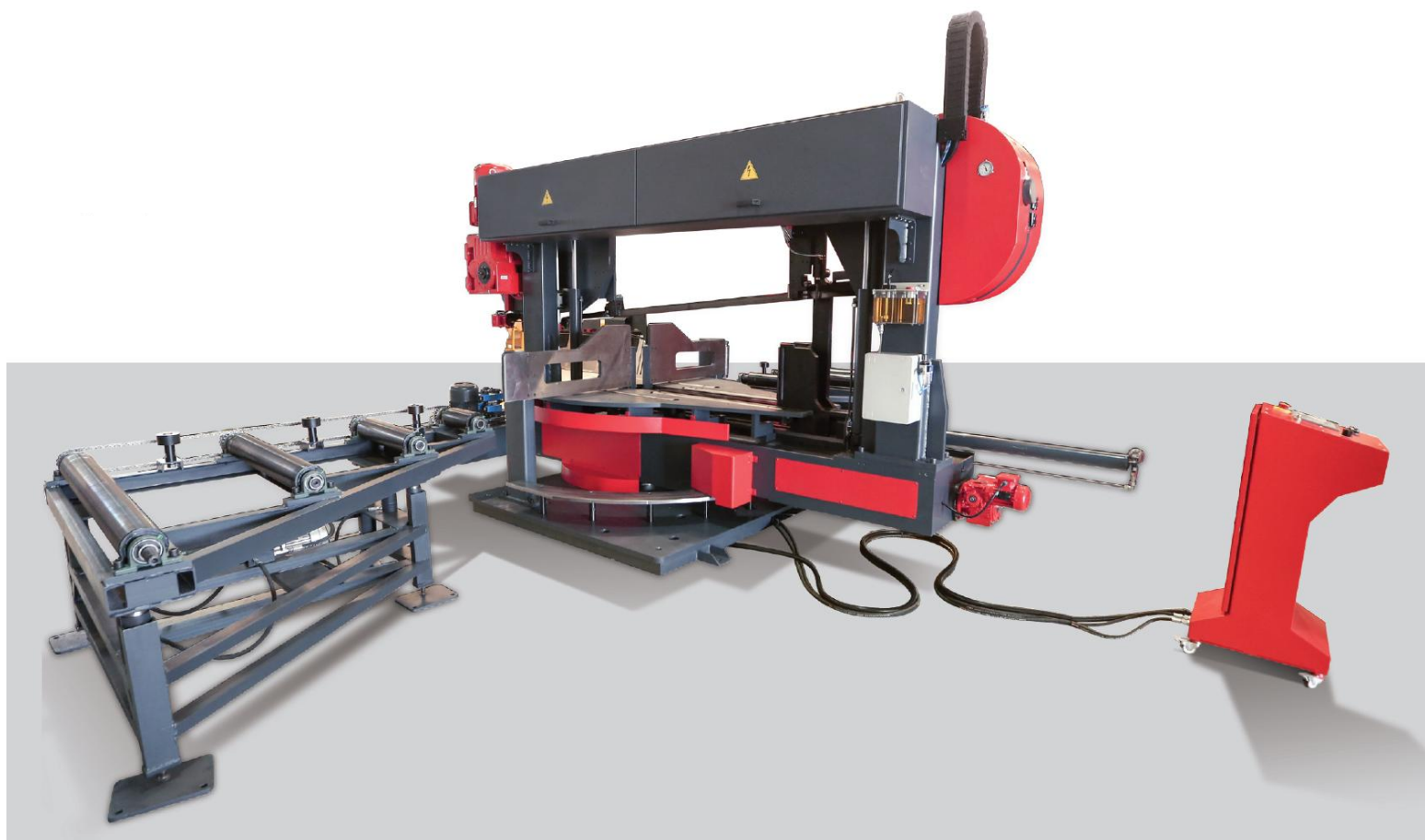
Source: CORIMPEX

Type: Edge rounding machine
Manufacturer: CORIMPEX, Italy
Flange width: 160-1250 mm
Web thickness: 6 - 25 mm
Working speed: 2.5 – 3 m/min

Manufacturing process



Material preparation - beams



Source: Akyapak

Type: CNC beam saw (AST 130 - 600)
Manufacturer: Akyapak, Turkiye
Sawing capacity max. (W x H): 1300 x 600 mm
Sawing capacity min. (W x H): 65 x 45 mm
Cutting speed: 20 - 100 m/min



Type: CNC beam processing (3 ADM 1200)
Manufacturer: Akyapak, Turkiye
Max. beam dimensions (H x W): 500 x 1200 mm
Drilling diameter: 10 - 40 mm
Weight per linear meter: 750 kg/m

Material preparation - beams



Type: Welded sections straightening

Manufacturer: Stierli-Bieger, Switzerland

Pressing force: 500 kN

Flange dimensions (W x T): 150 – 800 mm (H-beam) ; 100 – 400 mm (T-beam) x 5 – 20 mm

Web dimensions (H x T): 250 – 2000 mm x 4-20 mm

Length: 1500 – 15000 mm



Type: Beam saw

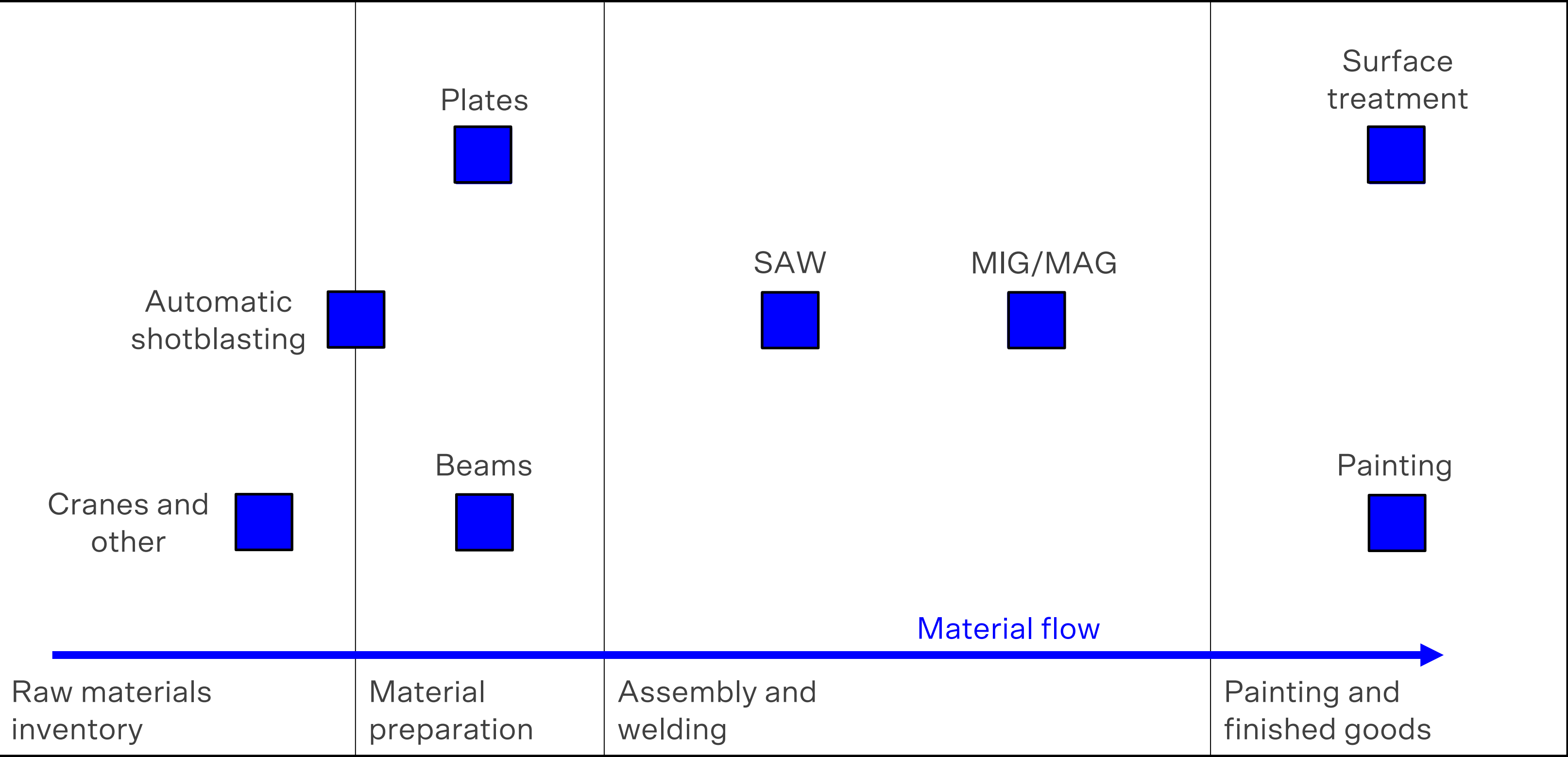
Manufacturer: SABI, Spain

Max. dimensions: 1350 x 600 mm

Max. plate thickness: 35 mm

Angle cutting: -60 to +45 degrees

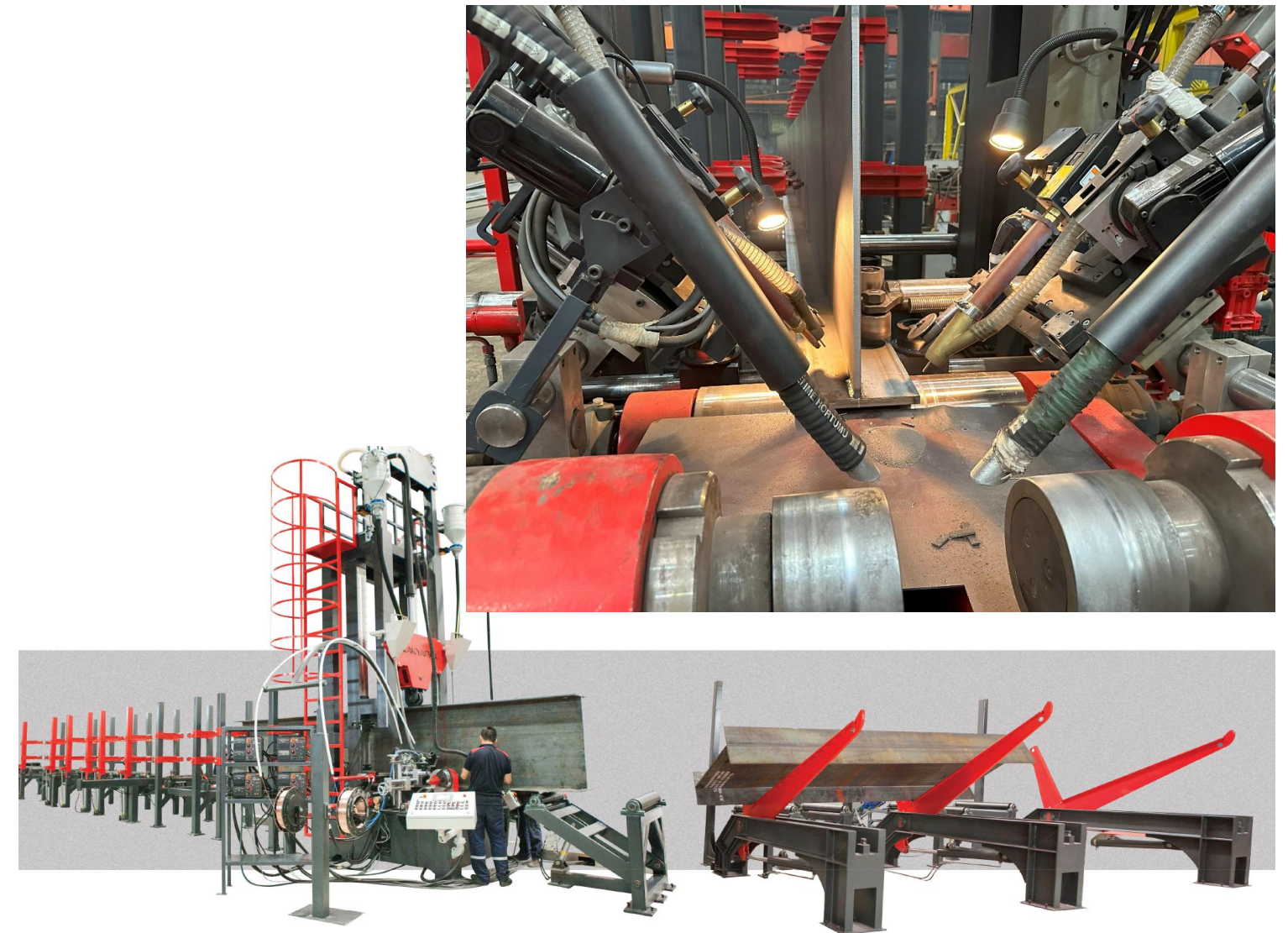
Manufacturing process



Welding - SAW



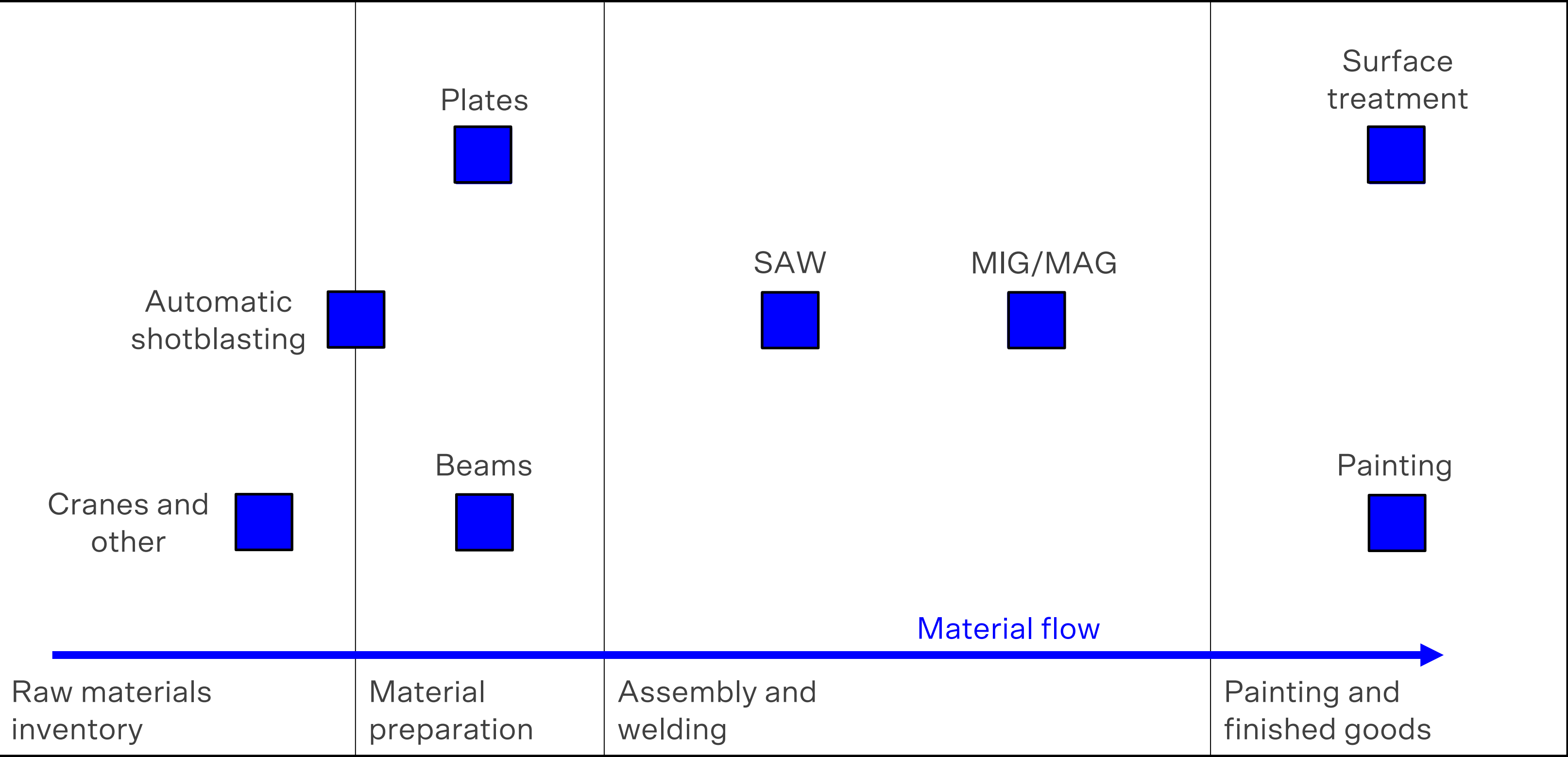
Type: Arc welding machines
Manufacturer: ARMCO, Italy
Number of lines: 12
Beam dimensions: 700/200/3000 mm
Welding sources: Lincoln Electric DC-1500 A

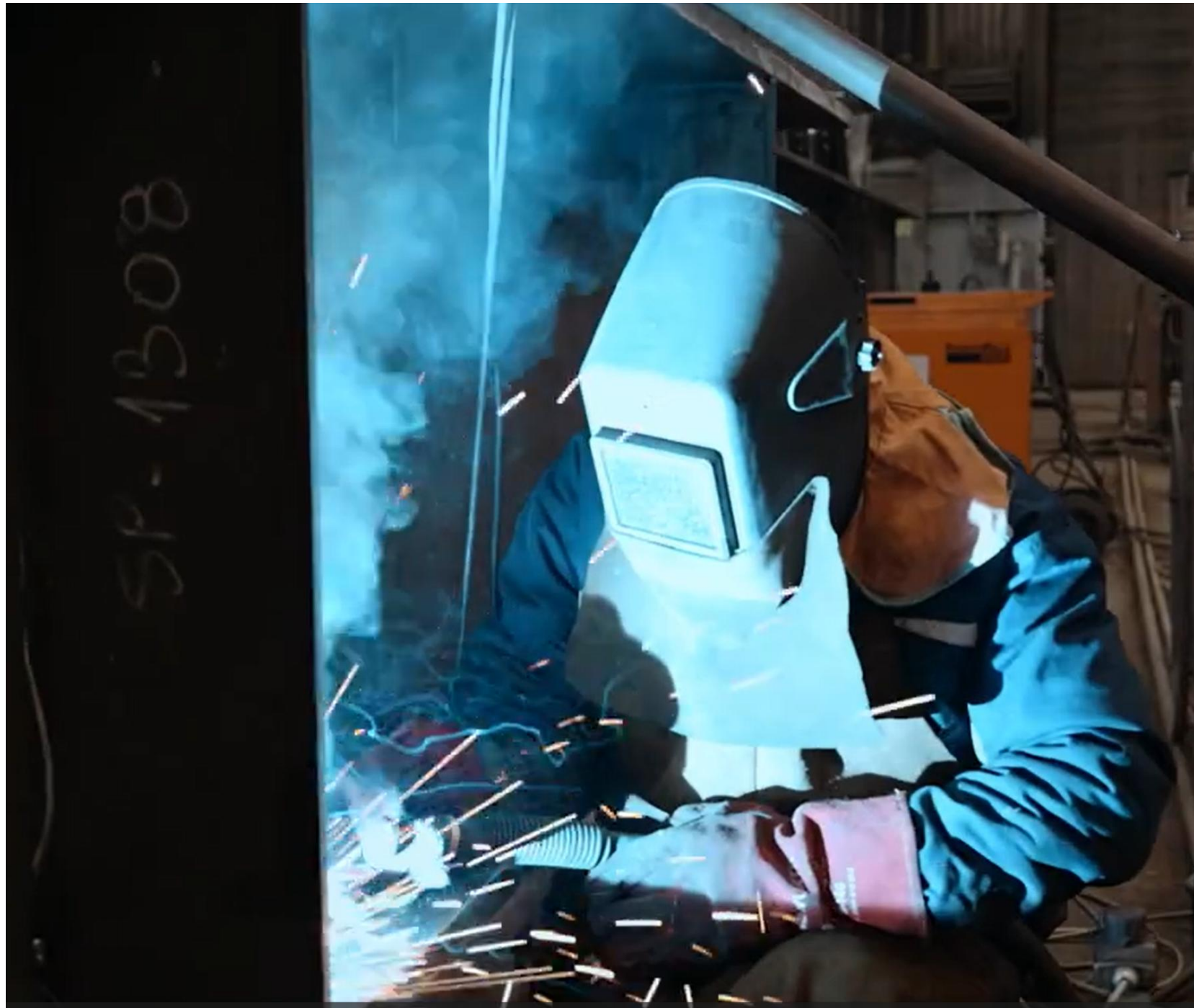


Source: Akyapak

Type: Automatic SAW welding machine (HBW 2000x1000)
Manufacturer: Akyapak, Turkiye
Beam types: H, I, T, L with 4 torches
Beam width: 150 - 1000 mm
Beam height: 200 - 3500 mm
Flange/ web thicknesses: 8-60 mm / 6 - 40 mm

Manufacturing process





Type: MAG welding equipment (KEMPO WELD 5500W)

Manufacturer: KEMPPI

Number: 52

Wire feeder: KEMPO WELD Wire 550

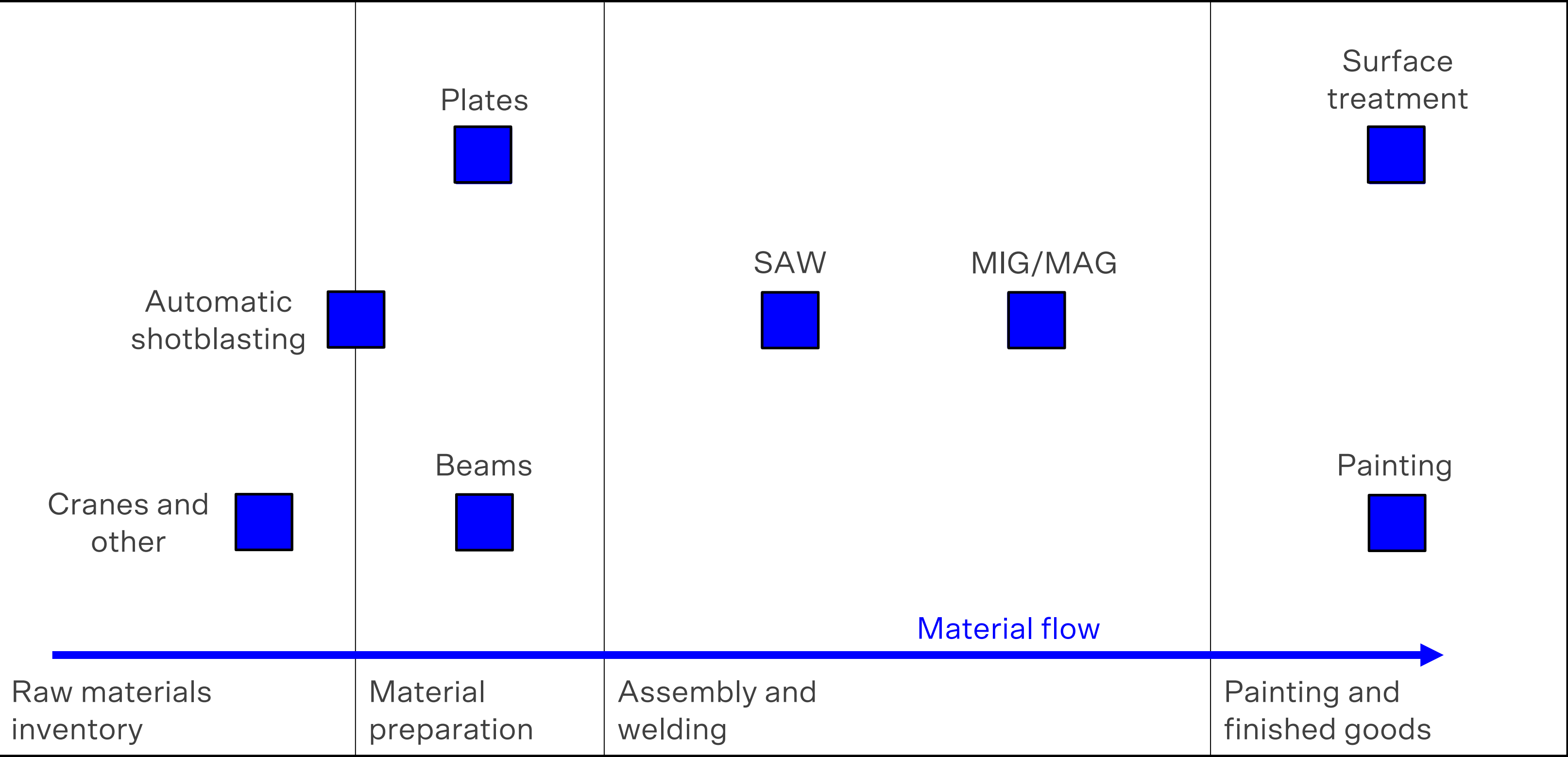
Type: MAG welding equipment (Lorch MicroMig 500 and LORCH MicroMig Pulse 500)

Manufacturer: KEMPPI

Number: 6

Wire feeder: LORCH MF-08

Manufacturing process



Surface treatment

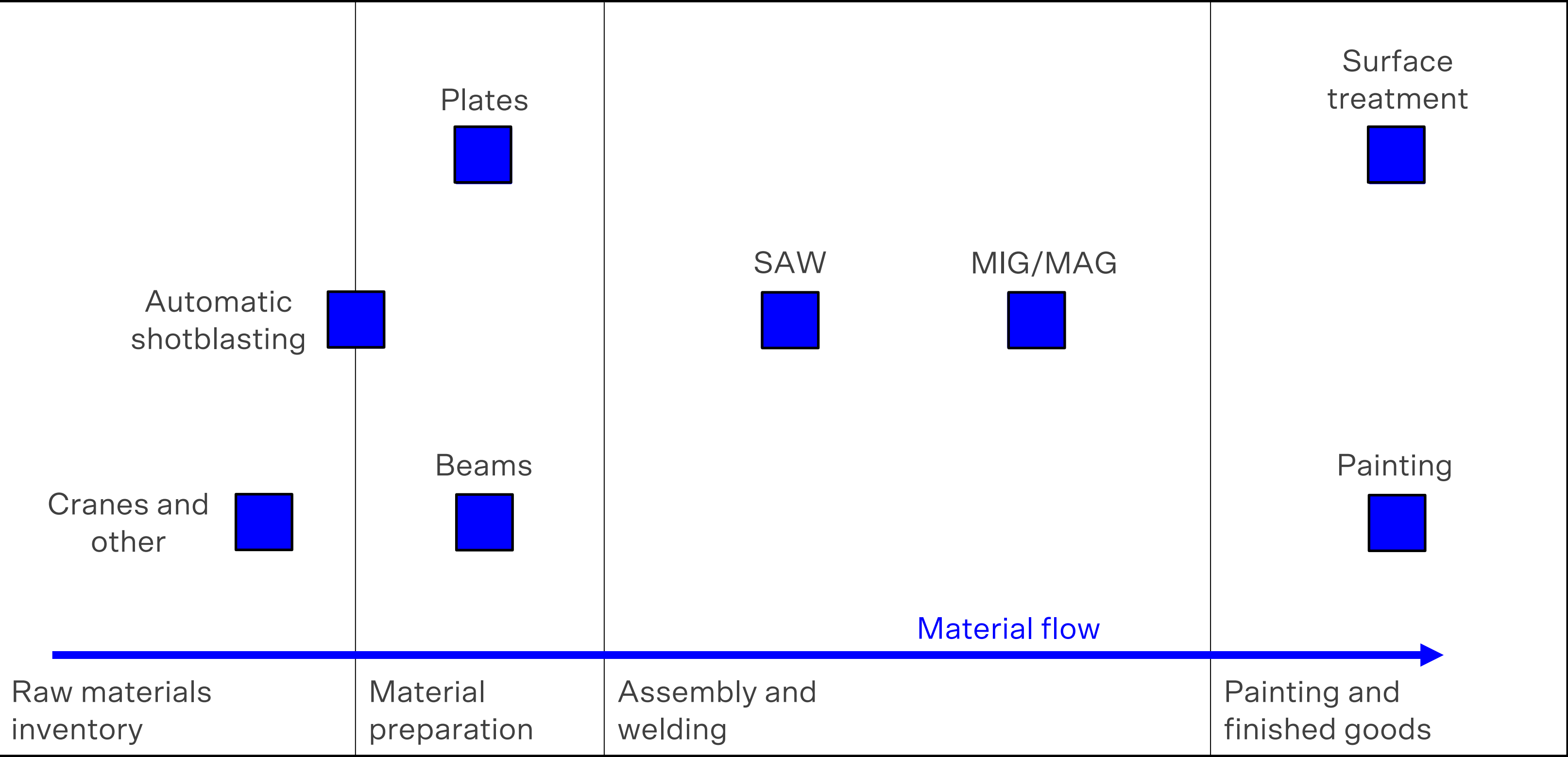


Type: Manual sandblasting equipment (293.K)
Manufacturer: Tovarna industrijske opreme, Slovenia
Number: 2
Work pressure: 10.4 Pa
Capacity: 0.015 m³



Type: Shotblasting hall
Manufacturer: SAPI, Germany
Dimensions (L x W x H): 18 x 6 x 5 m

Manufacturing process



Painting

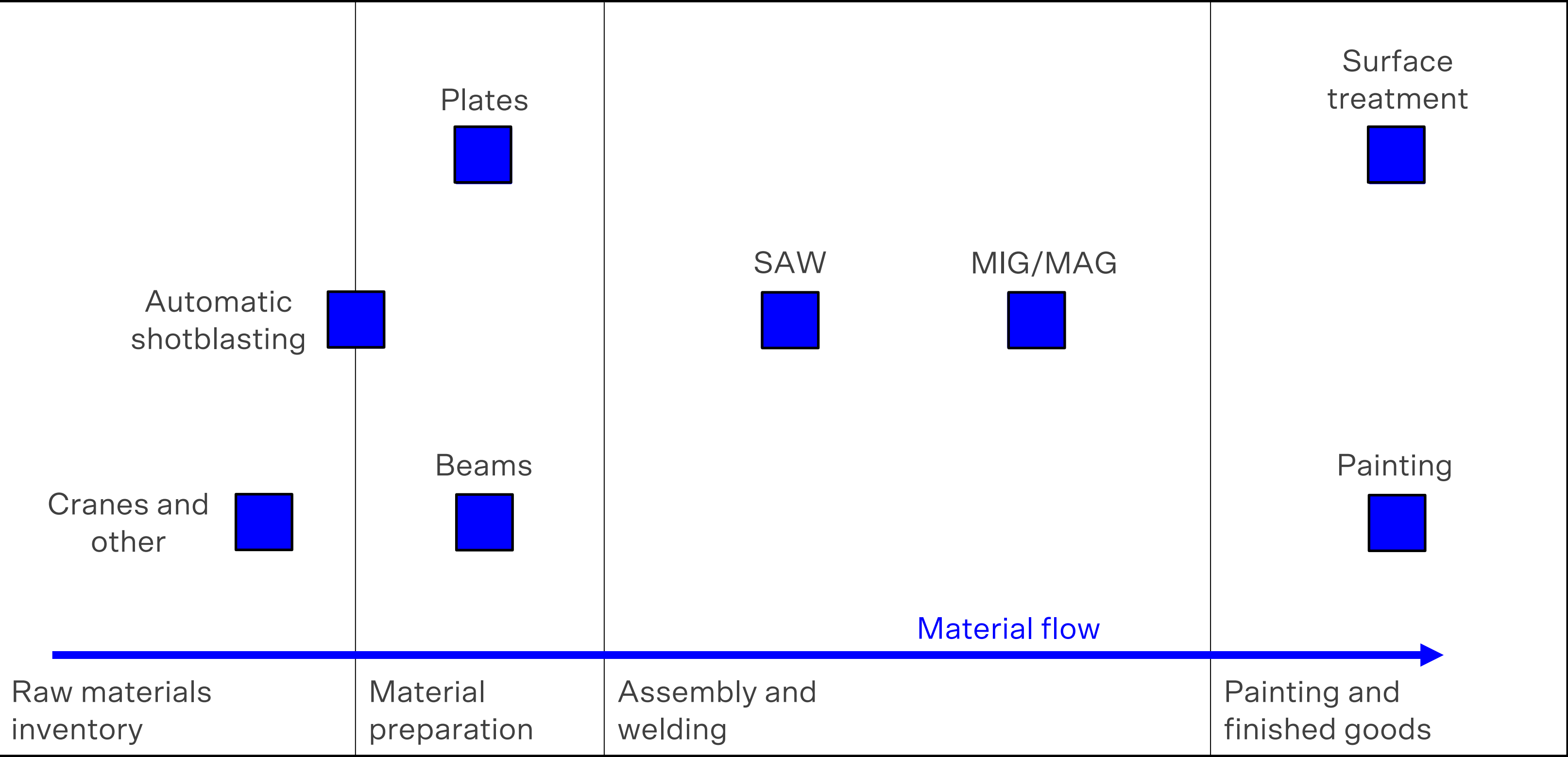


Type: Shotblasting hall
Manufacturer: SAPI, Germany
Dimensions (L x W x H): 16 x 6 x 5 m



Type: Manual painting equipment (XL 70-180)
Manufacturer: GRACO, USA
Max. fluid WPR: 500 bar
Max. air WPR: 7 bar

Manufacturing process



Cranes and other



Source: <https://www.youtube.com/watch?v=HTdJuH6F29A&t=69s>

Manufacturer: Ivo Lola Ribar Zeleznik Beograd, Serbia

Lifting capacity: 5 to 40 t

Types:

- 7 cranes 2 x 2.5 t
- 4 cranes 2x 5 t
- 1 crane 2 x 7.5 t
- 2 cranes 2x 10 t
- 2 cranes 2 x 15 t
- 2 cranes 2x 20.5 t



Type: Compressors (GA 90)

Manufacturer: Atlas Copco, Italy

Number: 2

Working pressure: 8.5 bar

Input power: 95 kW

Rotational shaft speed: 1487
r/min



Type: Gas reservoir (118.29)

Manufacturer: Heroj,
Smederevo

Capacity: 25 m quick

Working pressure: 10 atm



Calibrated QC and ND testing
equipment

CONTACT INFO



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