

	0,5 Kg - 15 Kg	15 Kg - 80 Kg	80 Kg - 800 Kg	800 Kg - 2.500 Kg
DESCRIPTION	Small Part Division (SPD)	Medium Part Division (MPD)	Big Part Division (BPD)	
SERIAL SIZE PRODUCTION	Large	Medium	Medium/Small	

Casting technology

	ELORRIO workshop	LEGUTIANO workshop	IURRETA workshop	
Technology	2 DISAMATIC Lines	1 HWS automatic line	1 IMF automatic moulding line	1 floor moulding
Moulding process	Vertical green sand	Horizontal green sand	Chemical automatic moulding	Chemical hand moulding
Pattern size (mm)	600 x 480	1000 x 770 x 330/330	2.000 x 1.600 x 600/600	2.500 x 2.500
Material	Nodular	Grey / Nodular	Grey / Nodular	Grey / Nodular
Max. capacity (Tn)	20.000	24.000	9.000	
Other processes (acc. to capacities)	Co-design Dept. / Process Lab. / Core shop / Deburing / Magnetic test (MT) / Ultrasonic test (UT) / Visual check Dpt. (VT) / 3-D Scan / CMM machines			

Machining technology

	LEBARIO workshop	ASTOLA workshop	
Technology	OKUMA, CMZ, MATSUURA, FAMAR Automatized CNC lathes and machining center lines	OKUMA, MORI SEIKI, MAZAK, MAKINO CNC lathes, machining centers and CNC milling machines	MAZAK, MANDELLI, CORREA MAZAK, MANDELLI, CORREA CNC lathes, machining centers and CNC milling machines
Max. pallet size (mm)	Up to 400 x 400	Up to 500 x 500	Diagonal up to 2700
Material	Casting and Forging	Casting and Forging	Casting and Forging Casting and Forging
No. of machines	70	50	
Other processes (acc. to capacities)	Assembly / Co-desing Dept. / Magnetic test (MT) / Ultrasonic test (UT) / Visual check Dpt. (VT) / 3-D Scan / CMM machines / Specific control stations		

SPECIFIC CERTIFICATIONS	ISO 9001 - ISO/TS 16949 - ISO 14001 - ISO 18001 - ADW0 2000	ISO 9001 - ISO 14001 - ISO 18001 - ADW 2000
-------------------------	---	---

INDUSTRIAL SECTORS	Automotive, Industrial vehicle, Agricultural vehicle, Wind power industry, Industrial machinery, Industrial engines, Elevation, Railway, Civil applications, Other
--------------------	--