



ISKRA CNS
Centrum Narzędzi Specjalnych



ISKRA **CNS**

Ladies and Gentlemen!

We are a long-standing manufacturer of tooling for industry.

We have high-tech machinery and experienced personnel.

We cooperate with Customers using bespoke tooling.

We make the following products:

1. Turning tooling, including:

- curved cutting edge tools of rapid steel or sintered carbides
- carbide-tipped tools
- profile carbide blanks
- automatic lathe collets
- technological tooling of single-spindle automatic and multi-spindle automatic lathes
- tooling of turning process line

2. Plastic forming tooling, including:

- press-forming dies
- replaceable parts of press-forming dies of steel or sintered carbides
- press tools

3. Grinding tooling, including:

- technological tooling of grinding machines (drivers, plates, work support blades) of steel or with sintered carbide inserts
- tooling of grinding process line

4. Hot forging tooling, including:

- tools (drop forging dies, punches, knock-outs) for press type Hatabur and Sakamura
- stellite-padded tools
- technological tooling of hot forging press

5. Assembling tooling, including:

- assembly jigs
- replaceable parts of assembly jigs
- tooling of assembly lines

6. Measuring devices, including:

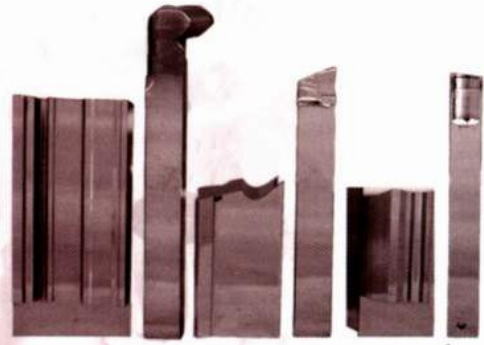
- cylindrical and ring-shaped masters
- curve gauges
- measuring instruments
- replaceable parts of measuring instruments

Required quality of the products is assured by highly skilled and experienced personnel.

Our Customers' safety is guaranteed by Quality System

in conformity with ISO-9001:2000 requirement standard

confirmed with a quality certificate issued by BVQI.



**We possess modern CNC machine tools
as well as conventional ones
with the following working ranges:**

turning

- workpieces of diameter up to 250mm
and length up to 2000mm
- disks of diameter up to 1000mm
- on CNC turning lathes
workpieces of diameter up to 250mm
and length up to 600mm, accuracy up to $\pm 0.005\text{mm}$

milling

- workpieces of dimensions up to 400mmx250mmx300mm
- on CNC milling machines
workpieces of dimensions up to 600mmx450mmx450mm,
accuracy up to $\pm 0.004\text{mm}$

grinding

- cylindrical grinding of workpieces
of diameter up to 250mm and length up to 1000mm
- internal grinding of bushes
of inside diameter up to 200mm and depth up to 200mm
- on universal CNC grinding machines
workpieces of outside diameter up to 350mm
and length up to 600mm, accuracy up to $\pm 0.0005\text{mm}$
- internal grinding of plates
of dimensions up to 400mmx300mm
- surface grinding of workpieces
of dimensions up to 300mmx600mm
- profile grinding of workpieces
of width up to 145mm and length up to 85mm
or diameter up to 150mm
- on CNC profile grinding machines
workpieces of width up to 120mm
and length up to 100mm or diameter up to 150mm,
accuracy up to $\pm 0.005\text{mm}$
- external thread grinding of workpieces
of pitch up to 6mm, diameter up to 125mm
and length up to 350mm

electron-discharge machining (EDM)

- die sinking of workpieces
of dimensions up to 35mmx250mmx300 mm
with accuracy up to 0.005mm
- wire cutting of workpieces
of dimensions up to 500mmx400mm
and length up to 500mm, inclination angle up to $\pm 30^\circ$,
accuracy up to 0.010mm
- drilling holes of diameter from 0.8mm to 3mm
and depth up to 300mm

heat treatment

- in inert gas (nitrogen) or in vacuum,
temperature up to 1350°C,
charge dimensions up to 600mmx300mmx200mm,
weight up to 60 kg

stellite

- use of high-quality materials
and modern welding machines

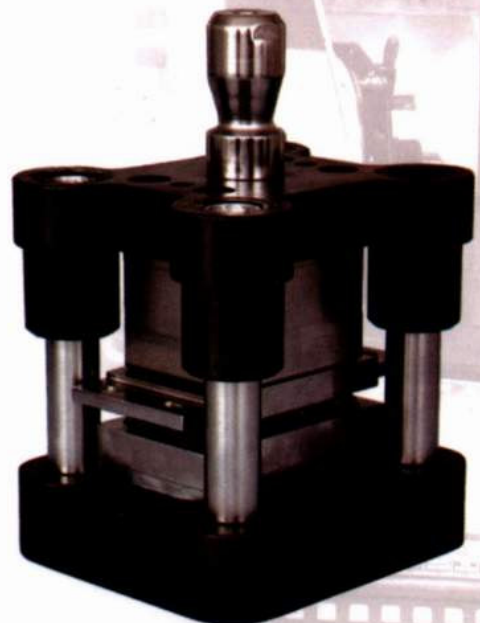
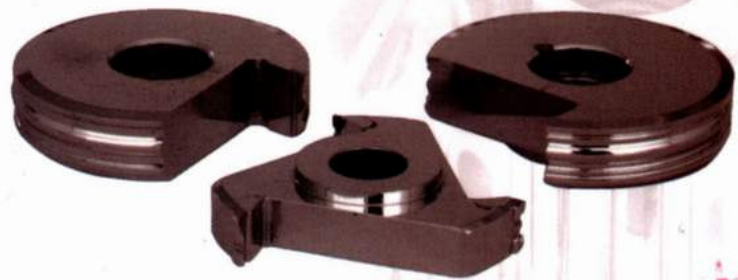
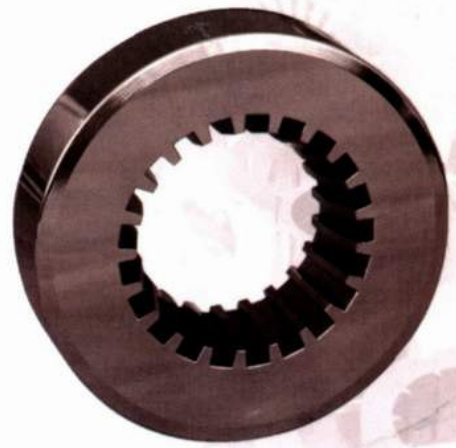
**The guarantee of quality of our products
is the high-class gauging equipment,
including a measuring machine, microscopes,
contour projectors, electronic reading apparatus
installed directly on machine tools.**

**Growing needs of our Customers
are satisfied with continuously enriched machinery.**

We invite you to establish cooperation.

**You can obtain more information about us
on our website: www.cnsk.pl**





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