MEISER® Sheet metal processing

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Production Site Oelsnitz

MEISER is a medium sized company specialising in Open Bar Grating, Profile Planks, Stairways, Stairtreads, Galvanising and Slit Steel Materials. There are two main factories in Germany, one at Schmelz-Limbach in the Saarland and the other at Oelsnitz in Saxony plus other subsidiaries in Belgium, France, Hungary, Egypt and Dubai. Both plants in Germany have galvanising, slitting and cold rolling facilities which ensure high quality is being maintained throughout our manufacturing processes. We have MEISER Sales Offices and Agencies worldwide, guaranteeing a local contact and a personal customer experience. The company employs 1.800 people worldwide with over 1.200 of them in the German factories.

The company was founded in 1956 by Edmund Meiser and to this day has remained a family owned and run enterprise with traditional values ensuring quality and reliability. We trust in our flexible and committed workforce along with our ability to invest in state of the art ultra efficient machinery.

To us, business has primarily to do with people. We place high value on personal and individual contact with our business associates and customers. We believe that progress and growth is only feasible when customers are satisfied with our products and levels of service. Various project collaborations that we have created together with our customers confirm our strategy.

We look forward to welcoming you as a customer!

Sheet metal processing

With our comprehensively equipped modern machinery halls, we are capable of producing an infinite variety of punched profiles and shapes. We can process virtually any punchable steel, stainless steel or aluminium.

Profile production can be in accordance with your specification or design. This can be enhanced with the addition of our product development and prototype production services. Our trained team of specialists are always available to discuss and develop your plans.

Our diverse equipment range permits us to respond to all production requirements ranging from individual "One Off" bespoke production up to large scale "Mass" production.

Our services

Edging, perforating, lasering, punching, shaping, bending, profiling, water jet cutting, welding, assembling, surface treatments ... all under one roof

Special perforation

Our modern production facilities allow us to create an unlimited number of hole shapes and positions for a wide variety of requirements. Technically possible special perforations can include: key-hole shaped perforations, round shaped perforations, rasp perforations, hatch perforations and shutter perforations.

Your fabrication

Our modules are produced with our own parts or with those of other companies, depending on the type of order. Our modules are mainly produced by further developing or processing our main products of sheet metal profiles and gratings. Often added to these products are parts we produce ourselves such as: lasered parts, punched parts, bent and edged parts, pipes, etc. ...

We offer both complete and part solutions for module production. Our additional services include job planning, logistics and quality control.

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Edging

Edging is as essential in modern sheet metal processing as laser cutting.

Our modern machinery, with various hydraulic CNC edging presses, makes it possible for us to use the right tool in each case so that we can produce economically and according to your needs. Our machines provide outstanding bending quality with minimum set-up effort.

Technical data

Edging presses	1.500 – 4.000 KN
Material thickness, normal steel	1.0 – 8.0 mm
Material thickness, stainless steel	1.0 – 6.0 mm
Max. edge length	6.250 mm

Punching

During the punching process, the material is de-coiled and several surfaces are produced in the punch press with progressive dies. Various surface structures can be produced with this system.

Technical data

Punching force	40 – 500 t
Widths	25 – 1.000 mm
Strengths	2.0 / 2.5 / 3.0 steel 2.0 stainless steel 2.5 / 3.0 aluminum

Other thicknesses are available on request.

Water jet cutting machine

A water jet cutter is a machine tool for cutting materials using a high-pressure water jet. High-performance cutting with 6.000 bar pressure!

- 45 % more pressure compared to other known methods
- More than 3.500 km per hour water jet speed
- Up to 50 % higher cutting speed compared to other methods
- Cutting table size: 2.000 x 7.200 mm

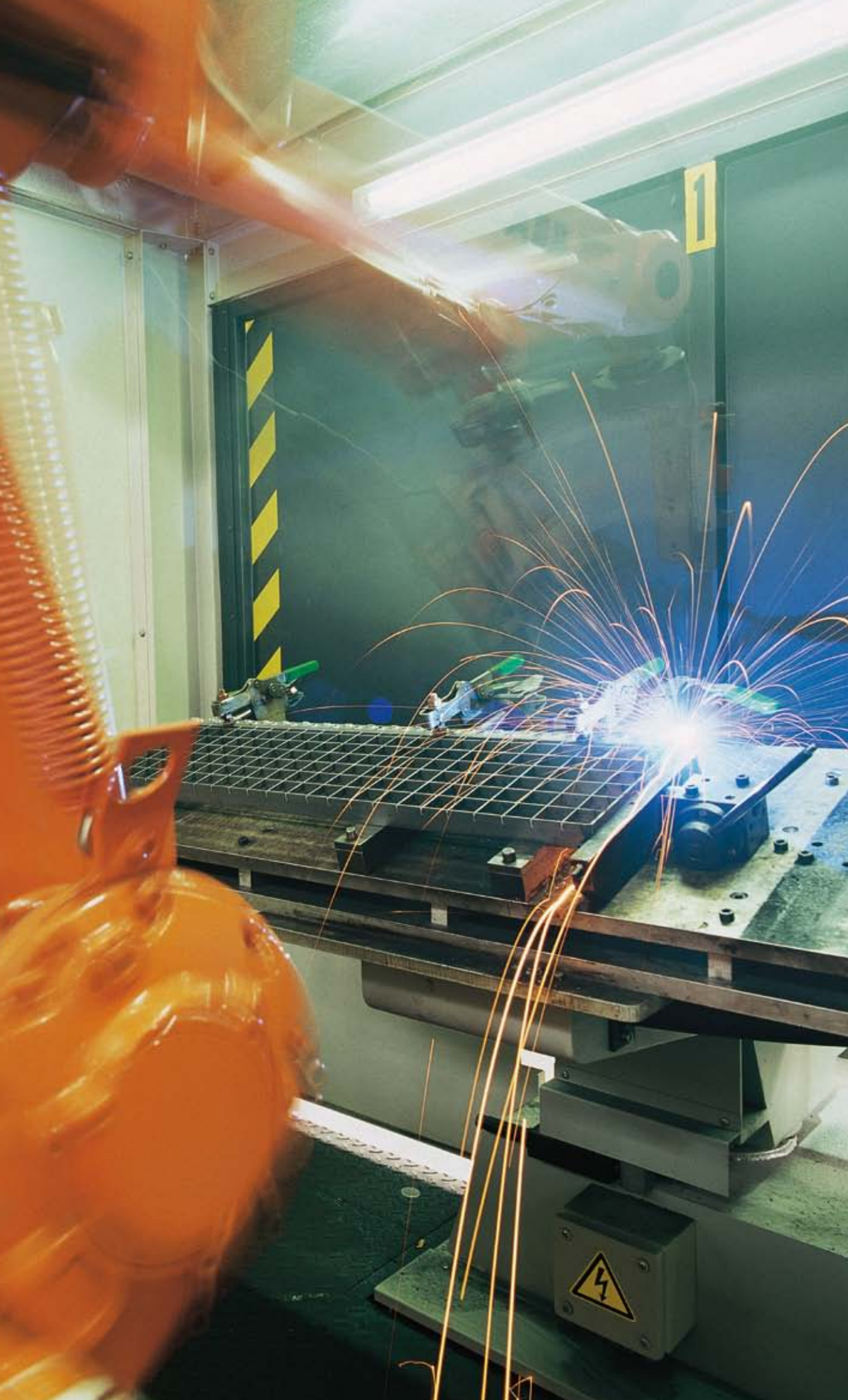
Advantages

- No heat-affected zones
- No increased hardness
- No stresses
- No cracks
- No deformation of the material
- No structural changes
- Narrow cut widths
- High edge quality

Materials which can be cut

- Ferrous and non-ferrous metals
- Plastic and composite materials
- Composite fibre materials
- Rubber, elastomers
- Foams and rigid foams
- Laminates, glass
- Ceramic materials, natural stone
- Others on request

Material thicknesses of 100 mm can be cut easily.



Welding

Welding means the connection of materials by applying heat or heat and pressure. This can be made possible or easier with welding auxiliary materials.

Welding is carried out according to the steel structure standard DIN 18800-7 – Execution and constructor's qualification, also known as "Class C, limited verification of qualification with supplements".

The MAG (Metal Active Gas) welding process is used for conventional and high-alloy steels, MIG (Metal Inert Gas) welding is used for aluminum alloys and TIG (Tungsten Inert Gas) welding is used if required by the customer. The brazing method is used for galvanised material.

Only welders tested to DIN EN 287 carry out the work, and we use inert gases to DIN EN ISO 14175 and filler metals to DIN EN 440 (MAG / MIG) and DIN EN 1668.

Of course, a number of welding robots are also used at MEISER. An advantage of this is for example the uniformity of the weld seam for work in which the architectural appearance is important.

With respect to quality, standard EN 729-1 "Fusion welding of metallic materials" still applies in full, in which these quality requirements are organisationally regulated.

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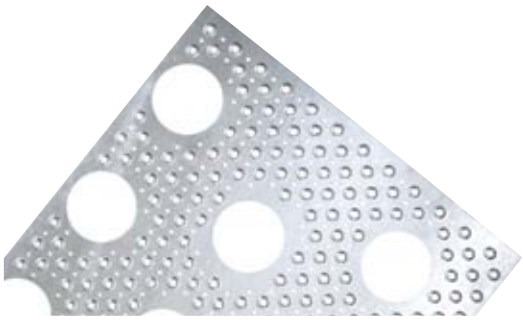
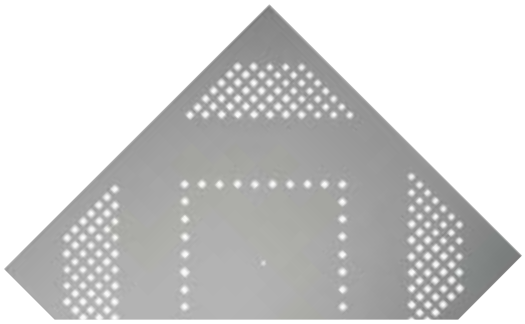
Punching / nibbling/ lasering

For flexibility during stamping, a CNC-controlled punching, nibbling and lasering machine is indispensible. It offers the perfect combination of many sheet metal preparation steps.

Round perforations, square perforations, threads, beads, lasering free shapes, engraving, centre punching, countersinking, stamping of numbers and letters... almost anything is possible.

Most MEISER surfaces can be applied here "on the metal". Bespoke, "One Off" production can be realised easily.





Technical data

Hydraulic high-performance punching (300 kN)

Integrated 2.5 kW laser cutter

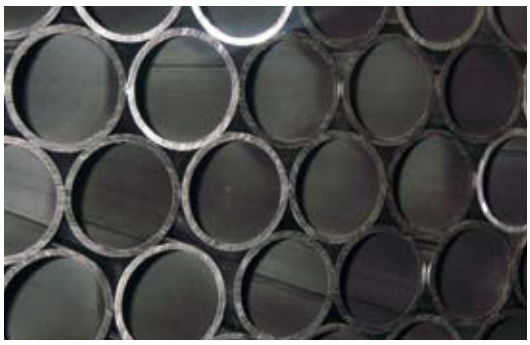
Max. sheet size:	3.074 x 1.565 mm
Punching:	8 mm
Stamping:	3 mm
Lasering:	8 mm (steel) 6 mm (aluminum) 6 mm (stainless steel)

Profiling

In comparison to a folding process, profiling gives the end product the desired shape with the aid of a set of profiling rolls in a series of steps. A quick-change cartridge system ensures very low costs for switching over between the individual products.

The individual systems of our extensive machinery are also often used in combination. For instance, a previously perforated steel strip can in a second step be given a special profile developed specifically for our customers.

With a wide variety of profiling machines, MEISER produces welded pipes, vineyard fence posts, sheet metal profiles, surrounds, crash barriers, solar profiles and much more.



Dimensions of the welded steel profile tubes:

Round tubes (D/mm)	26,9 60,0	33,7 60,3	38,0 63,0	42,4 76,1	44,5 88,9	48,3 101,6	51,0 114,3	57,0 127,0
Profile tubes (a x b) (mm)	30 x 30 35 x 35 40 x 20 40 x 40	50 x 30 50 x 50	60 x 30 60 x 40 60 x 60	70 x 30 70 x 70	80 x 40 80 x 60 80 x 80	90 x 70	100 x 40 100 x 100	
Wall thickness (t)	1.5 – 5.2 mm							
Tube lengths (L)	500 – 12.000, other lengths on request							
Length tolerance	- 0 / + 50 mm							
Steel grades	Standard S 235 JRH, others on request							
Packaging	Hexagonal bundles / rectangular packages or as required							
Production to DIN Standard	1615	1626 / 2458	2440	2440 / 2394 / 2395				
Production to EN Standard	EN 10217 – 1	EN 10219 – 1 + 2	EN 10255	EN 10305 – 3 + 5				

Internal Deburring

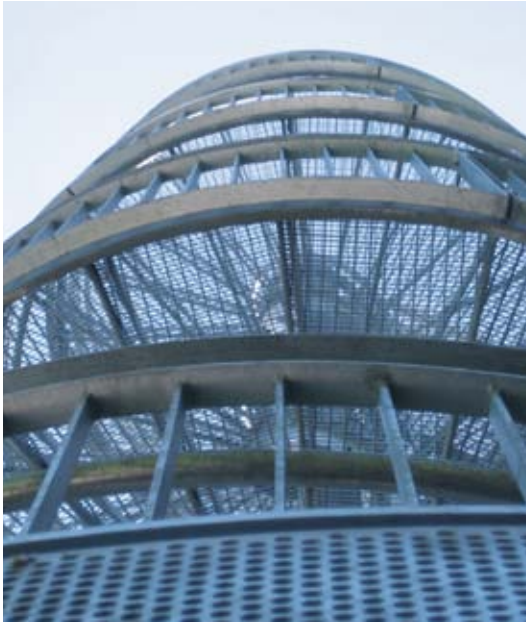
Round tubes (D/mm)	33,7 57,0	38,0 60,0	42,4 60,3	44,5 63,5	48,3 76,1	51,0 88,9
Square tubes	30 x 30	35 x 35	40 x 40	50 x 50	60 x 60	70 x 70
Rectangular tubes	40 x 20 60 x 40	50 x 20 70 x 30	50 x 30 80 x 40	60 x 30 80 x 60		

Rolling and coiling

As part of our stair production service we also have the option of rolling flat steel bars and sheet metals for staircase stringers on our 4-roll bending machine.

MEISER can also bend pipes, flat-rolled steels and square pipes with our own pipe-bending machines. With our additional coiling unit, we can coil pipes for handrails in a wide variety of diameters and pitches.

Our machines provide outstanding bending quality and minimum set-up effort.



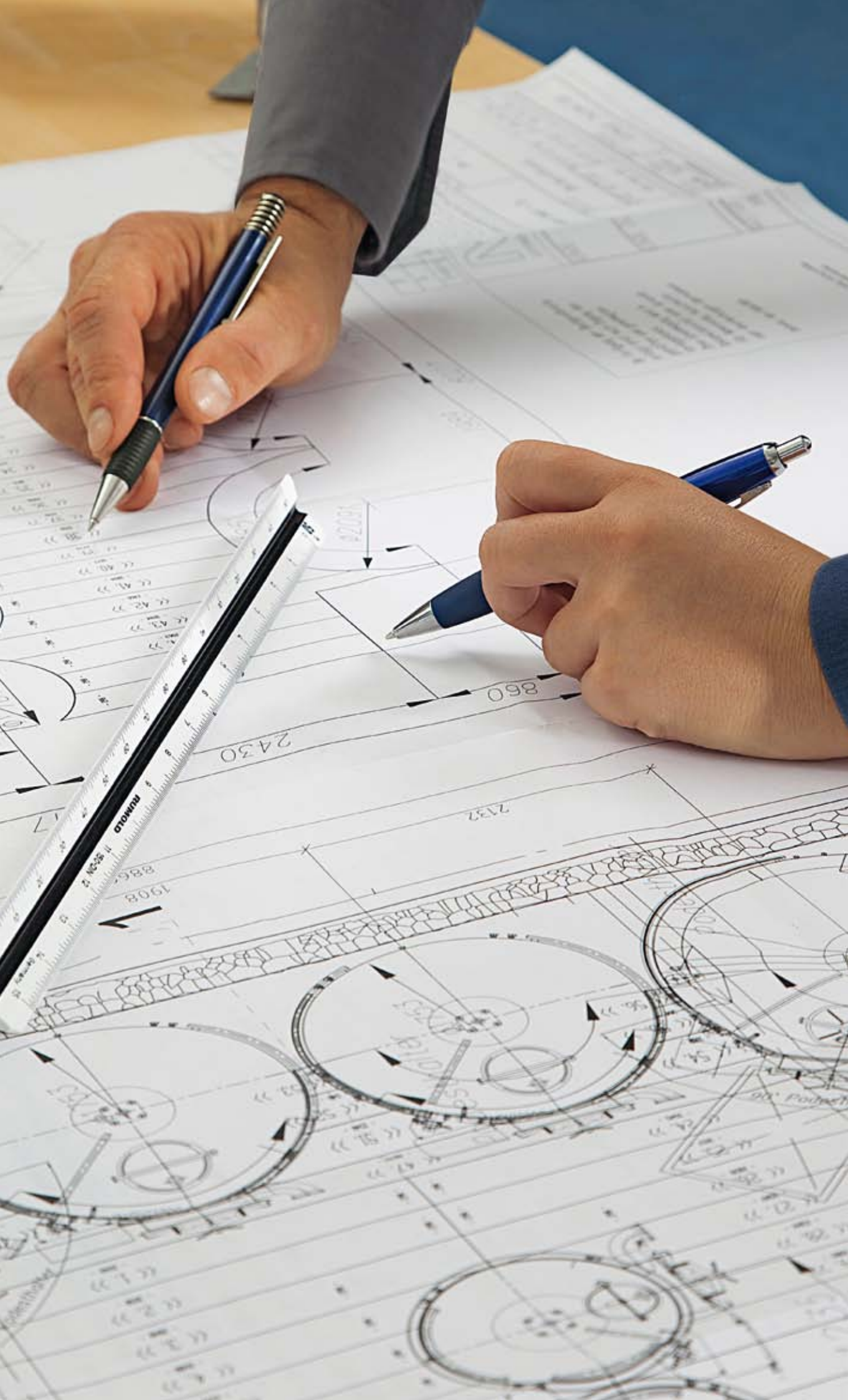
Technical data, 4-roll bending machine

Roll diameter	375 mm
Material thickness	30 mm width up to 800 mm
	18 mm width up to 2.000 mm

Technical data, pipe-bending machine

Roll diameter	150 mm
Pipes	Diameter up to 60.3 mm
Flat-rolled steels	Width up to 50 x 5 over high edge
Square pipes	Sizes up to 60 x 60 x 5

The smallest bending diameter will depend on the diameter and wall thickness of the respective profile.



Technology

Benefit from our years of experience in developing and planning processed sheet metal parts and modules (often in combination with other products from our portfolio) and enjoy the advantages these synergies give.

From individual part production to large-scale series production, our modern machinery is at your disposal. Our trained employees would be glad to carry out feasibility analyses and draw up an initial calculation of costs for you. For this we have the most up-to-date tools such as ERP, CAD and CAM systems. We can work with DXF, DWG, IGES, STEP, CATIA V5, Pro-ENGINEER, SAT, Solid-Works and UGS-NX files.

Send us your ideas, jobs or queries (preferably in DXF or DWG format), and we will be glad to help you.

Test us!

Service

To MEISER, service means looking after the wishes of its customers. We are happy to advise you and to ensure that you receive high quality products at all times.

This begins with us providing you with all the necessary technical documentation in the form of calculation tables, construction details and tender texts etc.

We offer you a wide-ranging, individual planning service in cooperation with our local partners.

For you, this means:

- Advice regarding technical execution, standards and regulations
- Production of statics calculations
- Development of customer-specific special solutions
- Quality assurance is a matter of course for us.

Product range

Other MEISER products:

Gratings

Profile Planking

Stairs

GRP floor systems

Profile tubes

Wooden beams

Fences

Steel processing

Galvanising

Would you like more information?
Ask or our product brochures or visit us online:

www.meiser.de
e-mail: info@meiser.de

Production sites

Germany
Gebr. MEISER GmbH
Edmund Meiser Straße 1
D-66839 Schmelz-Limbach
Tel +49 (0) 68 87 - 3 09-0
Fax+49 (0) 68 87 - 3 09-3000
E-Mail info@meiser.de

MEISER Vogtland OHG
Am Lehmteich 3
D-08606 Oelsnitz
Tel +49 (0) 37 421 - 50-0
Fax+49 (0) 37 421 - 50 2120 E-Mail info@meiser.de

Egypt
Hady MEISER Egypt
for Bar grating production S.A.E.
6, Ramo Buildings/Nasr Road
AE-Nasr City, Cairo
Arab Republic of Egypt
Tel +202 (0) 41 51 485
Fax+202 (0) 29 10 702
E-Mail mmeiser@link.net

Belgium
FAMECO S.A.
Rue Pelé-Bois 4
B-4590 Ouffet
Tel +32 (0) 86 36 64 31
Fax+32 (0) 86 36 64 33
E-Mail sales@fameco.be

Brazil
MARANGONI-MEISER
Pisos Metálicos Ltda.
Avenida João Pinto, 1017
Parque da Empresa
CEP 13803-360 Mogi Mirim - SP BRASIL
E-Mail info@meiser-brasilcom.br
www.meiser-brasil.com.br

France
MEISER SARL
Avenue de la Ferme du Roy
BP 80013
F-62401 Béthune Cedex
Tel +33 (0) 32 16 47 543
Fax +33 (0) 32 16 47 542
E-Mail bethune@meiser.fr

Marocco
MEISER EGL SARL
Zone industrielle sud ouest – Lot 118
MA-Mohammedia
Tel + 212 523 31 29 48
Fax + 212 523 31 29 45
GSM+ 212 661 18 16 19
E-Mail meiseregl@meiser.ma

Turkey
Kartal MEISER
Izgara Üretim Ltd. Şti.
Istanbul Yolu 30. km
Kartal Cad. No: 9
06980 Sarayköy Kazan/Ankara
Tel +90 (0) 312 815 43 22
Fax+90 (0) 312 815 52 23
E-Mail info@kartalmeiser.com

Hungary
MEISER Ferroste
Papirgyári ut 13
H-2400 Dunaújváros
Tel + 36 (0) 25 511 100
+ 36 (0) 25 511 012
Fax + 36 (0) 25 501 870
E-mail ferroste@ferroste.hu

UAE
Lionweld MEISER LLC
DUTCO Compound
Jebel Ali Industrial 2
DUBAI
United Arab Emirates
Tel +971 (0) 48 80 11 25
Fax +971 (0) 48 80 11 99
E-Mail info@lionweldmeiser.com

Offices

Algeria
MEISER Algerie SARL
Hay Benghazi "B" n° 424,
Baraki - Alger Algérie
Tel/Fax +213 21 76 26 84
Mobil +213 66 15 03 552
E-Mail m.kadri@meiser.dz

Bulgaria
MEISER Bulgaria EOOD
Rajko Zsinzifov ulica No 20,
vh. B, ap 19. / BG-Sofia
Tel +35 (0) 92 95 46 771
Fax +35 (0) 92 95 46 771
E-Mail meiser@abv.bg

Finland
Finnritilä Oy
Satamakatu 8
74120 Iisalmi
Finland
Tel +358 17 821 3800
Fax+358 17 821 3822
Sähköposti:
timo.koivistoinen@finnritila.com
www.finnritila.com

UK
MEISER UK Ltd
1B Poplar Road
Broadmeadow Industrial Estate
GB-Dumbarton G82 2RD
Scotland
Tel +44 (0) 13 89 76 50 00
Fax +44 (0) 13 89 76 11 66
Potto Office:
Tel +44 (0) 1642 701510
Fax +44 (0) 1642 701791
Mob +44 (0) 7823 322 456
E-Mail info@meiser.co.uk

Netherlands
RST MEISER Nederland BV
Goudsesingel 98
NL-3011 KD Rotterdam
Tel +31 (0) 10 23 31 300
Fax +31 (0) 10 41 47 847
E-Mail info@rstmeiser.nl

Agencies

Austria
MEISER Österreich GmbH
Anton-Hubmann-Platz 1
8077 Gössendorf
Fax +43 (0) 03135 - 409 53
E-Mail office@meiser.at

Poland
MEISER Polska Sp. z o.o.
ul. gen. Maczka 41
43-300 Bielsko Biała
Tel +48 33 755 23 85
Fax+48 33 755 23 87
E-Mail biuro@meiser.pl
www.meiser.pl

Romania
MEISER Romania S.R.L.
RO-3700, Oradea
Str. Henri Coanda Nr. 13
Bl. PC 23 Ap. 2 Romania
Tel +40 (0) 25 94 70 621
Fax +40 (0) 25 94 70 621
E-Mail meiser@rdslink.ro

Sweden
MEISER AB
Box 8778
SE-402 76 GÖTEBORG
Tel +46 (0) 10 - 4 58 00 00
Fax +46 (0) 31 - 55 40 51
E-Mail info@meiser.se

Switzerland
PMI MEISER Gitterroste AG
Schlüechtistrasse 6
CH-8104 Weiningen ZH
Tel +41 (0) 44 75 17 051
Fax +41 (0) 44 75 17 055
E-Mail info@meiser.ch

Spain
MEISER Rejillas Hispania S.L.
Poligono Industrial Cabezo Beaza
Avenida Luxemburgo s/n
Centro Empresarial Cartagena Plaza,
Planta 1a - Local 1,4
30353 Cartagena (Murcia)
Tel + 34 868 06 66 56
Fax + 34 868 06 66 56
E-Mail info@meiser.de

Estonia
Metal Disain Ltd
Suur-Sõjamäe 10,
EE-11415, Tallinn
Tel +372 (0) 61 01 150
+372 (0) 68 39 023
Fax +372 (0) 61 01 130
+372 (0) 68 39 021
E-Mail metaldis@metaldis.ee
www.metaldis.ee

Denmark
SEMITECH A/S
Reskavej 1
DK-4220 Korsør
Tel +45 (0) 57 52 75 75
Fax +45 (0) 57 52 75 77
E-Mail email@semitech.dk
www.semitech.dk

Croatia
MASERVICE-VRBOVEC d.o.o.
Gradecka ul. 33.
HR-10340 Vrbovec
Tel +385 (0) 12 791 - 609
Fax +385 (0) 12 791 - 884

Lithuania
UAB Morionis
Joint stock company Ltd.
Kestucio g.54
LT-3000 Kaunas
Tel +37 (0) 37 20 32 10
Fax +37 (0) 37 20 32 17
E-Mail morionis@takas.lt

Norway
NTJ AS
Melsomvikveien 3,
Postboks 113
N-3161 Stokke
Tel +47 (0) 33 30 58 30
Fax +47 (0) 33 30 58 31
E-Mail ntjas@ntj.no

Slovenia
METALnet
BENKO-Tehna Puconci d.o.o
Puconci 403
9201 Puconci
Tel +386 (0) 2 54 59 650
Fax +386 (0) 2 54 59 656
E-Mail: info@metalnet.si

South America
CUÑADO COLOMBIA
Centro histórico, plaza de la aduana edificio andian oficina 605
Cartagena **Kolumbien**
Tel (575) 660 0025
E-Mail mcaicedo@cunadousa.com

CUINTER
C/ Juan de la fuente nº334
Comuna de Lampa–Santiago-**Chile**
Tel + 56 2 27 47 11 47
Fax + 56 2 27 47 11 12
E-Mail mail@cunado.cl

CUMEX
León tolstoi, 18
Despacho 301, Col. Nuevas Anzures 11590 - **México** D.F.
Tel 00 525 55 255 27 83
Fax 00 525 55 255 26 81
E-mail cumex@prodigy.net.mx

CUPERSA
Centro Empresial Peruano Suizo,
Av. Aramburu 166, Oficina 2B -
Miraflores, Lima 18 - **Perú**
Tel +51 1 416 6200
Fax +511 421 0700
E-mail info@cupersa.com

CUVENSA
Avda. Norte Sur EM 1, Parcela L-161
Parque comercial Ind. Castillito
Edo. Carabobo, Valencia - **Venezuela**
Tel 00 58 241 87 17 810
Fax 00 58 241 87 17 623
E-mail finanzas@cuvensa.com

USA
I.T.F.
2825 Wilcrest Suite 161,
77042 Houston, Texas
Tel 713 952 4111
Fax 713 952 4777
Email: itfinc@cunadousa.com

Central America
CRIBAS Y TAMICES INTERVENISPA, S.L:
Crta. Sentmenat 48-50, Nave F
08213 Polinyá (Barcelona) - España
Tel +34 93713 51 96
Fax +34 93 713 16 36
E-Mail info@intervenispa.com
www. intervenispa.com

rachel-mrosek.de