



ЗММ СТОМАНА АД  
СИЛИСТРА БЪЛГАРИЯ

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# ZMM STOMANA AD

ISO - 9001 : 2015

ISO – 14001 : 2015





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## ABOUT US:

### *ZMM STOMANA AD:*

- ✓ Established in 1945 in the town of Silistra, Bulgaria.
- ✓ 300 Employees
- ✓ Manufactures woodworking machines of different types: multi-operational machines, jointer-surface planers, thickness planers, drilling machines, circular saws, milling machines, band saws, lathes, edge and band sanding machines, edge banding machines, dust collection systems.
- ✓ Casting foundry with a covered production area of 8000 m<sup>2</sup>.
- ✓ Production, development and optimization of castings made of ferrous and non-ferrous alloys.
- ✓ Capacity of liquid metal 2400 t/year.
- ✓ Cast iron capacity - 2000 kg.

# METAL CASTING

## Iron-carbon alloys:

- Grey cast iron
- Ductile cast iron



## Non-ferrous alloys :

- Aluminum alloys



## PRODUCTION CAPACITY (Liquid Metal)

➤ *Two middle frequency induction furnaces INDUCTOTHERM (system POWER TRAK) of:*

1) 2000 kg max. capacity

2) 2000 kg max. capacity



Melting capacity  
2000kg/h

Annual production of molten metal about 2400 t





## CASTING IN BENTONITE-BONDED MOLDS - I

- Molding conveyor – for 110 molding boxes;
- Press molding machines FOROMAT 20 with molding boxes 600x500x200/200 mm.;
- Press molding machines FOROMAT 30 with molding boxes 820x630x250/250 mm.;
- Press molding machines FOROMAT 40 with molding boxes 1000x800x200/200mm.;
- Pneumatic (manual) ramming – with molding boxes max. dimentions - 3000/2000/500 mm

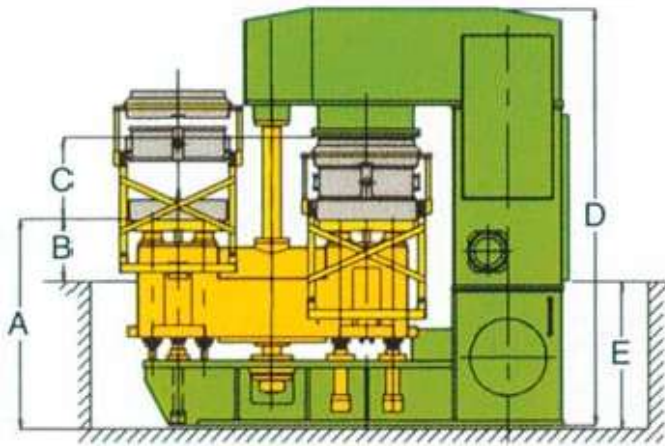




## CASTING IN BENTONITE-BONDED MOLDS - II

### *The most advanced casting technology in bentonite molds*

- The company applies the most advanced technology for obtaining bentonite molds with an automatic molding line and HSP-1 machine. **HSP-1** is working on the principle of SEIATSU type air impulse (shooting) and subsequent squeeze compaction. The equipment is produced by **Heinrich Wagner Sinto – Germany**.
- Box dimensions – 670x550x200/200 mm.





## No-Bake MOULDING

*One of the most advanced technologies with No Bake process*

- The company applies one of the most advanced technologies for mould production - **Furan-No Bake**;
- The equipment is manufactured by **Omega** – GB and is made for large size moulds up to 2 t;
- Whole process cycle of almost waste-free production and regeneration;
- Box dimensions:

max. 3000x2000x500/500 mm.







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# PRODUCTION OF FOUNDRY CORES AND GAS-HARDENING OF CORE MOLDS

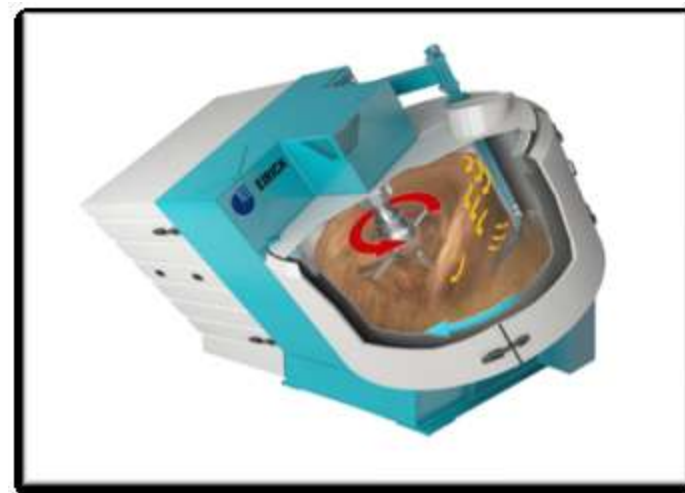
*Most advanced technology for production of moulds and cores*

- Most advanced technology for moulds and cores - **Fenol-CO<sub>2</sub>** , **Cold Box** ;
- Machine **LL20** manufactured by **Laempe-Mösner-Sinto GmbH, Germany**;
- Cores up to 40 kg, of high complexity and accuracy;
- Boxless moulds up to 50 kg; high complexity of the geometry and possibility for pack and store moulding.





*Most advanced technology for preparation of mixtures for bentonite molds*



- The company has the most advanced technology **EVACTHERM** for preparation of bentonite mixtures by using of an intensive vacuum mixer **RV11VAC**, manufactured by **EIRICH GmbH – Germany**.
- All functions are combined in one device: final fragmentation, cooling, mixing, homogenizing and control;
- Automatic sampling for measurement of the physical and mechanical properties of the mixtures;
- Standard mixer **AMK-2000H** for preparation of sand-bentonite mixtures



## THERMAL PROCESSING

### ➤ *Facilities for thermal treatment*

1. Electric furnace 1000x1500x1000, (64 kW) up to 1100 °C – two pieces
  2. Electric furnace 1600x2400x1500, (315 kW) up to 850 °C
- Precise control of temperature and time;
  - Tempering media – water, oil, forced air.





## CLEANING AND FINE PROCESSING

### ➤ *Surface cleaning machines*

- electric and pneumatic angle grinders
- shot blasting cleaning machine H12x18,5, manufactured by **STEM, Slovenia** – for castings up to 500 kg.
- shot blasting machine **КДД -10** (with a rotating table) for castings up to 2 t



# QUALITY CONTROL



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## *Express chemical analysis of the raw metal*

### ➤ *Device for express spectral analysis - SPECTRO MAX*

- alloys – based on Fe
- 32 elements per channel
- $10^{-4}$  measurement accuracy





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## NON-DESTRUCTIVE TESTING

### *Non-destructive testing*

✓ *Stationary and mobile device for hardness measurement (HRC, HRB)*



*Quality System : ISO 9001:2015*



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## DESTRUCTIVE TESTING

### *Desturctive testing*

- *Devices for physical and mechanical tests of tension and compression -WPMA*





## CASTING TYPES

- Transport engineering;
- Hydraulics - valves and pumps;
- Gears, bearing housings, crankshafts;
- Heat resistant plates, shields;
- Industrial armature – spherical, shutter fittings, butterfly;
- Industrial elements;
- Wear resistant parts  
- fingers, housings, armors;
- Shock hammers;







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## REFERENCE LIST

### MARKETS

Over 95% of the company's output is purposed for export.

The company has long-standing commercial relations with contractors from Germany, Austria, Spain, the Netherlands, France, Belgium, Norway, Hungary, Romania, Macedonia, Greece, USA, Russia, Ukraine, Sri Lanka, South Africa, United Arab Emirates, Saudi Arabia, Israel, Latvia, Argentina, etc.



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## COMPANY POLICY

### ZMM STOMANA AD:

- *The company is a modern and dynamic developing enterprise which maintains a high level of responsibility towards the needs of its customers;*
- *Our aim is to ensure highest quality, adherence to delivery times, and mutually beneficial prices;*
- *Our goal is that the manufactured products meet all the technical requirements of the customer. We advise our customers on optimization of casting to increase their efficiency by reducing metal consumption and then using mechanical processing;*
- *Our main belief is that your satisfaction is our success.*



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