



## THE PROFILING COMPANY

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## LWN 65

## Performance - Line

The external whirling machine LWN 65 is especially designed for workpieces produced in high quantity. The dwell times will be reduced to a minimum by a high tool life time as well as a short set up time. The machine can be equipped with a workpiece specific automatic loading and unloading unit.

### Performance Features

- short set up time
- high tool life time
- user-friendly
- dry cutting

### Workpieces



- *small gear worms*
- *bone screws (cortical screws, cancellous screws)*
- *special profiles*



## Technical Data

<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 15 mm
Spindle nose	4
Resolution of the C-axis	± 0.01 °
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>External whirling unit AWS</b>	
Through-hole (without tooling)	ø 65 mm
Speed range	1,500 - 6,000 rpm
Drive type	Spindle - motor
Power max.	1.9 kW
Helix angle adjustment (A-axis)	-2 ° / +22 °
Positioning accuracy	± 0.001 °
<b>Workpiece</b>	ø 4 - 15 mm
<b>Machining length (max)</b>	250 mm

## LWN 90

## Performance - Line

The external whirling machine LWN 90 allows finish machining of the workpieces based in the high profile and pitch accuracy. In interaction with the patented tooling system workpiece surfaces in grinding quality can be achieved. An integrated workpiece specific automatic loading and unloading device can complete the machining solution.

### Performance Features

- finish machining
- high tool life time
- hard and soft machining
- dry cutting

### Workpieces



- *EPS worms*
- *gear worms*
- *steering worms*
- *rack & pinion*
- *special profiles*



## Technical Data

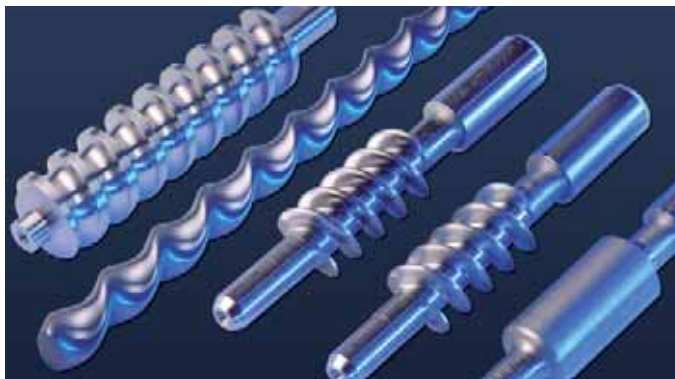
<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 50 mm
Spindle nose	5
Resolution of the C-axis	± 0.01 °
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>External whirling unit AWS</b>	
Through-hole (without tooling)	ø 90 mm
Speed range	1,000 - 4,000 rpm
Drive type	Spindle - Motor
Power max.	5.5 kW
Helix angle adjustment (A-axis)	-2 ° / +22 °
Positioning accuracy	± 0.001 °
<b>Workpiece</b>	ø 10 - 50 mm
<b>Machining length (max)</b>	350 mm

The external whirling machine LWN 120 is designed for universal use and fulfills highest requirements. The automatic tool changer enables unattended operation and reduces the dwell times to a minimum. This means highest efficiency and productivity for the production. Integrated workpiece pallets for the optimized deposit of the workpieces. The machine is laid out for high speed cutting (up to 10.000 rpm) due to a new designed and patented Torque-Motor. Almost all profiles could be produced due to the high swivelling angle ( $\pm 45^\circ$ ).

## Performance Features

- hard and soft whirling
- automatic tool changer
- high swivelling angle of the whirling unit
- wet and dry machining
- high speed cutting

## Workpieces



- gear worms
- EPS worms
- module worms
- small eccentric screws
- mini ball-screws
- small pump screws
- bone screws



## Technical Data

<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 50 mm
Spindle nose	5
Resolution of the C-axis	± 0.01 °
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>External whirling unit AWS</b>	
Through-hole (without tooling)	ø 85 mm
Speed range	1,000 - 10,000 rpm
Drive type	Torque - Motor
Power max.	8.0 kW
Helix angle adjustment (A-axis)	± 45 °
Positioning accuracy	± 0.001 °
<b>Workpiece</b>	ø 10 - 50 mm
<b>Machining length (max)</b>	500 mm (with tailstock)
	800 mm (without tailstock)

## LWN 160

## Performance - Line

The external whirling machine LWN 160 allows finish machining of the workpieces based in the high profile and pitch accuracy. In interaction with our patented tooling system workpiece surfaces in grinding quality can be reached. Optional a workpiece specific loading and unloading device can complete the machining solution.

### Performance Features

- finish machining
- high tool life time
- hard and soft machining
- dry cutting

### Workpieces



- ball-screws
- gear worms
- eccentric screws
- plasticizing screws
- special profiles



## Technical Data

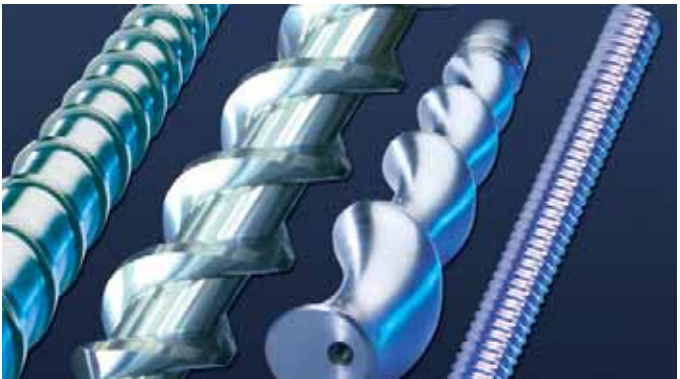
<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 94 mm
Spindle nose (for chuck acc. DIN 55026)	8
Resolution of the C-axis	± 0.01 °
<b>Follower rests</b>	
Stroke max.	80 mm
Clamping range	ø 10 - 100 mm
Steady rest jaw sets	3
Clamping force	800 - 8,500 N
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	< 0.002 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	< 0.002 mm
<b>External whirling unit AWS</b>	
Through-hole (without tooling)	ø 196 mm
Speed range	570 - 2,100 rpm
Drive type	Spindle - Motor
Power max.	12 kW
Helix angle adjustment (A-axis)	-20 ° / +30 °
Positioning accuracy	± 0.07 °
<b>Workpiece</b>	ø 10 - 100 mm
<b>Machining length</b>	to customer`s spec.

In the area of heavy cutting operations the LWN 190 is the best possible solution for the machining of eccentric screws resp. progressive cavity pumps (PCP), plasticizing screws and ball-screws. The LWN 190 is designed on a modular base and offers the customers a maximum of flexibility and efficiency for the production. The machine is designed as a whirling machine for high precision machining operations of ball-screws with a diameter up to 125 mm and a customized length.

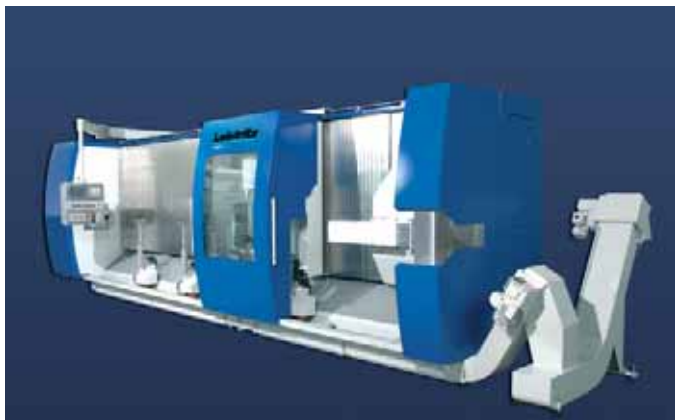
## Performance Features

- extremely high chip removal rates
- new spindle drive system
- whirling and milling in one setting
- thermal stability
- dry and wet machining

## Workpieces



- *screw pump rotors*
- *plasticizing screws*
- *single and multi-lobe progressive cavity pump rotors*
- *ball-screws*
- *special profiles*



## Technical Data

<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 104 mm
Spindle nose (for chuck acc. DIN 55026)	ø 120 mm
Resolution of the C-axis	± 0.01 °
<b>Follower rests</b>	
Stroke max.	80 mm
Clamping range	ø 15 - 125 mm
Steady rest jaw sets	3
Clamping force	800 - 8,500 N
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	± 0.0025 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>External whirling unit AWS</b>	
Through-hole (without tooling)	ø 190 mm
Speed range	600 - 4,500 rpm
Drive type	Torque - Motor
Power max.	16.5 kW
Helix angle adjustment (A-axis)	± 50 °
Positioning accuracy	± 0.07 °
<b>Workpiece</b>	ø 15 - 125 mm
<b>Machining length</b>	to customer`s spec.

In the area of heavy cutting operations the LWN 300 is the best possible solution for the machining of eccentric screws resp. progressive cavity pumps (PCP), rotors (positive displacement motors) for the oil industry and large ball-screws. The LWN 300 is designed on a modular base and offers the customers a maximum of flexibility and efficiency for the production. The machine is designed as a whirling machine for high precision machining operations of large ball-screws with a diameter up to 200 mm and a customized length.

### Performance Features

- extremely high chip removal rates
- new spindle drive system
- whirling and milling in one setting
- thermal stability
- dry and wet machining

### Workpieces



- screw pump rotors
- plasticizing screws
- single and multi-lobe progressive cavity pump rotors
- ball-screws
- special profiles



## Technical Data

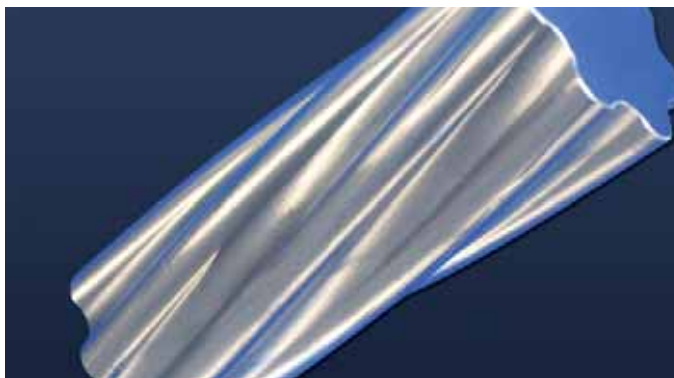
<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 130 mm
Spindle nose (for chuck acc. DIN 6353)	ø 220 mm
Resolution of the C-axis	± 0.01 °
<b>Follower rests</b>	
Stroke max.	150 mm
Clamping range	ø 40 - 200 mm
Steady rest jaw sets	3
Clamping force	800 - 8,500 N
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	± 0.0025 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>External whirling unit AWS</b>	
Through-hole (without tooling)	ø 340 mm
Speed range	250 - 1,000 rpm
Drive type	Torque - Motor
Power max.	26 kW
Helix angle adjustment (A-axis)	± 50 °
Positioning accuracy	± 0.07 °
<b>Workpiece</b>	ø 40 - 200 mm
<b>Machining length</b>	to customer`s spec.

In the area of heavy cutting operations the LWN 300 PM is the best possible solution for the machining of rotors (positive displacement motors) for the oil industry. The LWN 300 PM is equipped with a hobbing unit for the production of rotors for the oil industry or mud pumps and offers the customers a maximum of flexibility and efficiency for the production. The control of the LWN 300 will be carried out by a special developed software package with complex calculations, considering an easy operation of the machine.

### Performance Features

- extremely high chip removal rates
- new spindle drive system
- thermal stability
- dry and wet machining

### Workpieces



- *single and multi-lobe progressive cavity pump rotors*
- *single and multi-lobe rotors for downhole motors / positive displacement motors*
- *special profiles*



### Technical Data

<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 130 mm
Spindle nose (for chuck acc. DIN 6353)	ø 220 mm
Resolution of the C-axis	± 0.01 °
<b>Follower rests</b>	
Stroke max.	150 mm
Clamping range	ø 40 - 200 mm
Steady rest jaw sets	3
Clamping force	800 - 8,500 N
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	± 0.0025 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>Combined milling unit (milling/hobbing)</b>	
Tool diameter	150 - 260 mm
Speed range	120 - 800 rpm
Drive type	Spindle - motor
Power max.	22 kW
Helix angle adjustment (A-axis)	± 90 °
Resolution of A-axis	± 0.01 °
Shifting of Y-axis	180 mm / ± 90 mm
<b>Workpiece</b>	ø 25 - 250 mm
<b>Machining length</b>	to customer's spec.

## INNOVATION 200

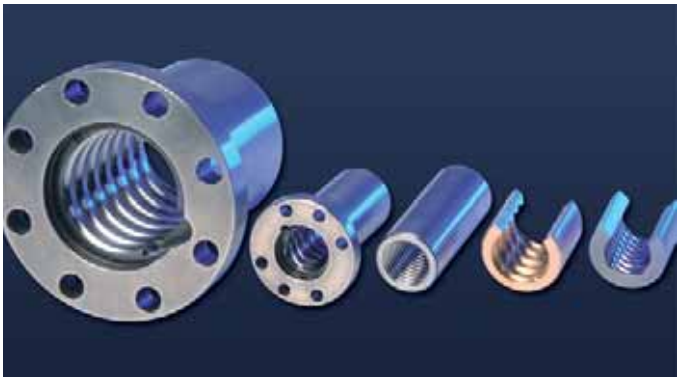
System - Line

The internal whirling machine Innovation 200 offers the possibility to produce internal profiles with complete machining and finish quality. By using the appropriate tooling hard and soft machining is possible. The machine offers highest quality and accuracy due to the rigid design.

### Performance Features

- short cycle times
- highest profile accuracy
- dynamic stiffness
- thermal stability

### Workpieces



- *ball-screw nuts*
- *internal profiles*



## Technical Data

<b>Machining range</b>	
Chuck diameter	260 mm (opt. 315)
Workpiece length max.	200 mm
Workpiece internal diameter max.	100 mm
Workpiece external diameter max.	200 mm
Axis travel X/Z	850/315 mm
<b>Internal whirling oscillator IWO 100</b>	
Max. power	11 kW
Tool arbor	HSK 40
Position sensing	with Marposs sensor and proximity switch
<b>Headstock</b>	
Headstock to DIN 55026	size 8
Max. speed	4,000 rpm
<b>Main drive</b>	
Max. power	58 kW
Full power available from shaft speed	900 rpm
Max. power	620 Nm
<b>Travel drive</b>	
High speed axis travel X/Z	45/30 m/min.
Axis force X/Z	11 kN

## COMBINATION 65 System - Line

Two proven machining processes (whirling / rolling) are combined in an unique machine line called "Combination". The originated machining center allows the production of workpieces within a short cycle time and with extremely smooth surfaces.

### Performance Features

- highest surface finish quality
- hard or soft machining operation
- shortest possible production times
- dry or wet processing capabilities

### Workpieces



- *small gear worms*
- *EPS worms*



## Technical Data

<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 15 mm
Spindle nose (for chuck acc. DIN 6353)	4
Resolution of the C-axis	± 0.01 °
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>External whirling unit AWS</b>	
Through-hole (without tooling)	ø 65 mm
Speed range	1,500 - 6,000 rpm
Drive type	Spindle - motor
Power max.	1.9 kW
Helix angle adjustment (A-axis)	-2 ° / +22 °
Positioning accuracy	± 0.001 °
<b>Workpiece</b>	ø 4 - 15 mm
<b>Machining length (max)</b>	250 mm

## COMBINATION 90 System - Line

Two proven machining processes (whirling / rolling) are combined in an unique machine line called "Combination". The originated machining center allows the production of workpieces within a short cycle time and with extremely smooth surfaces.

### Performance Features

- highest surface finish quality
- hard or soft steel machining
- shortest possible production times
- dry or wet processing capabilities

### Workpieces



- *small gear worms*
- *EPS worms*
- *steering worms*



## Technical Data

<b>Headstock (C-axis)</b>	
Spindle through-bore (may be reduced depending on chuck type)	ø 30 mm
Spindle nose (for chuck acc. DIN 6353)	5
Resolution of the C-axis	± 0.01 °
<b>Longitudinal slide (Z-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>Cross slide (X-axis)</b>	
Positioning accuracy	± 0.001 mm
<b>External whirling unit AWS</b>	
Through-hole (without tooling)	ø 90 mm
Speed range	1,000 - 4,000 rpm
Drive type	Spindle - motor
Power max.	5.5 kW
Helix angle adjustment (A-axis)	-2 ° / +22 °
Positioning accuracy	± 0.001 °
<b>Workpiece</b>	ø 10 - 30 mm
<b>Machining length (max)</b>	350 mm

## POLYJET 50

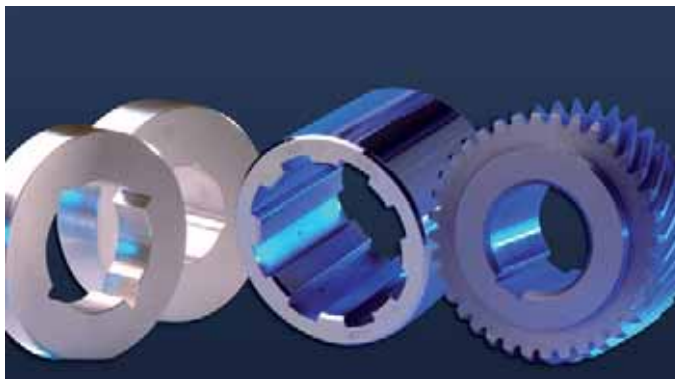
Poly - Line

The “hard” keyseating machine POLYJET 50 offers manufacturers the unique advantage of cutting keyways in hardened materials. Previously unimaginable, this machine combines the performance of complex broaching machines with the flexibility and efficiency of the well known keyseating operation.

### Performance Features

- machining of both hard and soft materials
- extremely fast cutting speeds
- maintenance free linear axis drive
- dry or wet machining

### Workpieces



- *simple keyways*
- *special internal profiles*
- *special external profiles*
- *grooves in tapered bores*
- *helical grooves*
- *special applications*

Poly - Line

POLYJET 50



## Technical Data

Cutting width	2 - 50 mm
Cutting length max.	400 mm
Cutting force	21,000 N
Workpiece weight	10,000 kg
Stepless cutting speed	0 - 120 m/min
Bore diameter to DIN 6885	10 - 300 mm

## POLYMAT NC/CNC **Poly - Line**

LEISTRITZ offers a complete product line of profile and keyseating machines, built up using a modular system. By combining a machine of a suitable size with individual components a system can be offered for each customer's specific requirements. The range of machines extends from the POLYMAT 25/300 NC to the POLYMAT 125/1500 CNC.

### Performance Features

#### 25/32 NC

- for small quantities and high flexibility
- economical solution for one-off and small batch production
- additional features as options

#### 70/100/125 CNC

- for medium and large batches
- many options
- producing of special keyways
- up to 4 controlled axes

### Workpieces



- feather keys
- internal profiles
- external profiles
- profile variants
- helical flutes
- keys in conical bores



## Technical Data NC

Cutting width	25 - 32 mm
Cutting length	300/400 mm
Cutting force	6,000 - 7,200 N
Workpiece weight	10,000 kg
Stepless cutting speed	0 - 20 m/min
Bore diameter to DIN 6885	10 - 140 mm

## Technical Data CNC

Cutting width	70 - 125 mm
Cutting length in mm	300/400/500/600/ 800 1000/1200/1250/1500
Cutting force	21,000 - 44,000 N
Workpiece weight	20,000 - 25,000 kg
Stepless cutting speed	0 - 25 m/min
Bore diameter to DIN 6885	10 - 750 mm

The profile rolling machines are built to roll high precision parts. It is our target to build the best available profile-rolling machines on the market.

The performance of the machines is excellent. LEISTRITZ provides rolling machines with automations as a package, if an even greater output is required. Setting-up and handling comfort are outstanding.

Decades of experience make profile rolling machines what they are.

<b>BHV</b>	Double-spindle machine, driven by variator One hydraulic sliding roller die head with mechanical stop
<b>BHF</b>	Double-spindle machine, driven by frequency controlled motor One hydraulic sliding roller die head with mechanical stop
<b>BHS</b>	Double-spindle machine, driven by one AC Servomotor One hydraulic sliding roller die head with mechanical stop.
<b>BCA</b>	Double-spindle machine, driven by two AC Servomotors One CNC-controlled, hydraulic sliding roller die head.
<b>CCA</b>	Double-spindle machine, driven by two AC Servomotors Two CNC-controlled, hydraulic sliding roller die heads



Product Range	BHV	BHF	BHS	BCA	CCA
LWN 70 RT	■	■		■	
LWN 120 RR		■			
LWN 120 RT		■	■	■	■
LWN 170 RT		■	■	■	■
LWN 250 RT					■
LWN 400 RT					■
LWN 630 RT					■
LWN 800 RT					■

The well established profile rolling machine built for rolling high-precision profiles and splines, designed for lower forming pressure. This machine can be supplied in different stages of extensions and is universal applicable.

### Performance Features

- compact
- wide variety of applications
- user-friendly
- excellent for automation due to expandable controllers
- applicable for profile rolling as well as for burnishing

### Workpieces



- ISO, special-, trapezoid- and acme threads
- thread-like profiles
- splines
- knurls
- burnishing
- special toothing



## Machine Data

	BHV	BCA
Rolling pressure, constant max. in kN	70	70
Roller-die-spindle diameter in mm	28	28
Roller-die diameter max. in mm	95	95
Roller-die width max. in mm	55	55
Infinitely variable speed range rpm	150	150
Sliding tool head stroke	5 (9)	65

## Process Data

	BHV	BCA
Work piece diameter max. in mm	36	36
Pitch for ISO Threads max. in mm	1.5	1.5
Pitch for ISO threads min. in mm	0.25	0.25
Diametric pitch for knurls and splines min.	0.25	0.25
Diametric pitch for knurls and splines max.	1.00	1.00
Width of profile at plunging-in mode	55	55

The economical profile rolling machine for high yield. The patented force framework guarantees highest precision and performance. The symmetrical arrangement of the ultrahigh exact, hydraulic linear axle allows an optimal flow of force. User-friendly PLC controls.

### Performance Features

- economically advantageous
- best repeat accuracy
- high flexibility to special needs
- operator convenience
- robust

### Workpieces



- ISO, special-, trapezoid- and acme threads
- thread-like profiles
- gear worms
- splines
- knurls
- special toothing



## Machine Data

	BHF	
Rolling pressure, constant max. in kN	120	
Roller-die-spindle diameter in mm	54	
Roller-die diameter max. in mm	175	
Roller-die width max. in mm	90	
Infinitely variable speed range in rpm	150	
Sliding tool head stroke	15	

## Process Data

	BHF	
Work piece diameter max. in mm	50	
Pitch for ISO Threads max. in mm	3.0	
Pitch for ISO threads min. in mm	0.35	
Diametric pitch for knurls and splines min.	0.35	
Diametric pitch for knurls and splines max.	1.60	
Width of profile at plunging-in mode	85	

High end machine, equipped with the newest generation of CNC control, highest positioning and repeat accuracy. User-friendly due to Windows-based user interface. The patented force frame guarantees high-grade precision and performance, thus an optimum accuracy of the workpieces is ensured.

## Performance Features

- suiting solution for every application
- easy integration for automation
- high output
- shortest setup time
- best repeat accuracy
- outstanding process security and availability

## Workpieces



- *ISO, special-, trapezoid- and acme threads*
- *thread-like profiles*
- *gear worms*
- *splines*
- *knurls*
- *special toothing*



## Machine Data

	120 RT	170 RT
Rolling pressure, constant max. in kN	120	170
Roller-die-spindle diameter in mm	54	54/69,85
Roller-die diameter max. in mm	175	200/210
Roller-die width max. in mm	90	130/140
Infinitely variable speed range in rpm	150	150
Sliding tool head stroke	15/105/2x55	140

## Process Data

	120 RT	170 RT
Work piece diameter max. in mm	50/48	48
Pitch for ISO Threads max. in mm	3.0	4.0
Pitch for ISO threads min. in mm	0.35	0.35
Diametric pitch for knurls and splines min	0.35	0.35
Diametric pitch for knurls and splines max.	1.60	2.0
Width of profile at plunging-in mode	85	130

The patented force framework guarantees a strain-free machine bed and thus highest precision and performance. By the consistent use of highly precise parts with the machine the highest accuracy of the workpieces is ensured.

## Performance Features

- suiting solution for every application
- easy integration for automation
- high output
- shortest setup time
- best repeat accuracy
- outstanding process security and availability

## Workpieces



- *high-precision ball-screws*
- *ISO, special-, trapezoid- and acme threads*
- *thread-like profiles*
- *gear worms*
- *splines*
- *knurls*
- *special tooling*



## Machine Data

	250 RT	400 RT
Rolling pressure, constant max. in kN	250	400
Roller-die-spindle diameter in mm	69.85	80
Roller-die diameter max. in mm	235	260
Roller-die width max. in mm	150	200
Infinitely variable speed range in rpm	150	125
Sliding tool head stroke	196	2 x 100

## Process Data

	250 RT	400 RT
Work piece diameter max. in mm	75	100
Pitch for ISO Threads max. in mm	10.0	14.0
Pitch for ISO threads min. in mm	0.35	0.50
Diametric pitch for knurls and splines min.	0.50	0.80
Diametric pitch for knurls and splines max.	2.50	3.50
Width of profile at plunging-in mode	150	200

The patented force frame with thermal decoupling guarantees a strain-free machine base and thus highest precision and performance. The consistent use of highly precise machine parts ensures the outstanding accuracy.

## Performance Features

- suiting solution for every application
- easy integration for automation
- high output
- shortest setup time
- best repeat accuracy
- outstanding process security and availability

## Workpieces



- *high-precision ball-screws*
- *ISO, special-, trapezoid- and acme threads*
- *thread-like profiles*
- *gear worms*
- *splines*
- *knurls*
- *special toothings*



## Machine Data

	630 RT	800 RT
Rolling pressure, constant max. in kN	630	800
Roller-die-spindle diameter in mm	100	100
Roller-die diameter max. in mm	300	305
Roller-die width max. in mm	300	300
Infinitely variable speed range in rpm	90	
Sliding tool head stroke	2 x 130	260

## Process Data

	630 RT	800 RT
Work piece diameter max. in mm	155	155
Pitch for ISO Threads max. in mm	18	
Pitch for ISO threads min. in mm	1	
Diametric pitch for knurls and splines min.	1	
Diametric pitch for knurls and splines max.	4	
Width of profile at plunging-in mode	300	300

## TOOLS

The design and manufacturing of all tools is done by LEISTRITZ. Thus, the customer is provided with a system solution - comprising machine and tool - from one supplier



- whirling rings
- keyseating tools
- roller dies

## TOOLS



- end finishing tools
- flat form tools
- supporting bars
- carbide milling cutters

The LEISTRITZ range of carbide metal tools is emphasised on the one hand the metal working with turning workpieces (end finishing, cut turning, thread turning and general turning) and on the other hand further processing of lathe parts (grinding rails for centerless circular grinding).

***Our high quality standards are ensured by state-of-the-art measuring technologies***

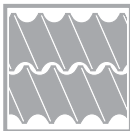
## **Leistriz** Product Range



LEISTRITZ TURBOMASCHINEN TECHNIK GMBH  
LEISTRITZ TURBINENKOMPONENTEN REMSCHEID GMBH  
LEISTRITZ ADVANCED TURBINE COMPONENTS, INC.  
Blades, Disks and Components for Turbines and Compressors



LEISTRITZ PUMPEN GMBH  
Screw Pumps and Systems



LEISTRITZ EXTRUSIONSTECHNIK GMBH  
Extruders



LEISTRITZ PRODUKTIONSTECHNIK GMBH  
Tubing Technology/Sheet Metal Forming,  
Machine Tools, Tools  
Profile Rolling Machines and Rolling Tools

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