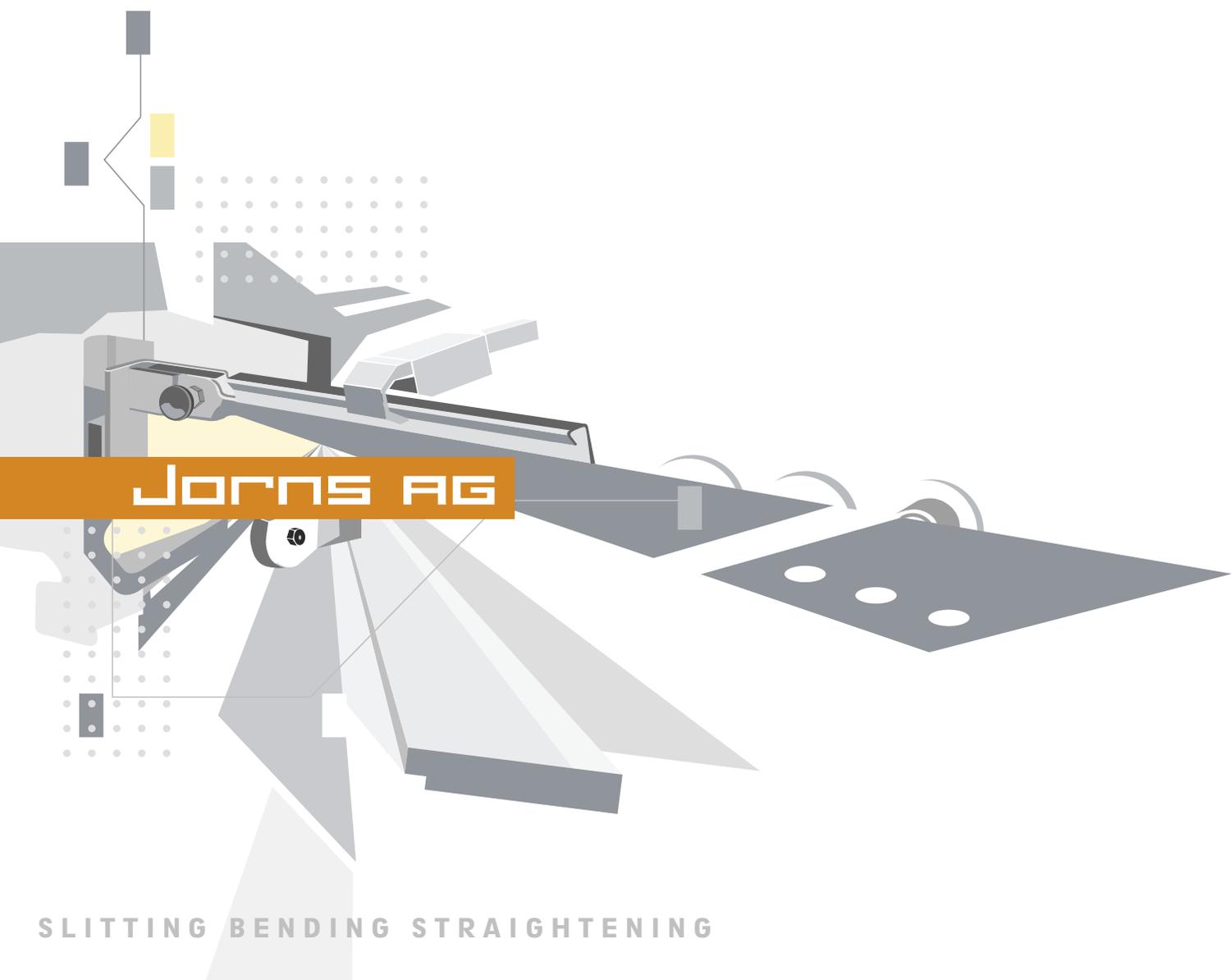
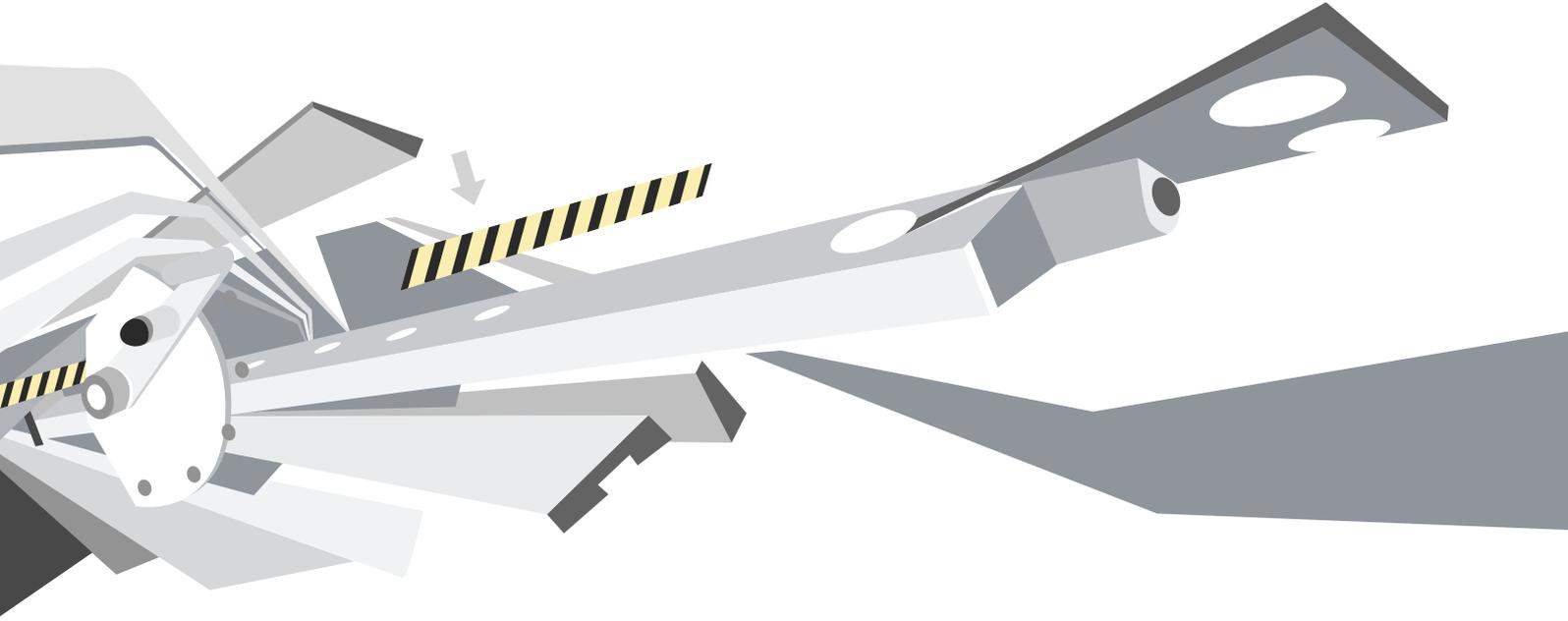


PRODUCTS LINES



Jorns AG

SLITTING BENDING STRAIGHTENING



Jorns AG has been manufacturing metal-working machines for more than thirty years. That means more than thirty years of quality and innovation.

Kurt Jorns began in 1973 with five employees. Since then the company has been steadily expanding. Today Jorns AG employs some 70 people and its turnover is growing constantly. And today Jorns AG is a global leader in the manufacture and sale of bending machines. The family-run business is now in its second generation, under the management of business administration graduate Marc Jorns. It was under his leadership that Jorns AG obtained

“We accept only those orders we know we can carry out to the full satisfaction of our clients.”

its ISO 9001:2000 certification. The 25 agencies around the world are proof positive of the enterprise’s success and quality.

This success is rooted first and foremost in our ability to innovate. Our business orientation is defined by the needs of our clients, essentially tinsmiths and hall constructors. The new products we develop reflect their requirements. That’s why metal-working plants all over the world have come to rely on our bending machines, slitting machines, decoilers and recoilers.

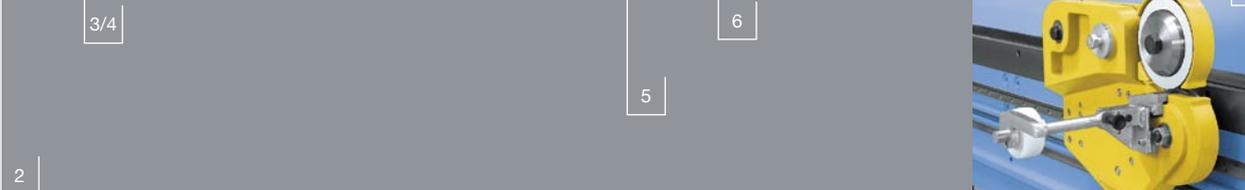
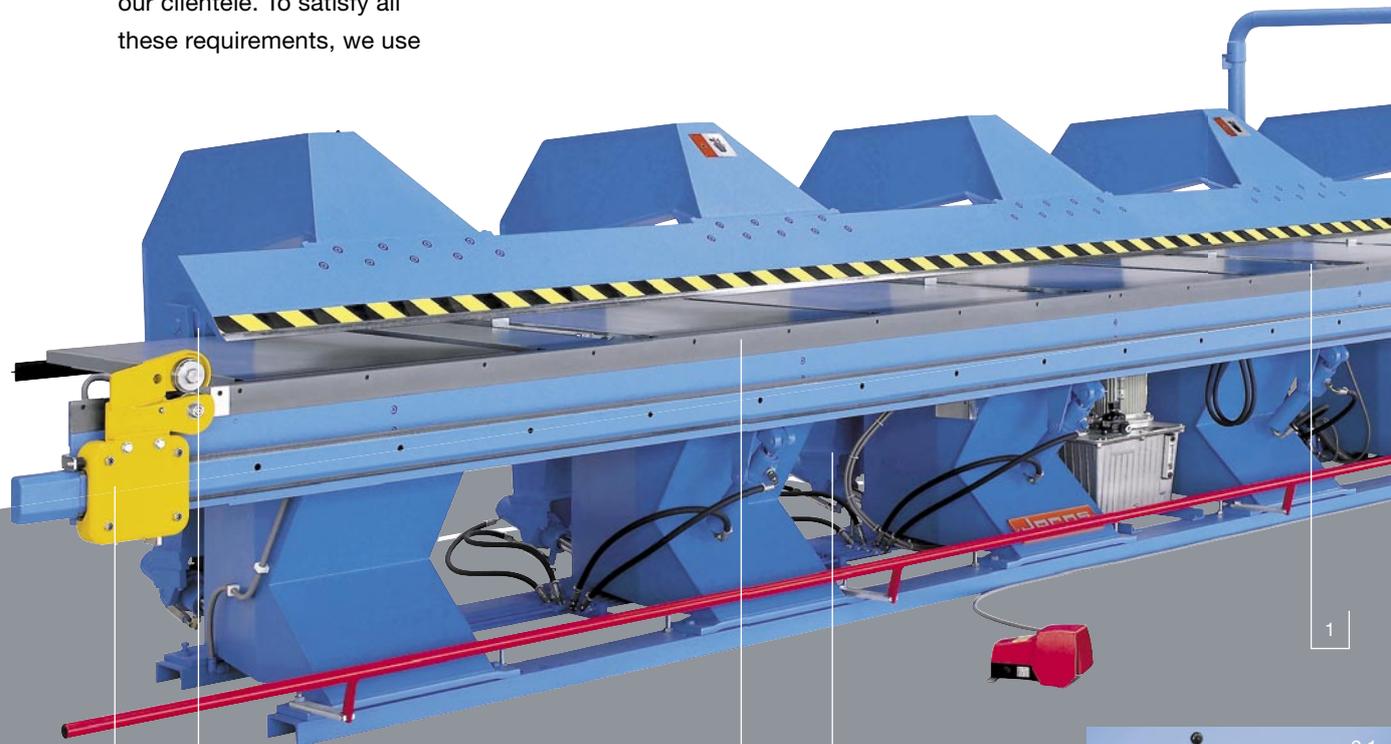
For instance: Company founder Kurt Jorns came up with the idea of designing a machine that would eliminate the time-consuming process of turning sheet metal over. Our engineers began working on the idea in 2001. A mere one year later they were able to present a prototype to the industry: the TwinMatic/TwinBend. With this product we believe we have filled yet another market gap.

MISSION

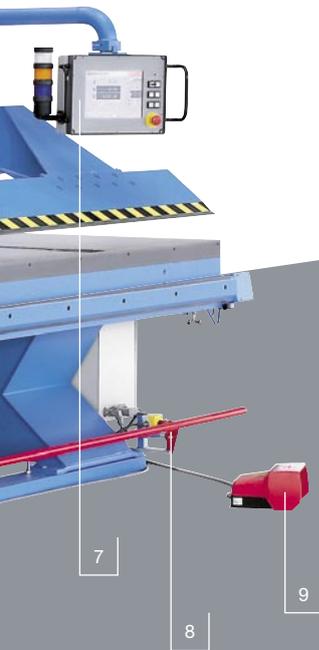
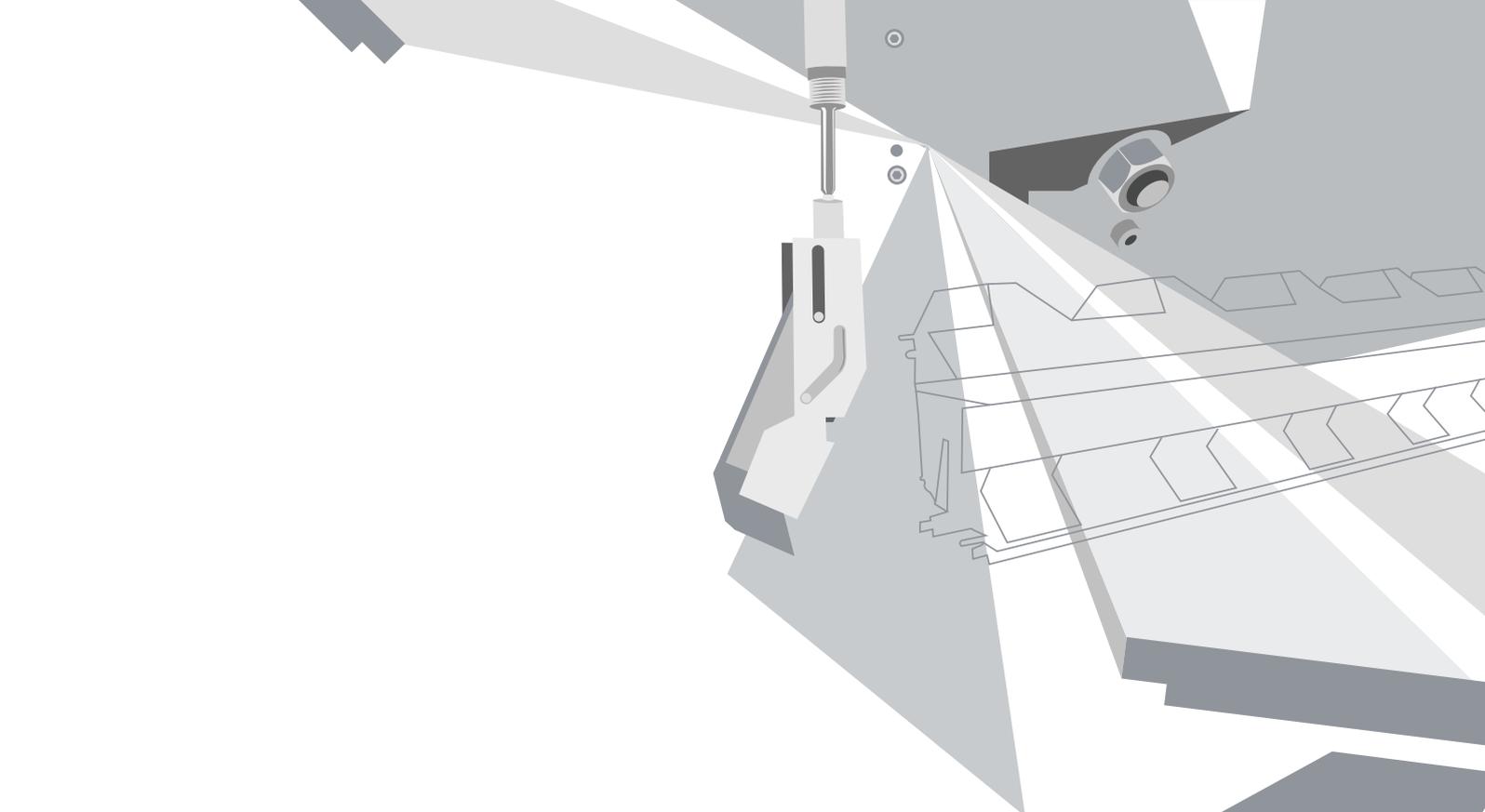
The Jorns-Line reflects the wealth of our experience, the technical applications required, the manufacturing options and the trends of the future.

The Jorns-Line will continue to set the trend for the next decade. The **Norma-Line, Maxi-Line, Super-Line** and **Multi-Line** series are consistent developments of the existing series. Our product development is driven by the ever increasing demands of our clientele. To satisfy all these requirements, we use

state-of-the-art production methods: laser technology, welding robots and CNC machining centres. In this way we create bending machine with a maximum continuous output.



2.1/2.2 Shearing machine
All our bending machines can be equipped with a cutting mechanism for 1.5 or 3 mm sheet thickness (St. 40).



1.1 Motor-driven stop, type 91, and stop fingers for machines with CNC control (standard). Measurement range: 25 – 1000 mm (1250 mm). The **manual stop, type 91**, is also available for OP control.

1.2 Spring-action finger for machines with CNC control (accessories). Measurement range: 12 – 1000 mm (1250 mm).



2.3 Profile rollers of the roll forming machine
The shearing carriage also serves as a support for the profile rollers of the roll forming machine. It is possible to use both horizontal and vertical profile rollers of the roll forming machine.

3.1/3.2 Top beam adjustment
Compensates different sheet thicknesses. Mechanical or hydraulic version, depending on the control system.

4 Top beam pretension
The top beam pretension is used to move each arm of the bending machine manually. This eliminates any torsion over and beyond the profile length.

Tight tolerances guarantee that all individual parts are easily replaceable.

Our bending machines are mounted on a frame and equipped with all the necessary levelling and fastening devices. They are driven by a modern hydraulic unit, designed according to the state of the art in linking-unit technology. Key words such as two speeds, top beam pre-tension, overload protection, bending cylinder with attenuation and pipe-break safety devices have long been part of our standard vocabulary.

The stands and arms are designed in a sturdy box-type welded design. The controls are fitted on to a swivel arm and integrate the safety stop for the top beam.



5



6.1



6.2



6.3



7.1

5 Attachment rail

All the machines can be shipped with bolted attachment rail. The offset bending table offers many advantages for profile production (e.g. 10 mm and 6 mm attachment rail only instead of a 16 mm bending beam). Horizontally and vertically displaceable sheet cassettes.

6.1/6.2/6.3 Coupling joints

The bending beam is bearing-mounted on coupling joints; depending on the series we use the K-24L, K-24S or K-28 coupling. Elegant radii and scratch-free sheet surfaces are the result of perfect lever ratios.

7.1 OP 2100 two-axis control system

with 9 memory slots (see our full brochure for more detailed information).

Series	Type	Working length mm	Feeder depth		Top beam stroke mm	Bending performance			Stands Qty/Type	Coupling Qty/Type	Bending cylinder Qty	Weight (version 1000 mm feeder depth) kg (approx.)
			Standard mm	Multi mm		Steel St-40 400 N/mm ² mm	V2A 600 N/mm ² mm	Alum. ½-hard 220 N/mm ² mm				
Norma-Line	100	6400	1000	1250	200	1.00	0.60	1.50	4 / L	4 / K-24L	2	3200
	100	8000	1000	1250	200	1.00	0.60	1.50	6 / L	7 / K-24L	3	4400
	125	4000	1000	1250	200	1.25	0.80	2.00	3 / L	4 / K-24L	2	2100
	125	6400	1000	1250	200	1.25	0.80	2.00	5 / L	5 / K-24L	3	3800
	125	8000	1000	1250	200	1.25	0.80	2.00	7 / L	7 / K-24L	4	4900
	125	10000	1000	1250	200	1.25	0.80	2.00	8 / L	9 / K-24L	5	5600
	125	12200	1000	1250	200	1.25	0.80	2.00	10 / L	11 / K-24L	6	7500
	150	4000	1000	1250	200	1.50	1.00	2.50	4 / L	5 / K-24L	3	2500
	150	6400	1000	1250	200	1.50	1.00	2.50	6 / L	7 / K-24L	4	4200
	150	8000	1000	1250	200	1.50	1.00	2.50	8 / L	9 / K-24L	5	5300
	150	10000	1000	1250	200	1.50	1.00	2.50	9 / L	11 / K-24L	6	6000
Maxi-Line	150	3000	1000	1250	200	1.50	1.00	2.50	3 / M	4 / K-24L	2	2800
	150	4000	1000	1250	200	1.50	1.00	2.50	4 / M	5 / K-24L	3	3600
	150	6400	1000	1250	200	1.50	1.00	2.50	5 / M	7 / K-24L	4	5100
	150	8000	1000	1250	200	1.50	1.00	2.50	7 / M	9 / K-24L	5	6700
	150	10000	1000	1250	200	1.50	1.00	2.50	8 / M	11 / K-24L	6	8000
	150	12200	1000	1250	200	1.50	1.00	2.50	10 / M	13 / K-24L	7	10000
	200	3000	1000	1250	200	2.00	1.50	3.00	4 / M	5 / K-24S	3	2900
	200	4000	1000	1250	200	2.00	1.50	3.00	5 / M	6 / K-24S	4	4200
	200	6400	1000	1250	200	2.00	1.50	3.00	6 / M	7 / K-24S	5	5700
	200	8000	1000	1250	200	2.00	1.50	3.00	8 / M	9 / K-24S	7	7800
	200	10000	1000	1250	200	2.00	1.50	3.00	10 / M	11 / K-24S	9	9300
	200	12200	1000	1250	200	2.00	1.50	3.00	12 / M	13 / K-24S	11	11300
	Super-Line	300	3000	1000	1250	200	3.00	2.00	4.00	4 / S	4 / K-28	4
300		4000	1000	1250	200	3.00	2.00	4.00	5 / S	5 / K-28	5	4900
300		6400	1000	1250	200	3.00	2.00	4.00	7 / S	7 / K-28	7	7000
300		8000	1000	1250	200	3.00	2.00	4.00	10 / S	10 / K-28	10	9000
300		10000	1000	1250	200	3.00	2.00	4.00	12 / S	12 / K-28	12	11400
300		12200	1000	1250	200	3.00	2.00	4.00	15 / S	15 / K-28	15	13700

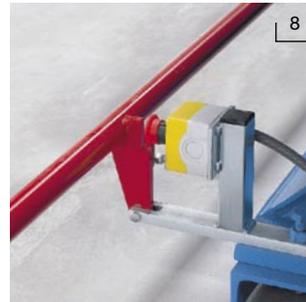
We explicitly reserve the right to effect changes and modifications to both version and function.



7.2 CNC500 touchscreen control system with colour display, automatic rear stop and graphics software (see our full brochure for more detailed information).



7.3 CNC5000 touchscreen control system with 17" TFT colour display. The control system operates with a Windows-based Pentium processor with automatic rear stop and the possibility of controlling a tapered rear stop. Included in the scope of delivery is a CAD drawing program (see our full brochure for more detailed information).



8 Emergency-Off rail
All our machines are equipped with a continuous (foot-operated) Emergency-Off rail.

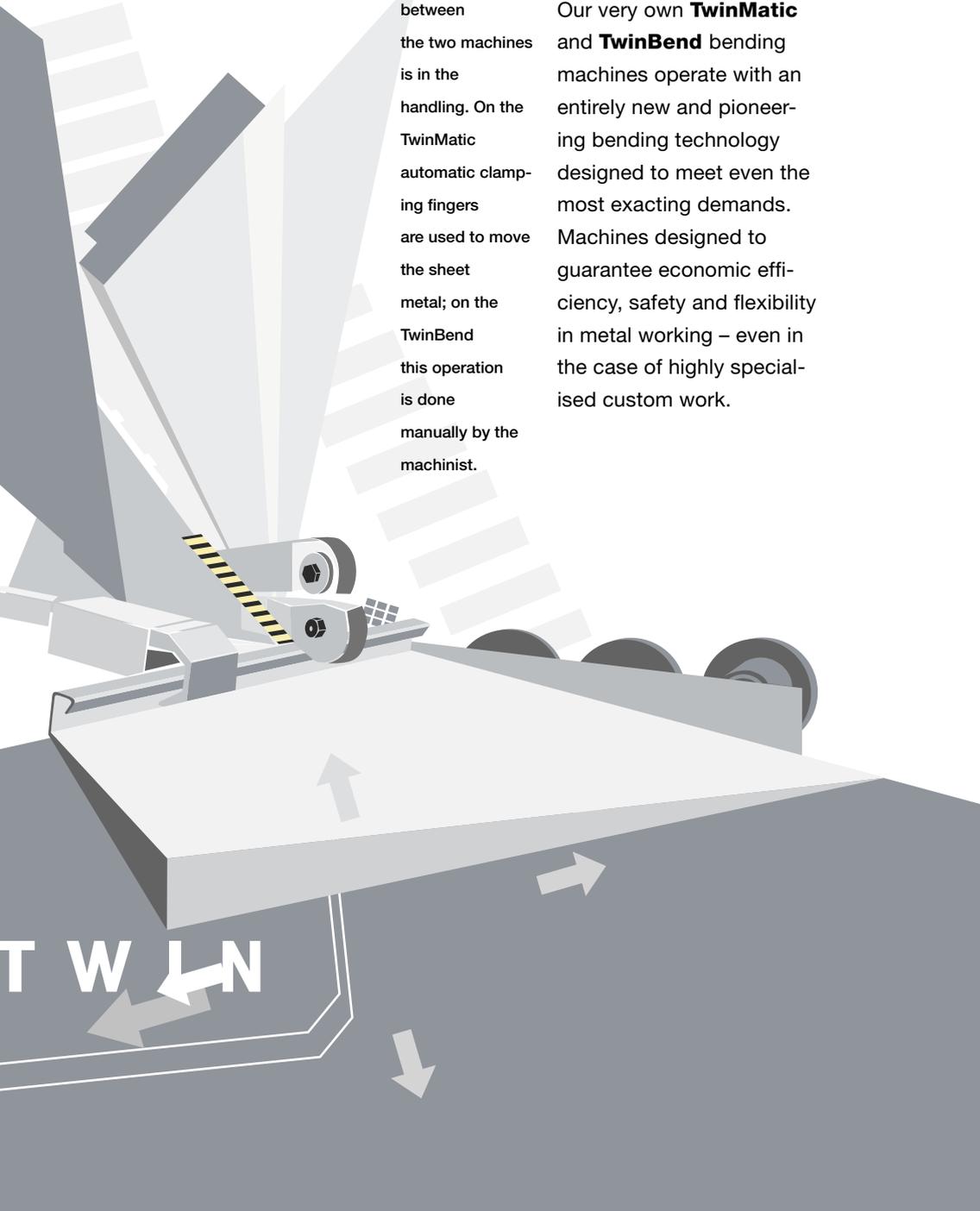


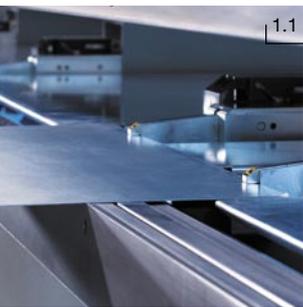
9 Dual-pedal foot control
With dual function, for very fast and convenient operation over the entire machine length.

DUALITY IN PROFILE BENDING

The main difference between the two machines is in the handling. On the TwinMatic automatic clamping fingers are used to move the sheet metal; on the TwinBend this operation is done manually by the machinist.

Duality in profile bending
Double bending is the new trend in sheet metal working. And Jorns AG is a genuine trendsetter. Our very own **TwinMatic** and **TwinBend** bending machines operate with an entirely new and pioneering bending technology designed to meet even the most exacting demands. Machines designed to guarantee economic efficiency, safety and flexibility in metal working – even in the case of highly specialised custom work.





1.1

1.1 TwinMatic finger

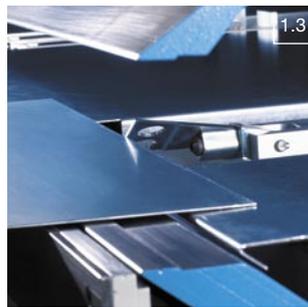
The clamping finger is capable of gripping sheet metal and, when closed, can also be used as an ordinary rear stop. Minimum shank lengths of 25 mm can be edged in this way. The travel distance is 25 mm – 1150/1300/1500 mm, at a speed of 250 mm/s.



1.2

1.2 TwinMatic finger

This clamping finger can grip folded sheet up to a flank height of 40 mm. The travel distance is 150 mm – 1150/1300/1500 mm, at a speed of 250 mm/s.



1.3

1.3 TwinBend finger

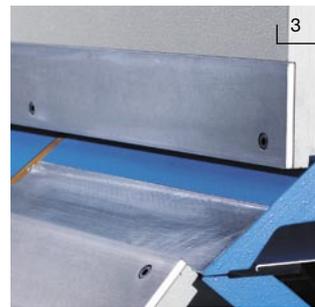
Standard stop finger, as used on our bending machines for over ten years. The travel distance is 25 mm – 1150/1300/1500 mm (option: spring-action finger 12 mm – 1150/1300/1500 mm), at a speed of 250 mm/s.



2

2/3 Beam assembly, side view

With a top and bottom bending beam the sheet metal no longer has to be turned over and rotated. This dramatically reduces the production time. While one bending beam is working, the other beam can be moved out of the bending area by up to 295 mm. This provides the room needed for the working process. With an add-on adjustment option (yellow unit), the bending beam can be accordingly pre-tensioned to produce precise profile pieces.



3



4

4 Tapered stop

The maximum cumulative taper is 2% on a 6.4 m machine.



5

5 SF shearing machine

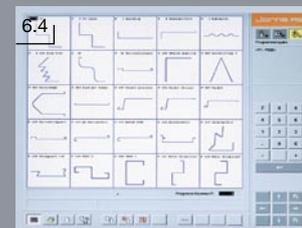
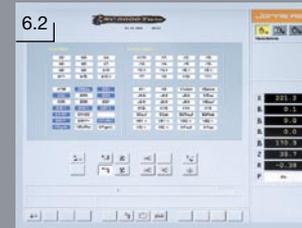
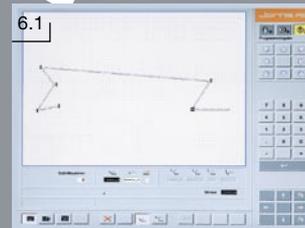
The SF shearing machine was especially designed to be slim so as to ensure enough room for profiles. The complete shearing machine is mounted on a linear guide. The shearing carriage also serves as a support for the profile rollers of the roll forming machine.

With positive-negative bending using two bending beams the TwinMatic and TwinBend are far more adaptable and faster than conventional bending machines. There is no more

The CNC5000 control system is simple to program and adds considerably to the machines' overall appeal.

need for auxiliary personnel. Unit costs are crucial, especially in industrial bending. Often high employment costs can seriously impact lucrative orders. Long, heavy workpieces in particular, with many reverse bending operations, entail considerable added expense.

It is specifically in this area of operation that the **fully automatic TwinMatic** and the **semi-automatic TwinBend** come into their own. Both machines are available in lengths of 4, 6.4, 8, 10 and 12.2 m. They can work iron sheet up to a thickness of 3 mm (400 N/mm²). The insertion depth is 1150/1300/1500 mm. A unique feature is the programmable air gap, which depending on the operating cycle (top and bottom bending beam) adapts automatically to the sheet thickness.



CNC5000 control system

- 17" TFT colour display touchscreen, with 425 mm visible diagonals
- 7 CNC-controlled axes (top beam, top and bottom bending beam, top and bottom bending beam displacement, radius adjustment, top)
- External programming software
- Servicing and diagnostics module
- Disk drive for external data backup
- USB Flash memory
- 128 MB main memory and 20 GB hard drive
- Software updates on diskette; no hardware replacement
- State-of-the-art CAN bus technology

6.1 Creating drawings

Our very own drawing software lets you create all the profiles you need simply and conveniently. The working piece is designed step by step on the screen or an external PC. Key data such as shank length, bending angle, radius, stop, plate thickness and plate quality is automatically prompted by the software.

6.2 Status display / manual mode

All inputs and outputs can be monitored. The Twin can also be operated in manual mode.

6.3 Automatic mode / process simulation

Once you have designed the profile, you can test its implementation with a bending simulation program. The program also highlights any potential collisions.

6.4 Folder storage

The CNC5000 control system is Windows-based, which means you can simply store your profiles in your own folders. The program also allows you to browse and open the profiles according to predefined criteria.



Type	Bending performance			Stands	Stand spacing	Number of couplings	Weight (version 1050 mm)	TwinMatic		TwinBend	
	Steel	Inox	Alum.					Stop unit		Stop fingers	Stop unit, type 91
	St-40 400 N/mm ²	V2A 600 N/mm ²	1/2-hard 220 N/mm ²					Clamping fingers and over grippers			
mm	mm	mm	Qty	mm	Type/Qty	kg (approx.)	Standard	Optional	Qty	Qty	
4 x 1.25	1.25	0.80	2.00	3	1600	K24 - 06	5200	3	4	4	2
6.4 x 1.25	1.25	0.80	2.00	4	1700	K24 - 08	7500	4	5	4	2
8 x 1.25	1.25	0.80	2.00	5	1700	K24 - 10	8900	5	6	4	3
10 x 1.25	1.25	0.80	2.00	6	1750	K24 - 12	10800	6	7	6	4
12.2 x 1.25	1.25	0.80	2.00	8	1600	K24 - 16	13800	8	9	6	5
4 x 1.5	1.50	1.00	2.50	3	1400	K24 - 06	6100	3	4	4	2
6.4 x 1.5	1.50	1.00	2.50	5	1300	K24 - 10	10500	4	6	4	2
8 x 1.5	1.50	1.00	2.50	7	1180	K24 - 14	14200	5	6	4	3
10 x 1.5	1.50	1.00	2.50	8	1270	K24 - 16	16000	8	9	6	5
12.2 x 1.5	1.50	1.00	2.50	10	1230	K24 - 20	20000	9	10	6	5
4 x 2	2.00	1.50	3.00	4	1020	K24 - 08	7500	3	4	4	2
6.4 x 2	2.00	1.50	3.00	6	1100	K24 - 12	11400	5	6	4	2
8 x 2	2.00	1.50	3.00	8	1020	K24 - 16	15500	6	7	4	3
10 x 2	2.00	1.50	3.00	9	1130	K24 - 18	17400	8	9	6	4
12.2 x 2	2.00	1.50	3.00	12	1020	K24 - 24	21400	11	12	6	5
4 x 3	3.00	2.00	4.00	5	910	K28 - 10	13000	4		4	2
6.4 x 3	3.00	2.00	4.00	7	910	K28 - 14	18000	6		4	2
8 x 3	3.00	2.00	4.00	9	910	K28 - 18	26000	8		4	3
10 x 3	3.00	2.00	4.00	11	910	K28 - 22	30000	10		6	4
12.2 x 3	3.00	2.00	4.00	14	910	K28 - 28	36000	13		6	5

We explicitly reserve the right to effect changes and modifications to both version and function.



Jorns slitting machines are characterised by short adjustment and retooling times. For constantly changing production units

A global customer service organisation with competent servicing engineers guarantees professional assembly, training and maintenance for the entire installation.

through to series production. The **MSC Mini Service Center** is the ideal, most cost-effective and professional solution around.

Our concept is confirmed by the steadily growing number of satisfied customers, the reward for all our development work.

1 Decoiler

Electronically actuated decoiler for the MSC Mini Service Center series, designed for strips of 1250 mm and 1600 mm, and a load-carrying capacity of 5000 kg. Ideal for max. sheet thicknesses of 1.5 mm iron sheet (400 N/mm²).

The sheet coil is tensioned by hand, over a crank. Two lateral plates allow the coil to unwind perfectly. The standard speed of 35 m/min is controlled via a compensating roller.

Accessories:

Hydraulically actuated loading block for strip widths of 1250 mm and 1600 mm, and a maximum load-carrying capacity of 5000 kg. The block and the height adjustment are operated hydraulically. The special design ensures that the overall machine height is kept low.

2 Slitting machine

Slitting machine of the MSC Mini Service Center series, available in strip widths of 1250 mm and 1600 mm; ideal for max. iron sheet thickness of 1.5 mm (400 N/mm²). Design size 125 and 150.

The slitting machine can be configured either without straightening unit or with 5 or 7 straightening rollers. The machine runs at 35 m/min at centre, thereby ensuring that the cutting forces are ideally distributed.

The slitting blades can be clamped mechanically and are easily adjusted by hand to the required strip width, minimum slitting width 70 mm.

Accessories:

Foil holder, additional slitting blades, various straightening units



3



3



3 Recoiler

Recoiler for the MSC Mini Service Center series, available in strip widths of 1250 mm and 1600 mm, and a maximum load-carrying capacity of 5000 kg.

The sheet strips are wound tightly by a pneumatic felt brake; the separating discs ensure that the strips are wound true and are not misaligned. The minimum winding strip width is 75 mm.

The winding speed of 35 m/min is generated by an electric drive unit and controlled via a compensating roller. The maximum iron sheet thickness that can be wound with the Jorns recoiler is 1.5 mm (400 N/mm²).

Accessories:

Hydraulically actuated unloading block for strip widths of 1250 mm and 1600 mm, and a maximum load-carrying capacity of 5000 kg. The block and the height adjustment are operated hydraulically. The special design ensures that the overall machine height is kept low.

Scrap coiler

in stepped arrangement with central electric motor. The finger's constant to-and-fro movement distributes the rest of the strip evenly over the mandrel. The maximum strip width is 25 mm.



2

1



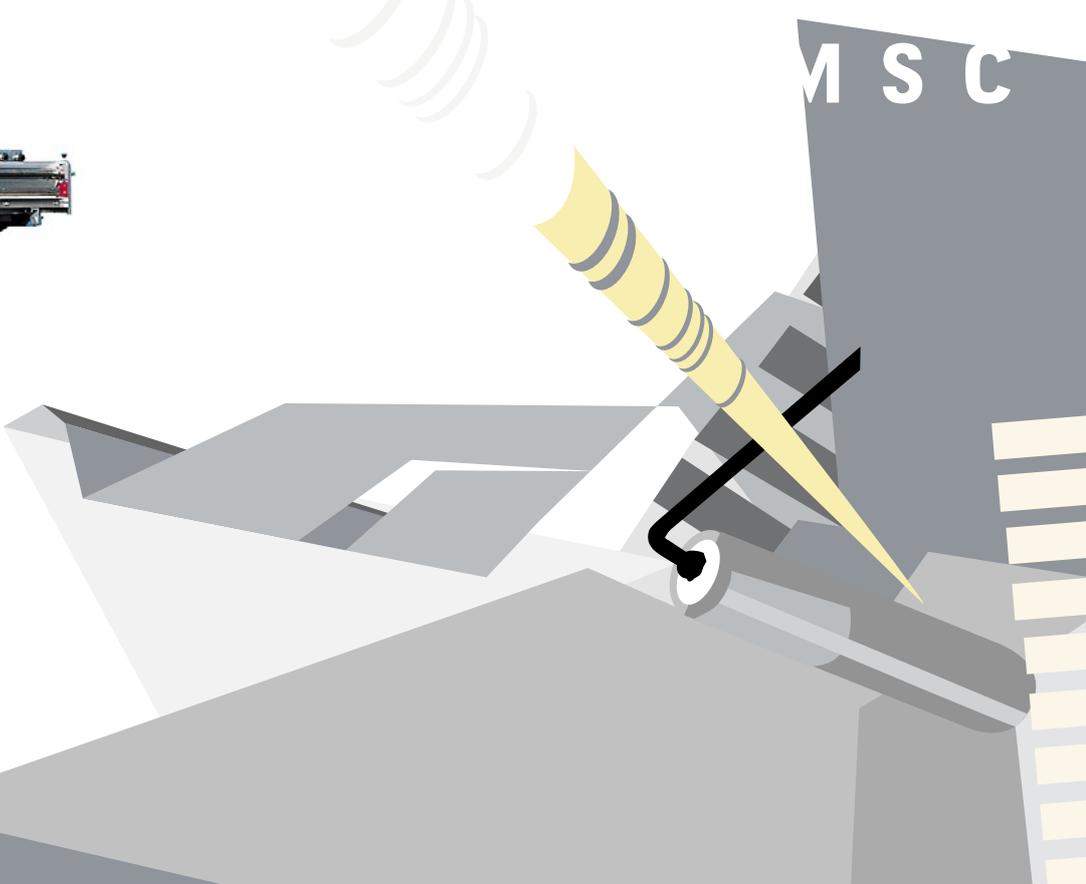
Cutting table

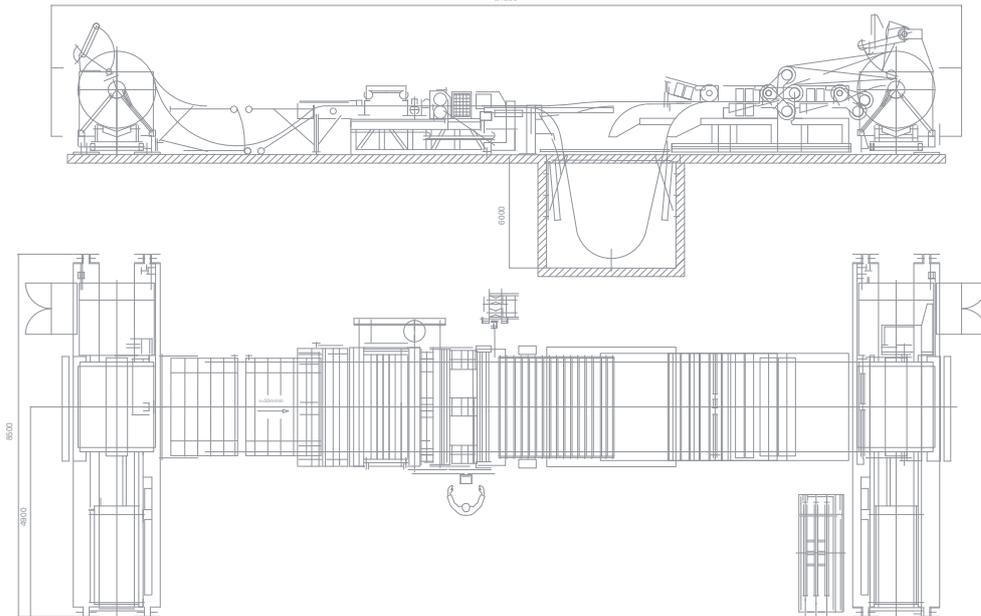
with sturdy underframe, phenol chip board, stop and lateral tape measure. The table is wheel-mounted and fitted with wheel brakes. Available in lengths of 4, 6 and 8 m and table widths of 800, 1000, 1250 mm.

Manual table shears

with swivel bearing for swivelling the shears from the table surface. Available in widths of 1000 and 1250 mm. Cutting capacity: St-40 steel: 1.0 mm, stainless steel: 0.6 mm, aluminium: 1.5 mm

M S C





For special designs, please contact Jorns AG. Together we are certain to find the solution you require.

1 Recoiler

The recoiler is driven by an electric motor. Proportional hydraulics are used to supply all the auxiliary functions such as expanding mandrel, unloading block and separating arm. The Jorns recoiler is equipped with a hydraulic felt brake as the braking system and a driven deflection roller. The recoiler is designed for coiling max. 2.0 mm of iron sheet (400 N/mm²) and is available in strip widths of 1250 mm and 1600 mm. The load-carrying capacity is 8000 kg and 15000 kg.

2 Slitting machine

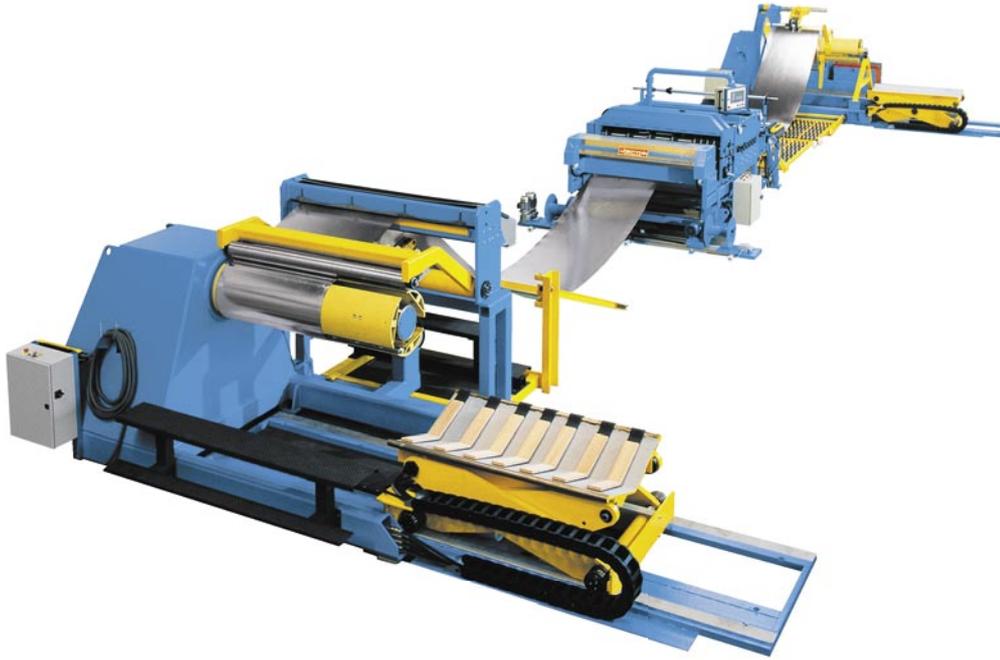
Electrically driven slitting machine. We design custom slitting machines for each customer, tailored specifically to their requirements. This way you can be assured that the machine you receive is configured precisely to your needs. Strip widths of 1250 mm and 1600 mm, straightening unit of 7, 11, 19 or more straightening rollers. The 200 serie comprise hydraulically clamping slitting blades; the complete blade set is adjusted quickly and conveniently to the correct strip width. The minimum strip width is 67 mm.

3 Decoiler

Electrically driven decoiler for strip widths of 1250 mm and 1600 mm and load-carrying capacities of 8000 kg and 15000 kg. The loading block, coil star expansion and contact roller are hydraulically actuated by means of a hand-operated pushbutton. The decoiler is designed for iron sheet thicknesses of up to 2.00 mm (400 N/mm²).



UNCOILING SLITTING UPCOILING



Series	Slitting shafts Ø	Slitting blades Ø	Blade pairs Qty	Max. workable sheet thickness					
				Strip width 1250			Strip width 1600		
				Steel St-40 400 N/mm ²	Alum. ½-hard 220 N/mm ²	Inox 600 N/mm ²	Steel St-40 400 N/mm ²	Alum. ½-hard 220 N/mm ²	Inox 600 N/mm ²
mm	mm	mm	mm	mm	mm	mm			
MSC 125	100	152	5	1.25	1.75	0.75			
MSC 125	140	202	5				1.25	1.75	0.75
MSC 150	140	202	5	1.50	2.00	1.00	1.50	2.00	1.00
200	180	270	5	2.25	2.75	1.75	2.00	2.50	1.50

We explicitly reserve the right to effect changes and modifications to both version and function.

Series	Strip width mm	Straightening unit			Slitting shafts Ø mm	Slitting blades Ø mm
		R5 5 Straightening shafts	R7 7 Straightening shafts	R11 11 Straightening shafts		
MSC 125	1250	•	•		100	152
MSC 125	1600	•	•		140	202
MSC 150	1250/1600	•	•		140	202
200	1250/1600		•	•	180	270

We explicitly reserve the right to effect changes and modifications to both version and function.

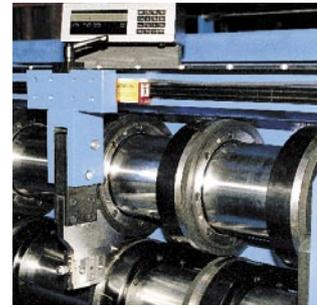
Shearing lifting table

hydraulically raised and lowered. The table length, width and load-carrying capacity are adaptable to requirements. All functions can be selected using a hand-operated pushbutton.



Absolute blade adjustment aid

with movable measuring head for easier adjustment of the air gap in the slitting blades. The digital display speeds up the positioning of the blade pairs.



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