



Meccanotecnica Centro srl

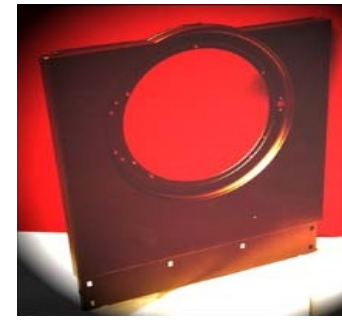


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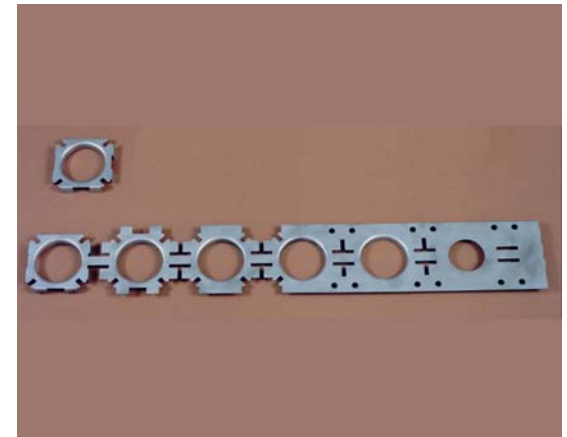
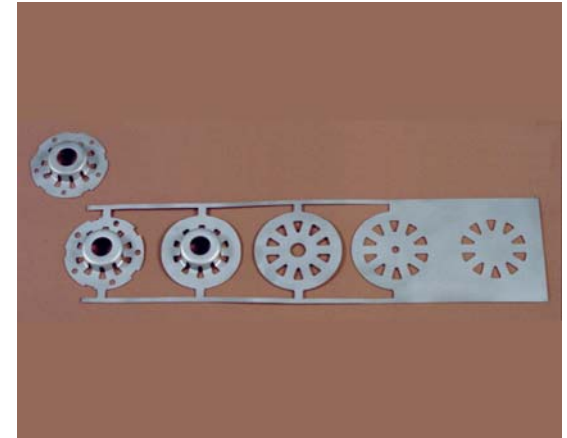
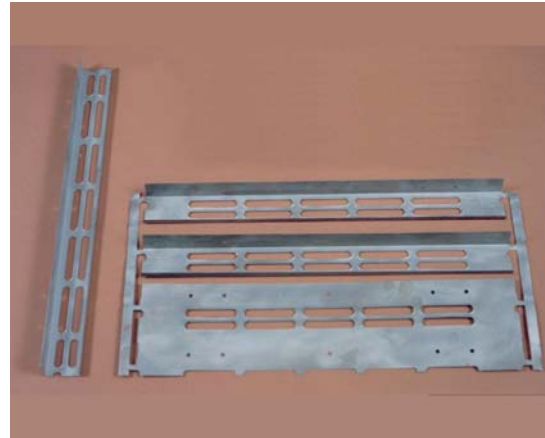
Dies

Domestic appliances

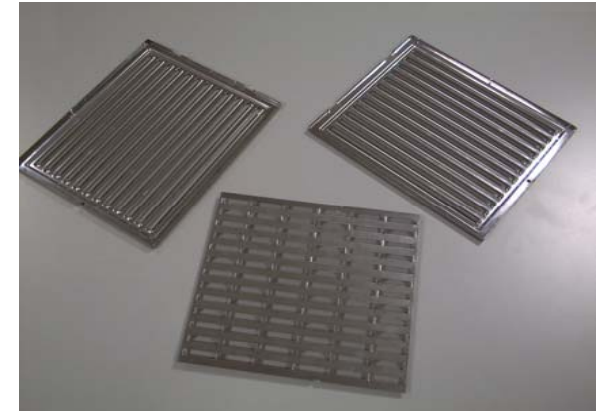
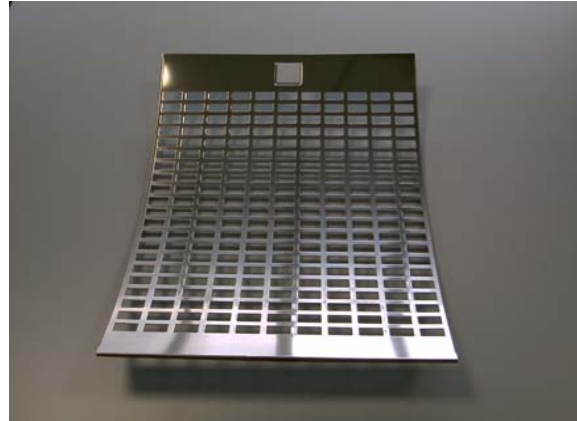
Photogallery 1



Photogallery 2



Photogallery stainless steel



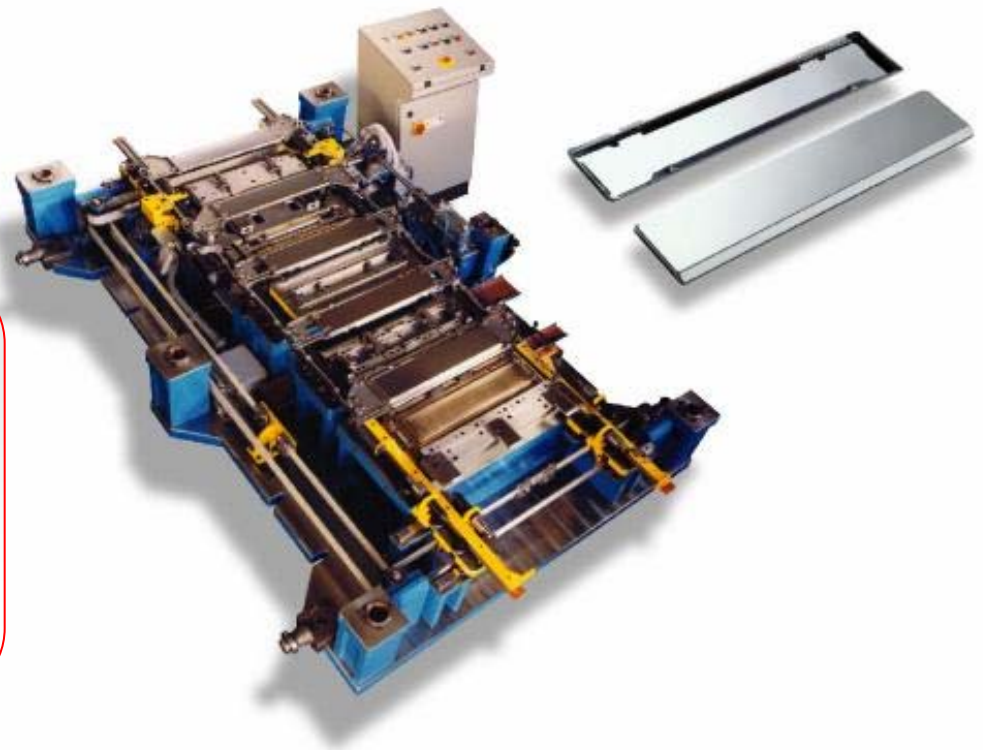
HEATING DOOR

| | |
|-------------------|---------------------|
| Material | stainless steel |
| Thickness | 0,8 mm |
| Type of die | integrated transfer |
| Dimensions of die | 2700x1200x600 mm |
| Weight of die | 8.000 kg |
| Coil | 655 mm |
| Pitch | 210 mm |
| Productivity | 10 stroke/minute |
| Lead-time | 5 months |

RESULTS

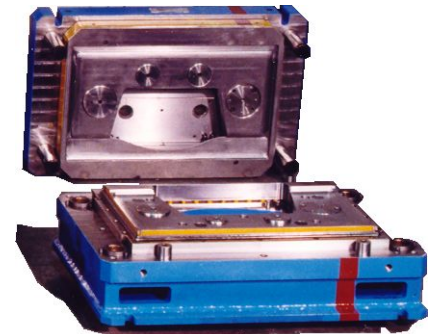
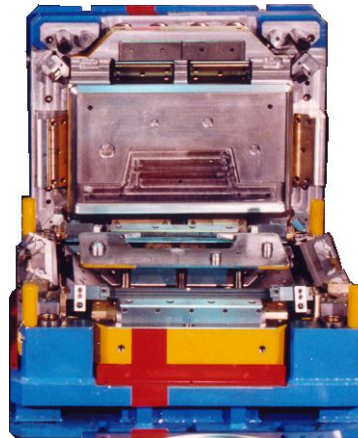
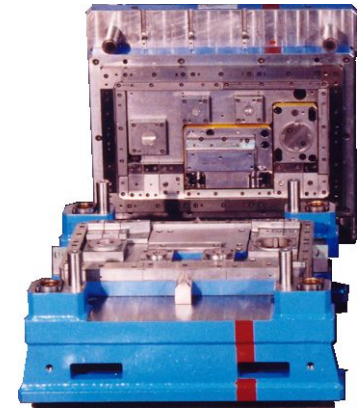
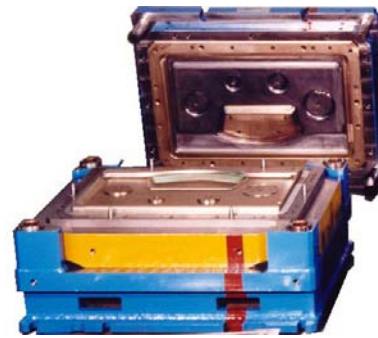
The piece is automatically carried from one station to the next one during the operations

The transfer system is integrated into the die and provided with PLC. This solution allows to Stamp with any coil-fed press



COOKER TOP

| | |
|----------------------|-------------------|
| Material | stainless steel |
| Thickness | 0,8 mm |
| Type of die | transfer |
| Dimensions of die | 1300x1000x700 mm |
| Total weight of dies | 15.000 kg |
| Coil | 670 mm |
| Pitch | 970 mm |
| Productivity | 12 strokes/minute |
| Lead-time | 6 months |



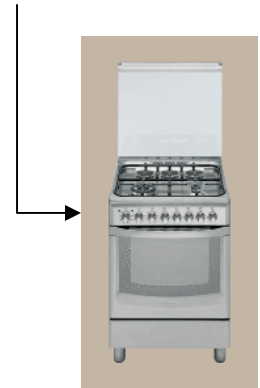
RESULTS

Very good esthetic results thanks to a special material used for the drawing

Only one set of dies to make different versions of cookers

BACK PANEL OVEN

| | |
|--------------------|------------------|
| Material | galvanized steel |
| Thickness | 0,8 mm |
| Type of die | manual |
| Dimensions of dies | 1000x1100x450 mm |
| Weight of die | 2.500 kg each |
| Blank | 800 x 620 mm |
| Lead-time | 4 months |

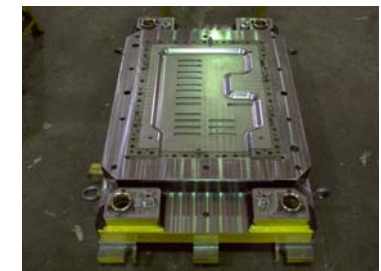
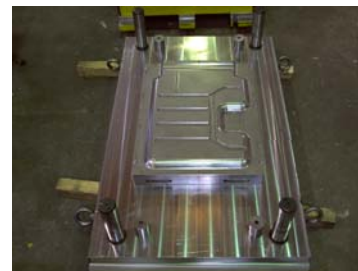
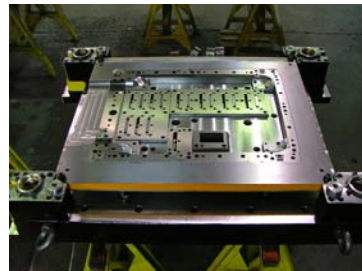


RESULTS

High quality part achieved with simple tools and manual production

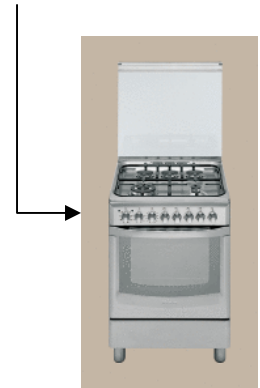
Optimized die dimension for usage on any type of press

Possibility to use multiple tools with one press at the same time



OVEN BOTTOM

| | |
|--------------------|------------------|
| Material | galvanized steel |
| Thickness | 1 mm |
| Type of die | manual |
| Dimensions of dies | 1100x1000x700 mm |
| Weight of dies | 2.500 kg each |
| Blank | 670 x 620 mm |
| Lead-time | 4 months |

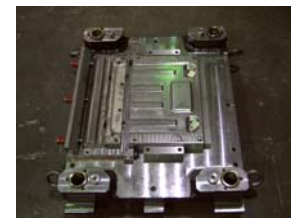
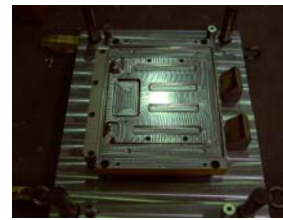
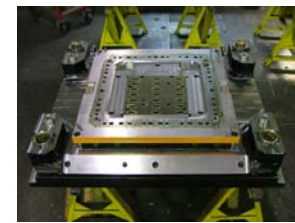


RESULTS

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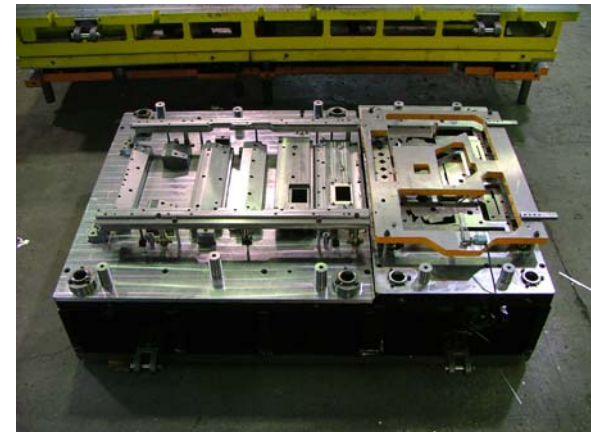
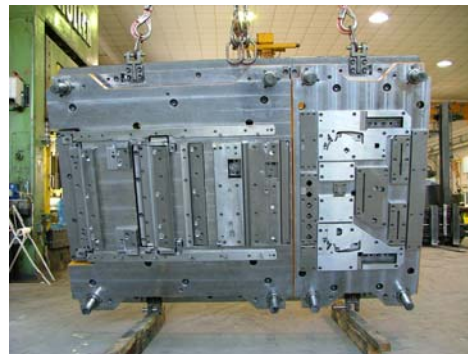
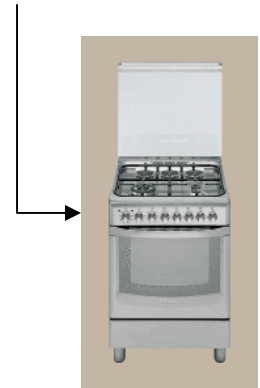
SUPPORT FRONT PANEL

| | |
|-------------------|-------------------|
| Material | galvanized steel |
| Thickness | 0,8 mm |
| Type of die | progressive |
| Dimensions of die | 1800x1300x700 mm |
| Weight of die | 4.000 kg |
| Coil | 670 mm |
| Pitch | 208 mm |
| Productivity | 15 strokes/minute |
| Lead-time | 4 months |

RESULTS

Capability to produce different versions with the same tool

High productivity

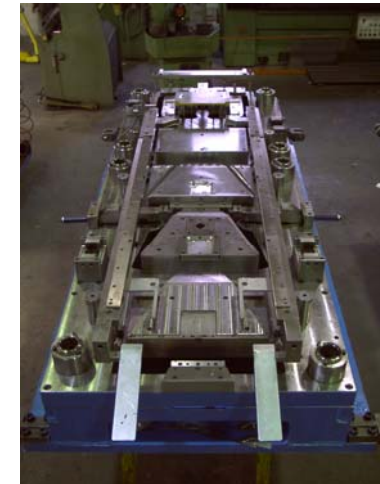
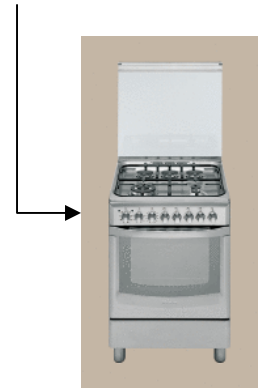


CANALIZATION OVEN

| | |
|-------------------|-------------------|
| Material | galvanized steel |
| Thickness | 0,5 mm |
| Type of die | progressive |
| Dimensions of die | 2400x1100x700 mm |
| Weight of die | 6.000 kg |
| Coil | 573 mm |
| Pitch | 499 mm |
| Productivity | 16 strokes/minute |
| Lead-time | 5 months |

RESULTS

High speed production with thin sheet



DISHWASHER DOOR

| | |
|---------------------|------------------|
| Material | SS & pre-painted |
| Thickness | 0,7 mm |
| Type of die | transfer |
| Dimensions of die | 1100x1200x700 mm |
| Weight of dies | 25.000 kg |
| Quadrotto | 850 x 900 mm |
| Produttività | 8 pezzi/minute |
| Tempo realizzazione | 6 months |

RESULTS

Very difficult esthetic requirements were met on stainless steel and pre-painted sheet metal



Ariston 2001



Indesit 2003



Ariston 2006

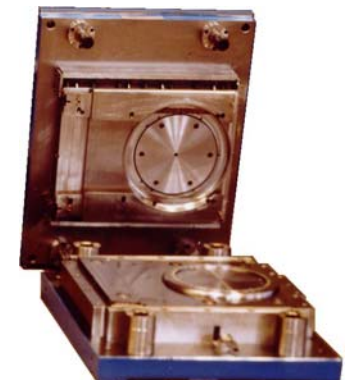
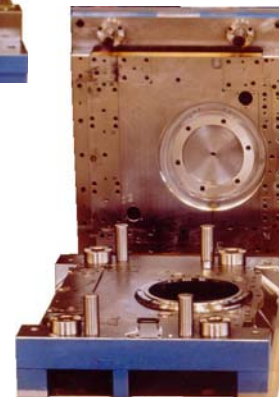
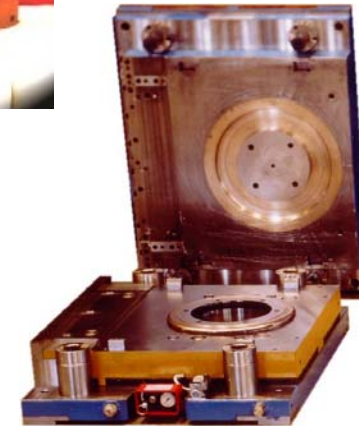
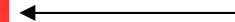


WASHING MACHINE FRONT PANEL

| | |
|-------------------|------------------|
| Material | galvanized steel |
| Thickness | 0,8 mm |
| Type of die | transfer |
| Dimensions of die | 1300x1000x700 mm |
| Weight of dies | 12.000 kg |
| Coil | 750 mm |
| Pitch | 700 mm |
| Productivity | 5 strokes/minute |
| Lead-time | 5 months |

RESULTS

High esthetic results thanks to a special material used for the drawing



FRONT UPPER CROSSBAR DISHWASHER

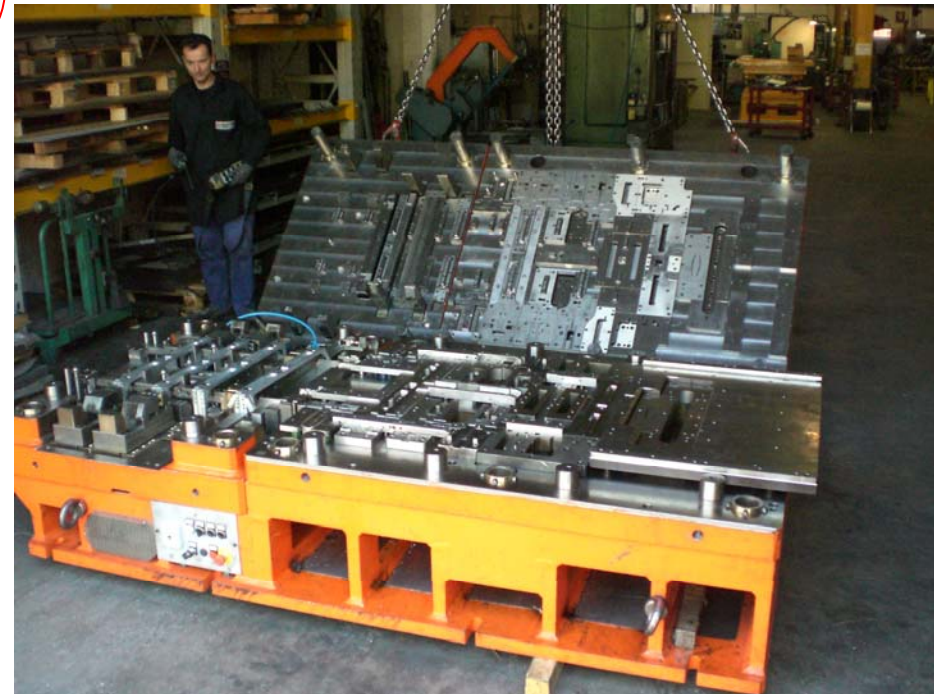
| | |
|-------------------|-------------------------------|
| Material | P04 |
| Thickness | 1 mm |
| Type of die | progress+transfert integrated |
| Dimensions of die | 2600x1400x770 mm |
| Weight of die | 10.340 kg |
| Coil wide | 860 mm |
| Pitch | 170 mm |
| Productivity | 15 strokes/minute |
| Lead-time | 5 months |



RESULTS

The progressive die becomes transfert in the last part

Optimum result considering the geometry of the piece and the esthetical parts to be respected



FRONT PILLAR DISHWASHER

| | |
|-------------------|--------------------|
| Material | P04 Z200 |
| Thickness | 1,2 mm |
| Type of die | progressive L/R |
| Dimensions of die | 3.000x1.600x680 mm |
| Weight of die | 13.800 kg |
| Coil wide | 1.220 mm |
| Pitch | 180 mm |
| Productivity | 17 strokes/minute |
| Lead-time | 6 months |



RESULTS

Optimum result considering the geometry of the piece

