

Haute couture for large sizes

Precision manufacturing of curved bevels

The flame cutting experts at Jebens GmbH master the highest precision: they even cut curved flame-cut parts from 400-millimetre-thick sheet steel with six different bevels so precisely that these components meet the tightest of tolerances. A global market leader in special machines has relied on this expertise for many years.

2,770 millimetres long, 960 millimetres wide and 400 millimetres thick, with a final weight of 8.5 tons each were the components recently manufactured for him by Jebens. The basis for just-in-time delivery is guaranteed access to material of this thickness – S355J2 + N with APZ 3.1 from Dillinger, which is available to us at all times : is itself far from usual in the market. However, as a subsidiary of Dillinger, Jebens has one of the largest stocks of high-quality steels in the thickness range from 100 to 650 millimetres and therefore offers the required delivery reliability. The flame cutting expert is almost unique in Europe in the production of components with this thickness and with such demanding chamfers: due to a lack of suitable machines and experience, hardly anyone else is able to offer this. In order to process sheet metal of this thickness, particularly complex and precise temperature control is necessary. Jebens preheat the sheet metal with lances – including all chamfers. This requires not only the necessary infrastructure, but also very specific knowledge. Jebens first drilled a recess to prevent the flame from hitting the component with too much energy. Otherwise, even the slightest increase in hardness would cause the jet to slip and create a bevel cut, making the entire component unusable. By drilling, the expert defined the cutting channel which guides the flame. Jebens then applied several chamfers at different levels within the arc-shaped component contour according to the drawing: 45-degrees laterally at two levels, 60-degree chamfers on the head sides at one level and a 10-degree chamfer in the inner centre of the arc. In view of the tight tolerances specified for this sheet

thickness, the cutting bevel and quality demanded for these chamfers were a fine art. The flame cutting experts from Korntal-Münchingen, Germany, achieved the extreme contours of the components within three weeks, and then cut the chamfers with the required precision. The renowned mechanical engineering company does not have this bundled competence in their own large welding department, so that they put the bespoke production of these parts - true haute couture – in the hands of the virtuoso flame cutting experts from Jebens.

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Jebens GmbH

As a leading specialist for heavy flame-cut components, mechanical processing and welded structures with weights of up to 160 tonnes per item, Jebens GmbH regularly sets standards in its locations in Korntal-Münchingen and Nördlingen. With seven-stage manufacture of products from eight to 1,400 mm, widths up to 5,000 mm and lengths up to 20,000 mm Jebens stands for precision steelwork. As a subsidiary of the most important heavy plate manufacturer worldwide, Dillinger, Jebens has access to technologically pioneering steel know-how at all times. Leading technology, the most modern machines and systems, as well as the largest annealing furnace in Southern Germany, make Jebens the experts for demanding jobs.

JEBENS

MASSARBEIT IN STAHL

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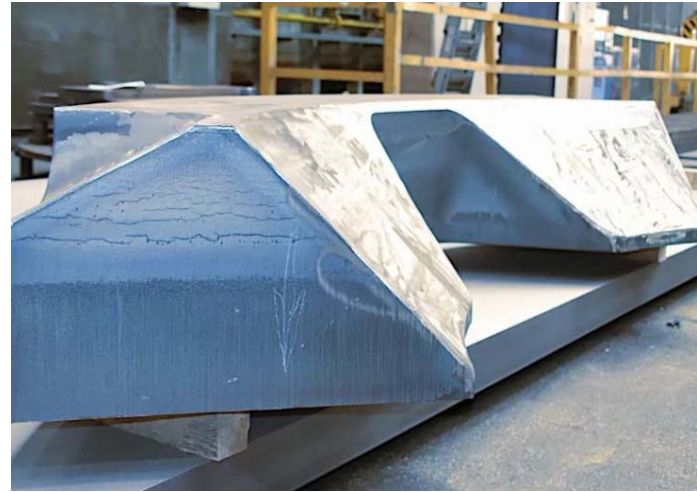
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Picture 1: High flame cutting expertise from Jebens in 400-millimetre thickness.



Picture 2: 2,770 millimetres long, 960 millimetres wide and 400 millimetres thick flame-cut part, with a final weight of 8.5 tons.



Picture 3: Jebens cut curved flame-cut parts with six different bevels so precisely that these components meet the tightest of tolerances.



Picture 4: In order to process sheet metal of the thickness S355J2 + N with APZ 3.1, particularly complex and precise temperature control is necessary.

Picture 1-4: © Jebens GmbH

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Picture 5: Jebens applied several chamfers at different levels within the arc-shaped component contour according to the drawing.



Picture 6: Laterally, 45-degree chamfers were cut in two levels.



Picture 7: In view of the tight tolerances specified for this sheet thickness, the cutting bevel and quality demanded for these chamfers were a fine art.



Picture 8: Jebens achieved the extreme contours of the components within three weeks with the required precision.

Picture 5-8: © Jebens GmbH

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