

KOTŁOREMBUD

BOTTOMS PRODUCTION PLANT

Wishing to interest you with our products, we would like to give you some basic information about us here. P.W. Kotłorembud as a Civil Company was established in 1986. Now it functions as an overt company, and its full name goes as follows:

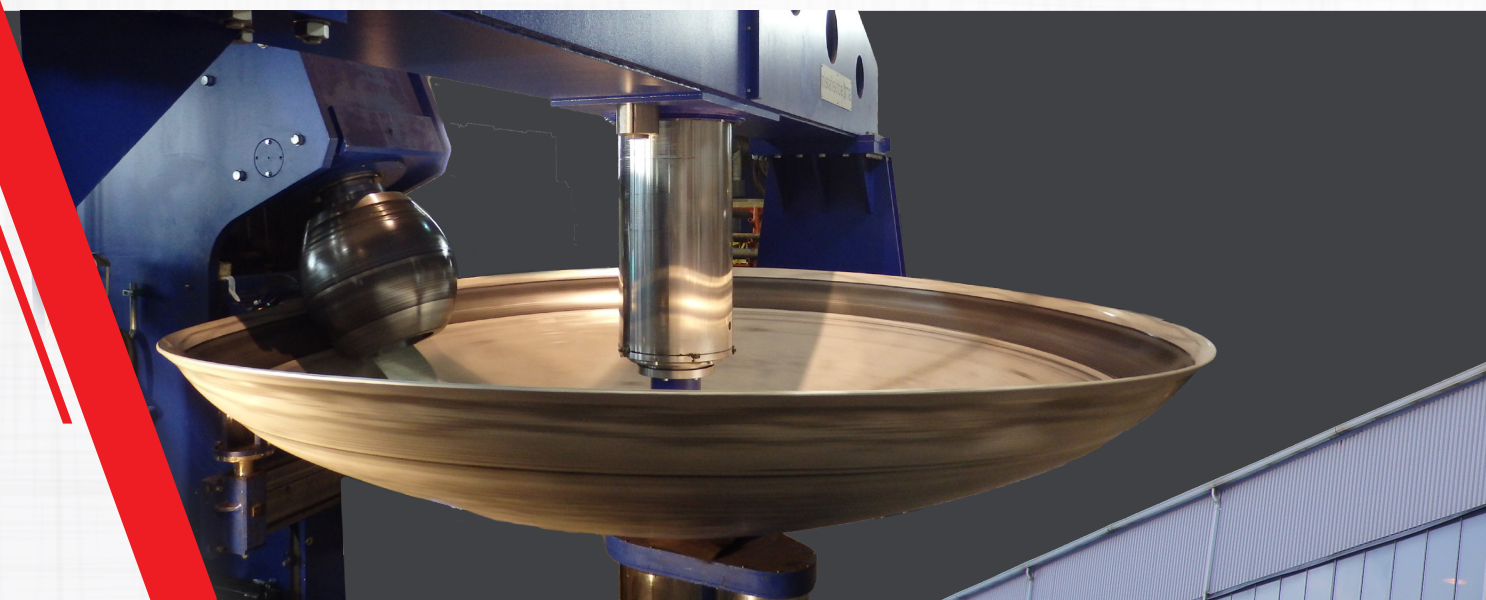
Multi-Sector company KOTŁOREMBUD L. Cichosz , B. Szatlach S.J.

The company has over 30 years of experience in the steel products industry. Long-term presence on the market allows us to carry out the assumed tasks. The basic aspect on which the activities of the Management Board and Staff are focused are customer satisfaction and high quality of products. Currently, the company employs about 120 qualified employees.

Steel heads are the basic product of the Plant. Their production began in 2008. Initially, the production of bottom heads was carried out on a small separate area of the hall of one of our plants in Bydgoszcz at ul. Solna 20. Earning ever greater experience, already in 2009 - expanding the product range, we started selling bottoms to the first recipients in the country. From the beginning of the production of the bottoms, we have paid attention to the ever-higher quality of our products and the service satisfying our customers.

In July 2012, production was moved to a new hall located in Bydgoszcz at ul. Ołowiana 17. In new, very good conditions, we have achieved the maximum performance of the Italian production line of FACCIN bottoms. In order to continue to meet your needs at an appropriate level - deadlines - decisions have been made about investments in the development of the Heads Production Plant.

In the Heads Production Plant, in 2015 new technologies for the production of bottoms were implemented. We purchased a PLB-1200 type collector from the German company Leifeld Metal Spinning AG. This machine allows us to make the bottom using the shape of the bottom on the template. On this device we currently produce bottoms, from 600, 800 and 1000 mm in diameter according to PN-75 / M-35412 and 1600 mm in diameter according to PN-69 / M-35413.



As a result of the decision taken by the Management Board of P.W. KOTŁOREMBUD on the purchase of a new production line for the production of bottoms of SMT Schleifstein Maschinentechnik GmbH since the beginning of 2016 we have expanded the range of manufactured bottoms. We offer bottoms with even larger diameters, made of materials of greater thickness and strength. This production line enables us to manufacture sheet metal bottoms up to 35mm thick in the following diameters:

up to 6000 mm - flat bottoms,
up to 5500 mm - torospheric bottoms,
up to 4500 mm - ellipsoidal bottoms.

We are constantly expanding the circle of our active recipients, which currently consists of around 300 domestic and foreign companies.

Currently, we make ends according to PN-75 / M-35412, PN-69 / M-35413, PN-69 / M-35414, DIN 28011, DIN 28013, PN-EN 12285, PN-EN 13445-4, NF E81- 101, NF E81-102, NF E81-103, NF E81-104 and flat bottoms and other non-standard made according to arrangements with the client. Our machine capabilities also allow for winding and grooving of conical bottoms.

The technology of making bottoms, which we have, is based on cold plastic forming. The technological process enabling the construction of heads consists of pressing on multi-terminal presses equipped with a rotary manipulator

and spinning on specialized, dedicated only to bottoms, flanging machines.

As part of cooperation with an external company, we can make the ends subject to the recommended heat treatment - standardization.

We have implemented, certified by UDT-CERT Quality System PN-EN ISO 9001 in the field of manufacturing materials for components for pressure equipment, tested for compliance with Annex I, point 4.3 of Directive 2014/68 / EC No. CSJ / 343 / WM / PED / 2015.

Our advantage is:

- matching the bottoms to the customer's needs,
- high quality of offered products,
- short deadlines,
- flexible payment terms.

In addition, we offer delivery of demountables by our means of transport (including over-standard transport). As much as possible, we mediate in the ordering of transport services provided by forwarding companies.

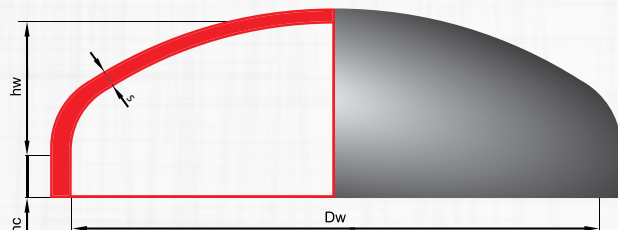
We invite you to cooperation.



Range of manufactured bottoms

Ellipsoidal acc. to PN

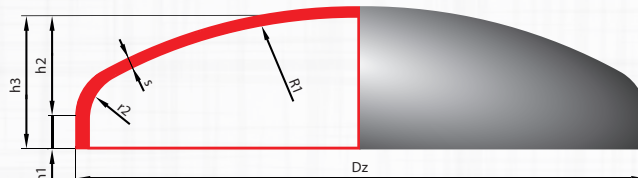
PN-75/M-35412



Range of manufactured diameters [mm]	Wall thickness [mm]*
600 + 4500	5 + 35

Torispherical

DIN 28011
NFE 81-102 (GRC)

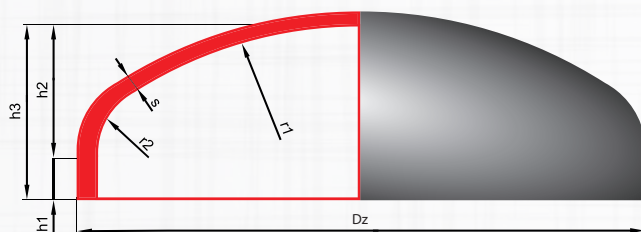


$$r1 = Dz \quad r2 = 0,1 Dz$$

Range of manufactured diameters [mm]	Wall thickness [mm]*
500 + 5500	4 + 35

Ellipsoidal acc. to DIN

DIN 28013
NFE 81-103 (ELL)

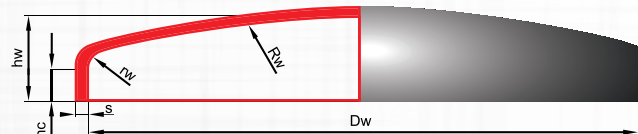


$$r1 = 0,8 Dz \quad r2 = 0,154 Dz$$

Range of manufactured diameters [mm]	Wall thickness [mm]*
1000 + 4500	5 + 35

Spherical

PN-69/M-35413



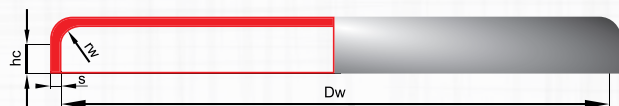
Range of manufactured diameters [mm]	Wall thickness [mm]*
800 + 5500	5 + 35

*We prefer to determine the minimum thickness MAF



Flat

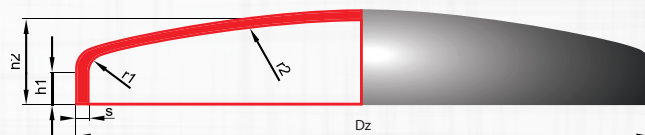
PN-69/M-35414



Range of manufactured diameters [mm]	Wall thickness [mm] [*]
800 + 6000	4 + 35

Dished

PN-EN 12285
NFE 81-104(MRC)
NFE 81-101(PRC)



Range of manufactured diameters [mm]	Wall thickness [mm] [*]
800 + 5500	5 + 35

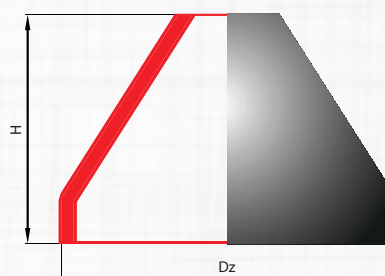
Dished discs



$r1 > 820$

Range of manufactured diameters [mm]	Wall thickness [mm] [*]
600 + 6000	3 + 60

Cones



Range of manufactured diameters [mm]	Wall thickness [mm] [*]
800 + 4000	5 + 35

^{*}We prefer to determine the minimum thickness MAF



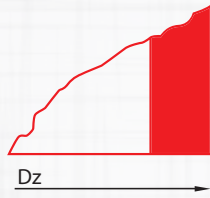
Methods for preparing the edges

♦ For heads

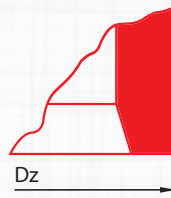
Shape R



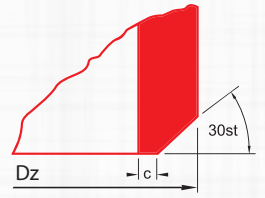
Shape I



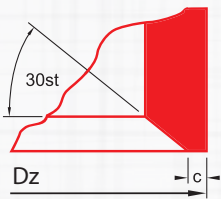
Shape I+BI



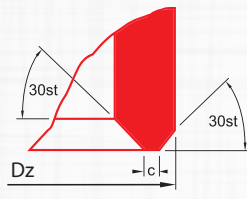
Shape YA



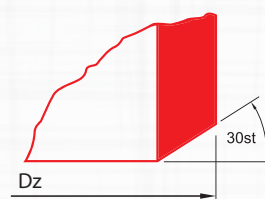
Shape YI



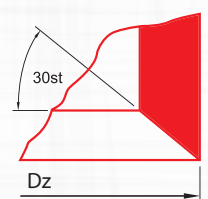
Shape DY



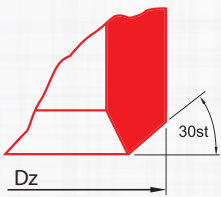
Shape VA



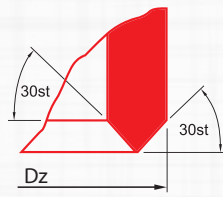
Shape VI



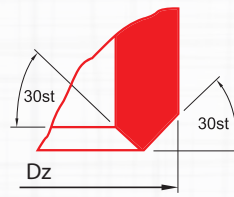
Shape VA+BI



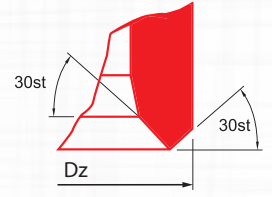
Shape DV



Shape 2/3 DV

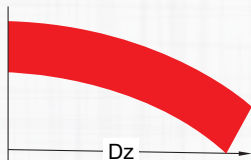


Shape DV+BI

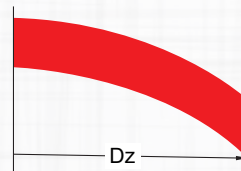


♦ For dished discs

Oblique edge



Straight edge



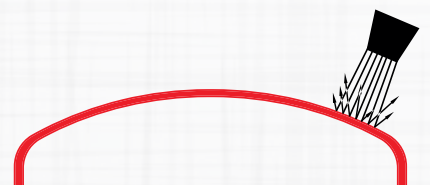
Surface finishing



Cleaned surface after forming the bottom



After heat treatment



Blasting

Transport

We offer delivery of demountables by our means of transport (including over-standard transport) in Poland and Europe or we mediate in the ordering of transport services provided by forwarding companies.

Due to the large dimensions of denominations, there is a problem with over-standard transport of items to the customer. Having a full range of racks enabling transportation in the contour of the loading platform of the trailer, unnecessary costs are avoided, which is an argument when offering a delivery.



Certificates

High quality of our products is confirmed by decisions and authorizations granted by National Organizational Units and Foreign Notified Bodies.

Management Systems

- ◆ Quality management system meeting the requirements of PN-EN ISO 9001
- ◆ Full welding quality requirements according to the PN-EN ISO 3834-2 standard

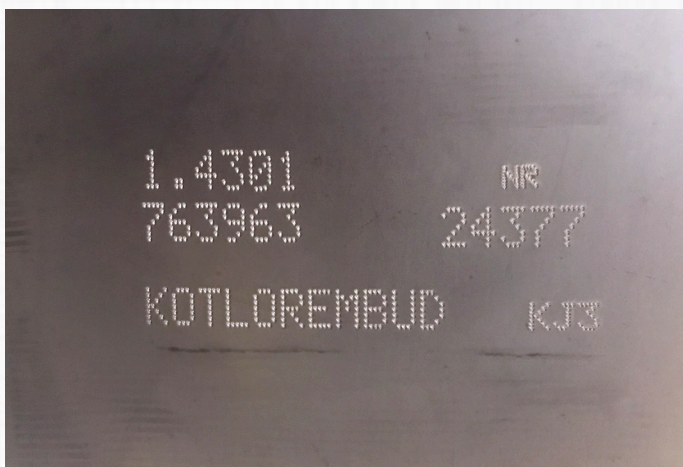
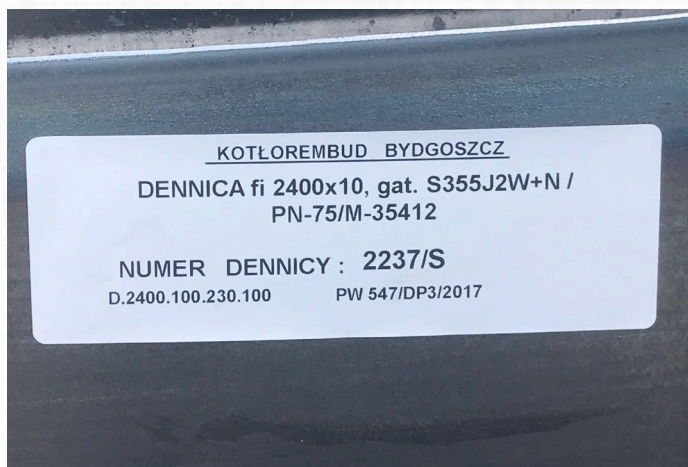
Certificates and recognition

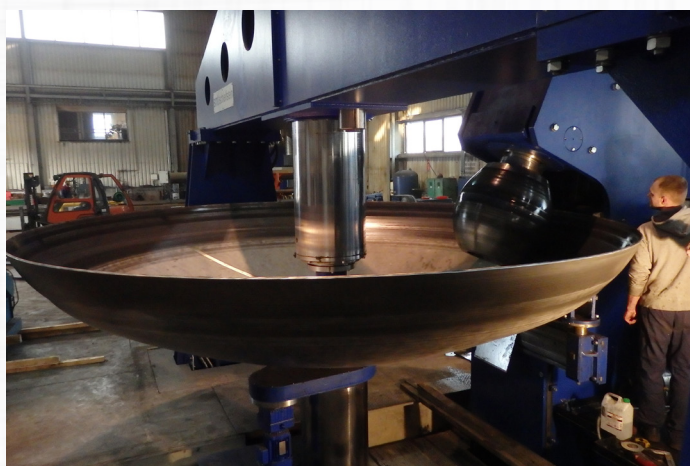
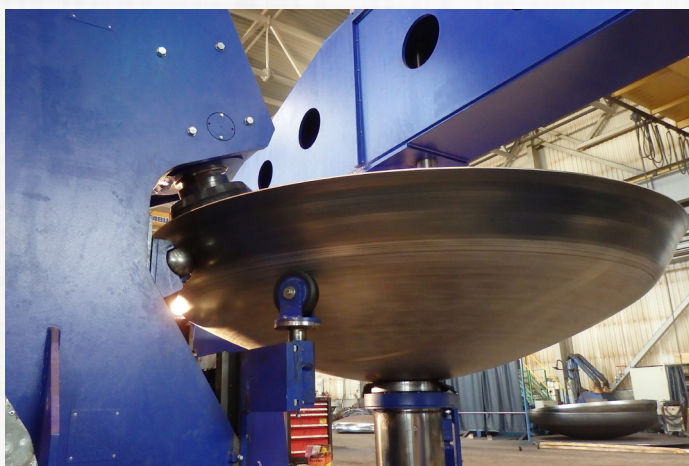
- ◆ UDT CERT - PED 2014/68/EU certificate (Quality assurance system for the manufacturer of Directive 2014/68/EU)
- ◆ UDT decision - of UDT Conditions (Production of elements according to the national conditions in accordance with WUDT)
- ◆ TDT certificate - ADR/RID regulations (excluding tanks for the transport of dangerous goods of 2,6,1,8 class according to ADR/RID, which are marked with the π sign in accordance with Directive 1999/36/WE)
- ◆ TUV Rheiland - AD 2000 certificate (Recognition as a producer of elements/materials according to AD2000)
- ◆ Recognition of the technical testing laboratory by UDT meeting the criteria regarding the requirements set out in the PN-EN ISO/IEC 17025 standard (approval number LB-hh188/03)

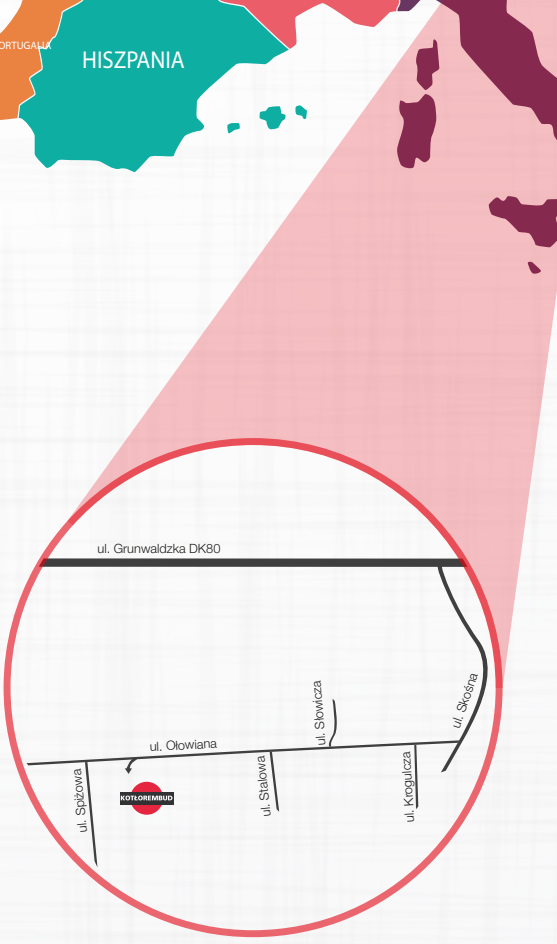


Warehouse

In the permanent disposal we have dozens of bottoms with diameters 600-2000mm thickness up to 10mm. Stock levels are maintained in different types of material (S235JR, S355J2, P265GH), even in different subject standards, namely: PN-75/M, PN-69/M-35413. The implemented and applied quality system ISO 9001 ensures full identification of the product, not only in terms of species, standards and melting, but also individual numbering of each produced bottom. The edges of the bottoms in stock are standardized at VA 30°.







KOTŁOREMBUD



PN-EN ISO 9001
PN-EN ISO 3834-2



Kotłorembud Sp. j.
ul. Ołowiana 17
85-461 Bydgoszcz
NIP 554 039 36 55



Sales department
Tel.: +48 52 320 19 41
Tel.: +48 668 429 453
Fax: +48 52 320 19 40
dennice@kotlorembud.pl



Production department
Tel.: +48 52 320 19 46
Tel.: +48 602 129 717

www.kotlorembud.pl

1986 / 30 YEARS
2016 ON THE MARKET