

BARNSHAWS PLATE BENDING

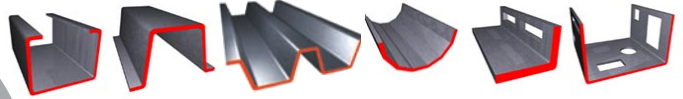
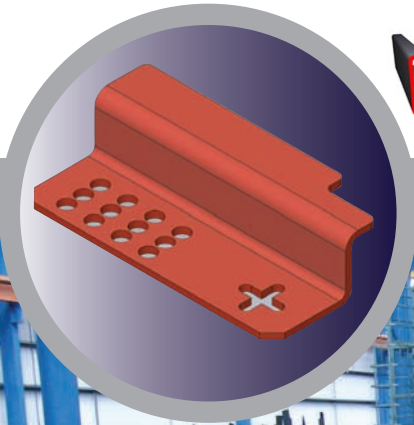


Press Braking



Key Points

- Largest range of press brakes in the UK from 175 to 1000 Tonne up to 12 Metres long
- All material from our own supply can be laser / plasma / sheared or flame cut to size / shape.
- Material grades processed include Carbon / Stainless / Aluminium / Wear Resistant and Armour Plate from complete supply / Free Issue.





Typical Capacity

Thickness (mm)	Max Length (mm)
≥ 13	12000
15	10000
20	6500
25	5000
30	3000
40	2800
50	2300
60	1900
70	1400
80	1000

Typical Applications

- Angles / Channels
- Boat Sides
- Chassis Rails
- Cones / Reducers
- Corrugations
- Cylindrical Segments
- U Type Sections
- Excavator Buckets
- Stair Treads & Landings
- Transitions (Rectangle to Rounds etc)

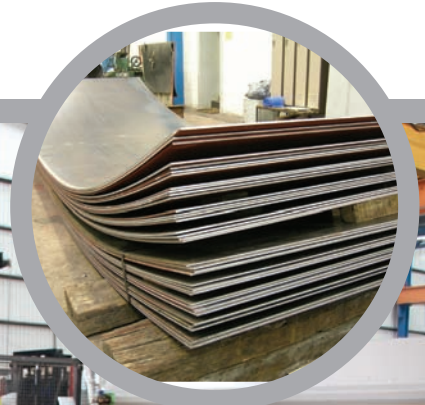


Plate Rolling



Key Points

- Largest and most advanced range of plate rolling machines in the UK
- Pre ending up to 45 mm x 3500 mm material without forming allowance, thus reducing material costs.
- Hardened chrome rolls to minimise marking and contamination on stainless and aluminium plate.
- All grades of material processed
- All material fully traceable.
- 24 Hour turnaround for rolled and tack welded cylinders from Free Issue material.





ROUND0

Plate Rolling Capacity

WALL THICKNESS (MM)

INSIDE DIAMETER (MM)

	3	5	6	8	10	13	15	20	25	30	35	40	4
110	900	200											
150	900	500	300										
200	2000	1500	600	600	450								
230	2500	1500	800	700	500	600	600	600	300				
250	2500	1800	1500	900	600	600	600	600	300				
300	2500	2000	1500	900	600	600	600	600	600	300			
350	2500	2500	1800	1500	1500	1200	600	600	600	300	300	300	
400	3050	3050	3050	1800	1500	1500	1500	600	600	300	300	300	2
450	3050	3050	3050	3050	3050	3000	1800	900	600	300	300	300	2
500	3050	3050	3050	3050	3050	3000	1800	1000	600	300	300	300	2
550	3050	3050	3050	3050	3050	3000	2500	1500	900	600	450	300	3
610	3050	3050	3050	3050	3050	3000	3000	3000	1200	900	900	450	4
650	3050	3050	3050	3050	3050	3000	3000	3000	2000	1000	1000	450	4
700	3050	3050	4600	4600	4600	3000	3000	3000	2200	1000	1000	600	4
750	3050	3050	4600	4600	4600	4600	3500	3000	3000	1250	1200	600	6
800	3050	3050	4600	4600	4600	4600	3500	3000	3000	1500	1200	600	6
850	3050	3050	4600	4600	4600	4600	3500	3500	3000	2500	1200	1000	6
900	3050	3050	4600	4600	4600	4600	3500	3500	3500	2500	2250	2000	1
950	3050	3050	4600	4600	4600	4600	4600	3500	3500	3000	2250	2000	1
1000	3050	3050	4600	4600	4600	4600	4600	4600	3500	3500	3500	3500	3
1200	3050	3050	4600	4600	4600	4600	4600	4600	3500	3500	3500	3500	3
1400	3050	3050	4600	4600	4600	4600	4600	4600	3500	3500	3500	3500	3
1600	3050	3050	4600	4600	4600	4600	4600	4600	3500	3500	3500	3500	3
1800	3050	3050	4600	4600	4600	4600	4600	4600	3500	3500	3500	3500	3
2000	3050	3050	4600	4600	4600	4600	4600	4600	3500	3500	3500	3500	3
2200	3050	3050	4600	4600	4600	4600	4600	4600	3500	3500	3500	3500	3
2400	3050	3050	4600	4600	4600	4600	4600	4600	4000	3500	3500	3500	3
2600	3050	3050	4600	4600	4600	4600	4600	4600	4600	3500	3500	3500	3
2800	3050	3050	4600	4600	4600	4600	4600	4600	4600	3500	3500	3500	3
3000	3050	3050	4600	4600	4600	4600	4600	4600	4600	3500	3500	3500	3
3500+	3050	3050	4600	4600	4600	4600	4600	4600	4600	3500	3500	3500	3

a)

45	50	55	60	65	70	75	80	90	100
100	150								
100	150								
100	150								
100	300	150							
150	300	300	150						
150	300	300	300	150					
150	300	300	300	200	150				
200	300	300	300	250	200				
200	400	300	300	300	300				
200	400	400	300	300	300				
275	1500	1250	1000	500	300				
275	1500	1250	1000	500	300				
350	3500	2500	2000	1500	1000	500			
350	3500	2700	2300	1900	1250	700			
350	3500	2900	2600	2250	1600	900	450		
350	3500	3100	2900	2750	2000	1200	450		
350	3500	3300	3200	3000	2300	1500	700	450	
350	3500	3500	3500	3500	2650	2000	1400	1100	
350	3500	3500	3500	3500	2750	2000	1600	1200	
350	3500	3500	3500	3500	3000	2250	1800	1300	
350	3500	3500	3500	3500	3000	2400	2000	1400	
350	3500	3500	3500	3500	3500	2600	2200	1500	
350	3500	3500	3500	3500	3500	3000	2500	1750	
350	3500	3500	3500	3500	3500	3500	2500	2000	1400

Capacity Guide
For S275
Yield Steel

Table gives maximum cylinder length we can roll for given diameter and wall thickness

Submerged Arc Welding



Key Points

- Column and Boom manipulators allow us to produce welded cylinders from 4000 to 350 diameter.
- Small diameters down to 350 mm can be Submerged Arc Welded from the inside utilising an adapted head.
- Circumferential seams can be produced, offering multiple belts up to 12 metres Long.
- All procedures and welders qualifications to EN / ASME codes.
- NDT & PWHT services available
- MMA – MIG & TIG processes also available.

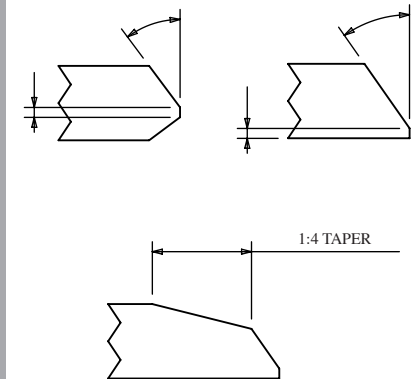
All welded cylinders re-rolled to maintain tolerance therefore avoiding return transport cost if done by others.



Edge Prepping

Weld preparations to Our Supply / Free Issue material can be produced utilising the following Methods:-

- Flame / Plasma Bevelling – By means of a motorised unit with a positional head. (Note: This can be adapted to produce Tapers such as 1:4 to inside or outside surfaces)
- Mechanical – Punch Nibbling / Rotary Shear
- All standard weld preps produced (Single or Double vee)



Shearing

- Capacity 8 Metres x 10 mm
- 6 Metres x 16 mm
- Complete Supply or Free Issue
- Carbon / Stainless / Aluminium

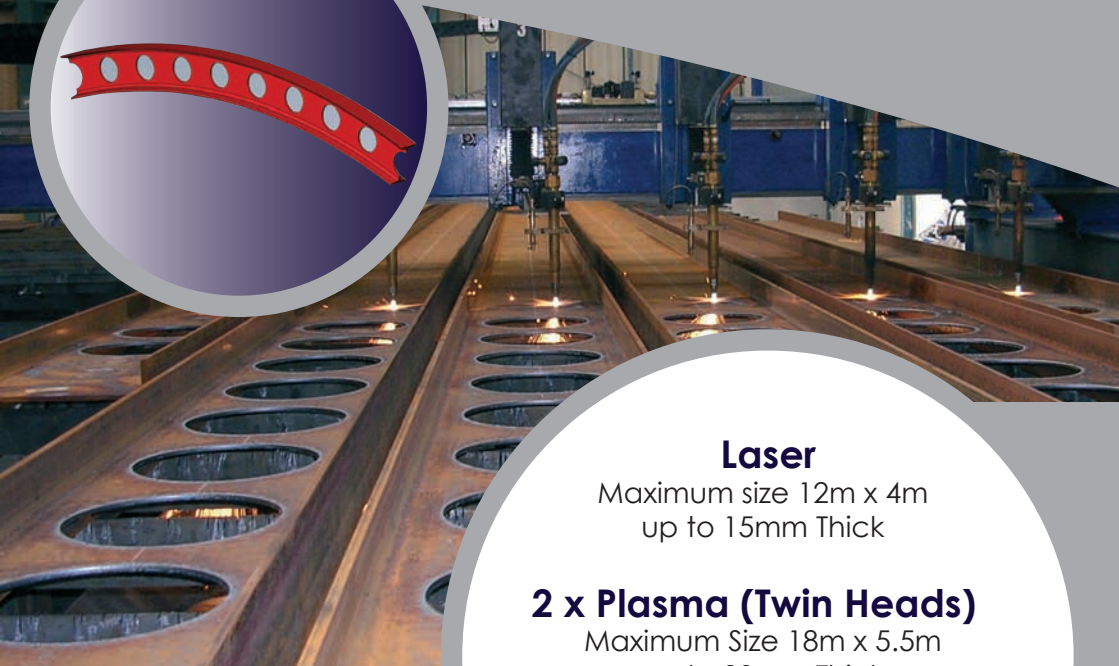
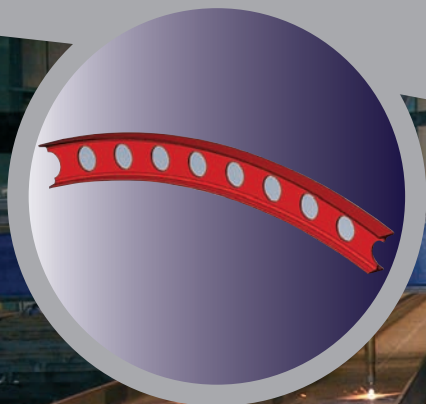


Laser, Plasma & Flame Cutting

Key Points

- CAD / CAM programming facilities supporting 2D & 3D file formats
- All types of development work undertaken
- All cutting facilities fully CNC controlled.
- All grades of Mild / Carbon / Boiler / Pressure & Stainless steel plates.





Laser

Maximum size 12m x 4m
up to 15mm Thick

2 x Plasma (Twin Heads)

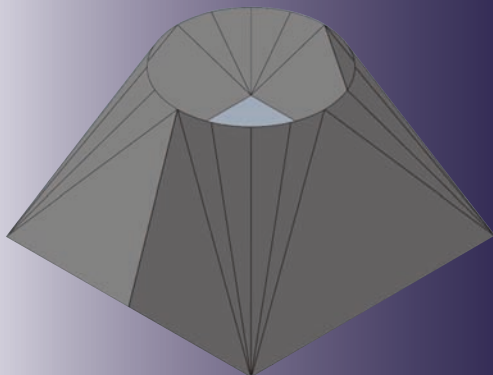
Maximum Size 18m x 5.5m
up to 30mm Thick

6 Head Flame Cutting

Maximum Size 18m x 5m
up to 200mm Thick

Typical Products

- Square / Rectangular straight line cutting
- All pipe work developments including Branches / Cones/ Lobster Back bends & Transitions (Square to Rounds etc)
- Standard / complex Laser cut shapes with or without holes / slots
- Porthole Beams



Our Company



- 6 manufacturing sites located around the UK
- Established in 1969
- 300, 000 Sq Foot of production floor space
- Over 120 specialist bending machines
- The Worlds largest Steel Bending Company

Press Braking & Plate Rolling

Barnshaws Plate Bending
Anchor Lane
Coseley
West Midlands
WV14 9NE

Tel: 01902 880250
Fax: 01902 880505
E-mail: platebending@barnshaws.com

Laser, Plasma & Flame Cutting

Barnshaws Profile Cutting
Anchor Lane
Coseley
West Midlands
WV14 9NE

Tel: 01902 663553
Fax: 01902 887379
E-mail: profiling@barnshaws.com

www.barnshaws.com