



— COMPANY BROCHURE

We Shape Steel to Perfection!

Certified welded structures, CNC large-part machining and ready-to-install assemblies — in Lorch since 1963.

63+

YEARS OF EXPERIENCE

50 t

MAX. PART WEIGHT

26 m

PORTAL MILLING TRAVEL

14,000 m²

PRODUCTION AREA

Owner-managed since 1963



Aerial view of Bock Maschinenbau production site in Lorch

Bock Maschinenbau GmbH is an owner-managed manufacturing company in Lorch, Baden-Württemberg. What began in 1963 as a metalworking shop is today a certified welding company and full-service manufacturer for steel construction, contract manufacturing and special machine building.

From flame cutting, forming, welding and CNC large-part machining to blasting, painting and assembly, everything is done under one roof — components up to 50 t part weight, made to customer drawing, as one-offs or in series.

We work to DIN EN 1090-2 EXC3 and EN ISO 3834-2 — with our own non-destructive testing, material traceability to DIN EN 10204 and predominantly European quality steels.

63+

YEARS OF EXPERIENCE

100

QUALIFIED SPECIALISTS

14,000 m²

PRODUCTION AREA

20+

MACHINES IN THE PARK

40+

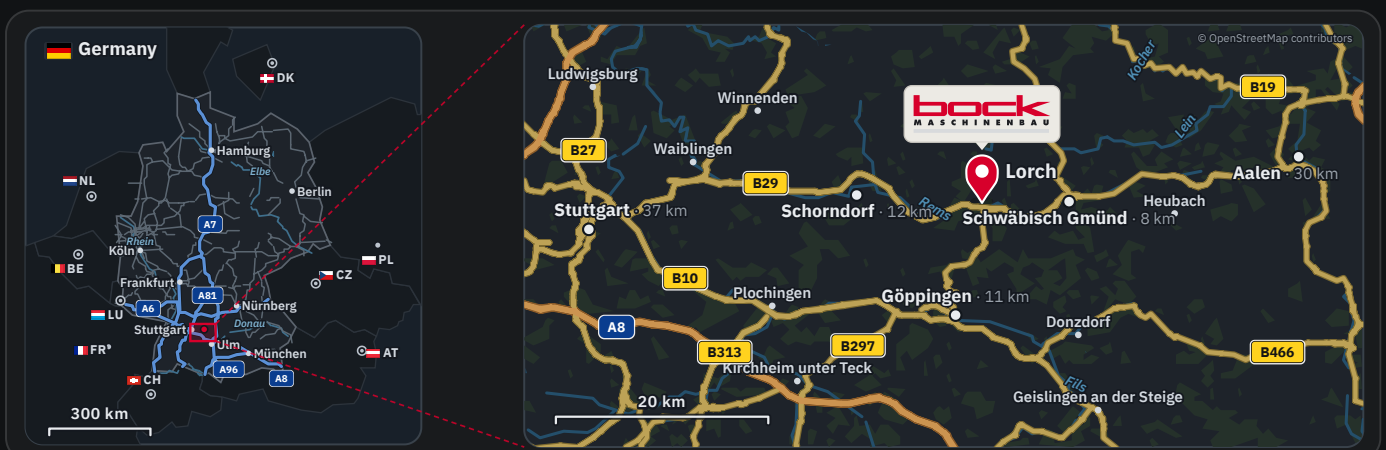
MATERIAL GRADES

50 t

MAX. PART WEIGHT

LOCATION & REACH

Lorch in the heart of the Stuttgart region — an owner-managed manufacturing partner with short distances to all of southern Germany.



Everything under one roof

One manufacturing drawing, one contact, one continuous process chain: every step stays in-house — no interfaces, no transport risk, full control of deadlines.

01 Cutting

Oxy-fuel, plasma and saw cutting for plate, tube and sections — up to 200 mm material thickness.

02 Forming

Press-brake bending with up to 1,000 t press force and plate rolling to large diameters.

03 Welding

MAG, TIG and SAW welding to DIN EN 1090-2 EXC3 and EN ISO 3834-2.

04 Post-treatment

Vibration stress relief and flame straightening for low-stress, dimensionally stable parts.

05 Machining

CNC large-part machining — milling, drilling and turning up to 26 m part length.

06 Surface

Shot blasting and industrial painting in two large-volume booths.

07 Assembly

Fitting and assembly work through to the ready-to-install assembly.

08 Quality & testing

Non-destructive testing (VT · MT · PT) and re-stamping certificate to DIN EN 10204.

Materials

Over 40 processed material grades — from structural steel to S1100.

Turnkey construction

Special machines and special containers from a single source.

Reconditioning

Repair and refurbishment — repair instead of replace.



Production, machinery and large-part machining in practice

Selected impressions from cutting, forming, welding technology, CNC machining and surface finishing.



OXY-FUEL CUTTING

Cutting thick steel plate to contour in large formats



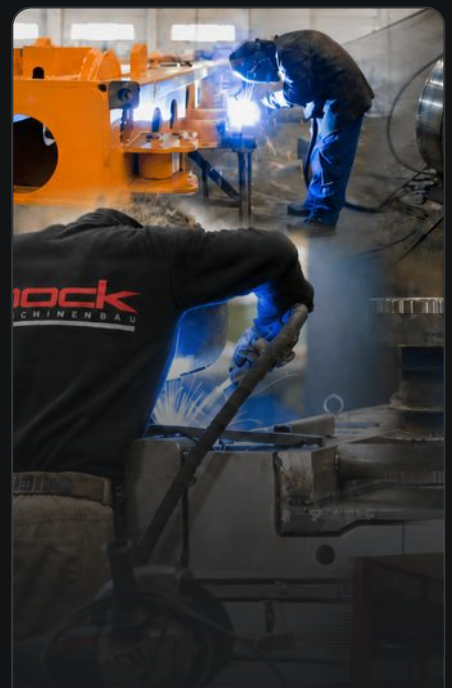
PLATE ROLLING

Rolling heavy plate into tubes, rings and cones



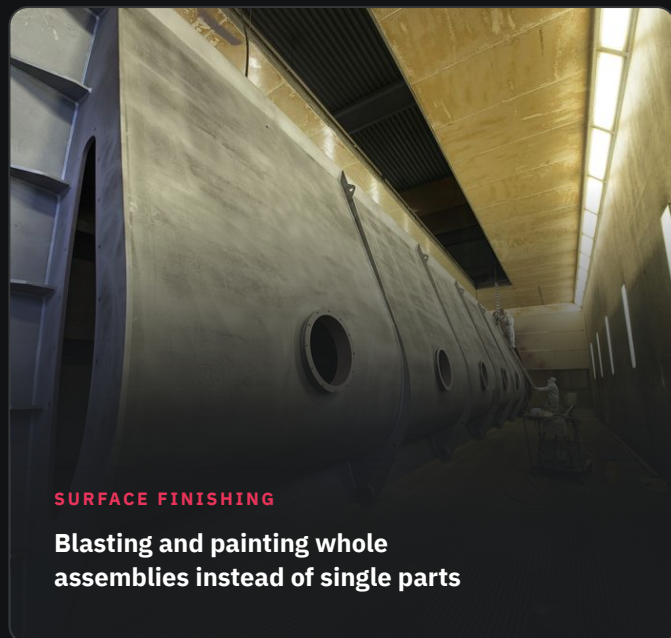
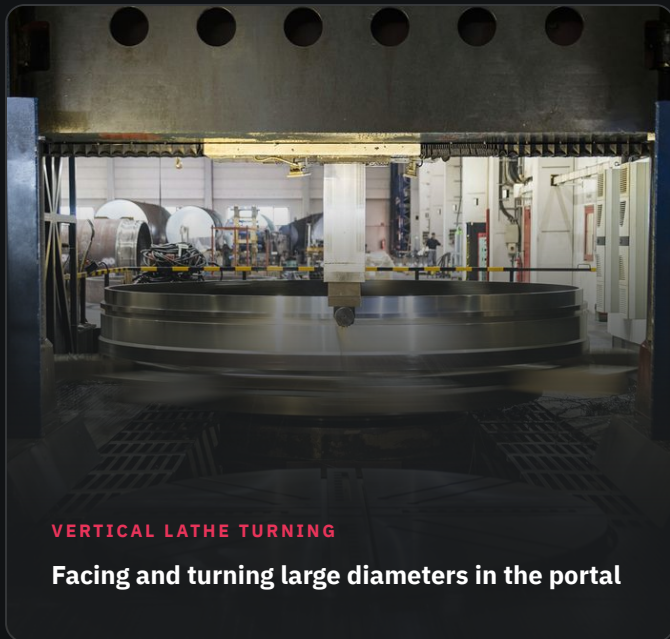
PRESS BRAKE BENDING

Cold-forming heavy steel plate instead of elaborate welding



WELDING TECHNOLOGY

Welded assemblies to DIN EN 1090-2 EXC3 from our own production



01 Large-format plasma cutting

CNC-controlled plasma cutting on two large-format systems sharing a 20 × 3.5 m table — up to 60 mm cutting thickness, plus guillotine shearing for plate.

20 × 3.5 m
FLAME-CUTTING FORMAT



MACHINE	FORMAT	CUTTING THICKNESS	BEVEL CUT
Messer OmniMat HT-L 5000 · HPR 400 · Plasma cutting system	20,000 × 3,500 mm	up to 60 mm	±45°
Zinser 4125 · Underwater plasma cutting system	8,000 × 2,500 mm	up to 30 mm	±40°



Guillotine shear
Cutting length 6,100 mm · sheet up to 15 mm

MACHINE	CUTTING LENGTH	PLATE THICKNESS
Eclair · Guillotine shear	6,100 mm	up to 15 mm

01 Flame cutting & mitre sawing

Oxy-fuel cutting up to 200 mm wall thickness on the same 20 × 3.5 m table — plus saw cutting: one band saw and three circular saws mitre-cut tube and sections up to Ø 406 mm.

200 mm
FLAME-CUT THICKNESS



Messer OmniMat L5000 Autogen Alfa
20,000 × 3,500 mm · up to 200 mm · bevels ±45°



MACHINE	FORMAT	CUTTING THICKNESS	BEVEL CUT
Messer OmniMat L5000 · Oxy-fuel cutting machine	20,000 × 3,500 mm	up to 200 mm	±45°



MEBA DGA 400
Band saw



Kaltenbach KKS 400EC
Circular saw



Kaltenbach KKS 400H
Circular saw



Behringer VMS 350
Circular saw

MEBA · Kaltenbach · Behringer 4x

Band saw + 3 circular saws · Ø up to 406 mm · miter up to 90°

MACHINE	ROUND STOCK Ø	FLAT STOCK	MITER ANGLE
MEBA DGA 400 · Band saw	Ø 406 mm	700 × 400 mm	-45°...+60°
Kaltenbach KKS 400EC · Circular saw	Ø 130 mm	300 × 40 mm	0°...90°
Kaltenbach KKS 400H · Circular saw	Ø 130 mm	300 × 40 mm	0°...90°
Behringer VMS 350 · Circular saw	Ø 102 mm	170 × 100 mm	0°...45°

01 Contour cutting on tube

Tube cutting with contours: copy flame cutting and 3D plasma tube cutting with bevel cuts.



ZINSER

Copy flame-cutting machine

up to 50 mm wall thickness · 2 torches simultaneously



MACHINE

Zinser · Copy flame-cutting machine

WALL THICKNESS

up to 50 mm

FORMAT

2,500 × 1,200 mm



ZINSER

3D plasma pipe-cutting system

up to 30 mm wall thickness · 3-axis CNC

MACHINE

Zinser · 3D plasma pipe-cutting system

WALL THICKNESS

up to 30 mm

BEVEL CUT

±45°

02 Bending & plate rolling

Force meets repeat accuracy: two press brakes and four 3-roll plate rolling machines form plate from small batches to thick-walled large shells.

1,000 t

PRESS-BRAKE FORCE

Ø 8,000 mm

PLATE ROLLING / BENDING

BENDING



Weinbrenner

WEINBRENNER · SCHARRINGHAUSEN · 2x

1,000 t press force · 6,100 mm length



Scharringhausen

MACHINE	PRESS FORCE	BENDING LENGTH
Weinbrenner · Press brake	1,000 t	6,100 mm
Scharringhausen · Press brake	550 t	6,100 mm

ROLLING



Sertom



SMT-Pullmax Kumla



Davi 2048S



Wilhelmsburger DWV

Plate rolling machine 4x

up to Ø 8,000 mm · up to 120 mm plate thickness · three-point bending

MACHINE	INNER DIAMETER Ø	PLATE THICKNESS	ROLL LENGTH	TOP ROLL Ø
Sertom · Plate rolling machine	Ø 400–8,000 mm	8–120 mm	up to 3,050 mm	Ø 300 / 450 / 650 mm
SMT-Pullmax Kumla · Plate rolling machine	Ø 400–6,000 mm	4–60 mm	up to 2,000 mm	Ø 375 mm
Davi 2048S · Plate rolling machine	Ø 340–6,000 mm	8–80 mm	up to 2,000 mm	Ø 305 / 460 mm
Wilhelmsburger DWV · Plate rolling machine	Ø 300–5,000 mm	4–30 mm	up to 3,150 mm	Ø 275 / 345 mm

03 MAG, TIG & submerged arc

Certified welding technology is our core: MAG, TIG and submerged arc — from the manual welding station to the SAW column, for structures up to 50 t part weight.

EXC3

CERTIFIED WELDING

EN ISO 3834-2

WELDING QUALITY

50 t

MAX. PART WEIGHT



Oerlikon · ESAB · Lorch · Böhler

DIN EN 1090-2 EXC3 · EN ISO 3834-2

- Welded structures up to **50 t**, components up to **26 m** long
 - S235 structural steel to **S1100**, plus Hardox and stainless steel
 - In-house non-destructive testing — VT · PT · MT to DIN EN ISO 9712
- 135 MAG · 141 WIG · 121 UP



Overhead crane 2x

2 × 25 t · up to 50 t part weight

- Coupled in tandem, both cranes lift up to **50 t**
- Vessels, crane girders and rolled large pipes — no two components alike
- Load securing and loading of heavy structures onto the low-loader XXL parts · Loading



ESAB ROMAR RM7070 SAR 400



ESAB CAB 300M



ESAB MKP

Submerged-arc welding column & boom 3x

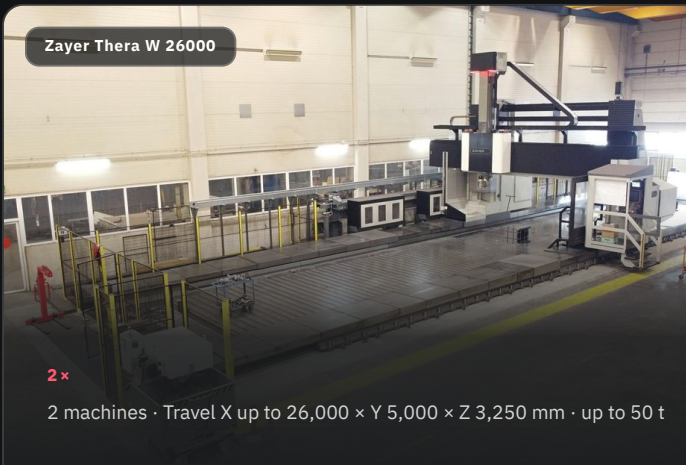
3 submerged-arc columns · up to 7 m reach · 1,250 A

- Fully mechanised submerged arc — reproducible weld quality on long components
- Longitudinal seams on shells, girders and large pipes in a single setup

MACHINE	REACH	WORKING HEIGHT	WELDING CURRENT	WIRE DIAMETER
ESAB ROMAR RM7070 SAR 400 · Submerged-arc welding column & boom	7 m	7 m	1,250 A	up to 4 mm
ESAB CAB 300M · Submerged-arc welding column & boom	4 m	5 m	800 A	up to 4 mm
ESAB MKP · Submerged-arc welding column & boom	5 m	5 m	800 A	up to 4 mm

04 Gantry milling up to 26 m

Large-part machining is our home ground: gantry milling with up to 26 m of travel and a floor-type milling centre with rotary table – for components that do not fit on the table elsewhere.



Zayer Thera W 26000

2 ×

2 machines · Travel X up to 26,000 × Y 5,000 × Z 3,250 mm · up to 50 t



Zayer Thera W 16000

PARAMETER	ZAYER THERA W 26000	ZAYER THERA W 16000
X travel (length)	26,000 mm	16,000 mm
Y travel (width)	5,000 mm	4,000 mm
Z travel (height)	3,250 mm	2,850 mm
Table clamping surface	26,500 × 4,000 mm	16,500 × 3,000 mm
Milling head	30°, positionable in any position to 0.001°	30°, positionable in any position to 0.001°
Main motor	Heidenhain · 43 kW	Heidenhain · 43 kW
Control	Heidenhain iTNC 640 HSCI	Heidenhain iTNC 530 HSCI
Guideway	Roller way with adjustable pre-tensioning	Roller way with adjustable pre-tensioning





Soraluce FR 20.000

Travel 20,000 × 4,000 × 1,600 mm · up to 50 t

Design	Floor-type milling-boring center, tilting milling head
X travel (length)	20,000 mm
Y travel (width)	4,000 mm
Z travel (height)	1,600 mm
Rotary table	Demmeler 2,500 × 2,500 mm
Machining operations	Milling · Boring · Line boring
Control	Heidenhain iTNC 530

04 Horizontal boring mills

Plus horizontal boring mills for complete machining after welding — hole patterns, fits and face surfaces on large components, planned in a single setup.

26 m

PORTAL MILLING TRAVEL



Number of machines	3 (parallel capacity, identical)
Boring spindle diameter	Ø 130 mm
Travel path X (transverse)	3,500 mm
Travel path Y (vertical)	2,500 mm
Travel path Z (longitudinal)	1,200 mm
Rotary table	360° rotatable – multi-face machining in a single setup
Machining operations	Boring · milling · line boring · facing · thread cutting
Control	Heidenhain iTNC 530

04 Vertical turning, radial drilling & threading

Vertical turning up to Ø 4,800 mm, plus radial drilling and thread cutting: hole patterns, threads and fits — even on large components that are already welded.

Ø 4,800 mm
TURNING DIAMETER



Feichter FKD30/20
Vertical turning lathe



TOS SUS 63H
Lathe



Meuser
Lathe

Turning & Vertical Turning 3x

Ø 4,800 mm · 2,400 mm height · up to 25 t

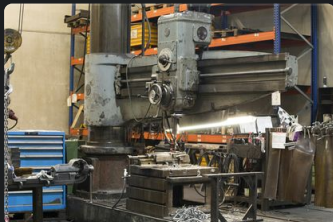
PARAMETER	FEICHTER FKD30/20	TOS SUS 63H	MEUSER
Turning diameter	Ø 4,800 mm	Ø 655 mm	Ø 350 mm
Turning height	2,400 mm	—	—
Drilling height	2,000 mm	—	—
Turning length	—	2,000 mm	1,000 mm
Table load	25 t	—	—



Raboma 12UH 3000
Radial drilling machine



Invema FR 65
Radial drilling machine



Kolb HK 80
Radial drilling machine



Gamor RHG-3BR
Tapping machine

Raboma · Invema · Gamor 4x

Drilling up to Ø 90 mm · threads M2–M60 · reach up to 3,000 mm

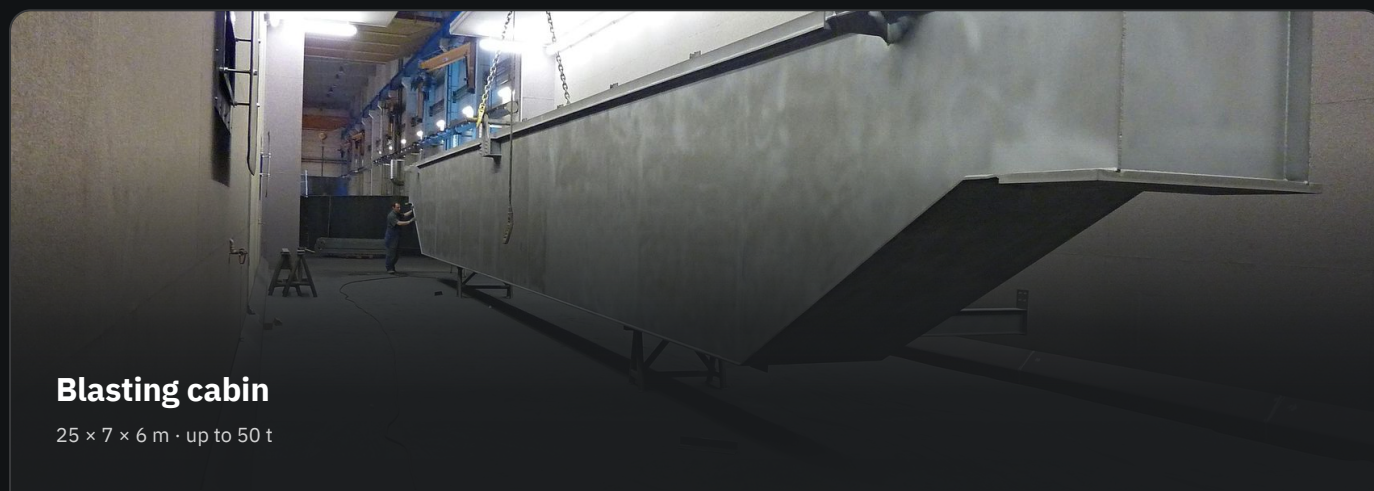
MACHINE	REACH	SPINDLE-TABLE	DRILLING Ø	THREAD
Raboma 12UH 3000 · Radial drilling machine	3,000 mm	up to 1,605 mm	up to Ø 90 mm	up to M60
Invema FR 65 · Radial drilling machine	2,000 mm	up to 1,740 mm	up to Ø 90 mm	up to M60
Kolb HK 80 · Radial drilling machine	1,600 mm	up to 1,205 mm	up to Ø 80 mm	up to M52
Gamor RHG-3BR · Tapping machine	—	—	—	M2–M48

05 + 06 Blasting, painting, stress relief

Corrosion protection at component scale: blasting and painting in two large-volume booths — preceded by vibration stress relief for the dimensional accuracy of the finish-machined structure.

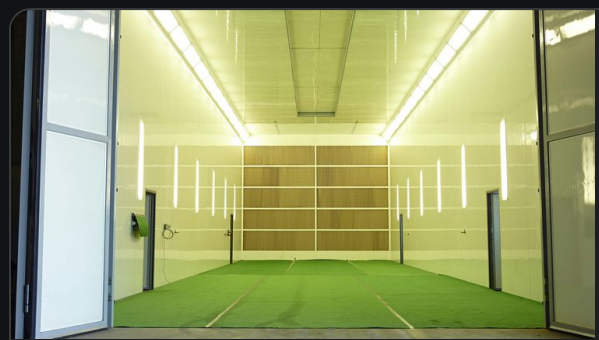
25 × 7 × 6 m

BLASTING & PAINTING



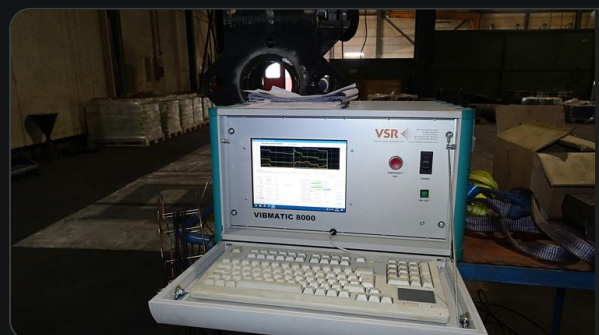
Blasting cabin
25 × 7 × 6 m · up to 50 t

MACHINE	CABIN DIMENSIONS	SURFACE CLEANLINESS
Blasting cabin	25 × 7 × 6 m	Sa 2,5



Paint booth
25 × 7 × 6 m · up to 50 t

MACHINE	CABIN DIMENSIONS	COATING STANDARD
Paint booth	25 × 7 × 6 m	EN ISO 12944



VIBMATIC 8000
Residual-stress reduction · dimensionally stable
VSR · without heat

Materials & certifications

Reliable quality starts with the material and ends with the evidence: every heat is traceable, every welding process qualified, every test documented.



EN 1090-2

Execution class EXC3

DVS ZERT — Zertifizierungsstelle des DVS



ISO 3834-2

Welding processes 121 (SAW) · 135 (MAG) · Material groups 1.1, 1.2, 3.1, 8.1

DVS ZERT — Zertifizierungsstelle des DVS



AD 2000 HP 0

Welding processes 135 (MAG) · Material groups 1.1, 1.2, 8.1 · unfired pressure vessels without heat treatment

GSI SLV — Gesellschaft für Schweißtechnik International mbH



ISO 9001

TÜO — Technische Überwachungsorganisation für Sicherheit, Qualität und Umweltschutz GmbH

In-house non-destructive testing (VT · MT · PT) to DIN EN ISO 9712, Level 2 — and re-stamping authorisation for 3.1 inspection certificates to DIN EN 10204 (GSI SLV).

PROCESSED MATERIAL GRADES (SELECTION)

Structural steel	S235, S355, S355J2+N, E295, E355, Cortenstahl
Fine-grained structural steel (high-strength)	S460, S690QL, S890QL, S960, S1100QL, S700MC
Wear-resistant steel	Hardox 400/500, XAR 400, Dillidur, Creusabro, Brinar, Weldox
Stainless steel (austenitic)	1.4301, 1.4307, 1.4404, 1.4541, 1.4571, AISI 304/316
Duplex & special materials	1.4462
Pressure-vessel steel	P265GH, P355GH, 16Mo3 (1.5415), 13CrMo4-5 (1.7335), A516
Quenched and tempered steel	42CrMo4 (1.7225), 34CrNiMo6, C45, 16MnCr5
Tool steel (martensitic)	1.4021, 1.4057, 1.2312, 1.2083
Cast iron	GJS, EN-GJS-400/500, GGG50

Preferably European quality steels with traceable origin; special materials according to availability and customer specification.

Show us your component.

A manufacturing drawing is enough — and you get an honest assessment of feasibility, lead time and price, directly from the people who make your part. One contact, everything under one roof: from single part to ready-to-install assembly.



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REGION

Baden-Württemberg
Ostalbkreis · Stuttgart Region



Straight to our machinery, services
and contacts



EN 1090-2



ISO 3834-2



ISO 9001



AD 2000 HP 0