

BOCK MASCHINENBAU GMBH • 73547 LORCH

Manufacturing capacities

19 machines and systems in 6 manufacturing stages — from flame cutting and forming through welding and CNC machining to surface and post-treatment.

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50 t

MAX. PART WEIGHT

26 m

PORTAL MILLING TRAVEL

200 mm

FLAME-CUT THICKNESS

1,000 t

PRESS-BRAKE FORCE

Ø 8,000 mm

PLATE ROLLING /
BENDING

Ø 4,800 mm

TURNING DIAMETER

EXC3

CERTIFIED WELDING

40+

MATERIAL GRADES

01 Cutting & blanking

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



Messer OmniMat HT-L 5000 · HPR 400
Plasma cutting system



Zinser 4125
Underwater plasma cutting system

Messer · Zinser 2x

20,000 × 3,500 mm · up to 60 mm · plasma source HPR 400

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°



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°



Guillotine shear

Eclair

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



Copy flame-cutting machine

Zinser

up to 50 mm wall thickness · 2 torches simultaneously

MACHINE	WALL THICKNESS	FORMAT
Zinser · Copy flame-cutting machine	up to 50 mm	2,500 × 1,200 mm



3D plasma pipe-cutting system

Zinser
up to 30 mm wall thickness · 3-axis CNC

MACHINE	WALL THICKNESS	BEVEL CUT
Zinser · 3D plasma pipe-cutting system	up to 30 mm	±45°

02 Forming

Press-brake bending with up to 1,000 t press force and plate rolling up to Ø 8,000 mm.



Weinbrenner



Scharringhausen

Press brake 2x

Weinbrenner · Scharringhausen
1,000 t press force · 6,100 mm length

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



Sertom



SMT-Pullmax Kumla



Davi 2048S



Wilhelmsburger DWV

Plate rolling machine 4x

Sertom · SMT-Pullmax · Davi · Wilhelmsburger

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 Welding technology

MAG and SAW welding to DIN EN 1090-2 EXC3, TIG by qualified welders — with welding positioners, turning rolls and SAW columns.



Oerlikon · ESAB · Lorch · Böhler

DIN EN 1090-2 EXC3 · EN ISO 3834-2

135 MAG · 141 WIG · 121 UP



ESAB ROMAR RM7070 SAR 400



ESAB CAB 300M



ESAB MKP

Submerged-arc welding column & boom 3×

ESAB

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

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



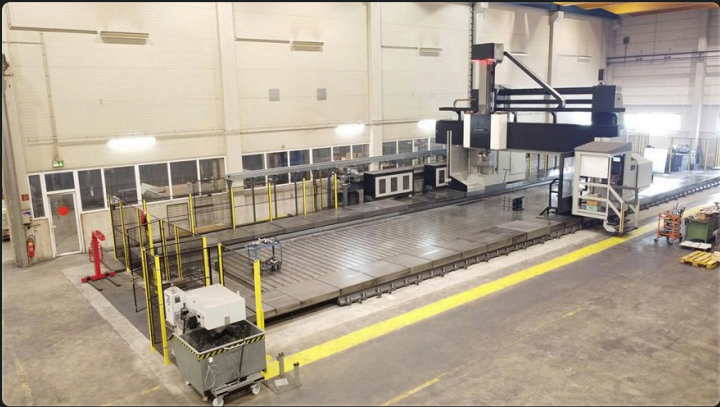
Overhead crane 2×

2 × 25 t · up to 50 t part weight

MACHINE	LIFTING CAPACITY
Overhead crane	25 t
Overhead crane	25 t

04 Machining

CNC large-part machining — milling, drilling, turning and line boring up to 26 m part length and 50 t.



Zayer Thera W 26000



Zayer Thera W 16000

Zayer Thera W 26000 + 16000 2x

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

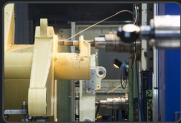
PARAMETER	ZAYER THERA W 26000	ZAYER THERA W 16000
X travel (length)	26,000 mm	16,000 mm
Y travel (width)	5,000 mm	4,000 mm
Z travel (height)	3,250 mm	2,850 mm
Table clamping surface	26,500 × 4,000 mm	16,500 × 3,000 mm
Milling head	30°, positionable in any position to 0.001°	30°, positionable in any position 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



TOS-Varnsdorf WHN 13 CNC 3×

Ø 130 mm spindle ·
Travel X 3,500 × Y 2,500 × Z 1,200 mm

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



Feichter FKD30/20
Vertical turning lathe



TOS SUS 63H
Lathe



Meuser
Lathe

Turning & Vertical Turning 3x

Feichter · TOS · Meuser

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 Surface & corrosion protection

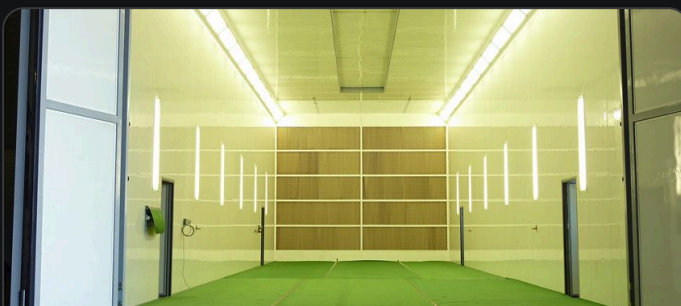
Shot blasting to Sa 2.5 and industrial painting to EN ISO 12944 in booths up to 25 × 7 × 6 m.



Blasting cabin

25 × 7 × 6 m · up to 50 t

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



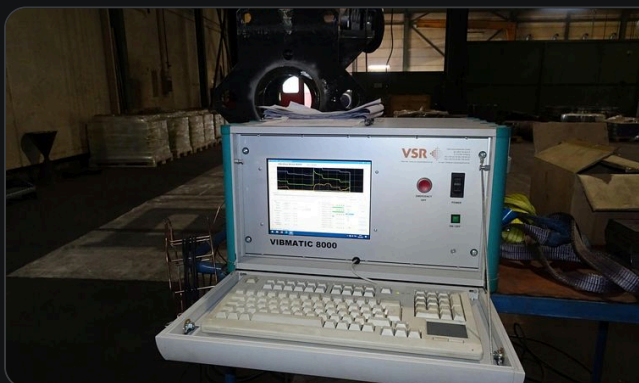
Paint booth

25 × 7 × 6 m · up to 50 t

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

06 Post-treatment

Vibration stress relief (VSR) for dimensionally stable components low in residual stress — without thermal distortion.



VIBMATIC 8000

Residual-stress reduction · dimensionally stable

VSR · without heat



Straight to our machinery and
contacts

Does your component fit in here?

You have now seen our complete machinery. Send us your manufacturing drawing — you will receive an honest assessment of feasibility, lead time and price. From single part to assembled unit.



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EN 1090-2



ISO 3834-2



ISO 9001



AD 2000 HP 0

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