



Precise moulding foundry










ABOUT COMPANY

SPL obchodní s.r.o. is the company which offers production of precisely moulded steel casts to her customers.

TENDER PROCESS

-  At this time, we have spare capacity and accept new demands.
-  Demands we accept via our contact.
-  Usual demand processing time is 1 – 3 days.
-  With low fixed costs and long-term experience with the production of casts we are able to guarantee highly competitive prices of produced casts to our customers.
-  We can guarantee precise delivery times and very individual family firm approach.

HISTORY OF PRECISELY MOULDED CASTS PRODUCTION IN DVŮR KRÁLOVÉ NAD LABEM

Production of steel casts by lost wax method in the foundry Dvůr Králové n/L has more than 25 year old tradition. Company Strojtex began with production in the 1980's. In 1990's in the context of large scale privatization the state property was moved into the hands of private company and this company was transformed on the company Strojtex a.s.

In 2005, our company acquired production of precise moulding after reorganisation of the company Strojtex a.s.

During the above mentioned years, our company delivered on market 40 – 50 t of precisely moulded casts per years. It is clear sign, that our company mastered the technology of lost wax method, her output is steel cast in high quality.

CURRENT TIME

Our company currently has 25 employees, our common goal is to produce and to delivery on market 100 t of precisely moulded steel casts yearly. Production of casts by lost wax method is carried out on machinery which we are continuously modernizing and the production process is constantly improving.

KEY CUSTOMERS

Most of the key customers of our company operate in the automotive industry of the Czech Republic. We also supply to agriculture and engineering industry, we produce also commercial casts for end customers. The company goal for the coming year is to develop export, currently export represents only a fraction of total turnover.



SPECIFICATION OF THE MOST USED MATERIALS

Class	Material marking	% C	% Mn	% Si	% Cr, Mo, Ni, V, Cu	% P+S	Tensile strength (MPa)	Hardness (HB)
Steels class 42 26xx	ON 42 2602	Max. 0,18	0,40 - 0,80	0,20 - 0,50	Max. 0,25 Cr	Max. 0,070	Min. 390	Max. 130
	ON 42 2603	0,17 - 0,25	0,50 - 0,90	0,20 - 0,50	Max. 0,30 Cr	Max. 0,070	Min. 390	Max. 130
	ČSN 42 2630	0,10 - 0,20	0,40 - 0,80	0,20 - 0,50	X	Max. 0,090	370 - 520	105 - 150
	ČSN 42 2633	0,10 - 0,18	0,50 - 0,90	0,20 - 0,50	Max. 0,30 Cr	Max. 0,070	Min. 390	Max. 130
	ČSN 42 2640	0,20 - 0,28	0,40 - 0,80	0,20 - 0,50	X	Max. 0,090	440 - 590	125 - 170
	ČSN 42 2650	0,28 - 0,38	0,40 - 0,80	0,20 - 0,50	X	Max. 0,090	500 - 650	145 - 185
Steels class 42 27xx	ČSN 42 2660	0,40 - 0,50	0,40 - 0,80	0,20 - 0,50	X	Max. 0,090	590 - 740	170 - 210
	ČSN 42 2709	0,20 - 0,28	1,20 - 1,60	0,20 - 0,50	X	Max. 0,090	520 - 670	149 - 184
	ČSN 42 2711	0,65 - 0,80	1,10 - 1,60	0,20 - 0,50	X	Max. 0,080	800 - 1000	235 - 295
Low- and medium alloyed steels Class 42 28xx	ČSN 42 2714	0,15 - 0,22	1,00 - 1,50	Max. 0,45	Max. 0,30 Cr Max. 0,50 Ni Max. 0,30 Cu	X	800 - 1000	235 - 295
	ON 42 2809	0,20 - 0,28	1,20 - 1,60	0,20 - 0,50	X	Max. 0,090	Min. 500	149 - 184
	Steels cl. 42 28xx	0,45 - 0,55	0,60 - 0,90	0,60 - 0,90	X	Max. 0,070	600 - 800	Max. 230
	ON 42 2825	0,95 - 1,05	0,40 - 0,70	0,20 - 0,40	1,25 - 1,50 Cr	X	Min. 740	Max. 225
Steels to cementation	ON 42 2842	0,10 - 0,20	0,60 - 0,90	0,30 - 0,60	0,80 - 1,10 Cr 0,20 - 0,35 Mo	Max. 0,070	Min. 500	Max. 234
	ON 42 2848	0,28 - 0,38	0,40 - 0,70	0,30 - 0,60	2,80 - 3,50 Cr 0,40 - 0,70 Mo 0,12 - 0,25 V	Max. 0,070	Min. 800	Max. 269
Steels to surface hardening	16MnCr5	0,14 - 0,19	1,00 - 1,30	Max. 0,40	0,80 - 1,10 Cr	X	Min. 785 (In hardener state)	Min. 152
	GS50CrV4	0,46 - 0,54	0,50 - 0,80	0,25 - 0,50	0,90 - 1,20 Cr 0,07 - 0,12 V	X		Max. 225

Production of materials with other quality than the quality mentioned in the table is possible to negotiate within tender.

Weight of steel casts	0,01 – 1,5 kg according to shape and dimensions of casts
Thickness of the casts	min. 2 mm
Maximal dimensions	200 x 200 x 70 mm
Roughness of surface	6,3 – 16
Casts are delivered according to standard	ČSN 421251
Dimensional tolerance of casts according to	ČSN 014470.2
Atests	chemical analysis
Hardness	in HB
Heat treatment	Casts are annealed according to standard

CONTACT

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OUR PARTNERS

