Stremet
LEVYSTÄ TUOTTEEKSI

Machinery

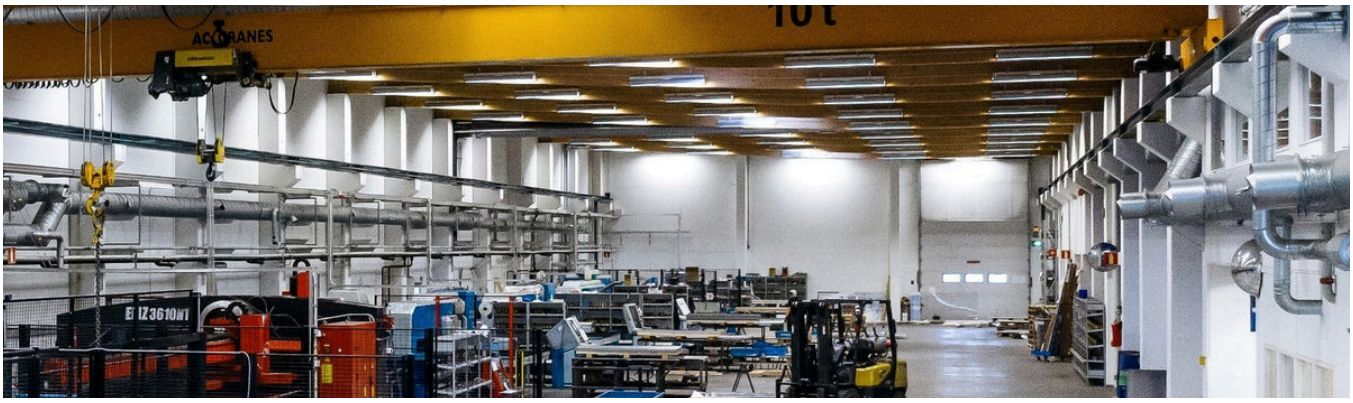
Machines and capacity for sheet metal parts and assemblies

Cutting Punching Bending Welding Assembly



Machinery at a glance

We make sheet metal parts and assemblies from one-off prototypes to batches of around 10,000 pieces. Cutting, bending, welding and assembly are done in-house. Surface treatment and robot welding are handled through our partner network on the same order.



1,500 × 3,000 mm
standard sheet size in laser cutting

30 mm
max cutting thickness, steel

4,000 mm
longest sheet on the combi machine

3,500 mm
max bending length

1,700 kN
max press brake force

1–10,000 pcs
batch sizes

Machines by process

Process	Machines	Page
Laser cutting	5 fibre lasers	4–5
Punching and combi machines	9 punching machines, 2 punch-laser combis	6–8
Press brake bending	21 press brakes	9
Automated bending	3 robotic bending cells, 2 panel benders	10–11
Rolling and welding	2 plate rolls; MIG/MAG, TIG and laser welding	12
Finishing and secondary operations	Deburring, tapping, laser marking, drilling, pressing	13
Joining and packing	4 insertion presses, 4 spot welders, 2 stretch wrappers	14

01
Design
Manufacturability, SolidWorks

02
Cutting
Laser, punching, combi

03
Bending
Press brakes, robots, panel benders

04
Welding
MIG/MAG, TIG, laser, spot

05
Surface treatment
Through our partner network

06
Assembly
Inserts, riveting, packing

Dimensions and materials

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Limits by process

Process	Thickness	Max size
Laser cutting	Steel 30 mm, stainless 10 mm, aluminium 8 mm, copper and brass 6 mm	Sheet 1,500 × 3,000 mm
Combi machines	Combi Genius 0.5–8 mm, QX-L 0.5–3 mm	Sheet 1,500 × 4,000 mm
Punching	Mostly 0.5–4 mm, copper 0.5–2 mm	Sheet 1,500 × 3,000 mm
Press brake bending	Mostly 0.5–6 mm; thicker, up to about 15 mm, in lengths under 1 m	Bending length 3,500 mm
Robotic bending	EG-6013AR: 0.6–2.5 mm	Part up to 600 × 400 mm (RBS 4); bending length 3,100 mm (Amada cell)
Panel bending	Steel 0.5–3.0 mm	Bending length 2,200 mm, height 204 mm
Plate rolling	Steel up to 7 mm	Working width 2,050 mm
Laser welding	Best for 0.5–3 mm	–
Deburring and grinding	0.5–30 mm	Width 800 mm
Laser marking	–	Marking field 300 × 300 mm
PEM inserts	Typically M2–M6, internal and external threads	–

Materials in stock

The most common sheet grades and thicknesses are in our own stock, so work can usually start as soon as the order has been processed. We stock more than 300 items, about 1,000,000 kg.

Sheet	Thickness
Cold-rolled steel	0.5–4.0 mm
Galvanised steel	0.5–3.0 mm
Aluzinc-coated steel	0.7–2.0 mm
Electro-galvanised steel	1.0–3.0 mm
Aluminium (1050, 5754, 5005)	0.5–6.0 mm
Copper	0.5–6.0 mm
Stainless steel (1.4301, 1.4404, 1.4016)	0.5–10 mm
Hot-rolled steel	3.0–30 mm
Spring steel	0.5–1.5 mm

- Sheet sizes 1,000 × 2,000, 1,250 × 2,500 and 1,500 × 3,000 mm. For large quantities we order cut-to-size sheet to avoid waste.
- Material certificates available on request.
- We also punch and bend PC and PVC plastics, and punch Bakelite.
- General tolerance ISO 2768-m unless the drawing states otherwise.

Laser cutting

We cut on five fibre lasers, from one-off prototypes to series production. Two of the machines have an automatic storage tower that loads the sheets and unloads the cut sheets, so they can run unmanned overnight and the blanks are ready for bending in the morning.

Maximum cutting thickness

30 mm	10 mm	8 mm	6 mm
Steel	Stainless steel	Aluminium	Copper and brass

Standard sheet size 1,500 × 3,000 mm. Also 1,000 × 2,000 and 1,250 × 2,500 mm, and special sizes by agreement.

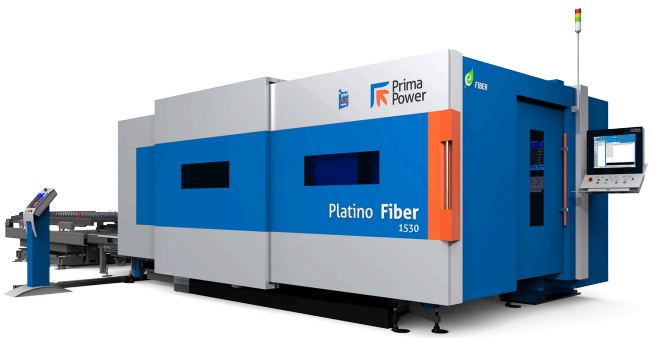
Prima Power Platino Fiber 1530

2 MACHINES

2D fibre laser, flying optics

Laser power	6 kW
Sheet size	1,500 × 3,000 mm
Accuracy	positioning and repeatability 0.03 mm
Positioning speed	up to 140 m/min
Automation	Storage tower, automatic loading and unloading

Best for: Large batches and unmanned night runs



Prima Power Laser Genius+

1 MACHINE

2D fibre laser, automatic pallet changer

Positioning speed	up to 180 m/min
Acceleration	2.8 g
Accuracy	positioning and repeatability 0.03 mm
Acquired	2025



> Positioning accuracy and repeatability (VDI/DGQ 3441) describe the machine. The general tolerance for parts is ISO 2768-m unless the drawing states otherwise.

Laser cutting

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Both machines have an exchange table: the next sheet is loaded on the second table while the previous one is being cut.

HSG G3015X Pro

1 MACHINE

2D fibre laser, automatic pallet changer

Sheet size	1,500 × 3,000 mm
Acquired	2023

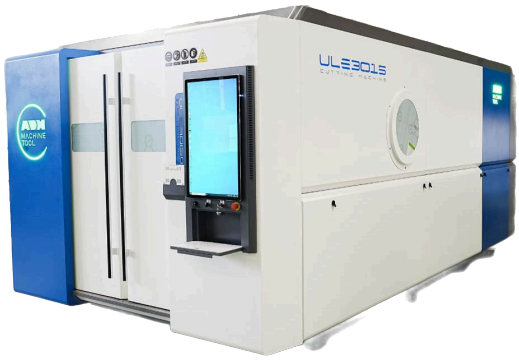


ADH ULE3015

1 MACHINE

2D fibre laser, automatic pallet changer

Sheet size	1,500 × 3,000 mm
Acquired	2020





Prima Power Platino Fiber with storage tower

Combi machines

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A combi machine punches, forms and taps like a punching machine and laser-cuts a free contour on the same part. Unusual shapes need no special tooling, and the part is finished in one setup.

2	1,500 × 4,000 mm	0.5–8 mm
combi machines	largest sheet (Combi Genius)	thickness (Combi Genius)

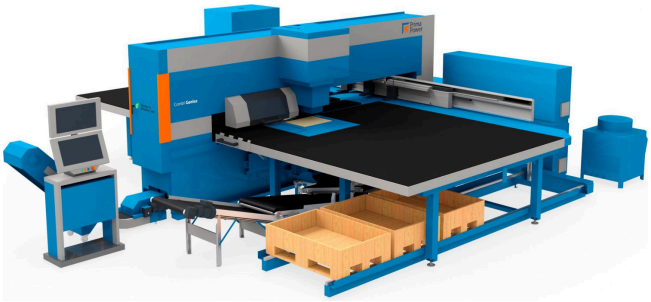
Prima Power Combi Genius 1540

1 MACHINE

Servo-electric punching and fibre laser, LSR robot

Max sheet size	1,500 × 4,000 mm (with repositioning)
Thickness	0.5–8 mm (steel, stainless, aluminium)
Sheet weight	up to 250 kg
Automation	Fully automatic: the LSR robot loads the sheets, picks the finished parts and stacks them on EUR pallets
Unmanned running	Programmed batches run without an operator, also overnight

Best for: Parts combining punched forms and threads with a laser-cut contour, e.g. 2,100 mm door frames and door leaves



LVD Strippit QX-L

New 2026

1 MACHINE

Punching and 4 kW fibre laser

Sheet size	1,525 × 3,050 mm
Thickness	0.5–3 mm
Punching force	20 t
Tooling	20 stations, all indexable 360°; magazine for up to 200 tools
Forming	high forms up to 75 mm
Automation	Storage tower, part picking and stacking

Best for: Thin parts that combine forms with laser-cut shapes



Automated punching

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A punching machine punches, forms, taps and countersinks in one operation. In 0.5–3 mm sheet it is often the most cost-effective way to make blanks. Larger batches run on our automated punching machines.



Prima Power Shear Brilliance

Prima Power Shear Brilliance (SBe)

1 MACHINE

Servo-electric punch with right-angle shear

Sheet size	1,500 × 3,000 mm
Punching	up to 8 mm
Shearing	steel 4 mm, stainless 3 mm, aluminium 5 mm
Automation	Stacking system for sheared parts

Best for: Rectangular parts and panels in large batches, straight edges without nibbling marks

Amada EMZ-3610NT

1 MACHINE

Servo-electric turret punch press

Punching force	300 kN
Working range	1,525 × 2,500 mm, longer sheets with repositioning
Automation	Picking robot that removes and stacks the parts

Best for: Larger batches

Finn-Power Shear Genius SG 1530 and SG6

2 MACHINES

Punch with right-angle shear

Sheet size	1,500 × 3,000 mm

Best for: Rectangular parts, straight edges without nibbling marks

Punching machines

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Our manually loaded punching machines handle short runs of a few sheets. A typical batch is from a few dozen to a few thousand parts, and part size ranges from millimetres to metres.

0.5–4 mm
main punching thickness range

0.5–2 mm
copper punching

9
punching machines, plus 2 combi machines

Manually loaded punching machines

Machine	Qty	Sheet size	Notes
Prima Power E5x	1	1,250 × 2,500 mm	Servo-electric, forming and marking
Finn-Power E5-25	1	1,250 × 2,500 mm	Servo-electric, 200 kN
Finn-Power A5	1	1,250 × 2,500 mm	Hydraulic, 230 kN
Finn-Power F5 S	1	1,250 × 2,500 mm	Hydraulic, 300 kN
Finn-Power A4-20	1	1,000 × 2,000 mm	Hydraulic, 230 kN

In the same operation

Punching, threads, forms, cup forms, stiffening ribs and countersinks. Largest standard round tool Ø 89 mm on the 1,250 × 2,500 mm machines.

Tooling

One of the largest punching tool stocks in Finland: standard, tapping, cup, forming and cluster tools. If the right tool isn't in stock, our supplier delivers it within a few days.

Copper

Copper has its own punching machine, with tooling and clearances chosen for copper. Rounder shapes and thicker parts up to 6 mm are laser-cut (p. 4). A shaped busbar fits an electrical cabinet better than a straight flat bar.

Nesting

Our nesters choose the method and machine for each part (Jetcam, NCExpress).

Press brake bending

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Bending is one of our specialities. Typical work is bending a punched 1–3 mm part or a laser-cut 4–15 mm part to the drawing. Long parts are bent with a lifting assist, so one operator can handle them.

3,500 mm
max bending length

1,700 kN
max press brake force

21
press brakes

Press brake	Qty	Drive	Force	Bending length
Amada HFP 170	1	hydraulic, CNC	1,700 kN	3,100 mm
Prima Power eP-1336	2	servo-electric	1,350 kN	3,500 mm
LVD PPBL 135/30	1	hydraulic	1,350 kN	3,000 mm
Amada HFE M2 130.3	1	hydraulic, CNC	1,300 kN	3,100 mm
Amada HFBO 125	1	hydraulic, CNC	1,250 kN	3,140 mm
Prima Power eP-1030	2	servo-electric	1,050 kN	3,060 mm
Amada HFE 100-3	2	hydraulic, CNC	1,000 kN	3,110 mm
CREA BEND WE67K	1	hydraulic, CNC		
Amada HFT 80-25	1	hydraulic, CNC	800 kN	2,500 mm
Prima Power eP-0520	2	servo-electric	550 kN	2,000 mm
LVD PPBL 40/20	1	hydraulic	400 kN	2,000 mm
CoastOne Cone C15X	1	electric	440 kN	1,600 mm
CoastOne Cone C9	2	electric	220 kN	900 mm
CoastOne Cone 900	3	electric	180 kN	900 mm

- Ram repeatability on the Prima Power press brakes is ±0.005 mm.
- Thicker parts, up to about 15 mm, are bent in lengths under 1 m.
- The CoastOne C15X has an 800 mm open height for deep parts.
- We also bend plastic sheet.





Robotic bending

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Our robot cells are for repeat batches of more than 100 pieces. Two of the cells are for small parts and one for large, heavy parts.

LVD RBS 4 New 2026

1 MACHINE

Robotic bending cell: LVD press brake and KUKA robot

Part size	up to 600 × 400 mm
Part weight	up to 4 kg
Programming	Offline programming in CADMAN, no manual robot teaching

Best for: Small brackets, tabs and covers in repeat batches



Amada EG-6013AR

1 MACHINE

Small robotic bending cell: servo-electric press brake with integrated robot

Press brake	600 kN, bending length 1,300 mm
Part size	40 × 80 to 300 × 300 mm
Thickness	0.6–2.5 mm
Automation	The robot changes tools and grippers

Best for: Small parts in repeat batches



Amada HFE M2 130.3 L + Yaskawa Motoman MH180

1 MACHINE

Robotic bending cell for large parts

Press brake	Hydraulic CNC, 1,300 kN, 3,100 mm
Robot	Yaskawa Motoman MH180, 180 kg payload, 2,702 mm reach

Best for: Large, heavy parts in repeat batches



Panel bending

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Our panel benders are for repeat batches of more than 100 pieces. A typical panel takes about a minute, which means about 600 finished panels in ten hours.

2	2,200 mm	204 mm
panel benders, one robotised	max bending length	max bending height

Prima Power BCe Smart 2220

2 MACHINES

Servo-electric panel bender

Bending length	up to 2,200 mm
Bending height	up to 204 mm
Sheet size	180 × 360 to 1,500 × 2,850 mm
Thickness	steel 0.5–3.0 mm
Setup	Automatic tool change, barcode reader
Robot cell	One unit is robotised: Yaskawa GP180-120 (120 kg) on a 6 m linear track

Best for: Panels in repeat batches



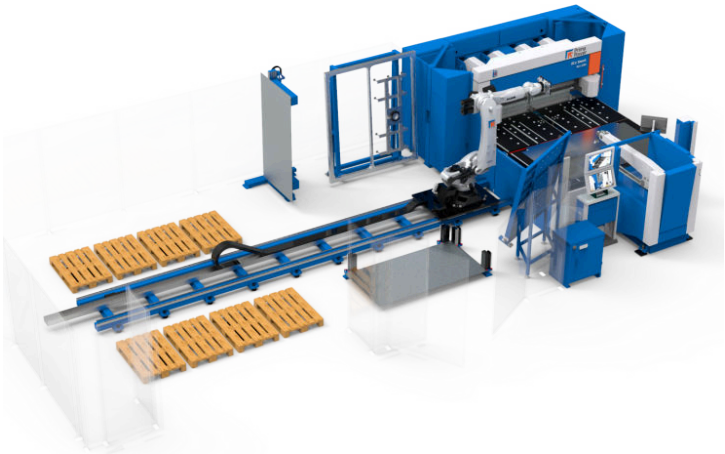


Plate rolling and welding

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Plate rolling

We roll punched and laser-cut blanks into curved parts and cylinders. Typical work includes sauna stove shells, tanks, curved chain guards and agricultural machine parts.

Promau plate roll

1 MACHINE

Plate rolling machine

Working width	up to 2,050 mm
Thickness	steel up to 7 mm

ASM S-120 × 1800

1 MACHINE

Three-roll plate roll

Working width	1,800 mm

Welding

We weld steel, stainless steel and aluminium. In medium-heavy material a typical job is laser cutting, welding and painting on one order. Robot welding is subcontracted to our partner network.

MIG/MAG welding

Manual welding

Materials	Steel, stainless and aluminium

TIG welding

Manual welding

Materials	Steel, stainless and aluminium

Laser welding

1,500 W laser welding unit

Thickness	best for 0.5–3 mm
Benefit	Low heat input reduces distortion and post-grinding
Materials	Recommended for stainless steel; for galvanised steel we use other methods

Spot welding

Laser and resistance spot welding

Laser spot	Clean finish, also in awkward corners
Resistance spot	TECNA and KRW 41, see p. 14

Finishing and secondary operations

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Secondary operations are done on the same order before delivery.

Deburring and grinding

2 MACHINES

Lanuss grinding line and BEKE R G4/1000

Working width	up to 800 mm
Thickness	0.5–30 mm
Stations	A coarse belt removes the burr, rollers round the edges, the last belt grinds the surface
Levels	1 light deburring, 2 pre-paint grinding, 3 edge rounding
Materials	Steel, aluminium and stainless, both sides if needed

Laser marking

1 MACHINE

Finnlaser FL-100GS, 50 W fibre laser

Marking field	300 × 300 mm; finer marking in a 200 mm field, extra-fine in 110 mm
Materials	Steel, stainless, copper, brass, titanium and painted surfaces (not aluminium)
Use	Product IDs, serial numbers, logos and dimension marks; logos as DXF or vector files

Tapping

2 MACHINES

Smarttap tapping machines

Most economical	Threads made during punching on a punching machine or the combi
Added later	On the tapping machines, e.g. in bent or welded parts
No extrusions	PEM inserts, see p. 14

Drilling and countersinking

2 MACHINES

Arboga A2608 and Optimum DH 35G drilling machines

Spindle	MT3 and MT4, 75–2,900 rpm
Countersinks	Punched on a punching machine or drilled
Drilling capacity	up to Ø 35 mm in steel

Pressing

1 MACHINE

Rönnqvist & Söner PE-25 eccentric press

Force	25 t

Joining, assembly and packing

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Inserts, riveting, spot welding and small assemblies are done in the same work area, so the joining method can be changed quickly to suit the part.

Fastener insertion (PEM)

4 MACHINES

Auto-Sert AS-7 and Haeger insertion presses

Fasteners	Self-clinching nuts, studs and standoffs, typically M2–M6
Materials	Copper, aluminium, and stainless, acid-proof and galvanised steel
Stock	Wide range of inserts in stock, so work usually starts straight away

Resistance spot welding

4 MACHINES

TECNA 8005D, TECNA 4646 and KRW 41

Typical work	Ventilation products: air distribution boxes, ceiling frames, louvres and duct parts
Also	Laser spot welding for a cleaner finish
Power (8005D)	60 kVA, peak 200 kVA

Riveting

Blind riveting (pop rivets)

Capacity	Several riveting machines and a wide range of rivets in stock

Assembly

Subassemblies and finished products

Typically	Simple assemblies
Scope	Purchased parts, labels, rating plates and agreed final testing

Packing

2 MACHINES

Atlanta stretch wrappers

Standard	Small box 30 × 40 × 30 cm, half pallet, EUR pallet and long pallet for parts over 1,200 mm
Special	With JS-Pack in the same factory
Instructions	We pack to the customer's packing instructions

Delivery

Freight and terms

Typically	EXW with the customer's carrier
No carrier specified	We book the freight and invoice it with the order

Quotes and contacts

For a quote, send

Quantities, material and thickness, surface treatment and delivery method. CAD files as DXF, DWG or STEP, plus a PDF drawing.

Tolerances

ISO 2768-m unless the drawing states otherwise.

Lead time

Flat punched parts typically ship within a week, bent parts without painting in about 1.5 weeks and painted parts in about 2.5 weeks. Batch size always plays a part, so we confirm the lead time with each order.

Batch sizes

No minimum order. The lowest unit price comes when the batch matches a full sheet or a multiple of it.

Surface treatment

Powder and wet painting, hot-dip and electro-galvanising, anodising, electroless nickel plating, chrome plating, passivation and tinning through our partner network. We are responsible for the schedule, quality and logistics of the whole order.

Quality

ISO 9001 and ISO 14001 (DNV). Material certificates on request. Electricity and heat at the Salo plant are 100% renewable.

Quote requests: stremet@stremet.fi or stremet.fi/en/request-a-quote

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