



LAKI 131 LTD.

ALUMINUM DIE-CASTING AND MECHANICAL
PROCESSING OF ALUMINUM CASTING PARTS

LMT-Laki Mouldin Technologi

Tool workshop for production of
die casting molds

Laki11 Ltd. - Bulgaria

Production place



Plovdiv City South East
Industrial Zone – 15 700 m²



Mechanical work - section

- Robodril milling machines



- 3 pcs. 5-axis milling

Lakill Ltd. - Bulgaria



Die casting machines



Laki131 Ltd. using

- 280 tons – 1 machine - full auto.
- 300 tons – 1 machine full automatic
- 400 tons – 1 machine full automatic
- 950 tons – 1 machine

New die casting machines that will be installed by October 2019

- 400 tons – 1 machine – full automatic

New machines that will be installed by December 2016

- 300 tons – 1 machine – full automatic
- 400 tons – 2 machine – full automatic
- 650 tons – 1 machine – full automatic

New die casting machines that will be installed by May 2021

- 800 tons – 1 machine

The company Laki 131, has a total of 10 die casting machines



NEW FACTORY FOR DIE CASTING AND FOR FINISHING OF
CASTING PARTS -PUNCHING , GRINDING.



Lakill Ltd. - Bulgaria



NEW DIE CASTING MACHINES THAT WILL BE
INSTALLED BY OCTOBER 2019

← - 400 TONS - 1 MACHINE - FULL AUTOMATIC

DECEMBER 2020 IN OUR COMPANY WILL
BE INSTALLED A NEW DIE CASTING
MACHINE -800TONS



2 - ALUMINUM MELTING GAS FURNACES WITH A CAPACITY OF 5000KG IN 24 HOURS

**5 - HOLDING FURNACE FOR ALUMINUM 800KG/1200KG
INSTALLED OCTOBER 2016**



Die casting machines DM 800 2021 year



- New machines that will be installed by May 2021
- - 800 tons – 1 machine



NEW DIE CASTING MACHINE - 800T

- New die casting machines already installed in August 2022
- 800 tons – Full automation with KUKA robots



- In June 2022, another new 800t die casting machine will be installed

The machine will be a fully automated casting cage with robots



IT IS PLANNED TO PURCHASE A NEW FULLY AUTOMATED CASTING CELL OF 2500 TONS



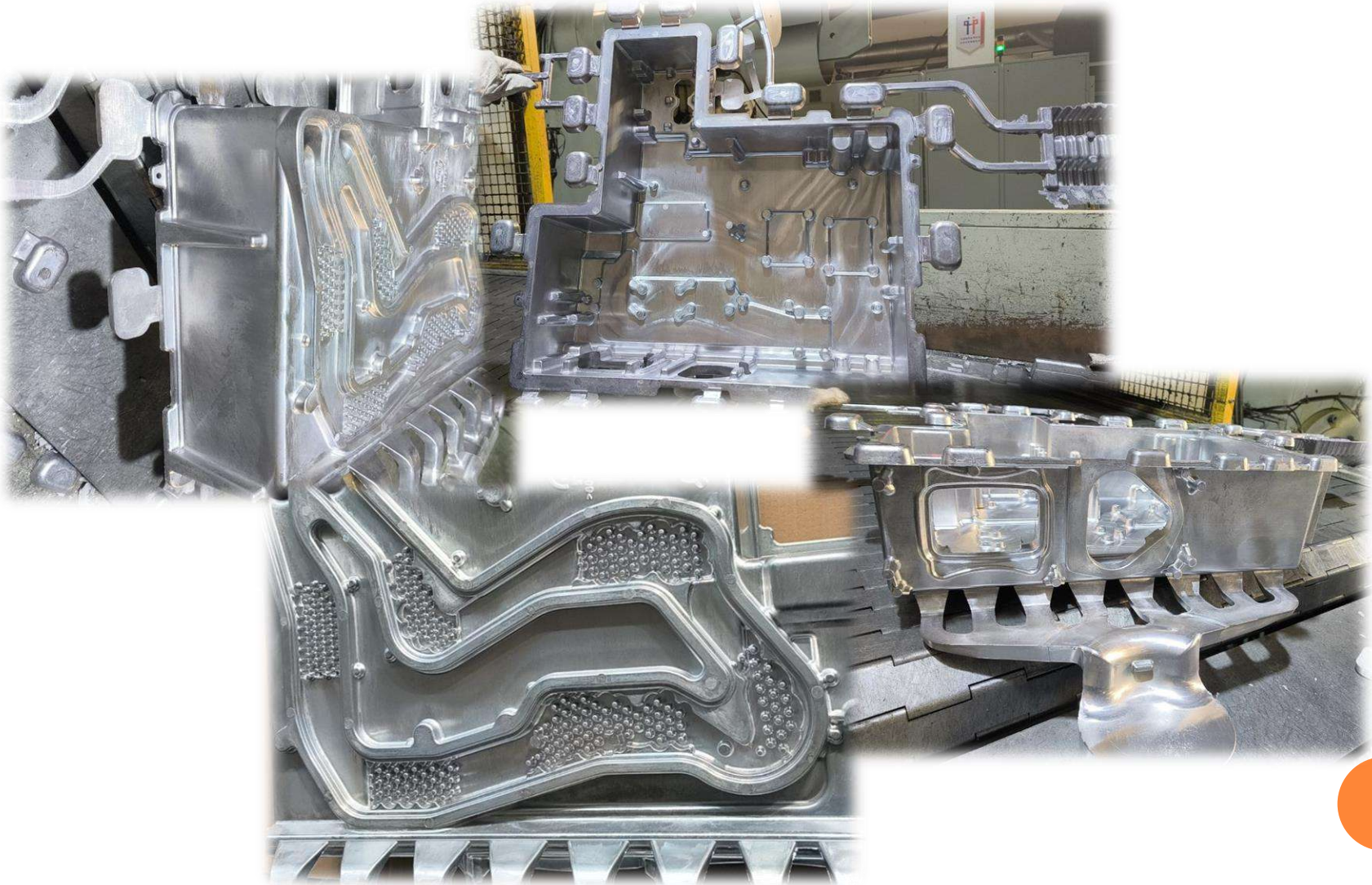
The investment will be around €1,500,000

This will be the second fully automated casting cell to be installed in the company's foundries.

***The investment in this machine is for parts for hybrid chargers fitting trucks for Daimler and Volvo



Aluminum parts that will be produced on a 2500t casting machine.



IT IS PLANNED TO PURCHASE A NEW FRICTION WELDING MACHINE -FSW



The machine will be installed in the fall of 2024.

For Which product — Aluminum Structure
(Military, automotive, rail transit, aerospace, communications and other industries)



Battery tray



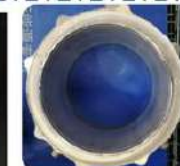
Cooling plate



wheels



Electric Control Box

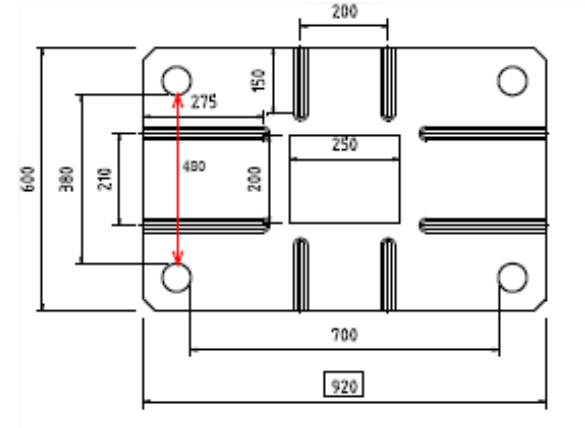
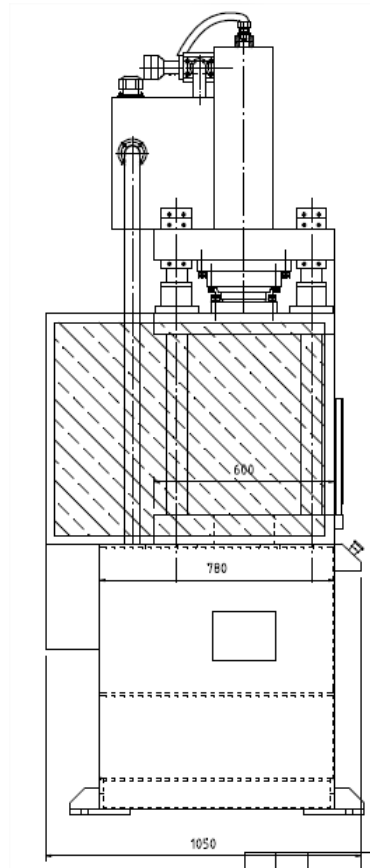
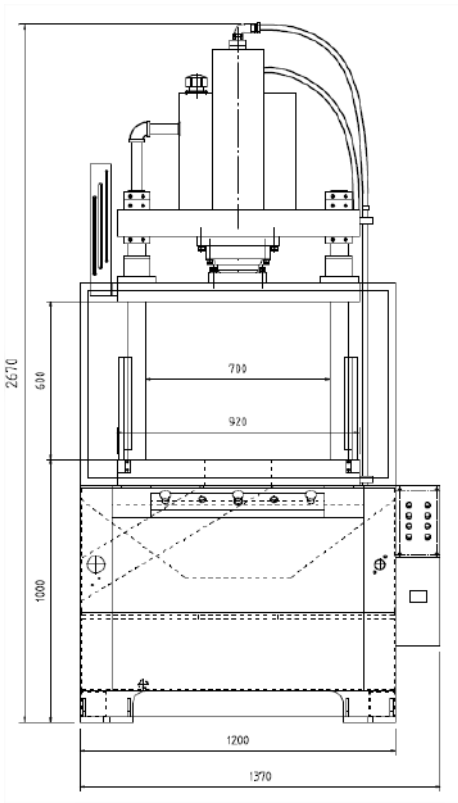


Motor shell

4 PUNCHING PRESSES - INSTALLED AUGUST 2019



WE HAVE INSTALLED 2 NEW HYDRAULIC PRESSES IN MARCH 2023.



Two new hydraulic presses for cutting tools aluminum parts

Finishing treatment



Shot blasting part



-Workshop for preparation casting parts and finishing processing:

- * shot blasting machines with hooks.
- * shot blasting machine with drum line.
- * vibratory machines, trovalizing machine

In October 2020 - will be installed new shot blasting machine



Finishing treatment



Vibro Machine



The result after vibro machining



Machining of parts



POWDER COATING LINE - INSTALLED IN NOVEMBER 2023



Lakill Ltd. - Bulgaria



Painting



Lakill Ltd. - Bulgaria

Powder coating parts

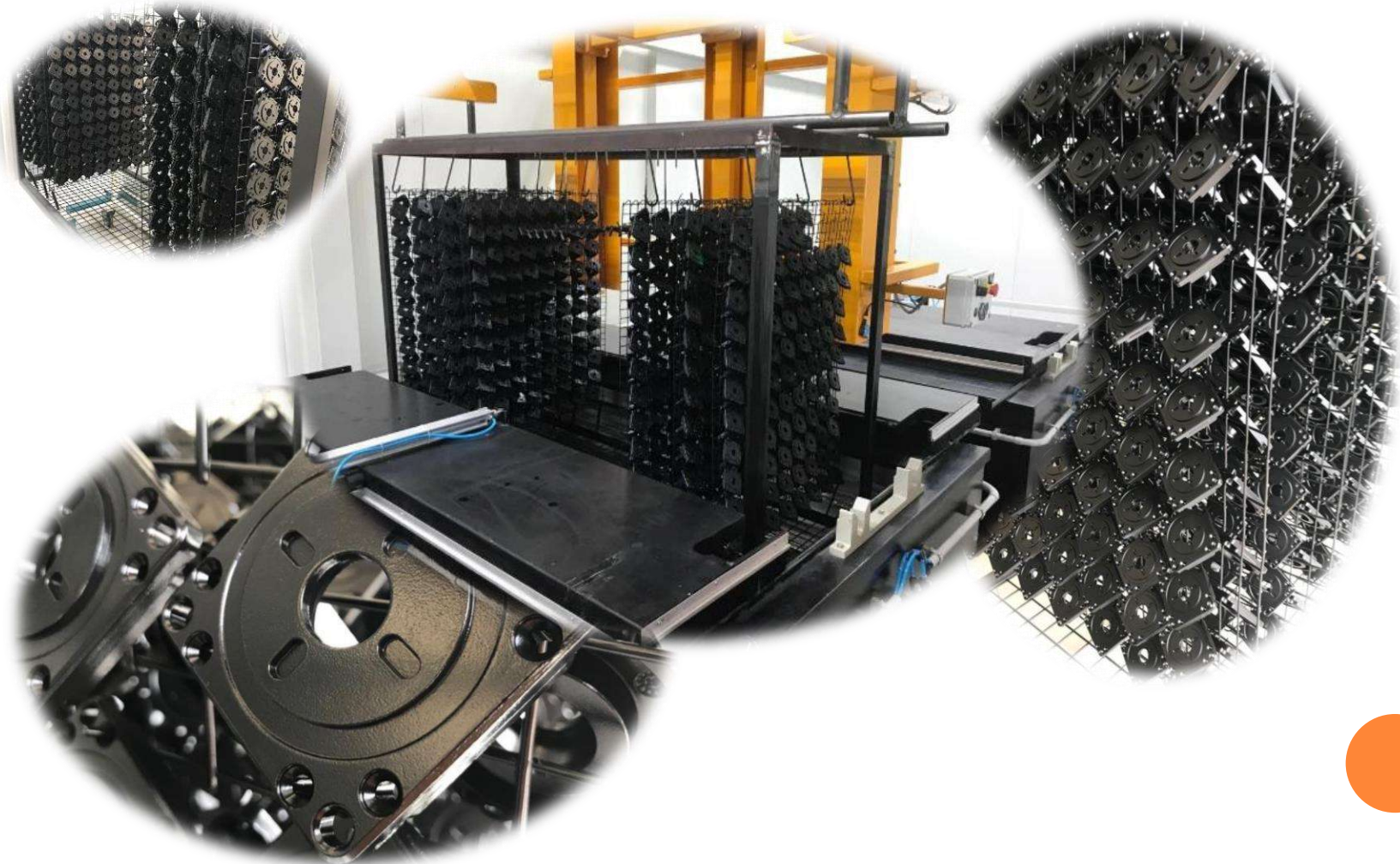
The parts are coated in the desired by the client colors according to RAL.



CASTINGS FOR - LIGHTING FIXTURES



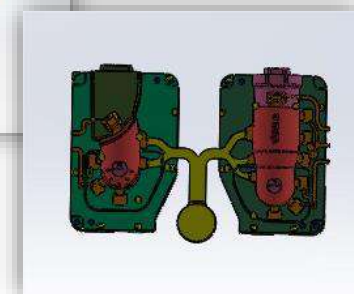
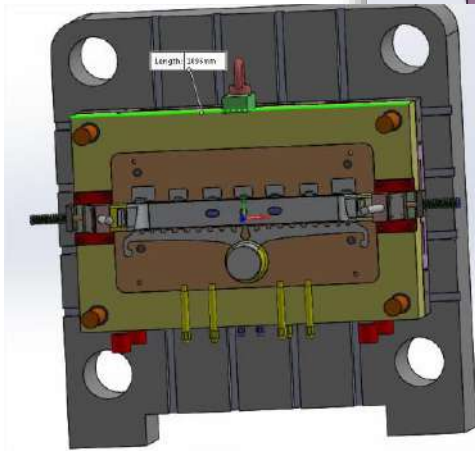
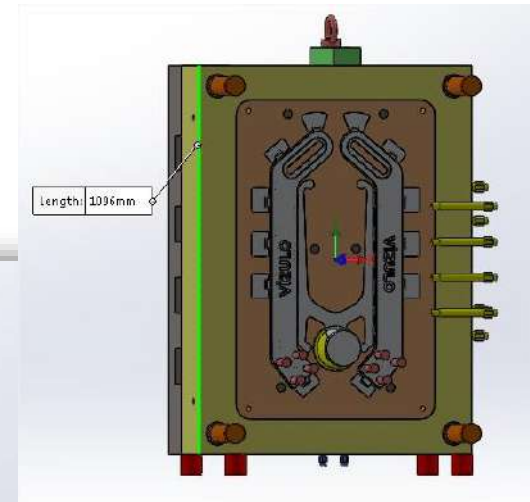
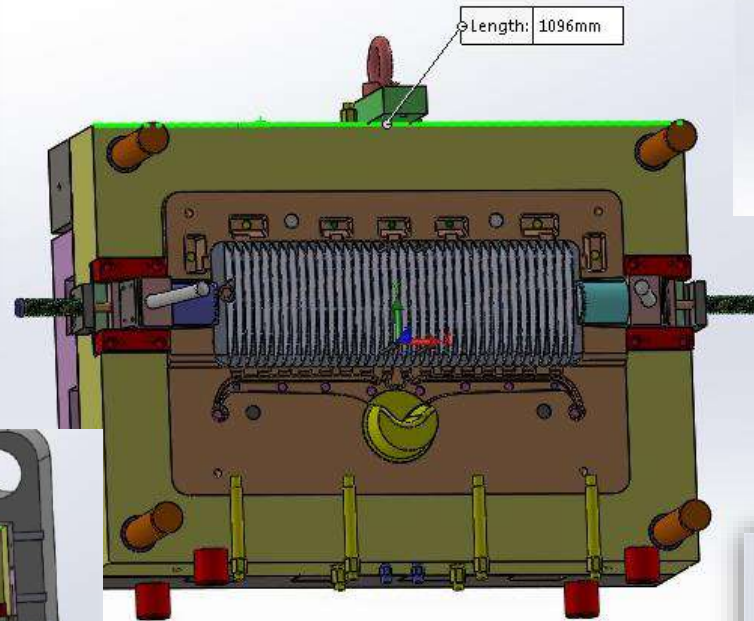
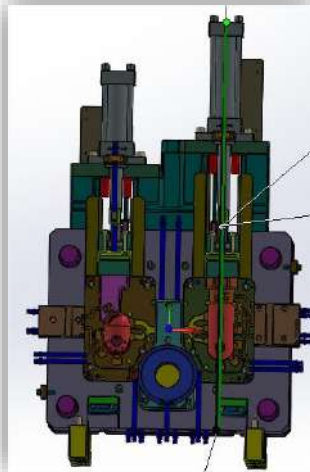
ELECTROPHORESIS - KTL



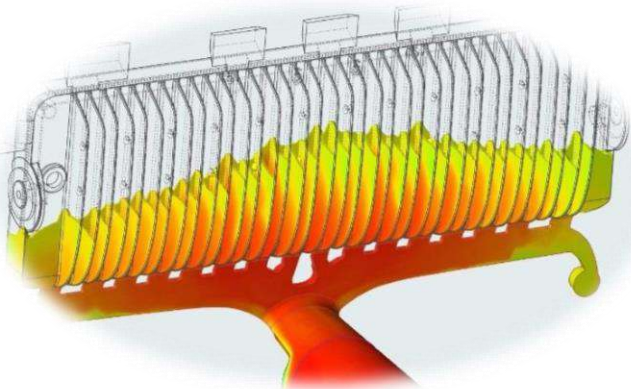
Lakill Ltd. - Bulgaria



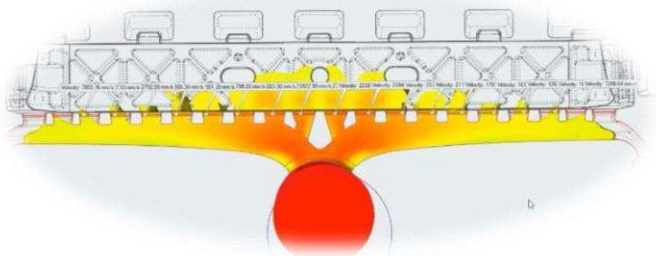
Design of die casting molds



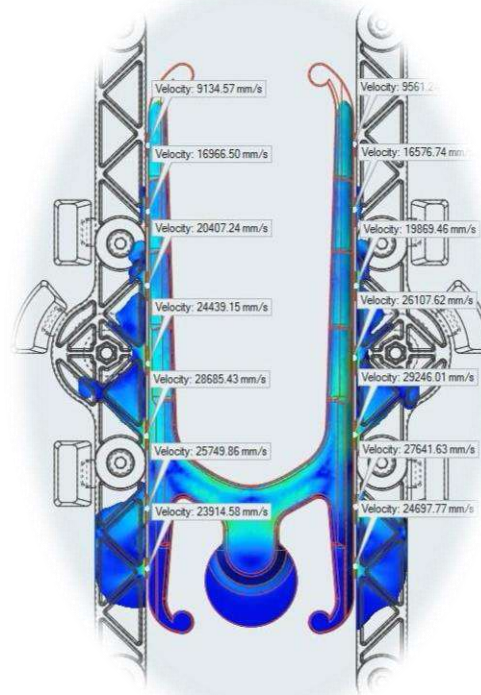
CASTING SIMULATION



Aluminium 44 300 /3,250kg



Aluminium 47 100 /2,730kg

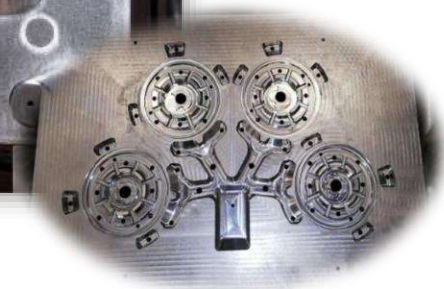
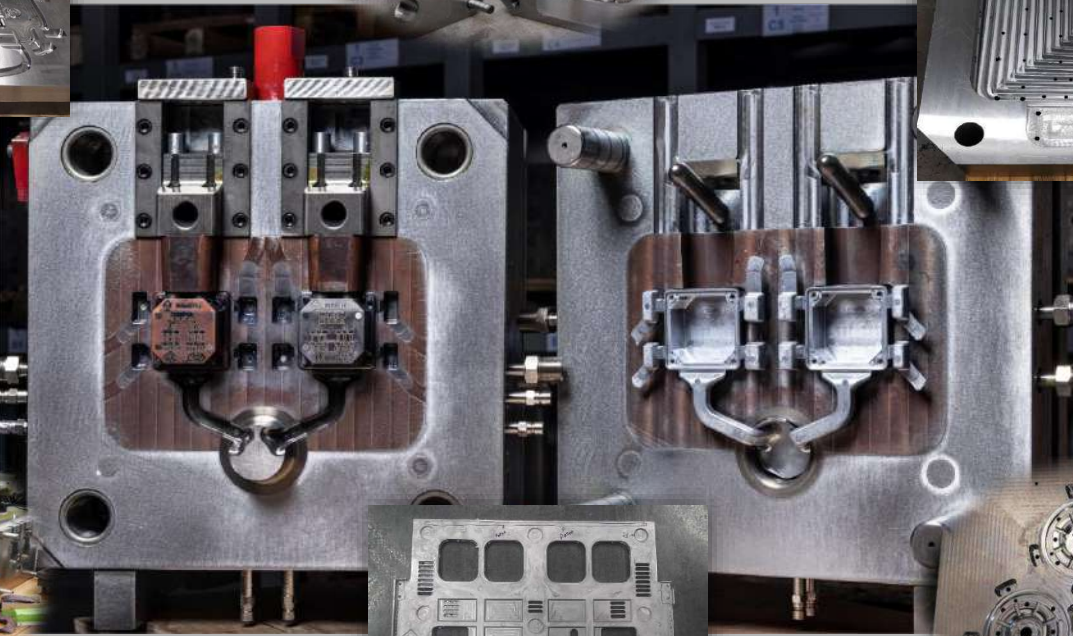


Aluminium 46 100 /2x 2,120kg



Tool workshop for production of die casting molds

LMT-Laki Moulding Technology

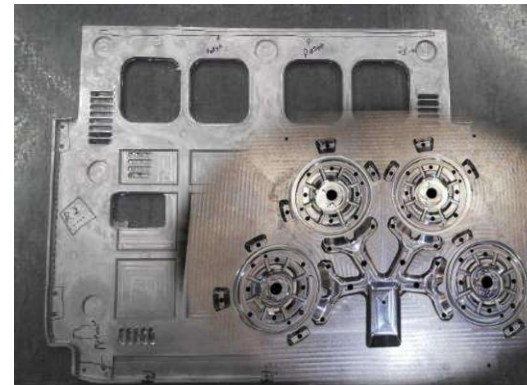


Tool workshop for production of die casting molds

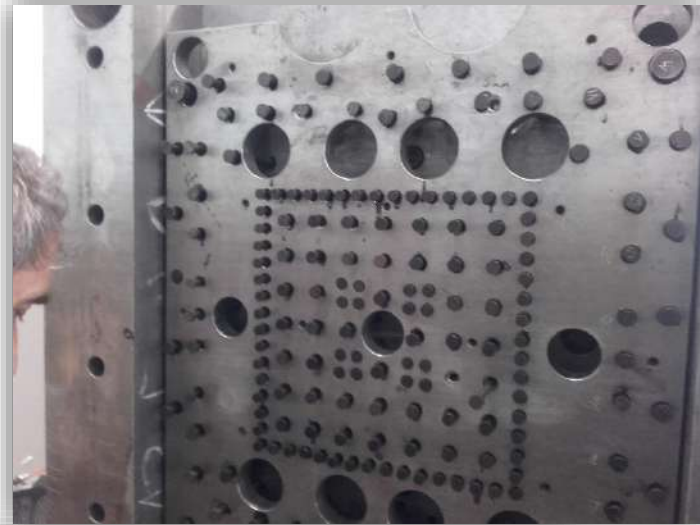
LMT-Laki Moulding Technologi



Die casting mold - 3800kg



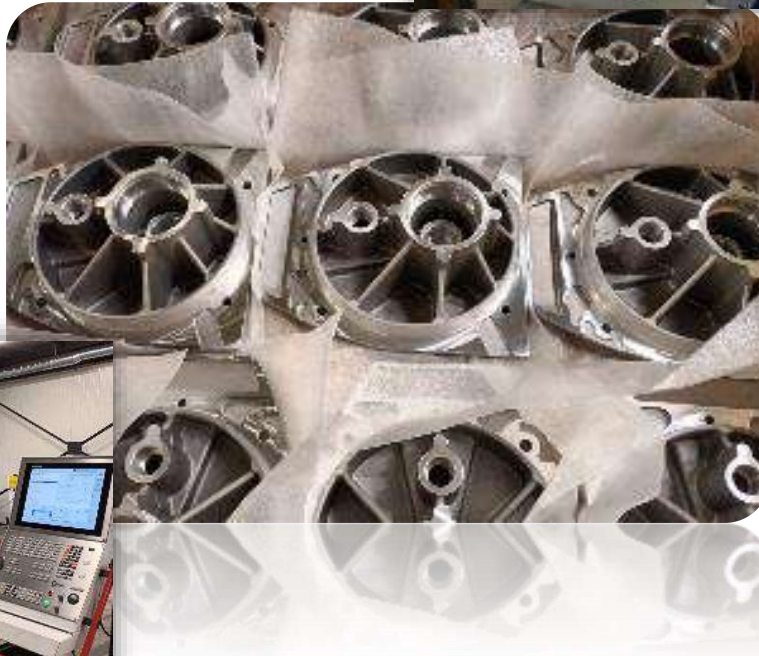
DIE CASTING MOLDS - 4800 KG FOR DIE CASTING MACHINE - 1000 TONS



Finish Mechanical Products

-Mechanical processing workshop:

- * CNC turning centers
- * CNC milling centers 3 axes and 5 axes
- * CNC robot drilling machine
- * threading and drilling machines - multi-spindle threading machines for serial work, and many others.



Drilling – threading

- Several drilling, few threading machines.
- Special multi-spindel threading machine



Measurement equipment

- Gauges, gap gauges, thread calibers, angle measurement etc.

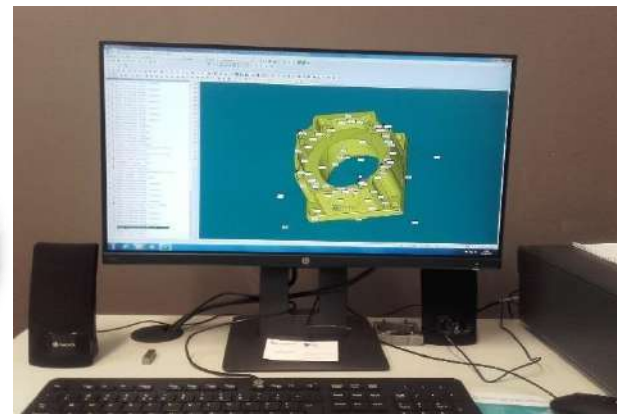


Measurement equipment

- Spectral analyze – Aluminum and Zinc alloys



- 3D measuring machine –X-700mm/Y-1000mm/Z-500mm



X-ray machine for aluminum casting

X-700mm / Y 800 mm / Z 1200 mm

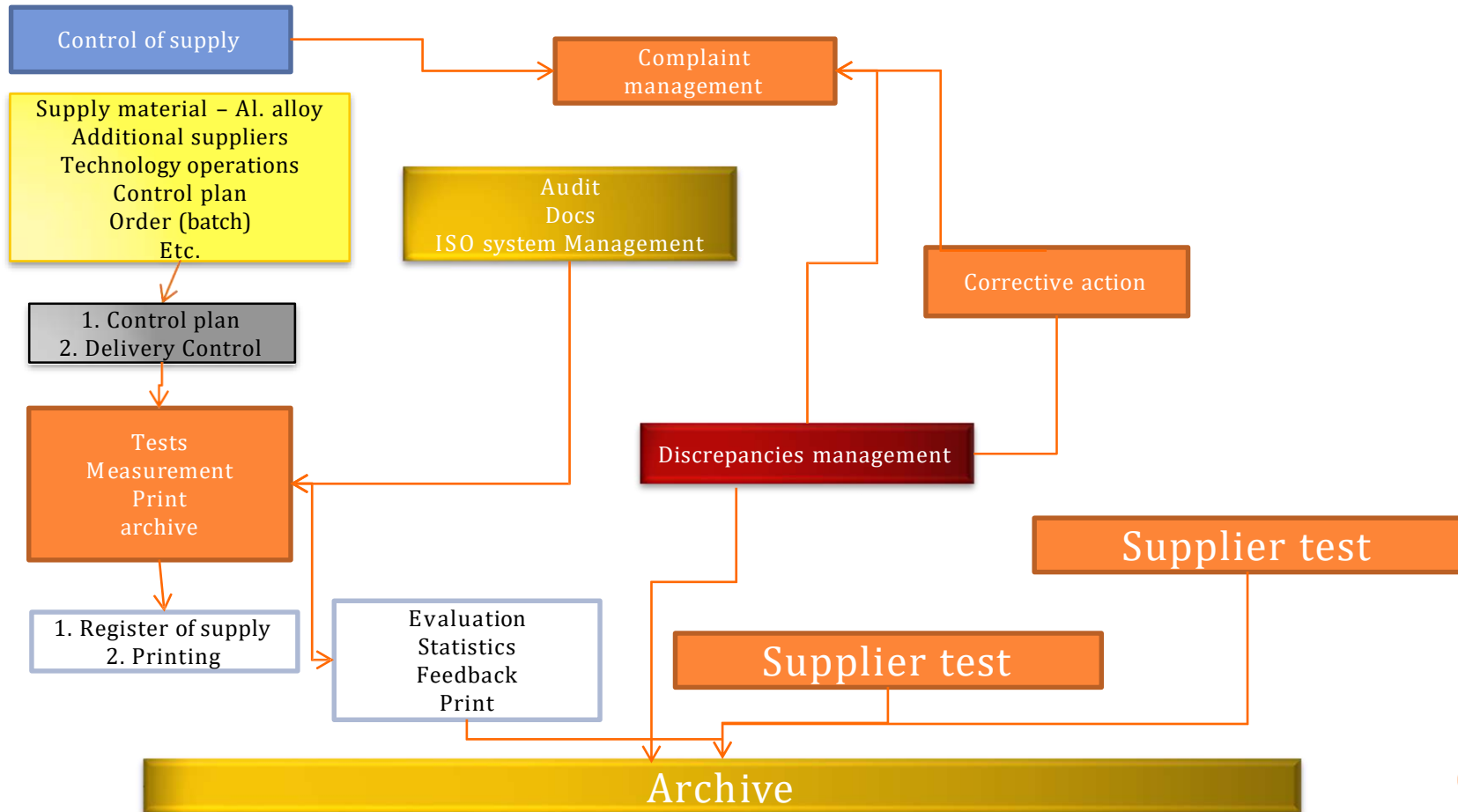


Quality control



Лакшми Лал. Пулгари

- 



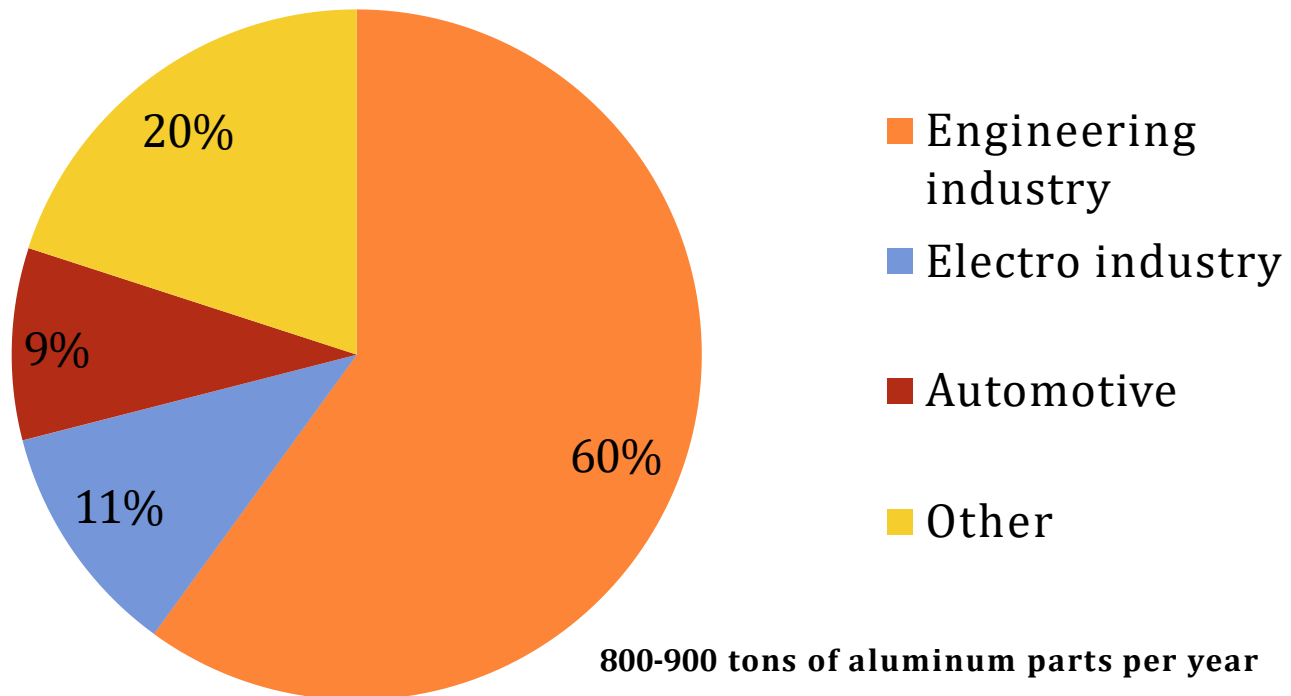
Main customers

- **ATB MOTORENWERKE GmbH - Austria,**
- **ATB MOTORENWERKE GmbH -Tamel Poland**
- **ATB ANTRIEBESTECNIK GmbH - Germany**
- **LENZE ITALIA GmbH - Italy**
- **LENZE OPERATIONS GmbH - Germany , Austria, Poland, Czech Republic , China**
- **ATLAS COPCO LIFTON Ltd. - Bulgaria, China, Belgium**
- **Husqvarna Group - Sweden**
- **Schneider Electric -Germany, France, Switzerland**
- **Husqvarna-Sweden**
- **SENSATA TECHNOLOGIES Germany , USA**
- **LEDVANCE(OSRAM) - Germany**
- **Watts Industries Italia S.r.l.**
- **Festo - Germany, Bulgaria**
- **VIZULO -Latvia /LED lighting**
- **ATRA- Bulgaria**
- **ELPROM HARMANLI JSC - Bulgaria**
- **OBERTON SD - Bulgaria**



Production by category

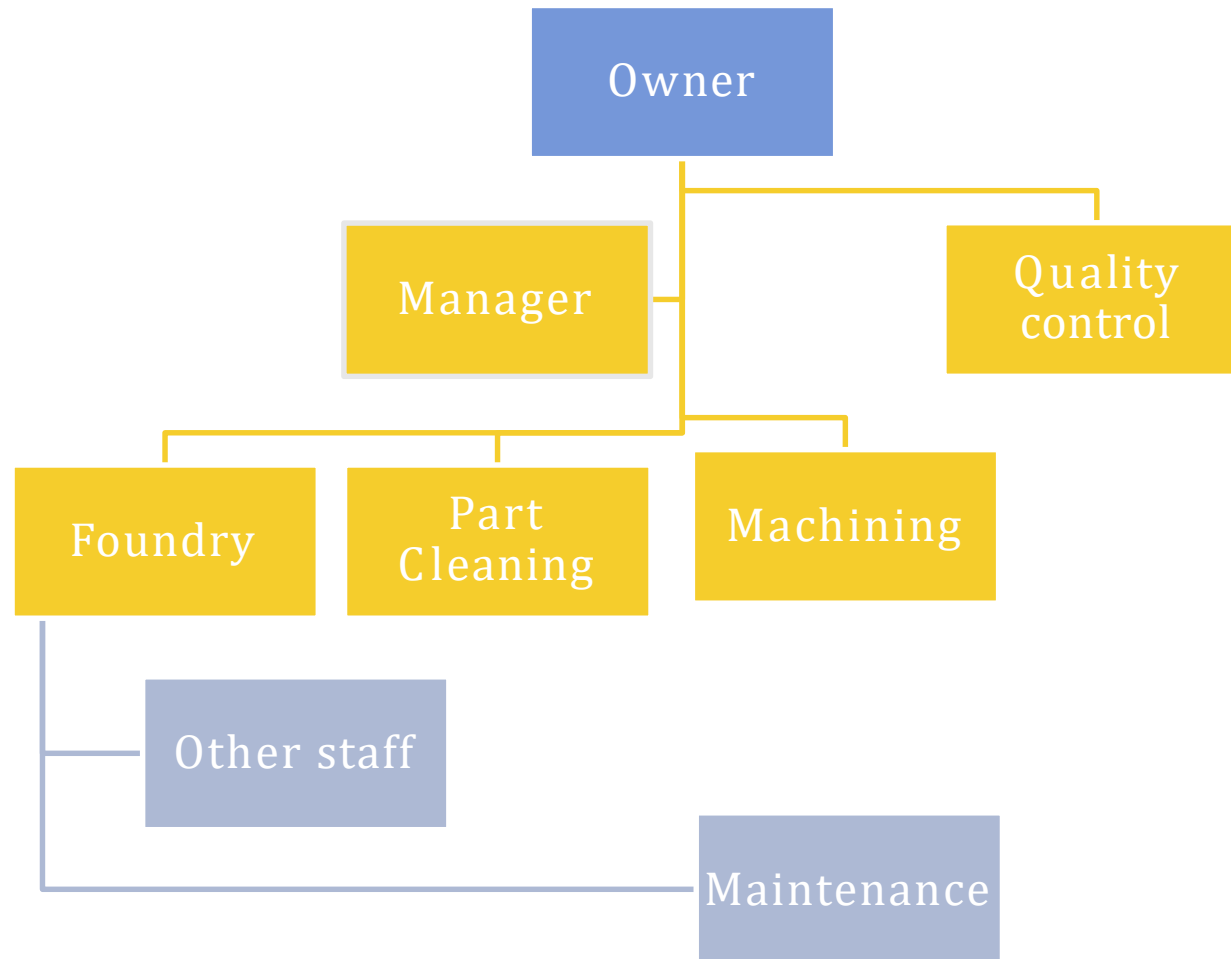
CATEGORY



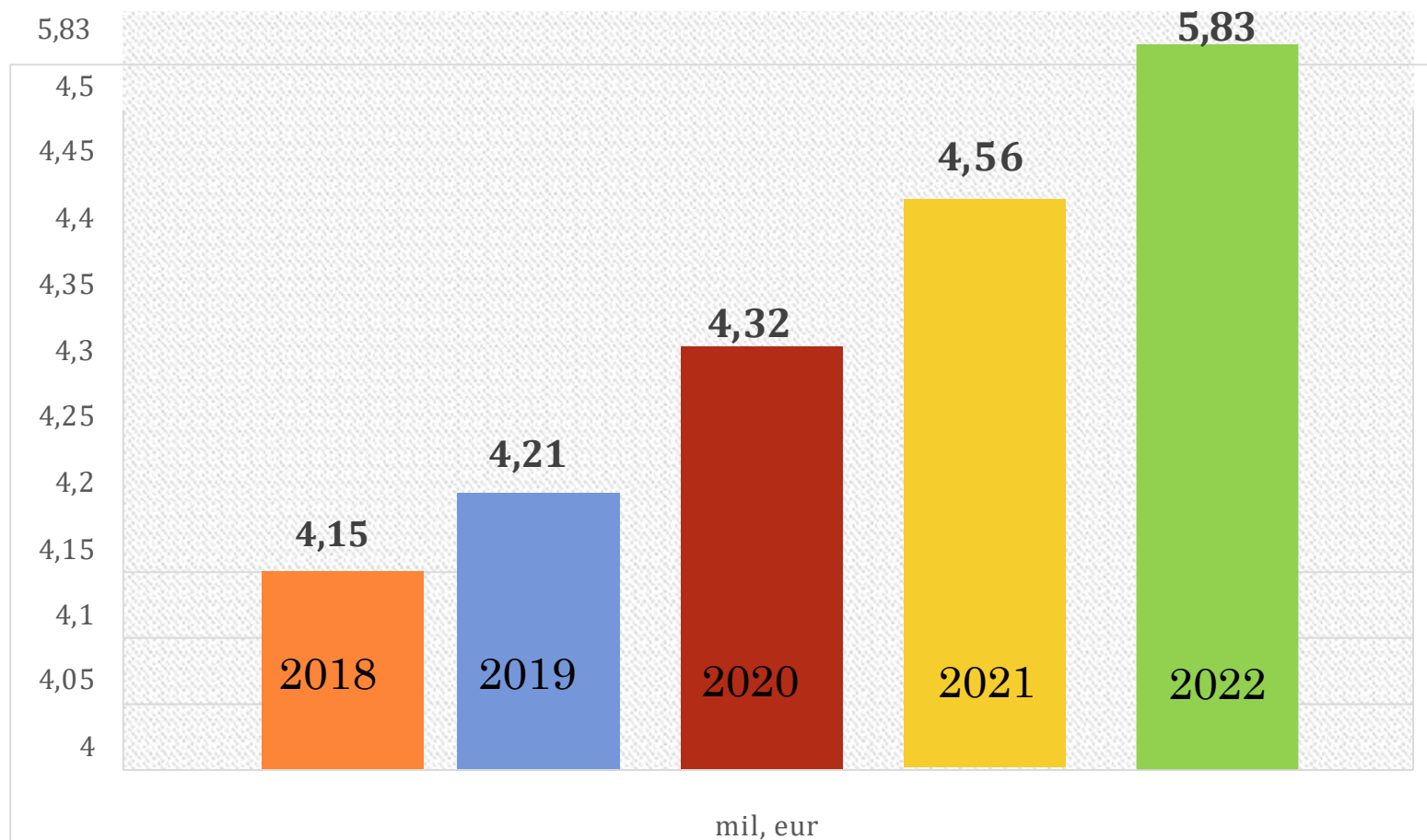
Work process



Company structure



Financial results



ISO 9001:2015



Management system as per
BDS EN ISO 9001 : 2015

In compliance with the procedures of the Management Systems Certification Body at TÜV NORD Bulgaria EOOD,
it is hereby certified that:



Laki 131 OOD
21 Dimitar Talev str.
4004 Plovdiv
Bulgaria

applies a management system in line with the above standard for the following scope:

Pressure die - casting of non-ferrous alloys. Mechanical processing

Certificate Registration No. 32 104 148196

Audit Report No. 3220 1160

MS Certification Body at
TÜV NORD Bulgaria EOOD

The certification was conducted in compliance with the procedures of the MSCB at TÜV NORD Bulgaria EOOD for audit
and certification, and is subject to regular surveillance audits.

TÜV NORD Bulgaria EOOD

13, Nadein Geroev str.

4000 Plovdiv

www.tuv-nord.bg



Valid From 2023-10-28

Valid until 2025-10-27

Initial certification 2014

Plovdiv, 2020-10-22



Management system as per
BDS EN ISO 14001 : 2015

In compliance with the procedures of the Management Systems Certification Body at TÜV NORD Bulgaria EOOD,
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TÜV NORD Bulgaria EOOD

13, Nadein Geroev str.

4000 Plovdiv

www.tuv-nord.bg



Valid From 2020-10-34

Valid until 2025-10-25

Initial certification 2017

Plovdiv, 2020-10-22

Laki11 Ltd. - Bulgaria



33
YEARS
ALUMINUM DIE-CASTING
MECHANICAL PROCESSING
DIE CASTING MOLDS



THANK YOU FOR YOUR ATTENTION!

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[Click here for Laki131 web site!](#)



Enter correct coordinates:

42°07'11.8"N

24°47'01.5"E

