



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

Laki 11 Ltd. - Bulgaria

Production place



Plovdiv City South East
Industrial Zone – 15 700 м2



Mechanical work - section

- Robodril milling machines



- 3 pcs. 5-axis milling

Lakil Ltd. - Bulgaria



Die casting machines



Laki11 Ltd. - Bulgaria

Laki131 Ltd. using

- 280 tons – 1 machine - full auto.
- 300 tons – 1 machine full automatic
- 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 2022

- 800 tons – 2 machine

New die casting machines that will be installed by October 2019

- 400 tons – 1 machine – full automatic

New die casting machines that will be installed by March 2025

- 2500 tons – 1 machine

The company Laki 131, has a total of 11 die casting machines

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



Lakil 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



IN MARCH 2025, IT WILL BE INSTALLED NEW
AUTOMATED CASTING CELL 2500T.



Laki11 Ltd. - Bulgaria

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.

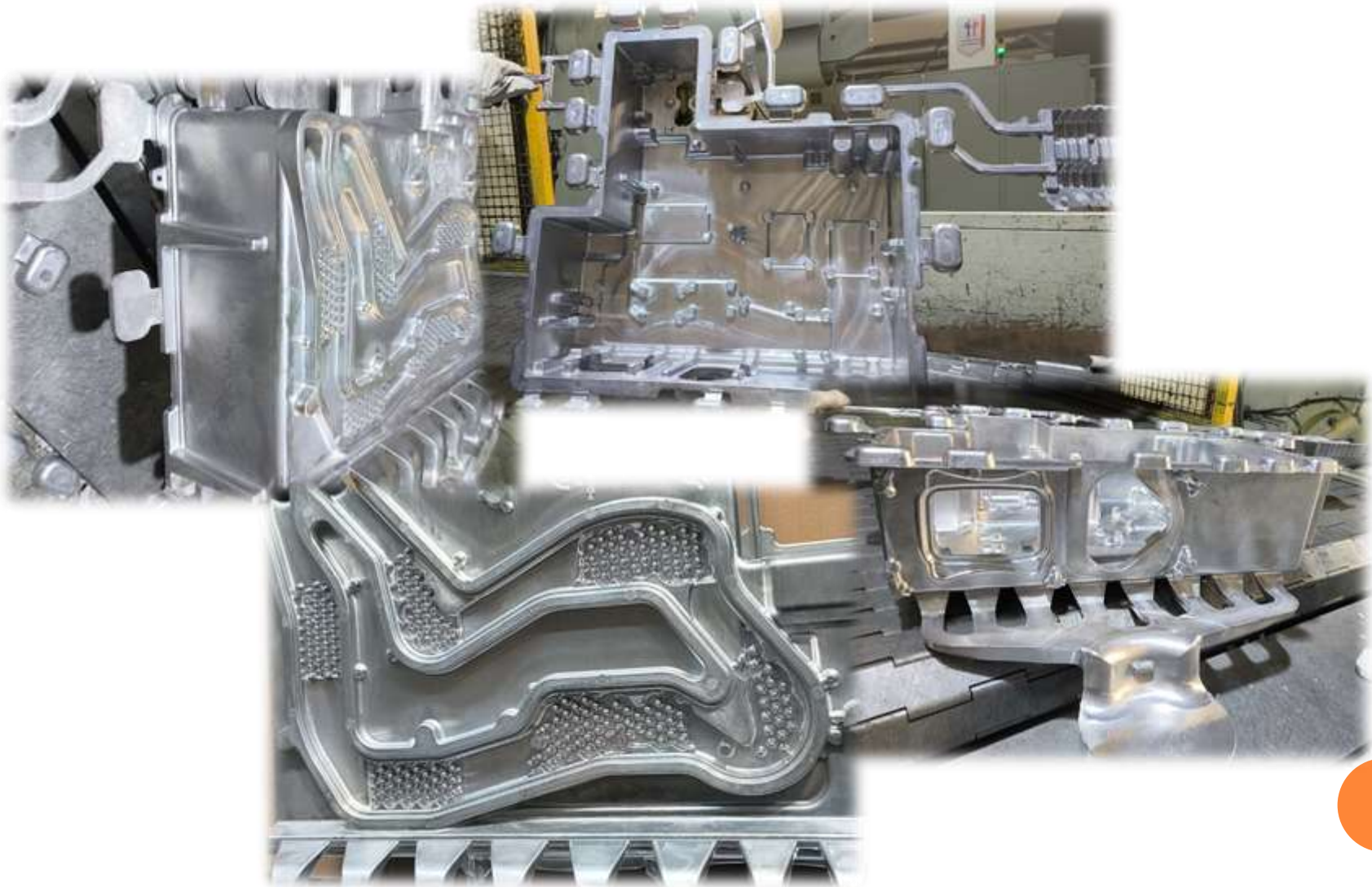
***The investment in this machine is for parts for hybrid chargers fitting trucks for Daimler and Volvo



On February 26, installation of a new automated casting cell - 2500t began



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



IN MARCH 2025, IT WILL BE INSTALLED A NEW FRICTION WELDING MACHINE -FSW



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



Battery tray



Cooling plate



wheels



Electric Control Box



Motor shell



CASTINGS FOR - AUTOMOTIVE INDUSTRY

DAIMLER AND VOLVO

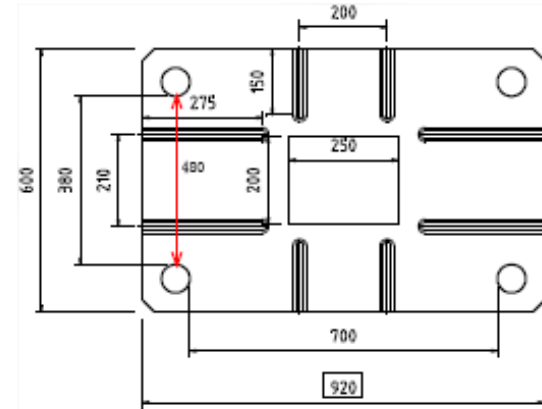
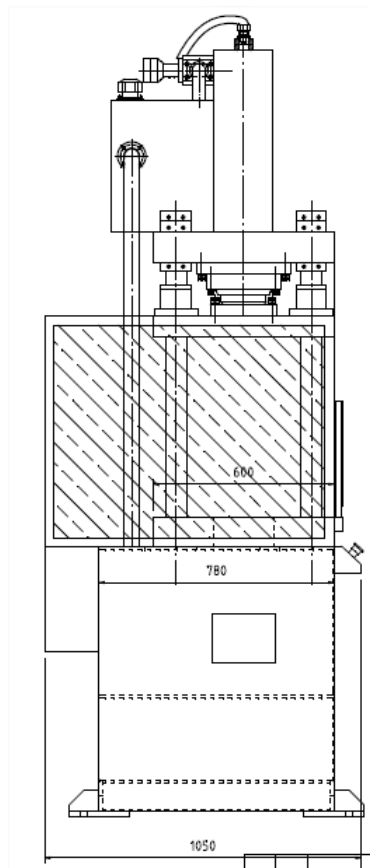
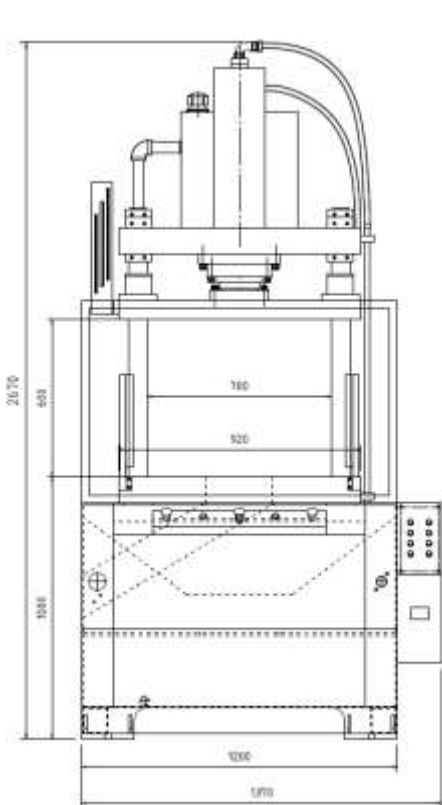
FSW



4 PUNCHING PRESSES - INSTALLED AUGUST 2019



WE HAVE INSTALLED 4 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



Lakil Ltd. - Bulgaria



Painting



Powder coating parts

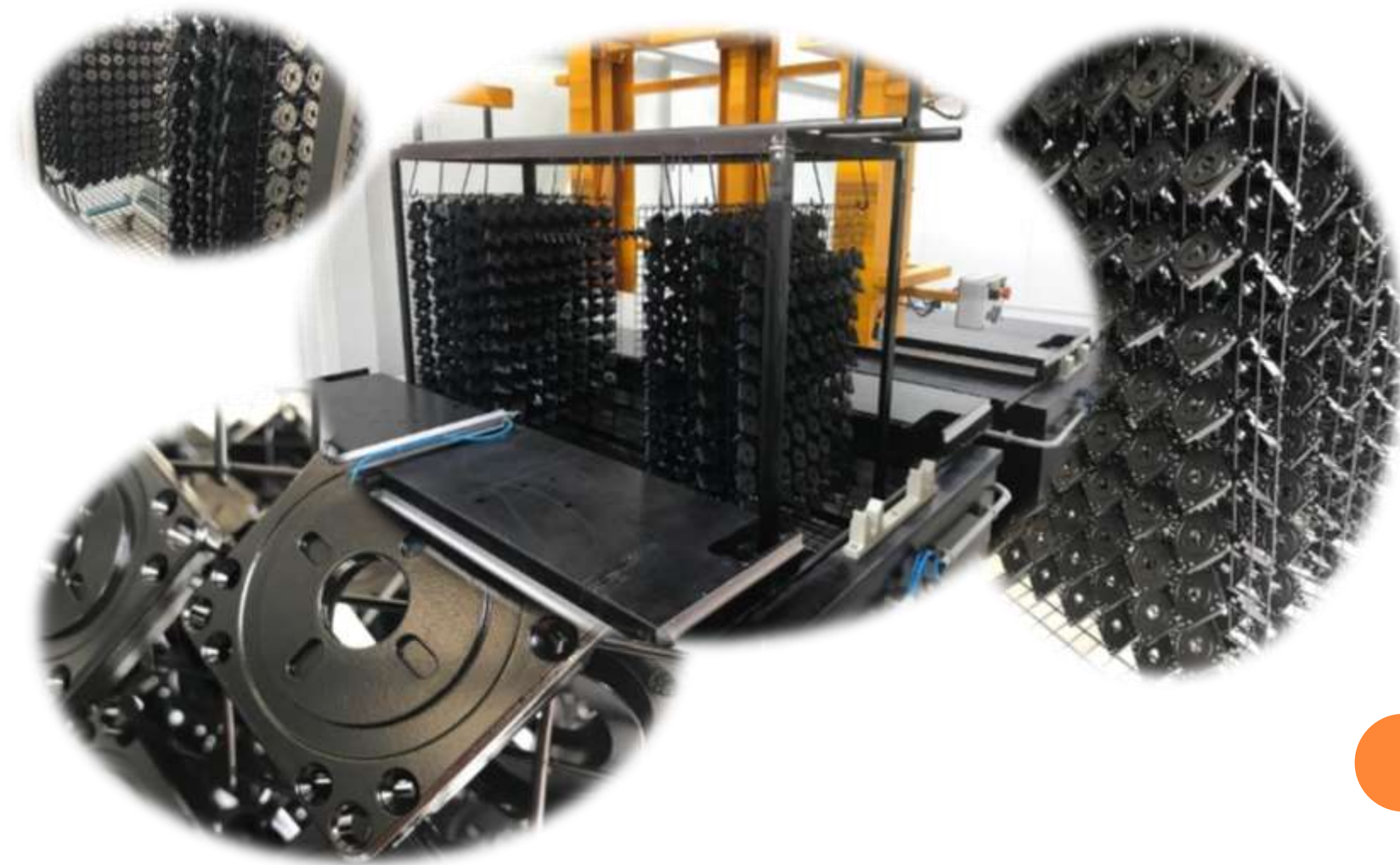
The parts are coated in the desired by the client colors according to RAL.



CASTINGS FOR - LIGHTING FIXTURES



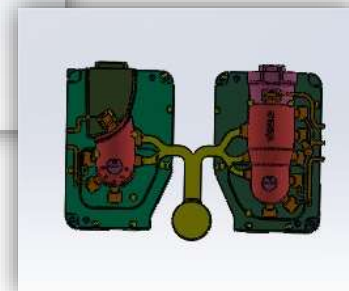
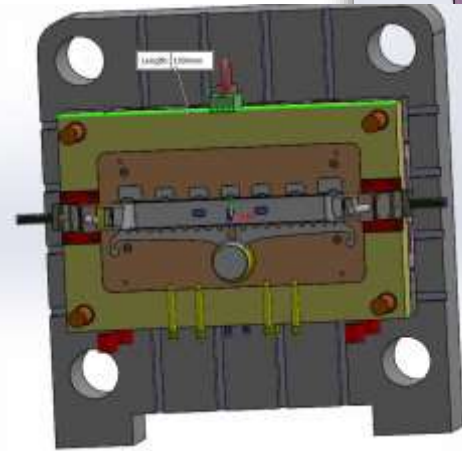
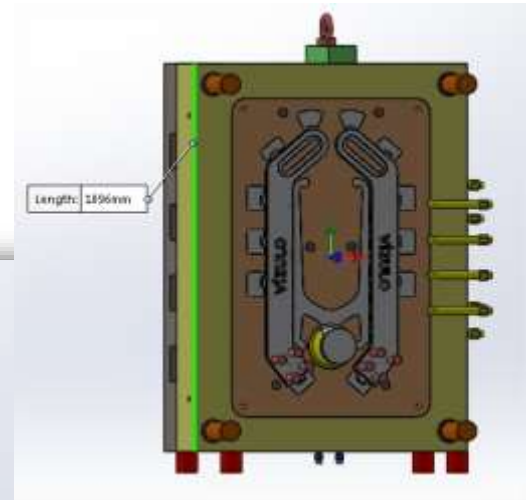
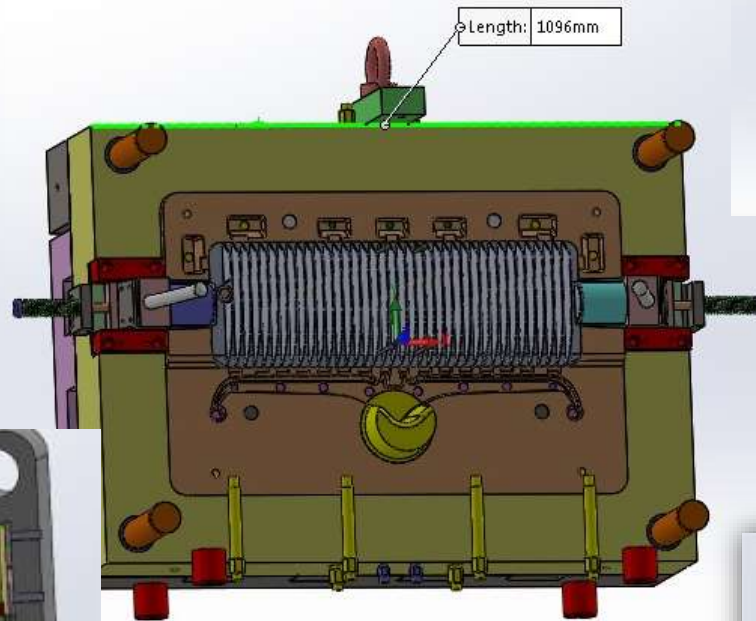
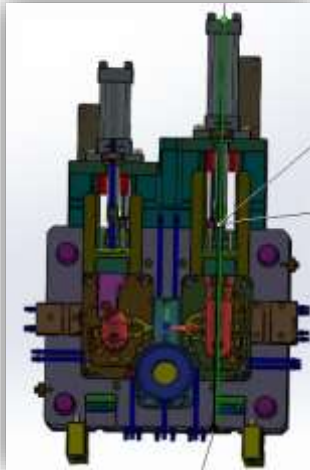
ELECTROPHORESIS - KTL



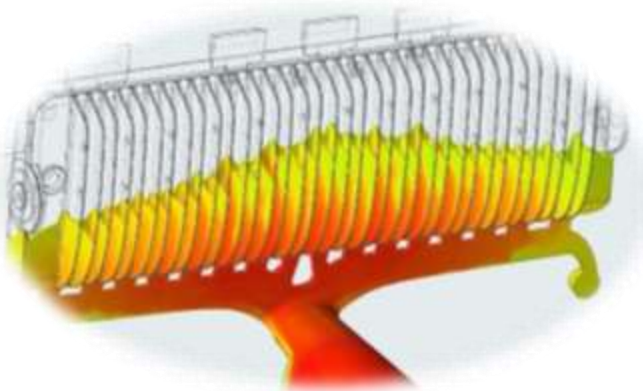
Lakil Ltd. - Bulgaria



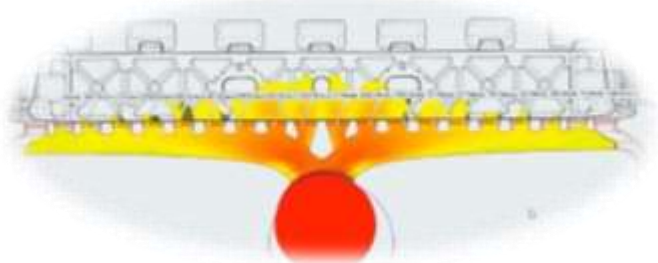
Design of die casting molds



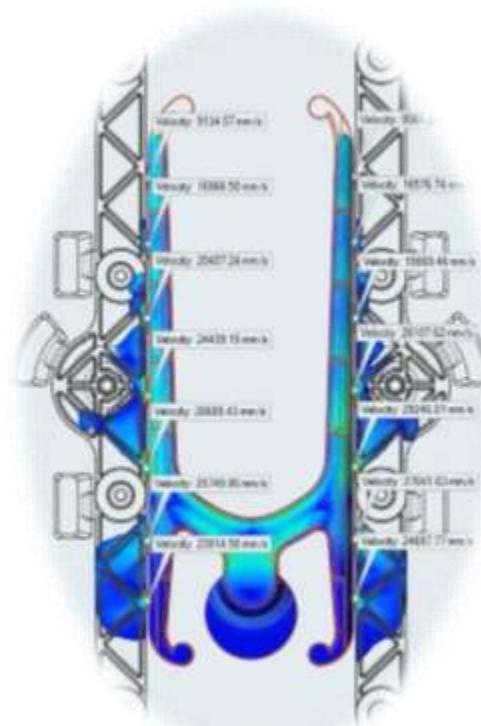
CASTING SIMULATION



Aluminium 44 300 /3,250kg



Aluminium 47 100 /2,730kg

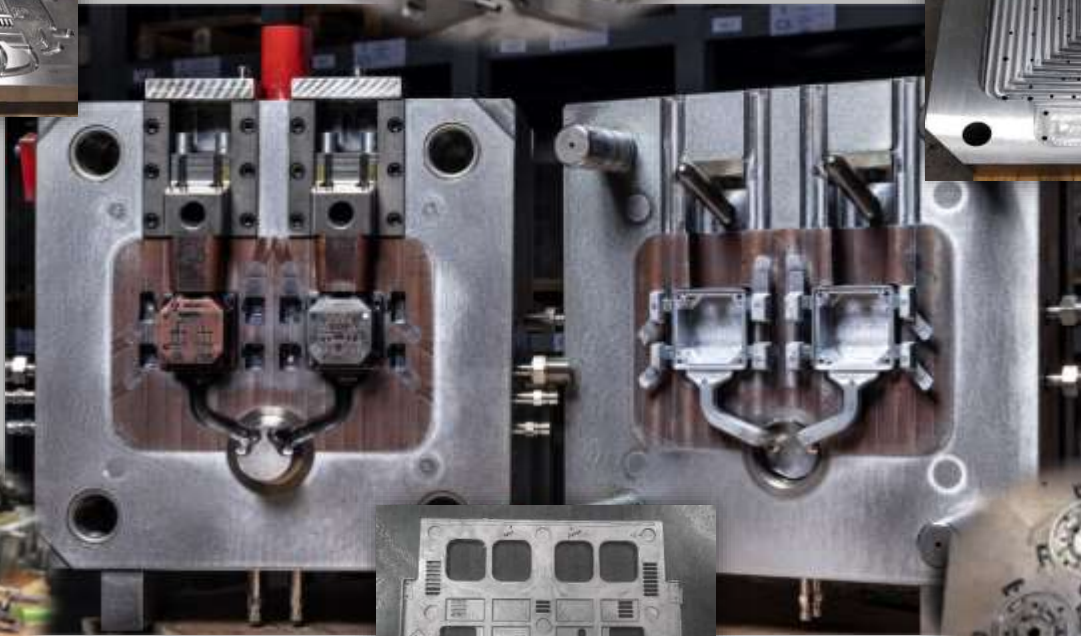


Aluminium 46 100 /2x 2,120kg



Tool workshop for production of die casting molds

LMT-Laki Moulding Technology

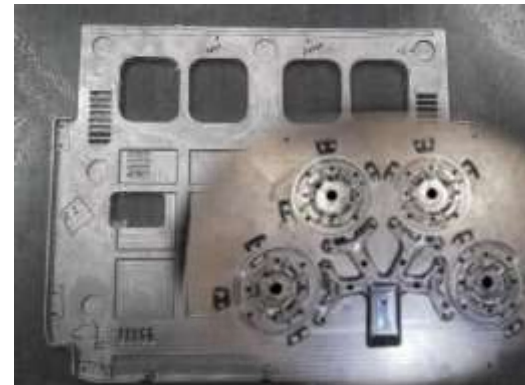


Tool workshop for production of die casting molds

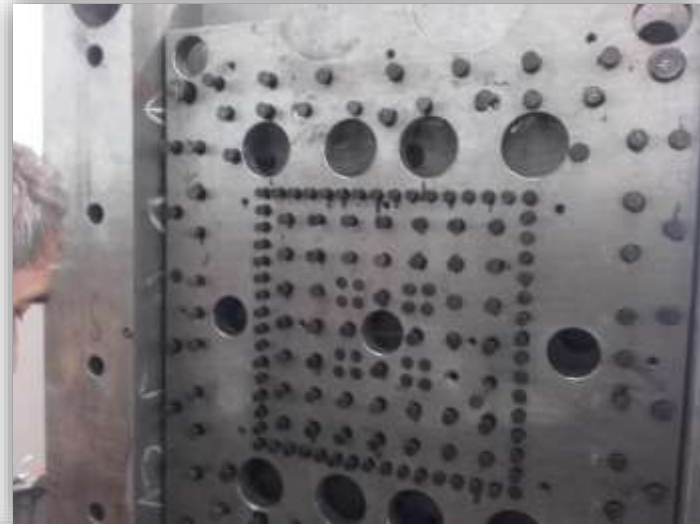
LMT-Laki Moulding Technologi



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 alloys



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



X-ray machine for aluminum casting

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

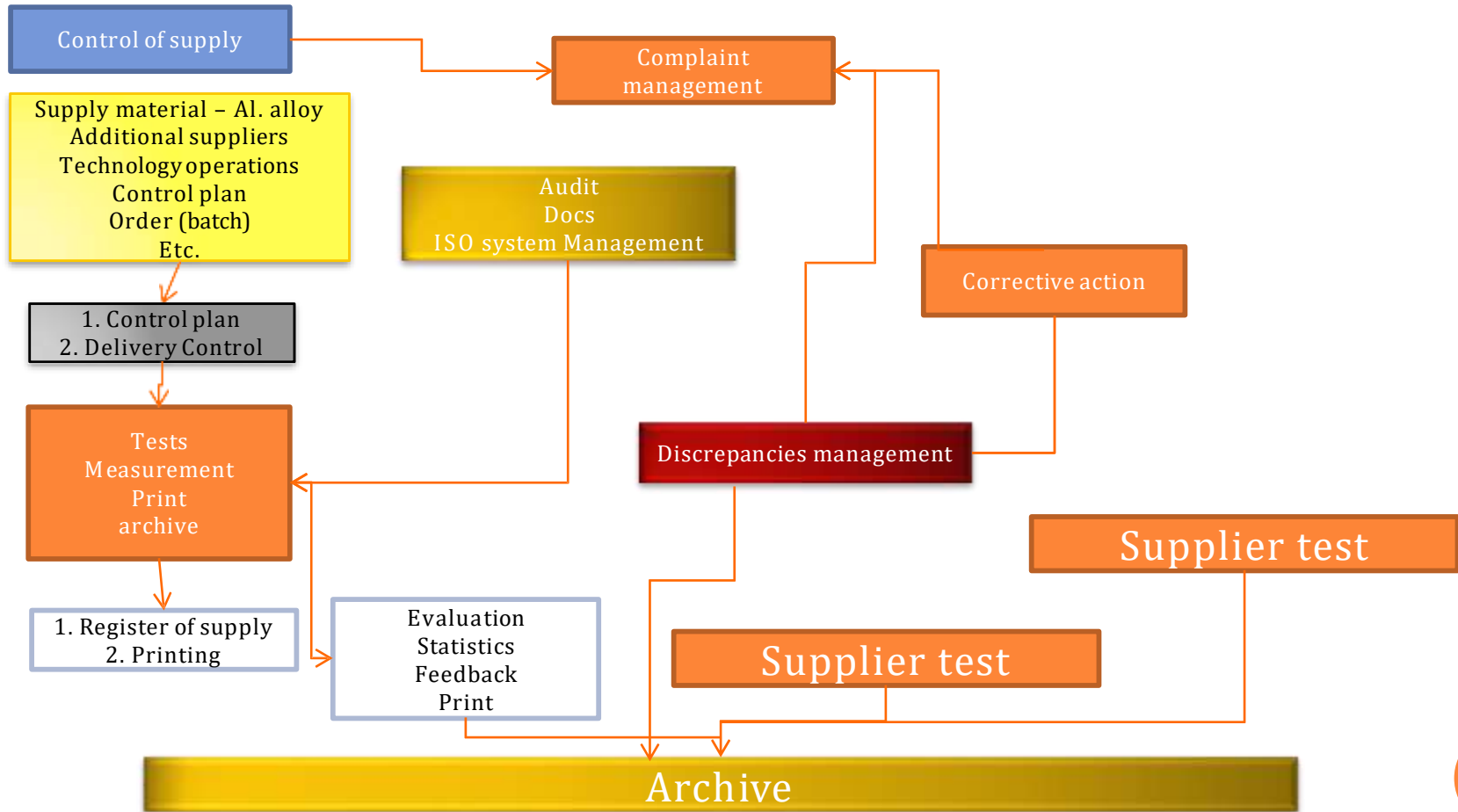


Quality control

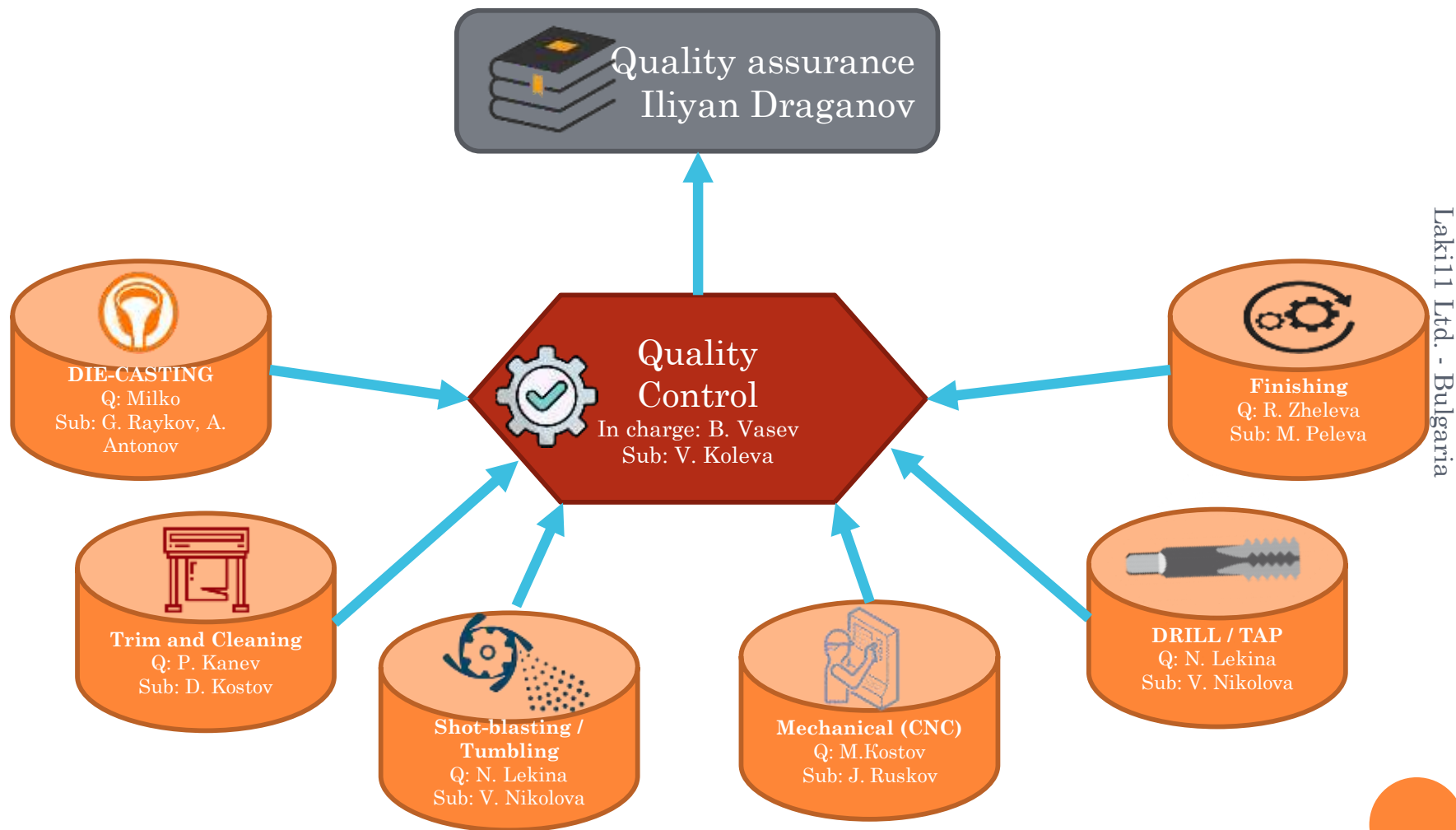


QUALITY CONTROL

- In common cases - ISO 2859 Sampling Standard
- Some costumers have request to make different type of control and measurement
- Following ISO 9001 standards



Контрол на качеството
Quality Control approach



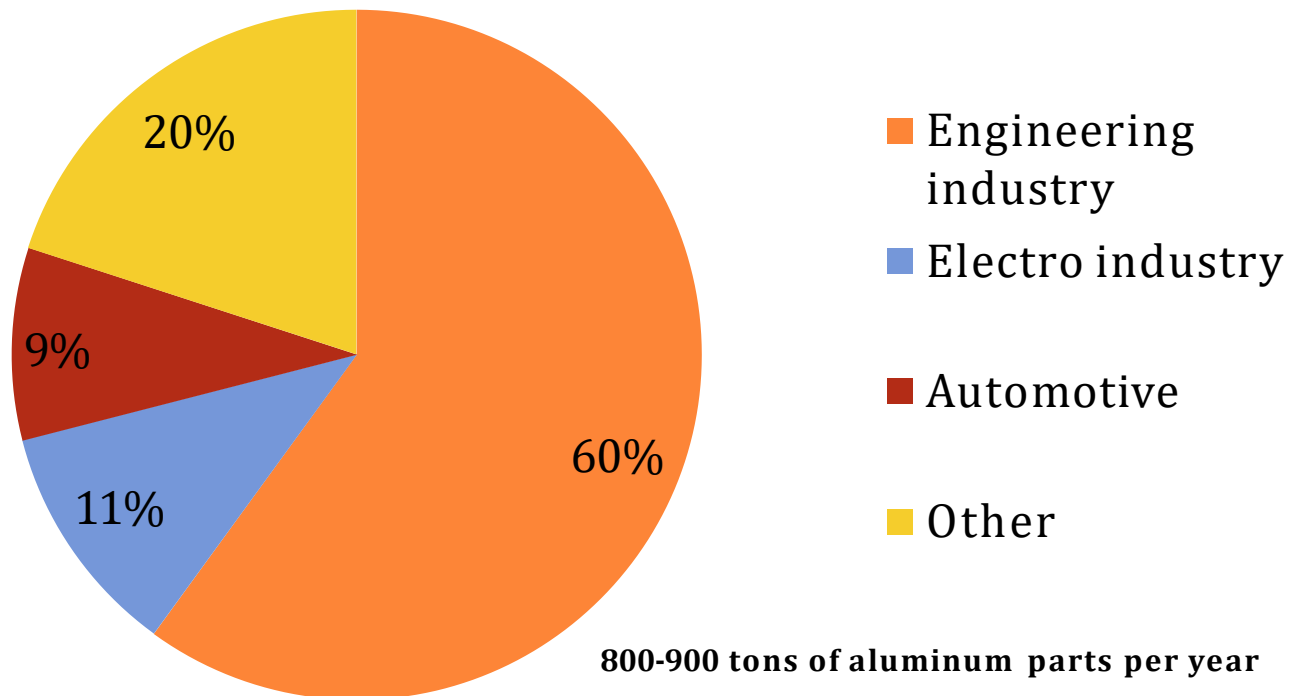
Main customers

- **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**
- **ABB -Bulgaria**
- **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

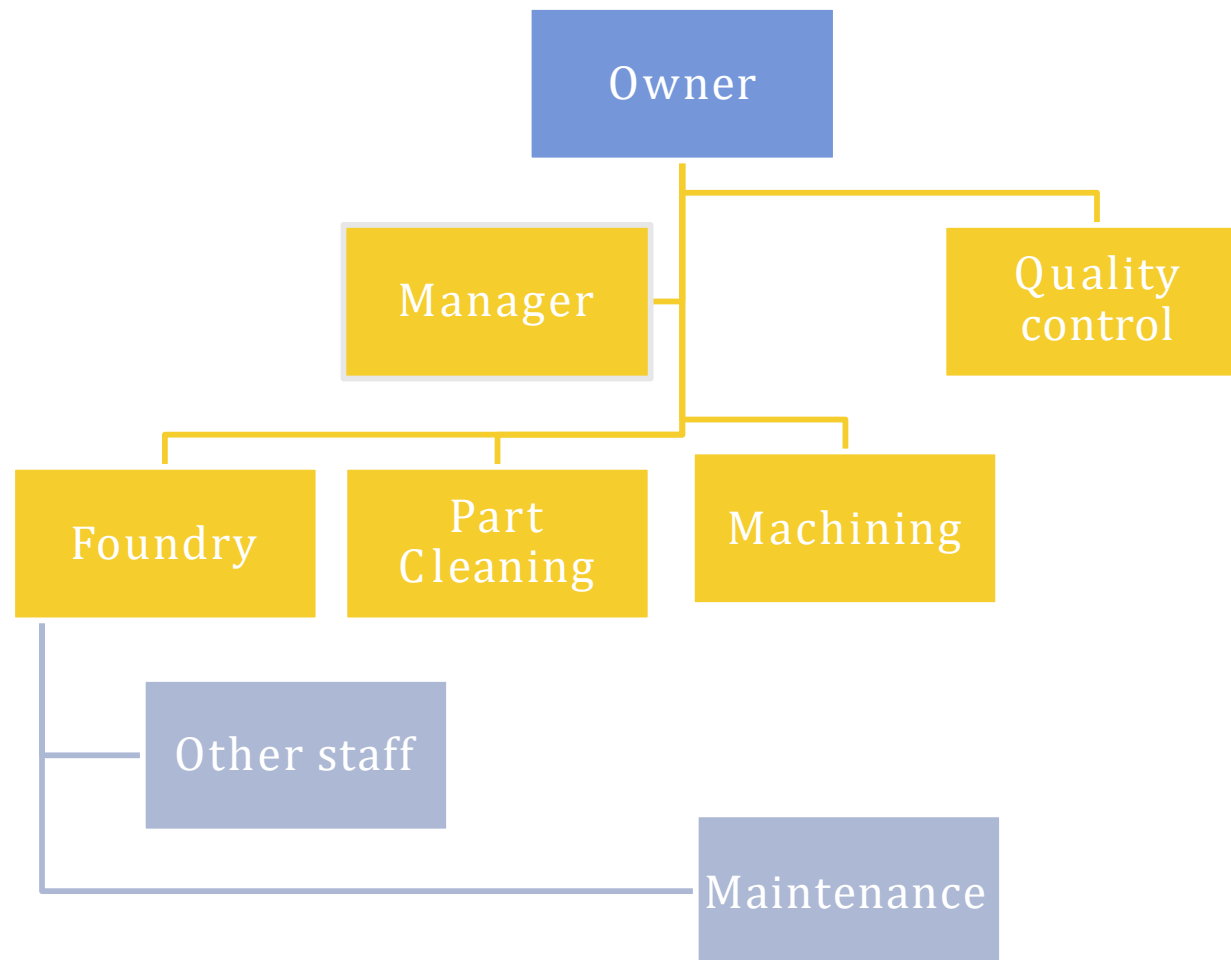
CATEGORY



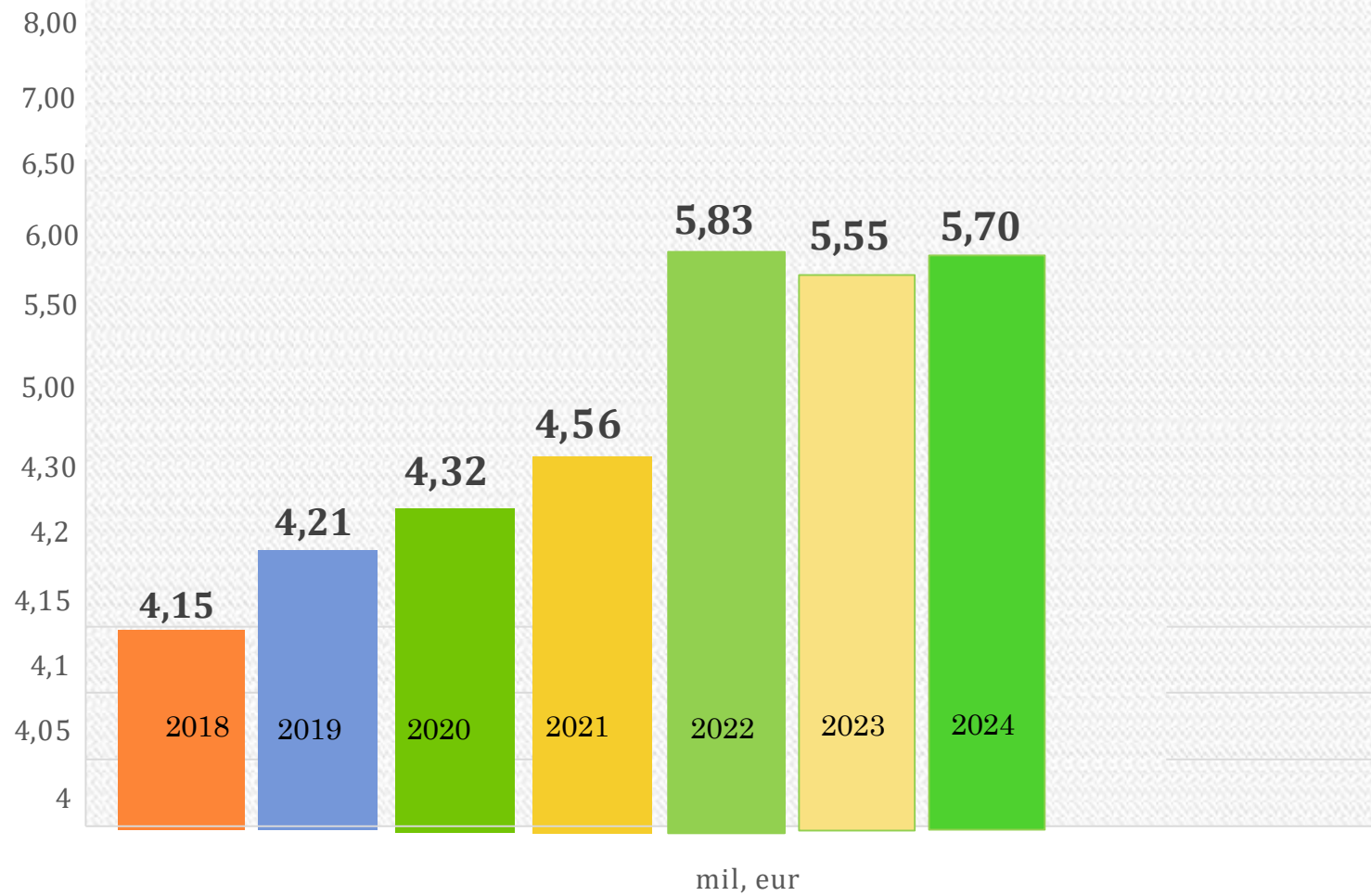
Work process



Company structure



Financial results

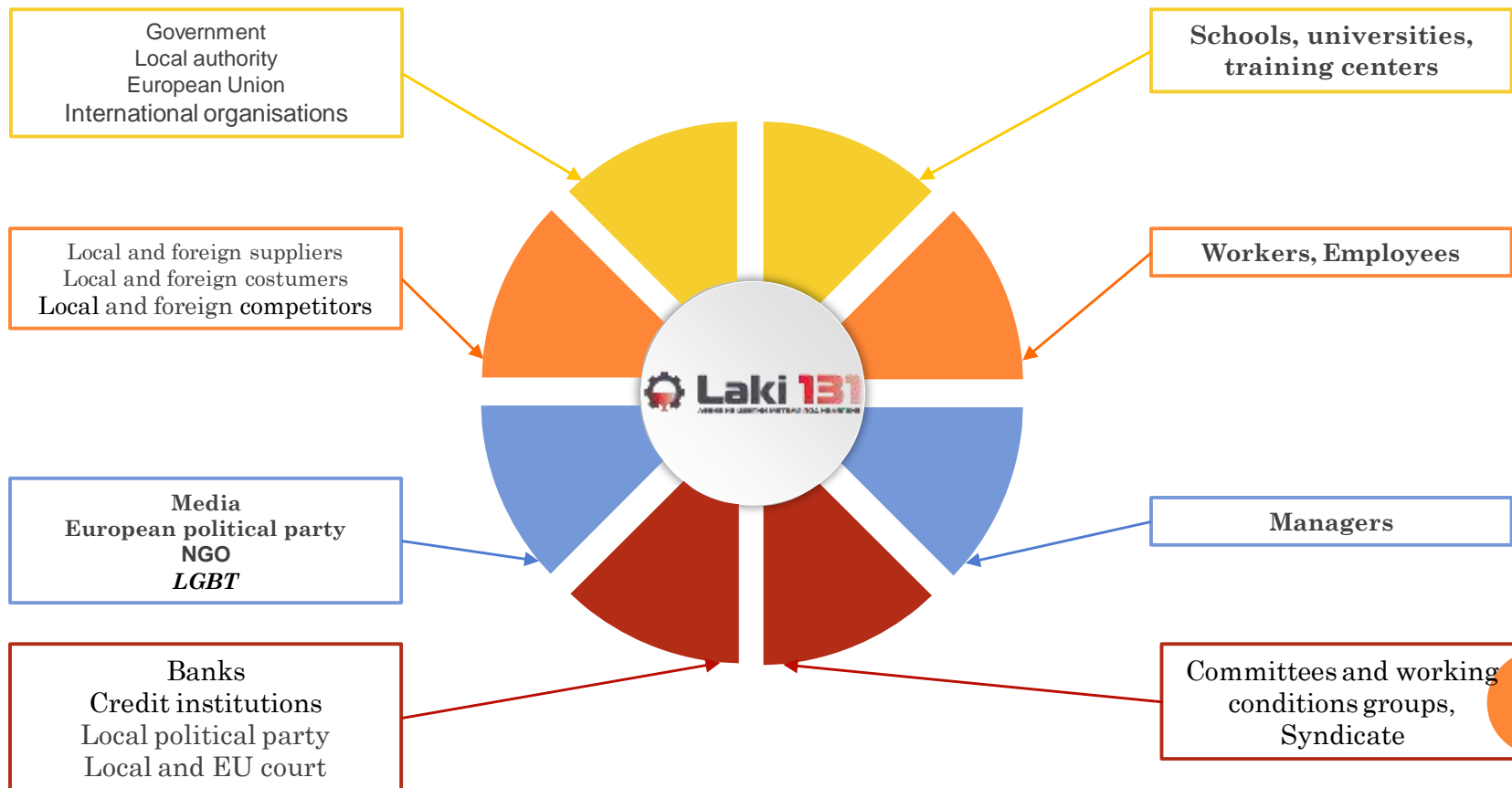


ЗАИНТЕРЕСОВАНИ СТРАНИ В РАБОТАТА НА ЛАКИ131 ООД

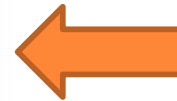
STAKEHOLDERS

EXTERNAL

INTERNAL



ISO Certificates





**34
YEARS**

**ALUMINUM DIE-CASTING
MECHANICAL PROCESSING
FSW - FRICTION STIR WELDING
POWDER COATING
DIE CASTING MOLDS**

THANK YOU FOR YOUR ATTENTION!

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Enter correct coordinates:

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24°47'01.5"E

