

COMES Materials – Handling Technology

for drop forges in particularly in the
fields of hotformers and coldformers



Maschinen- und Apparatebau

Comes Maschinen- und Apparatebau GmbH
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History

Comes Maschinen- und Apparatebau (Machine and Apparatus Construction) GmbH was founded in a small blacksmith shop in 1967 in Zemmer, a village near Trier. In the initial stage of this workshop the traditional commercial activity of this region was depending on the 'Industry' and the 'Building - Construction'.

As a result of the increasing industrial development and the resultant demand, the growth of Comes was directly influenced by the needs of the local industry. While working mainly in the areas of the forging, tobacco-, the tyre- and the accumulator industries, our company gained a huge knowledge, thereby expanding our customer's base far beyond the region of Trier.

After achieving the 'Great Verification of Suitability' with scope of direction DIN 18800 Part 7 Clause 6.2 and DIN 15018 'Crane - Steel Frame Structure' as well as the 'Welding - Procedure Qualification' according EN 288-3 for the handling and welding of high strength fine grain structural steel S690QL / S890QL / S960QL and the certification according DIN EN ISO 3834-2 'Quality Requirements for Welding - Design Companies' new industrial sectors of general machine building and heavy industry opened up.

The manufacturing plant Montanstrasse 12 in Trier - Hafen got completed in July 2009. Here piece weights up to 200 tons can currently be handled.



Formation of the company
1967 in Zemmer



Relocation to Seiferstraße 6,
Trier - Ehrang



Expansion of the manufacturing
plant Seiferstraße 16



Expansion of the manufacturing plant
Montanstraße 12, Trier - Hafen



Comes Materials Handling for Drop Forges

COMES Maschinen- und Apparatebau (Machine and Apparatus Construction) GmbH is an accredited and specialist firm in the welding of fine grain structural steels and offers an extensive product range, which includes materials handling equipment for drop forges of the best quality. All materials handling equipment for drop forges are manufactured in accordance with the current safety regulations and quality assurance measures. COMES materials handling equipment for drop forges are categorised by their high level of durability and applied load reserve. In operation, materials handling equipment for drop forges by COMES are highly stable and wearresistant.



COMES material handling equipment for drop forges

constructs and manufactures materials handling equipment for drop forges individually tailor - made for the requirements of the customers.

Our engineers have a solution ready for every situation. Custom tailored and enhanced on a constant basis, our robust products have proven their value in the field.

The knowledge of the employees, together with the high standard of machinery and the complimenting Business Park is the company's base for innovation.

Comes provides a wide range of material handling equipment for drop forges right up to special construction.



Products at a glance

Discharge belts according to the customers' request

- Version: as wire belt
 as steel plate belt
 as fishplate belt
- With or without housing / heat protection
- With or without ventilation - blowing on of the conveyor belt

Box filling stations, open / closed version

Outward transfers of start - up parts

BY – process – from the forging temperature controlled cooling

Tool setup units and **transport units**

Cooling Tower

Conveyor belts and **spray systems**

for example water spraying

Discharge belts to kilns

Scraper conveyor Mud - Cooling water

Manipulators for tools (Polymaster)

Concatenation of forging machine for annealing furnace

Filling: into boxes, cooling lines
 into boxes for shipping

Buffer zones, blasting systems

Spare parts service

Materials handling equipment for the following forging machines :

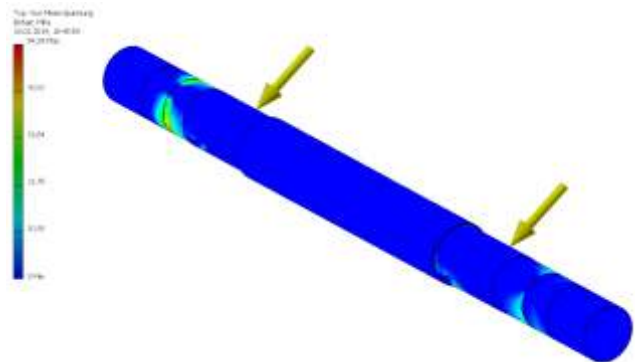
- Polymaster
- Forgemaster
- Hatebur AMP 30 HM 35 HF
 AMP 40 HM 75 HF
 AMP 50
 AMP 70

With know - how, experience, quality and reliability Comes has grown in the past decades and will thus continue to meet the high demands of customers.

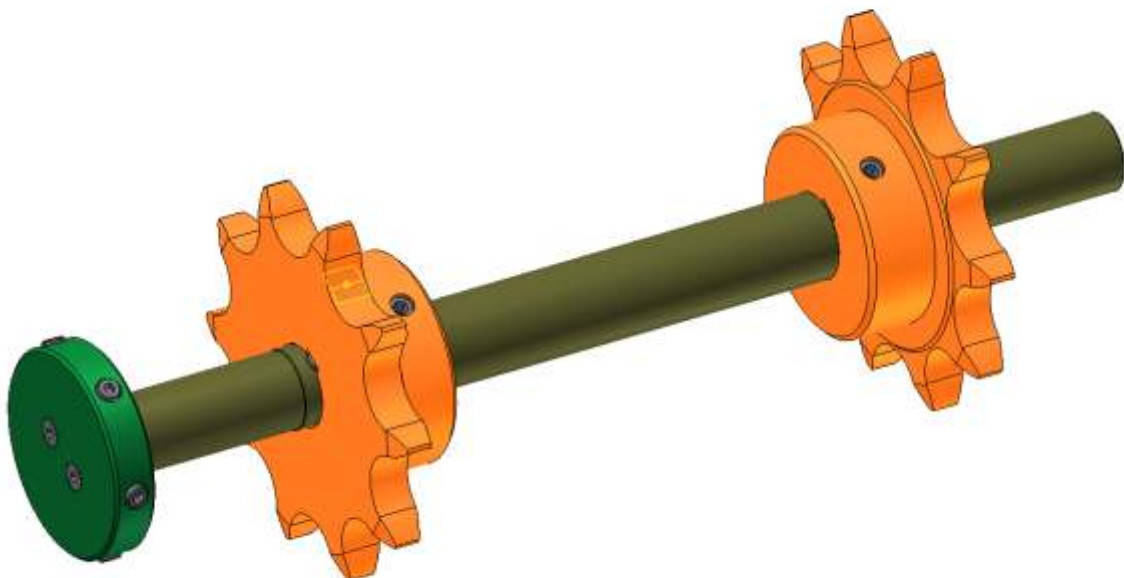
Design

The material handling equipment for drop forges are fundamentally designed in accordance with the appropriate standards for the structural detailing and design.

The quality of construction, assembly, documentation and final approval are guaranteed by In-House and external welding engineers and authorized experts.



Wave of a tail station of a conveyor belt





Manufacturer Qualifications

DIN 18800 Teil 7 Abs. 6.2

DIN 15018 „Krane“

DIN EN 13155 „Lose Lastaufnahmemittel“

DIN EN 3834 Teil 2

Recognised manufacturer certified in compliance with Pressure Equipment

Directive 97/23/EC, in conjunction with AD 2000-HP 0

Pressure Equipment Directive 97/23/EC in collaboration with

GTÜ Spezialists for § 19 I WHG

Procedure Test for:

S 690 QL steel plate

S 890 QL steel plate

S 960 QL steel plate

StE 770 pipe

S 355 J2+N steel plate

S 355 J2H rigid frame slab DIN 18808

P 265 GH

NiCroFer 6025 HT

Welders with welder qualifications in accordance with DIN EN - 287 -1 and machine operator qualifications in accordance with DIN EN 1418 for:

Welding process 135

Welding process 135

Welding process 111

Welding process 141

Welding process 121

Fine grain structural steel

Normal and high grade construction steel

Normal and high grade construction steel

High grade steel

Nickel-based alloy

Our external auditors

SGS TÜV GmbH

TÜV Rheinland Holding Aktiengesellschaft

GTÜ Gesellschaft für Technische Überwachung mbH

GSI Gesellschaft für Schweißtechnik International mbH

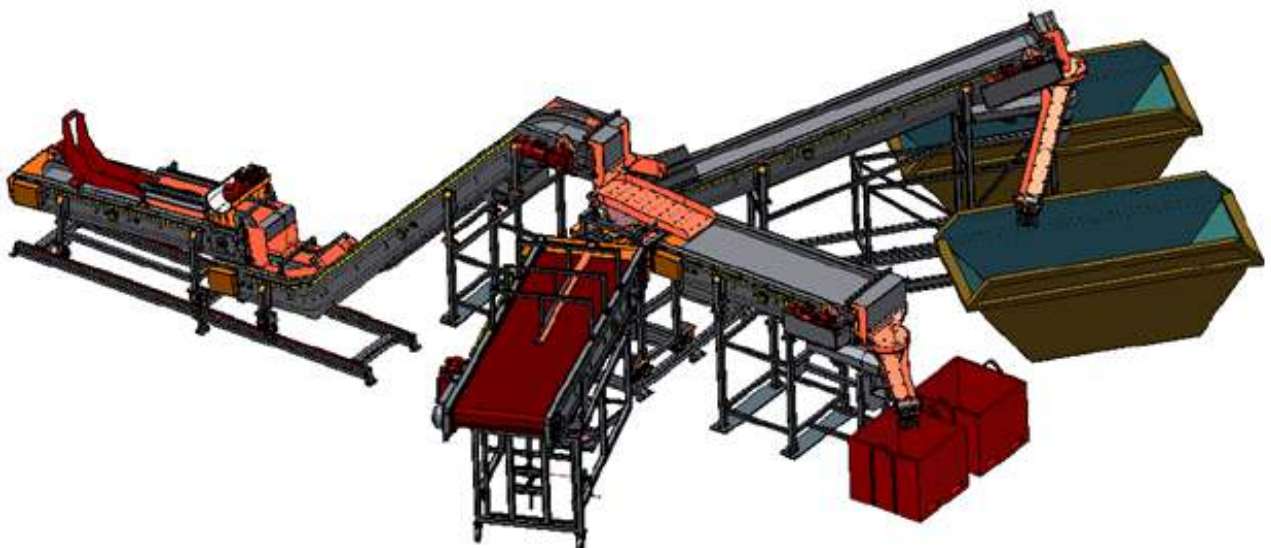
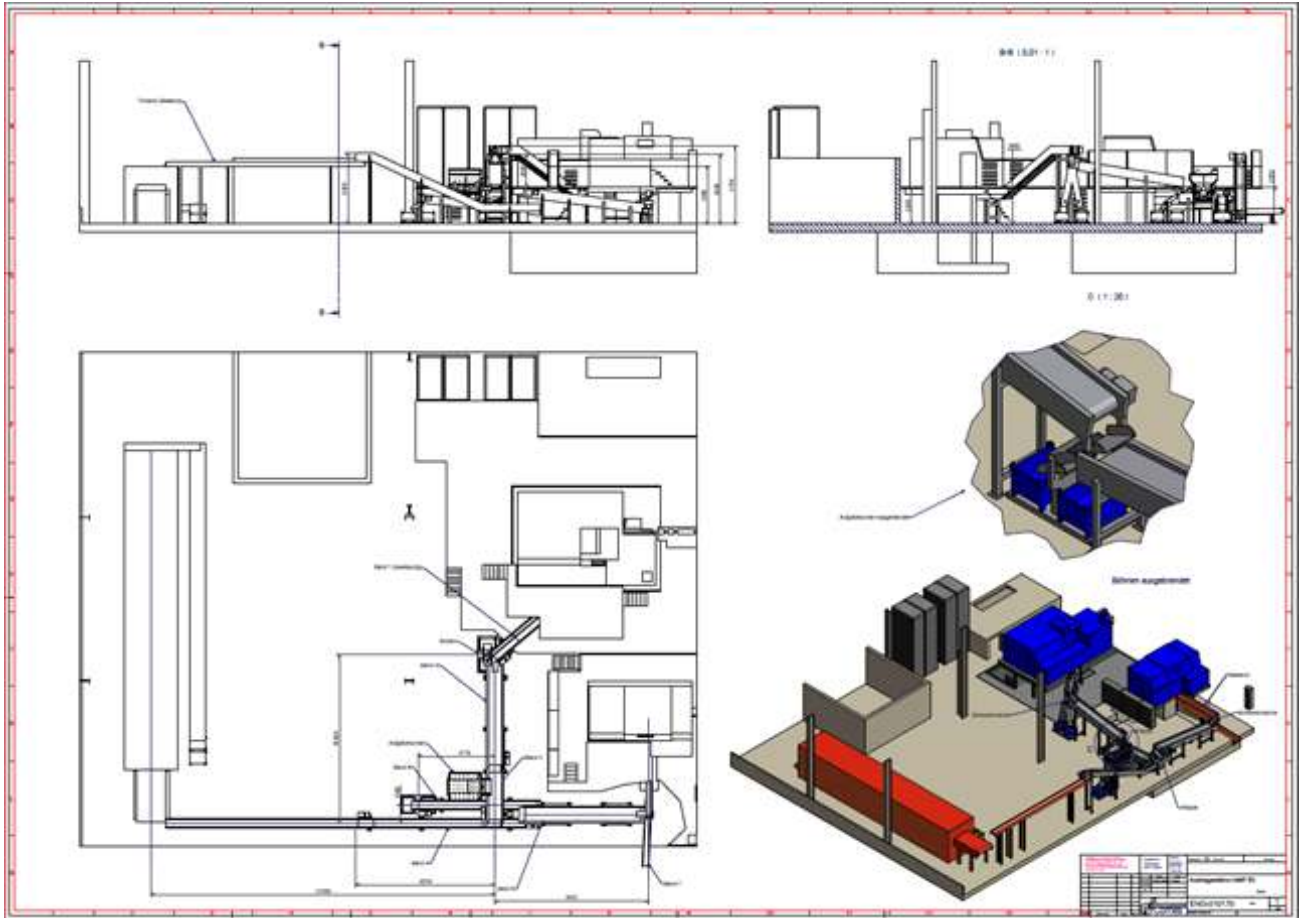
SLV Schweißtechnische Lehr- und Versuchsanstalt Saarbrücken

TÜV SÜD AG

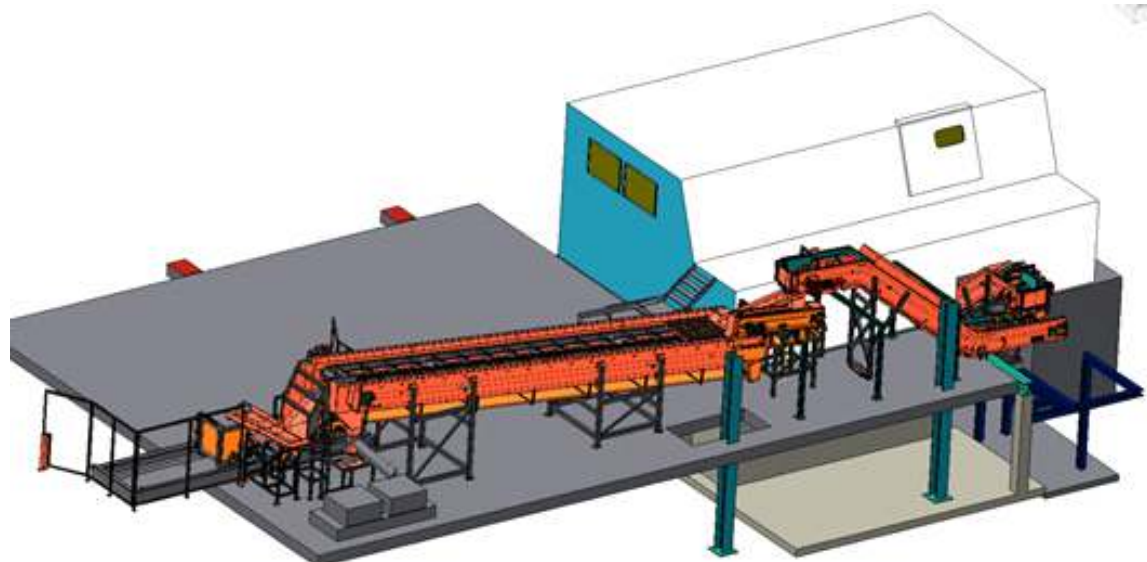
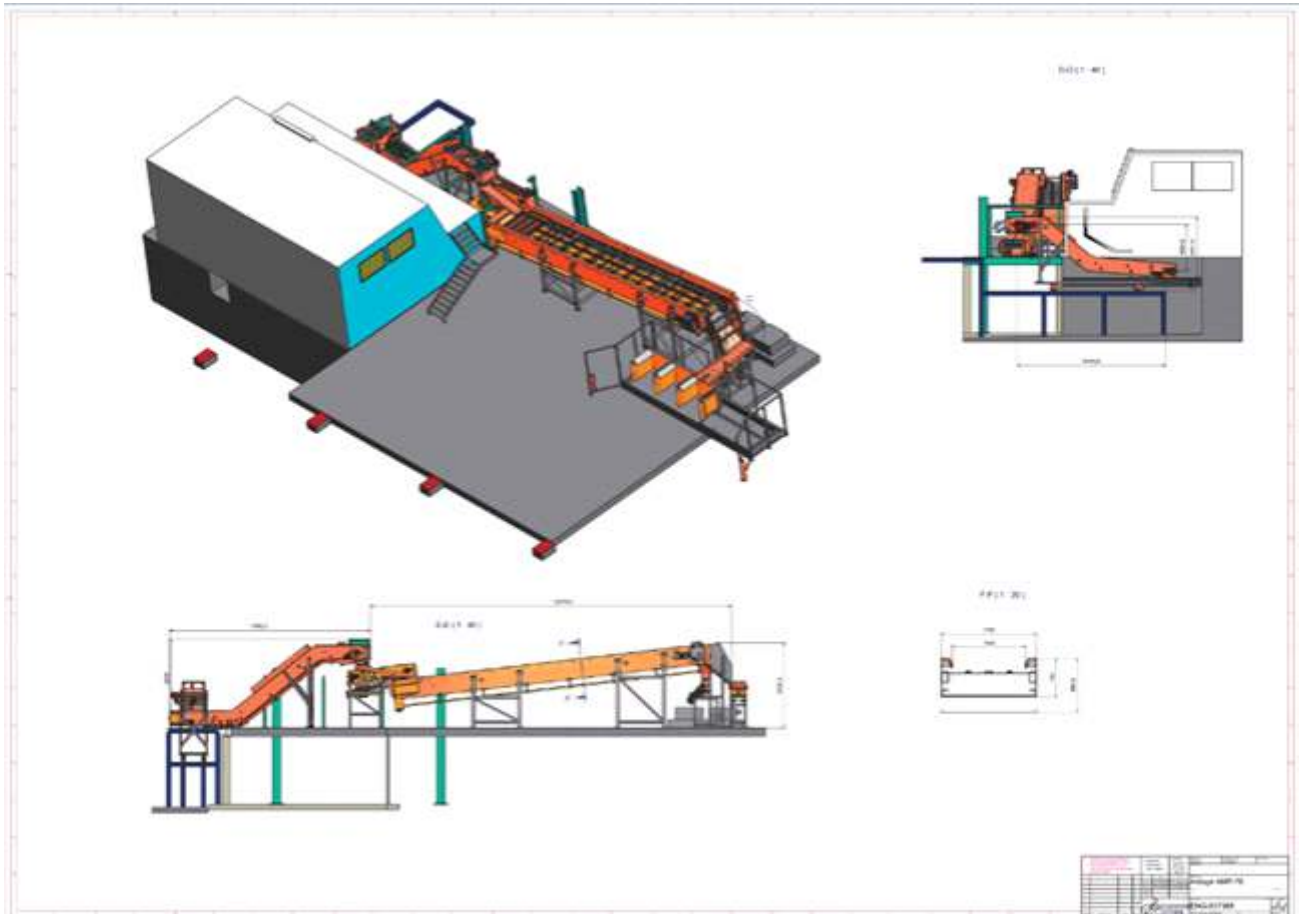
Germanischer Lloyd - GL Group



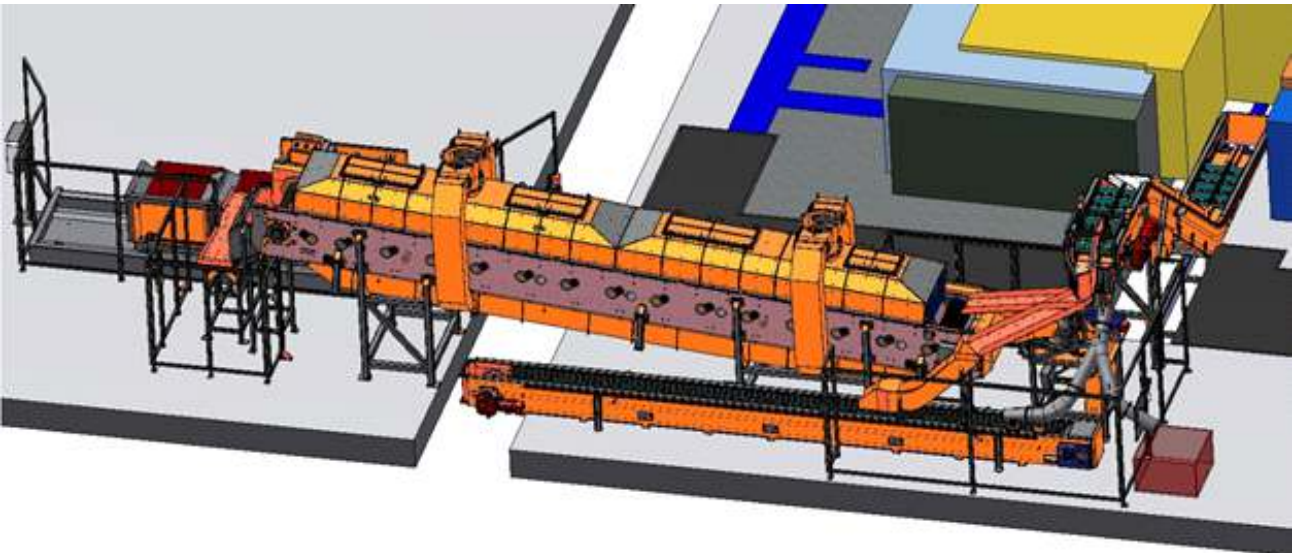
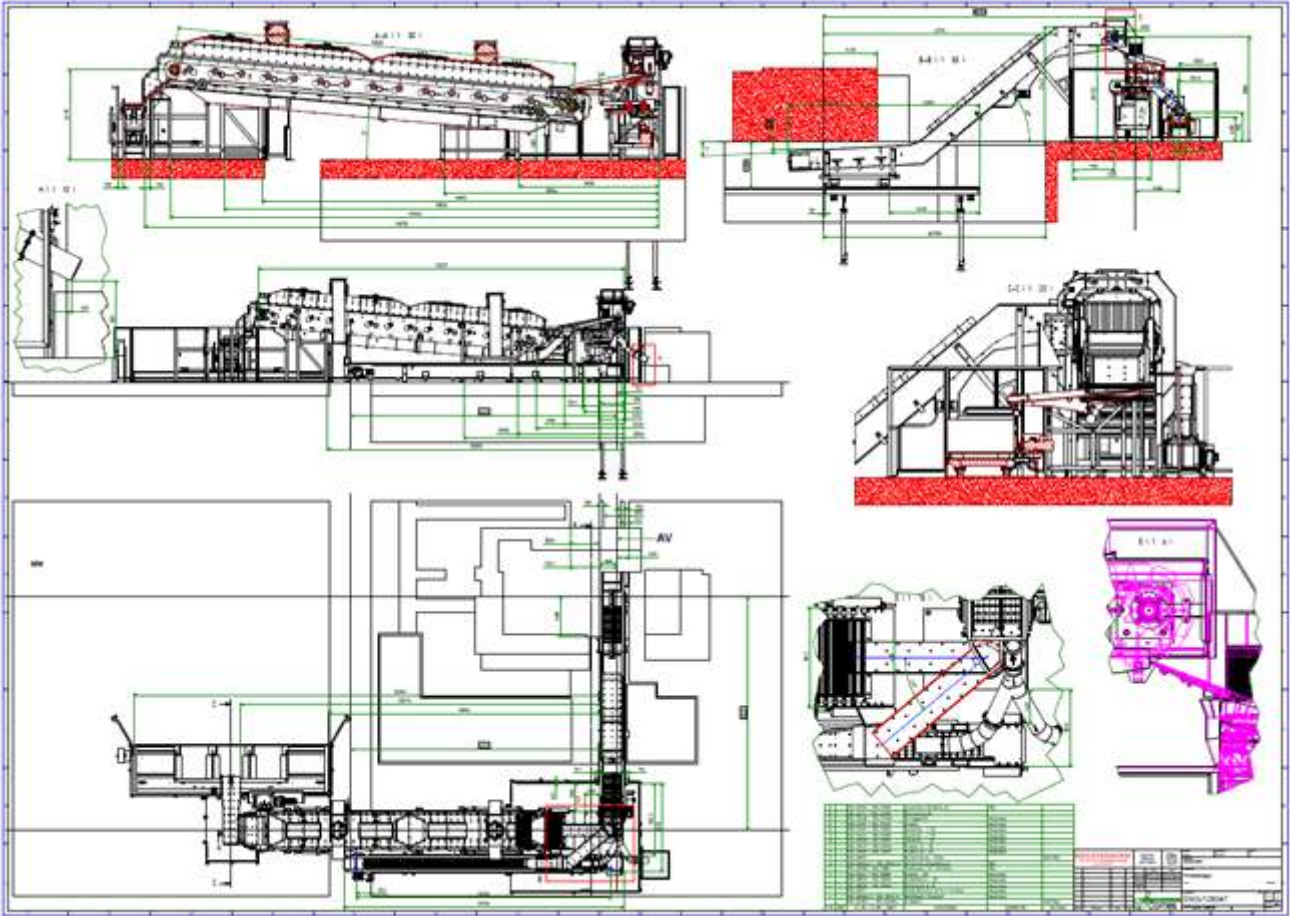
Discharge belts for hotformer type Hatebur AMP 50



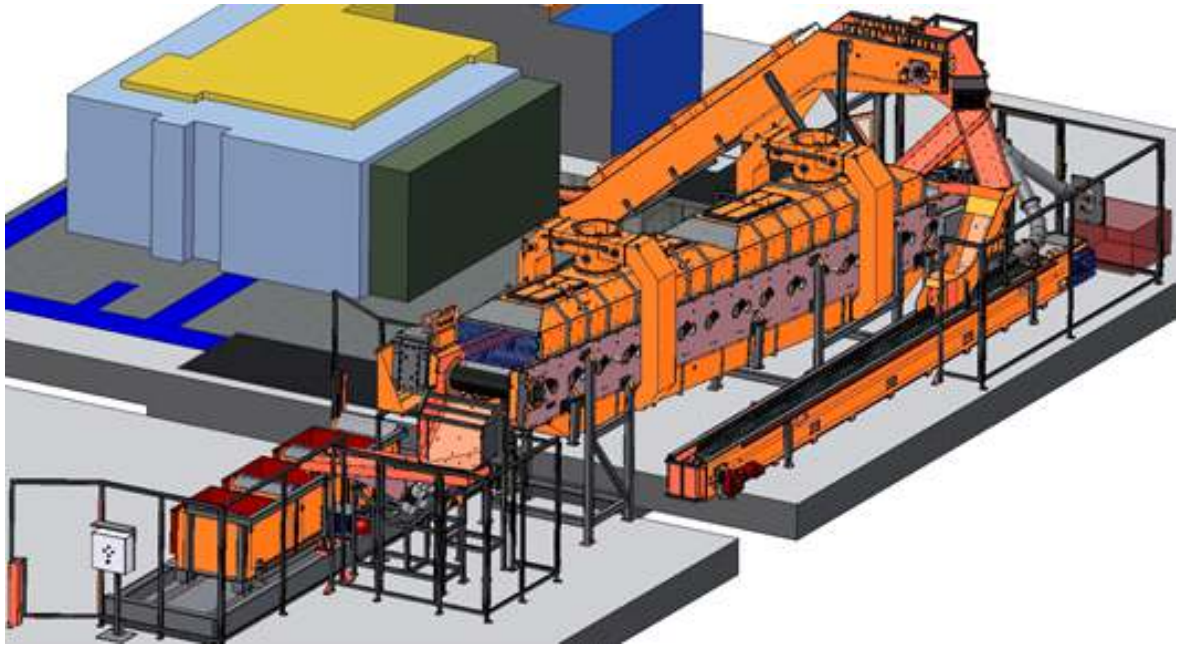
Discharge belts hotformer type Hatebur AMP 70



Discharge belts for hotformer type Hatebur AMP 70



Discharge belts for hotformer type Hatebur AMP 70



Discharge belts for hotformer type Hatebur HM 75 XL





Discharge belts for blasting systems



Discharge belts for hotformer type Hatebur AMP 70



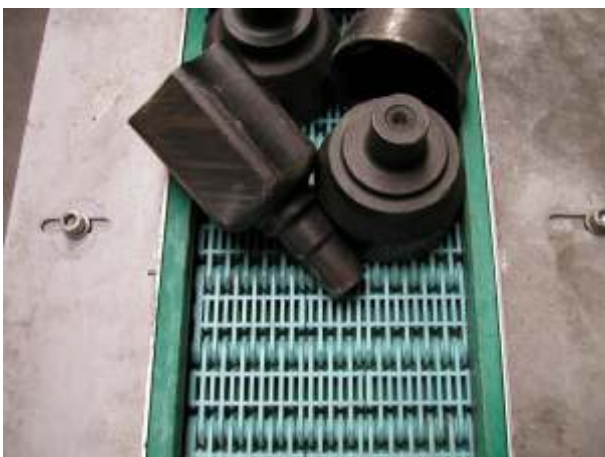
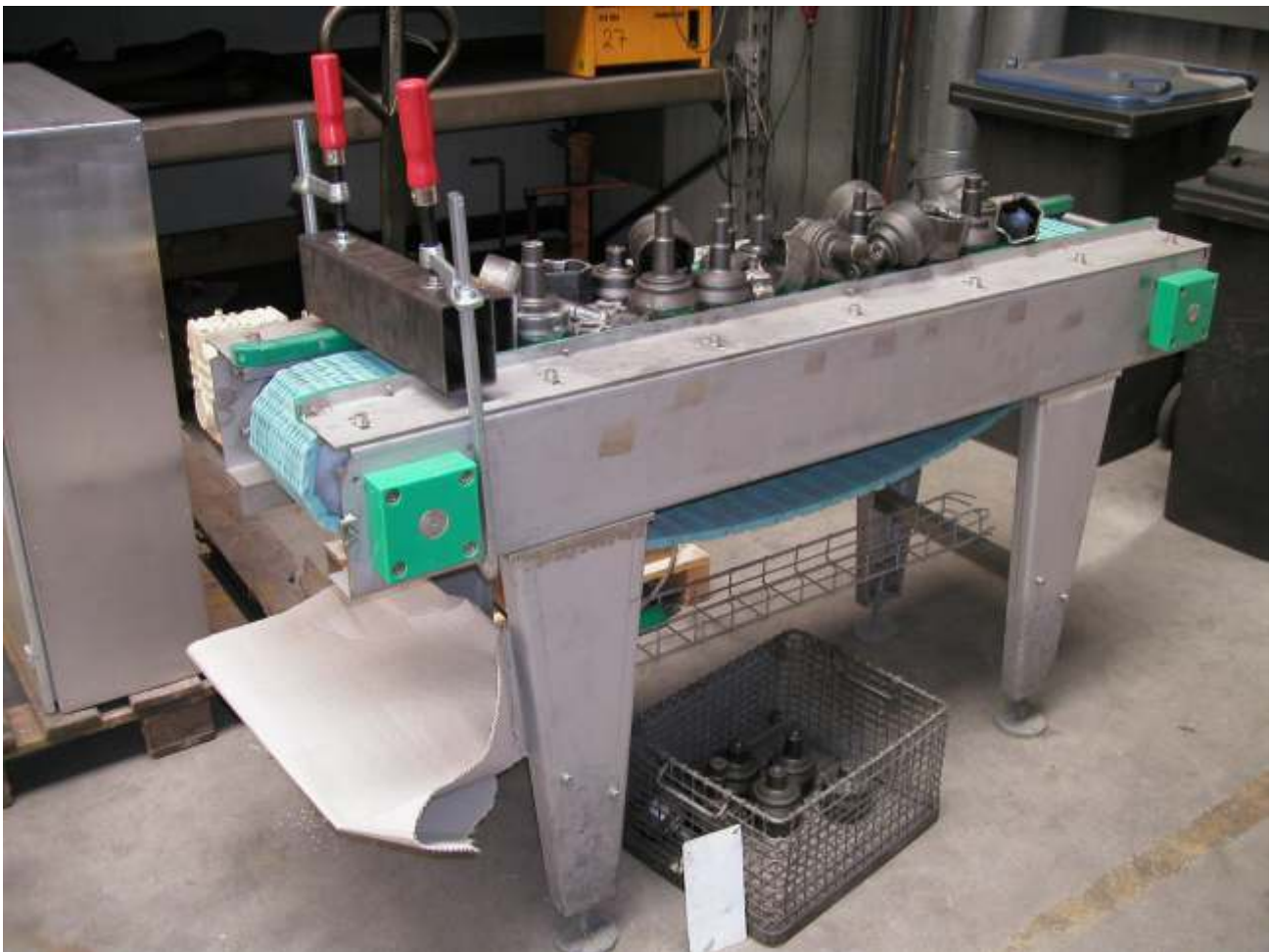
Discharge belts for hotformer type Hatebur AMP 70



Burr removing unit for good parts



Endurance test of a conveyor belt in a forging line



Discharge belts for hotformer type hatebur AMP 70



Discharge belt for annealing furnace





Small manufacturing facility with bunkers and Tipper





Discharge belt + box filling station for forgemaster



Discharge belts for hotformer type Hatebur AMP 70



Feed hopper - vibration channel





Special Welder's Certificate according to DIN 18800-7 Seiferstraße 16

Gesellschaft für Schweißtechnik International mbH
Schweißtechnische Lehr- und Versuchsanstalt SLV Saarbrücken



Bescheinigung

über die Herstellerqualifikation zum Schweißen von Stahlbauten nach DIN 18800-7:2008-11
Klasse E

Dem Unternehmen **Comes Maschinen- und Apparatebau GmbH**
wird für den Schweißbetrieb in **54293 Trier, Seiferstr. 16**

bescheinigt, dass er über die erforderlichen Fachkräfte und Vorrichtungen verfügt, Schweißarbeiten zur Herstellung tragender Stahlbauteile im folgenden Anwendungsbereich durchzuführen:

Normen/Regelwerke **DIN 18800-7
DIN 4112, DIN 4132, DIN 15018**

Schweißprozesse
(Ordnungsnummer nach
DIN EN ISO 4063) **E (111), t-MAG (135, 136), m-WIG (141), UP (121)**

Grundwerkstoffe **S235, S355, S420,
S690, S890, S960 gemäß Verfahrensprüfung,
CrMo-Stähle Werkstoffgruppe 5 nach CEN ISO/TR 15608,
Nichtrostende austenit. Stähle nach gültigem Zulassungsbescheid DIBt.**
Erweiterungen/Einschränkungen **keine**

Verantwortliche
Schweißaufsichtsperson
(Name, Vorname, Geburtsdatum,
Qualifikation) **Dipl.-Ing. Harborth, Holger, geb. am 20.07.1963, EWE**

Vertreter
(Name, Vorname, Geburtsdatum,
Qualifikation) **Scherbenok, Sergej, geb. am 26.11.1966, EWE
Steinmetz, Stefan, geb. am 10.12.1965, SFM**

Bemerkungen **siehe Rückseite**

Gültigkeitszeitraum **vom 19.09.2010 bis 18.09.2013**

Bescheinigungs-Nr. **100/10**

ausgestellt am **09. September 2010
Dipl.-Ing. Stiefel**

Leiter der Prüfstelle
(Name, Unterschrift, Stempel)

Allgemeine Bestimmungen
siehe Rückseite



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Internet: www.slv-saar.de

Niederlassungsleiter: Dr.-Ing. Helmut Hock

GSI - Gesellschaft für Schweißtechnik International mbH, HRB 27119 Gießenstr. 6, 34109 Kassel, Geschäftsführer: Prof. Dr.-Ing. Stefan Kretz, Aufsichtsrat: Prof. Dr.-Ing. Rainer Flegel, Vorsitz



Seiferstraße 16 DIN EN ISO 3834 - 2:2006

ZERTIFIKAT

CERTIFICATE

DVS

Z E R T

bescheinigt hiermit, dass das Unternehmen
hereby certifies that the company

Comes Maschinen- und Apparatebau GmbH
Seiferstraße 16
D-54293 Trier-Ehrang

den Nachweis erbracht hat,
die schweißtechnischen Qualitätsanforderungen nach
has furnished proof to fulfil the quality requirements for welding according to

DIN EN ISO 3834-2:2006

in dem auf der Rückseite angegebenen Umfang zu erfüllen.
in the extent mentioned on the reverse side.

<p>Registrier-Nr./Registration No. DE-2009-087-A gültig bis/valid until 22. November 2012 Lfd. Betriebsprüfer/Lead Assessor</p>	<p>Düsseldorf, 23. November 2009 Zertifizierungsstelle/Certification Body</p>
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 <hr style="width: 80%; margin: 0 auto;"/> <p>Dipl.-Ing. Bernd Stiefel</p>	 <hr style="width: 80%; margin: 0 auto;"/> <p>Dipl.-Ing. M. Lehmann</p>
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DVS ZERT® e.V., Aachener Straße 172, D-40223 Düsseldorf, www.dvs-zert.de

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Montanstraße 12 DIN EN ISO 3834 - 2:2006

ZERTIFIKAT

CERTIFICATE

DVS

Z E R T

bescheinigt hiermit, dass das Unternehmen
hereby certifies that the company

Comes Maschinen- und Apparatebau GmbH
Montanstraße 12
D-54293 Trier-Hafen

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 Dipl.-Ing. Bernd Stiefel	 Dipl.-Ing. M. Lehmann
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Not updated. Valid version on the website: www.comes-trier.de



Produktion Plant 1: Seiferstraße 16 • Trier - Ehrang - Piece weight 50/80 Tons
Produktion Plant 2: Montanstraße 12 • Trier - Hafen - Piece weight up to 200 Tons



Responsible for Pictures and Content:

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Status: 04.2014