

CIE LT Forge presentation

January 2021



CIE LT Forge



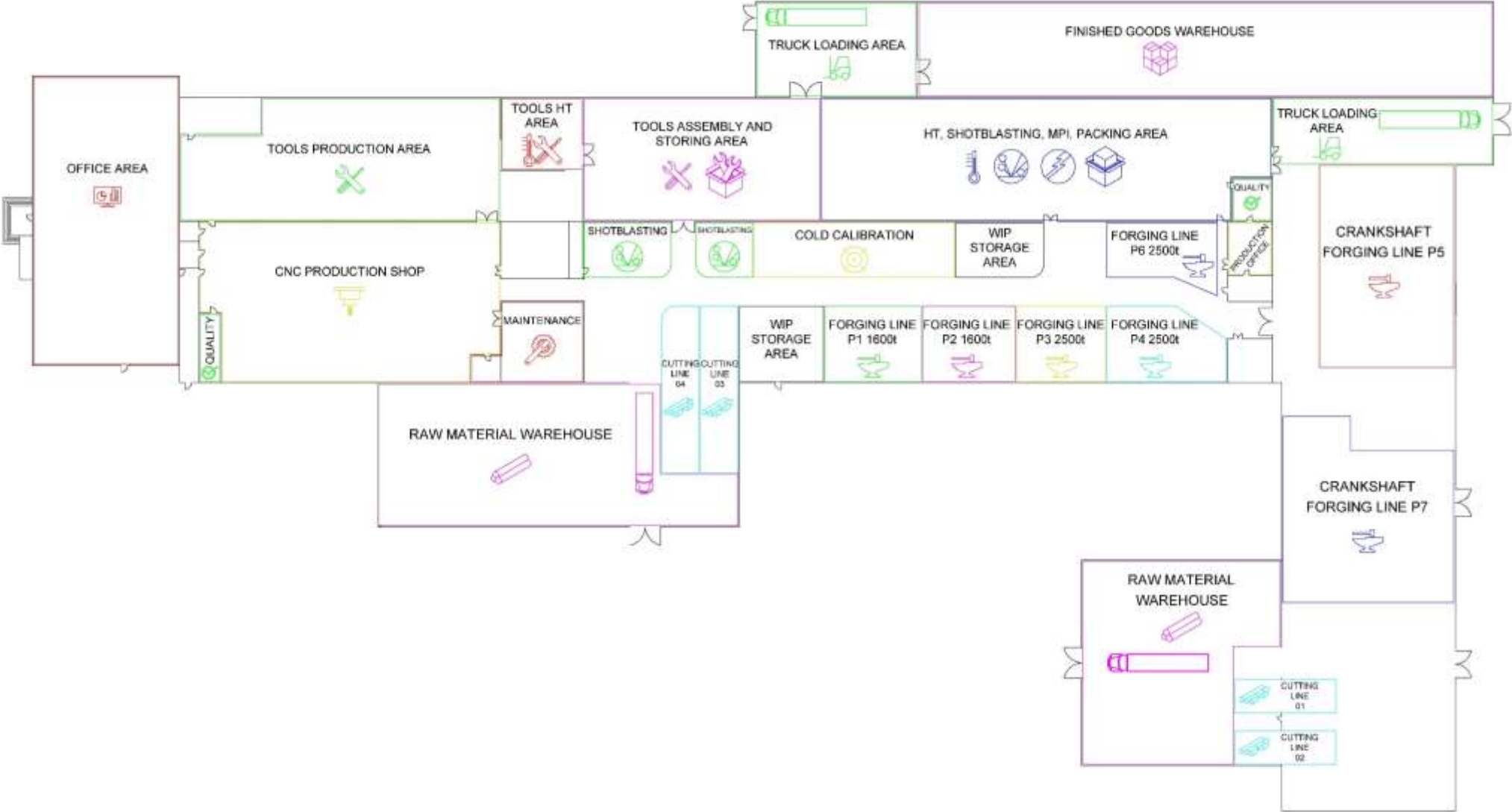
TURNOVER 2020: 30 Mio €

EMPLOYEES 2020: 227

SURFACE: 16.000 M²

www.cieautomotive.it

CIE LT Forge: LOYOUT



CIE LT Forge: PROCESSES

CUTTING

Material is received in bars up to 7500mm in length and cut according to technology requirements

CURRENT FACILITIES

- 1 automatic shear line
- 3 circular saw lines

CURRENT CUTTING CAPACITY

- GAMEI automatic shear – 4.800.000 units/year
- TSUNE sawing machine – 750.000 units/year
- 2 SIMAX sawing machines – 1.500.000 units/year

TOTAL – 7.050.000 units/year



CIE LT Forge: PROCESSES

FORGING

CURRENT FACILITIES

2 vertical press of 5,000 Tn
2 vertical presses of 2,500 Tn
1 vertical press of 2,000 Tn
2 vertical presses of 1,600 Tn



CIE LT Forge: PROCESSES

HEAT TREATMENT AND FINISHING CURRENT FACILITIES

3 high temperature & 3 low temperature
gas ovens IPSEN
1 quench tank
4 Shot blasting machines
HT capacity – 8.000 Tn/year

Cold calibration

3 cold calibration presses

Available processes – Normalizing,
Isothermal annealing, Quench and
tempering, Soft annealing

CIE LT Forge: PROCESSES

MACHINING

CURRENT FACILITIES

- 14 Gildemeister CNC lathes (turning centers)
- 1 Mori Seiki CNC lathes (high precision manufacturing center)
- 2 CNC (milling centers)
- 2 induction hardening machines
- 2 special machines for cleaning parts before packing

Rough machining of forged parts and finished machining of some specific parts



CIE LT Forge: PROCESSES

TOOLING SHOP CURRENT

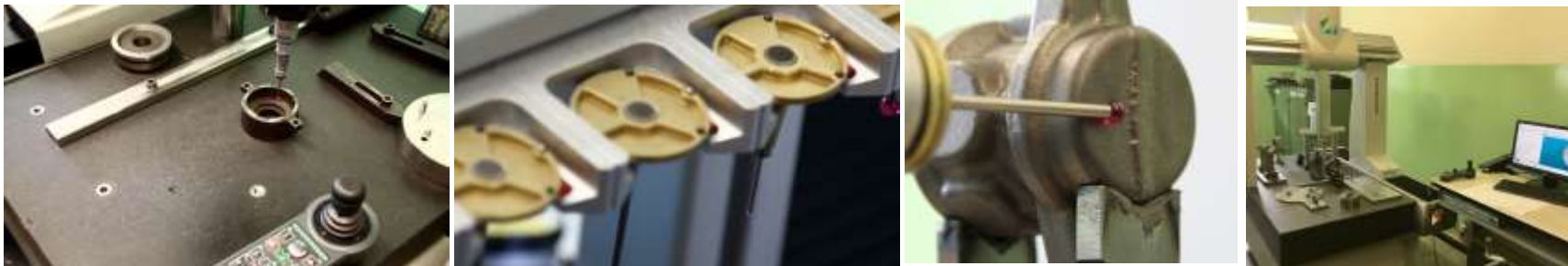
- 1 YCM CNC vertical milling machine
- 3 Deckel Maho CNC vertical milling machines
- 1 Gildemeister CNC turning machine
- 1 MoriSeiki CNC turning machine
- 2 Manual turning machines
- 1 Manual milling machine
- 1 EDM wire cutting machine
- 2 EDM volume machines
- 1 EDM drilling machine with wire
- 2 Horizontal grinding machines
- 1 Metal cutting machine
- 1 HT line
- 1 ABB welding robot
- 1 Rosler tumbling machine
- 1 Manual drilling machine
- 1 Nitrating bath



CIE LT Forge: LABORATORY EQUIPMENT

QUALITY INSPECTION CURRENT FACILITIES

- 2 - 3D CMM measuring mashines (max Measuring range 700x1000x700)
- 1 - Projector
- 1 - Spectrotester (For material chemical composition control)
- 1 - Equipment for control of microstructure
- 5 - Equipment for hardnes tests (HB, HV, HRC)



CIE LT Forge: PRODUCTS



- **ENGINE**
- **GEAR BOX**
- **DRIVELINE**
- **COMMERCIAL VEHICLES**



CIE LT Forge: PRODUCTS (ENGINE)



CIE LT FORGE: PRODUCTS (GEARBOX)



Pinion shaft
(Forged and/or pre-machined)



Pinion shaft
(Forged and/or pre-machined)



Differential crown
(Forged and/or pre-machined)



Differential crown
(Forged and/or pre-machined)



Flange shaft
(Forged and/or pre-machined)



CIE LT Forge: PRODUCTS (DRIVE LINE)



CIE LT Forge: PRODUCTS (COMMERCIAL VEHICLES)



King pins
(Forged and/or pre-machined)



King pins
(Forged and/or pre-machined)



CIE LT Forge: MAIN CUSTOMERS



CIE LT Forge: QUALITY CERTIFICATIONS

CIE LT Forge is certified in accordance with the applicable requirements for the automotive parts manufacturing organizations:

CIE LT Forge has been audited and homologated by GM group, VW group, MERCEDES-BENZ, RENAULT-NISSAN group, ZF, MAGNA and etc.

IATF 16949



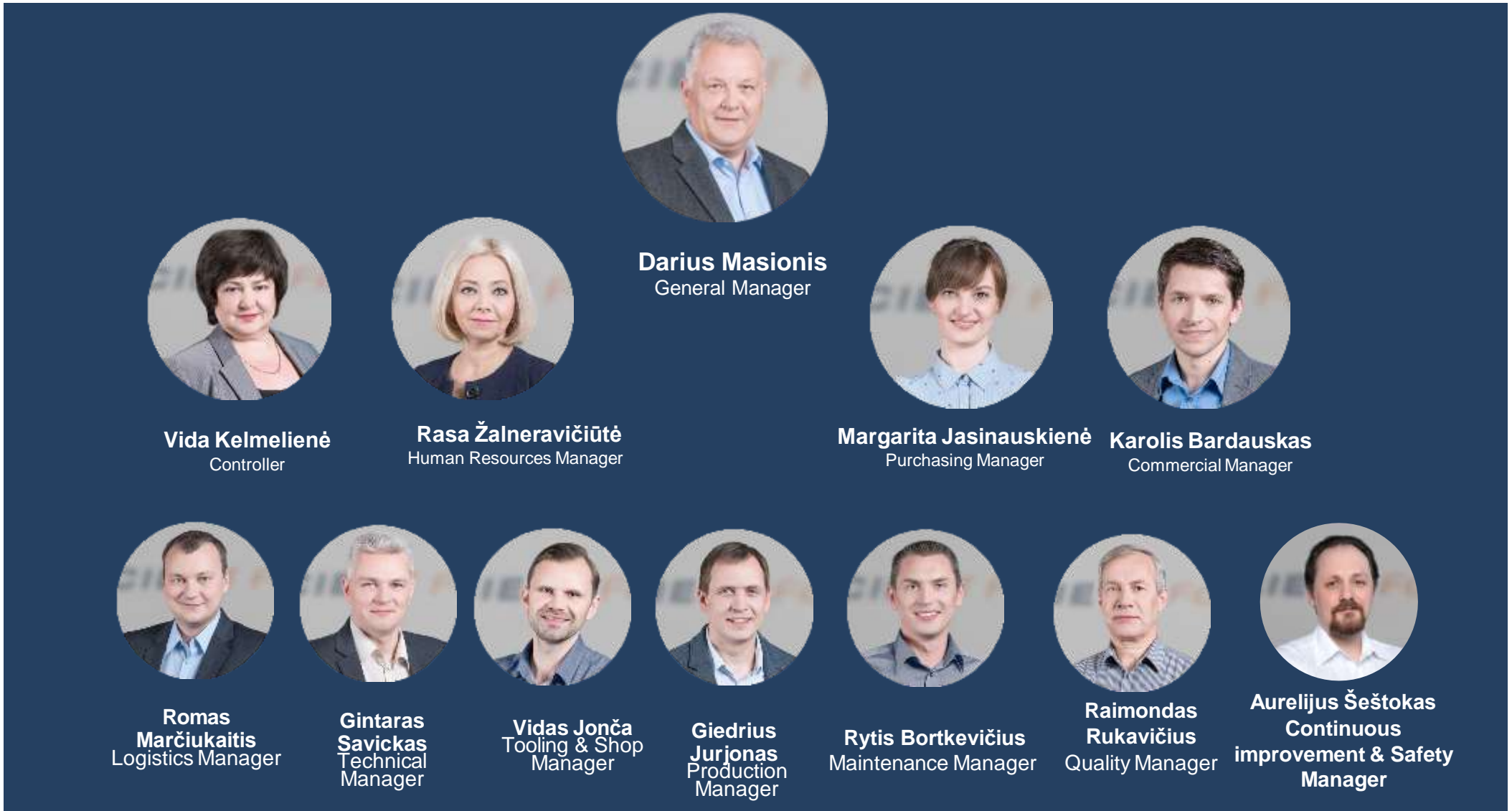
ISO 14001



ISO 45001



CIE LT Forge: ORGANIZATION CHART



Thank you

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