

stratford tools

PRECISION SHEET METALWORK



Excellence in precision sheet metalwork



We meet the exacting standards of a wide range of industries, including audio, telecoms, defence, motorsport, POS/retail and industrial equipment.

Stratford Tools provides a complete and efficient service in precision sheet metalwork, backed by continuous investment in the latest production technology and a depth of engineering experience.

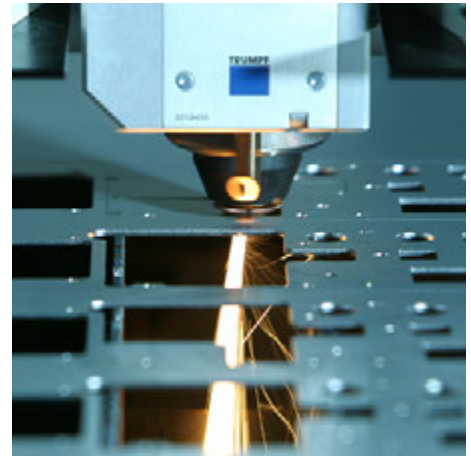
Consistently high standards of manufacture and service are applied to every product we produce – from prototypes to long run production .

Under one roof

All manufacturing is carried out in our purpose-built factory in Buckingham. The 78,000 building is designed and laid-out to provide logical work-flow, an ideal working environment and the flexibility to add and change plant and machinery.

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We regularly review developments in production machinery to ensure that we have the capability and capacity to provide the best service to fulfil customers' demands.

Quality Manufacturing

We were an early adopter of recognised, quality standards more than 30 years ago and are certified to BS EN ISO 9001:2008. Completing all processes in house gives us total control over quality, supported by real-time monitoring and reporting of all processes. We are frequently trusted to ship to line for many of our customers.

Investment In Technology

As an established and profitable family company, we are able to make investment decisions as required in order to maintain our competitive advantage – in quality, delivery and price.

Complete Service

From your drawing to
our production line

CNC Punching	Laser Profiling
Welding	CNC Folding
Machining	Assembly
Finishing	Packing
Printing	Dispatch



Planning and Programming

Our bespoke Manufacturing Control System links key business areas – through estimating, planning, production and accounts – to give real-time control of costs and delivery times. CAD/CAM software accepts all industry standard drawings and generates accurate programs for efficient production.

Laser Profiling and Punching

A comprehensive range of production machines equipped with automatic loading and unloading and programmed tool change allow efficient 24/7 production to high standards of quality. Stand-alone lasers, punching and combination machines offer true flexibility in processing a wide range of materials, gauges and sizes.

Precision Folding

Our suite of Press Brakes provide high levels of accuracy in precision bending and forming. CNC control and program storage minimises setup and cycle times to give high quality and short lead times.

Stud Welding

Auto-fed stud welding provides a low-cost method of precise fastener attachment for small and large scale manufacture. CNC control allows studs to be applied reliably and consistently to visually sensitive faces.

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Inserts and Fasteners

CNC controlled technology with automatic feed allows the insertion of various fasteners in a single operation to a consistent standard. Quick change tooling ensures minimum setup times and cost efficient production

Welding and Assembly

MIG and TIG welding processes are carried out to controlled procedures by experienced operatives. Full graining, deburring and cleaning facilities are available.

A dedicated clean area for mechanical assembly, undertakes riveting and assembly of manufactured and supplied components. With guaranteed standards, we are regularly trusted to ship sub-assemblies straight to customer production lines.





Finishing and Printing

Finishing operations are all carried out in our factory, ensuring consistent quality from a single source. Clean working conditions contribute to the high standard of finish. Only electroplating is entrusted to reliable subcontractors.

Our electrostatic powder coating department uses a conveyerised line and the latest electrostatic powder gun technology for commercial application of powder paint on high volume products to ensure maximum efficiency and consistency. Conventional wet spray booths are used for stoving enamels and acrylic paint application for a finish typically associated with audio and high end equipment products. Semi automated silk screening benches for front panel notation ensure we achieve repeatability over large batches and high quality detail on both small and large components.

Packaging and Delivery

Manufactured Items are packed, ready for despatch in paper, foam, boxes or bespoke systems as required and delivered by our own transport.



Precision sheet metalwork

Stratford Tools provides a highly efficient service in precision sheet metalwork for a wide range of equipment manufacturers who demand timely delivery of quality components.

Our core manufacturing facility is supported by a bespoke management system, which has been refined over many years to provide realtime planning and control of our processes.

Estimating & Planning

Day-to-day operations are controlled by our bespoke Management Control System. This specially designed software gives us real-time control of all key business areas. It is built around four modules:

- Estimating/ Quoting
- Capacity & Production Planning
- Data Control
- Accounts Integration

Design & Programming

Our combination of software and experienced staff gives us the flexibility to interrogate all industry standard 2D and 3D files.

Solidworks CAD software, an industry standard package for development of 2D blanks and 3D models.

Computes 3D is the CAD/CAM system for our Amada machines, importing DXF and DWG files for efficient programming of our punching machines.

TruTops CAD/CAM was specially developed for 2D laser machines and refined for programming of our Trumpf TruLaser cutters.

Assembly, Packaging and Dispatch

In addition to our core manufacturing processes, we have a dedicated clean area which is fully equipped for mechanical assembly of finished metalwork parts.

Subassemblies or complete assemblies can be supplied on a ship to stock basis, packaged as required.

We maintain our own transport to ensure efficient and safe delivery of finished product.

CNC Laser & Punch

Stratford Tools has invested heavily in this core technology. It is essential to our fast, flexible and highly cost effective service.

Regardless of complexity, we can cut any shape in a broad range of materials and thicknesses. Set-up times are minimal. We generate our own nitrogen on-site to ensure purity. All parts are clean cut to prevent edge oxidation and burring, so that no secondary finishing is required before welding, coating or assembly.

Combination

I Trupf TruMatic 6000d Combination Laser Punch

25 Multi Tooling Punch Station
Truflow 2000 Oscillator
2kw Laser

Max Working Range

Sheet Size	
X-Axis	2500mm
Y-Axis	1250mm

Material Gauge	
6.0mm	Mild Steel
3.0mm	Stainless Steel
5.0mm	Aluminium

Laser Profiling

I Trupf Trulaser 2025

Sheet Load & Unload System
(Lights-out)
Trucoax 2000 Oscillator
(2Kw Output)

I Trupf Trulaser 2030

Sheet Load & Unload System
(Lights-out)
Trucoax 3200 Oscillator
(3.2Kw Output)

I Amada Quattro

Max Working Ranges

Sheet Size	
X-Axis	3000mm
Y-Axis	1500mm
Z-Axis	115mm

Material Gauge	
Mild Steel	20.0mm
Stainless Steel	12.0mm
Aluminium	8.0mm

Punching

I Amada PEGA 357 CNC Turret Press

I Amada Vipros 358 King Hydraulic Turret Press

LKI 250 Pallet Loader/Part Picker
PR 250 (Lights-out)
45 Station with auto indexing

I Amada Vipros Z 3510 Turret Press

PDC Carousel (262 Tool Station),
Tivox AS 250 Material Stack
(capacity 30 tonnes) &
PR 250 Part Picker

Max Working Ranges

Sheet Size	
X-Axis	2500mm
Y-Axis	1250mm

Material Gauge	
6.0mm	Mild Steel
3.0mm	Stainless Steel
6.0mm	Aluminium

Fabrication

Highly accurate cutting is matched by highly accurate bending at Stratford Tools. Our machines have eight axis capability which enables complete folding of components, minimising handling and production time.

Auto-fed stud welding and bushing machines can be set up quickly to give cost effective and highly accurate performance. MIG and TIG welding are carried out to commercial standards and follow the standards as laid out in our company procedures. Full graining, deburring and cleaning facilities are available.

Bending

- 3 Amada 7-Axis HD 1003 NT Hybrid Drive Press Brake
3m x 100 Tonne (Down Stroking)
- 2 Amada 7-Axis HFE 100-3s
3m x 100 Tonne (Down Stroking)
- 1 Amada 8 Axis HFB 5020 Press Brake
2m x 50 Tonne (Down Stroking)
- 1 Amada 5 Axis ITPS CNC Press Brakes
2.5m x 80 Tonne
- 1 Promecam Press Brake
1.5m x 25 Tonne

Studwelding

- 1 Soyer KTS-1550 CNC coordinated table
Working envelope
1.1m x 1.5m
Twin Head & Auto Feed
3mm to 10mm
Mild Steel
Stainless Steel
Alluminium

Machining

- 1 Hass VF-4SS Vertical Machining Centre
30Hp-12,00rpm Spindle
24 Automatic Tool Changer
Working Area
X-Axis 1270mm
Y-Axis 508mm
Z-Axis 635mm
- 1 XYZ SMX SLV CNC Turret Mill
5 hp variable speed head
1471mm x 305mm Table
1000mm x 410mm Travel
- 1 Colchester 2000 Centre Lathe
- 1 Counter Balanced Multi-Axis Tapping Station
Working envelope 1.8m x 1.8m

Fastener Insertion

- 4 Haeger 824 Bush/Stud Insert Press with Auto Feed

Welding & Cleaning

- 3 Miller Synchronwave T.I.G.Welders 300 amp
- 2 Miller Dynasty T.I.G.Welders 350 amp
- 1 Miller 300 DX T.I.G
- 1 Murex Tradesmig 230
- 1 Murex Autolynx MIG 41
- 2 Lorch M.I.G.Welder
- 2 Meritus 30 KVA Spot Welder
- 1 British Federal 3000a Spot Welder
- 2 Grindmaster Flatbed Grainers 900mm wide

Finishing

A choice of finishing processes, stove enamelling or commercial powder coating. Front Panel notation and graphics are applied using semi-automated silk screen printing.

Stratford Tools is an environmentally responsible manufacturer. All coating products are carefully selected and handled to minimise any environmental impact.

Powder Coating

- 1 Conveyor Component Line
1300mm x 500mm Access
- 1 Three-stage Iron Phosphate Pretreatment Process
- 1 Drying Oven
- 2 Powder Application Booths with Extraction Filtering & Cyclone
- 1 Stoving Oven

Silk Screening

- 1 Kippax Manual Bench
1450mm x 900mm Max Print Area
- 1 Kippax Manual Bench
900mm x 900mm Max Print Area
- 1 Manual Bench
500mm x 700mm Max Print Area
- 1 Electric Box Oven
Capacity 2m x 2m x 2m

Wet Spray Plant

- 2 4m Dynaclean Wet Back Booths
- 2 Deville-Bliss Application Guns
- 1 Box Ovens
3m x 3m x 3m
- 1 Manual Degreasing Tank
2m x 1m x 1.25m
- 2 GEMA Easy IB Application Guns

Electroplating

(Sub-Contract Process)

Anodising

Zinc Plating

Chromate Conversion - Alocrom

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ISO 9001

- Purpose built 78,000 sq.ft temperature controlled facility
- Highly trained and focussed personnel
- Twenty-four hour manufacturing

