



Kvenna Workshop Capabilities

Workshop Capabilities

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1. Workshop Capabilities

1.1. Machining hall

Kvenna disposes a 5000m² machining hall.

Kvenna supplies a wide range of parts and components based on advanced CNC machining and a high level of quality control

1.2. Assembly hall

Kvenna disposes a 500m² assembly hall, containing assembly and pressure testing facilities, multiple cranes, and a seawater pool for testing.

Assembly hall:

- Total Area: 500m²
- Cranes (traveling + gantry)
 - 2 x 40 tons
 - 2 x 5 tons
- Assembly and testing facilities
- HPU units ranging up to 315bar
- Pressure test units for fluid and N₂, max. capacity 1300bar
- Hytorc Torque Tool for bolt make-up
- HBM Hottinger for temp./pressure logging
- Weighing Cells for 3, 12 and 50tons
- Range of Hydraulic Jacks

Testing

- Flow testing including sand slurry testing to ISO 10423
- Leak testing to ISO 10423 & ISO 14723
- Temperature testing
- Pressure testing to API & ISO codes
- Functional testing of valves & tools
- Cool down-and thermal testing
- Full scale cool down testing in pit w/ seawater of subsea insulation systems for connectors and spools

2. CNC Drilling and Milling machine

2.1. WMW Bacau AFP-160 CNC



General	
Brand & Model	WMW BACAU AFP-160 CNC
Control:	Siemens 840D
Capacity	
Axis	X = 8000 mm / Y = 4000 mm Z+W = 800mm + 1000 mm Full B-axes with table size 2500 x 2000 mm Fixed table size
Max Load	40 000 kg with centric load

2.2. WMW Bacau FK-1000 CNC



General	
Brand & Model	WMW BACAU FK-1000 CNC
Control:	Siemens 840C
Capacity	
Axis	X = 3000 mm / Y = 1800 mm Z+W = 500mm + 1000 mm W1 = 500 mm Full nc-controlled b-axis
Max Load	25 000 kg with centric load
Tool Magazine	30

2.3 Juaristi MX5 RAM floor type



General	
Brand & Model	Juaristi MX5 floor typ
Control:	Heidenhain TNC 630
Capacity	
Axis	X = 9000 mm / Y = 3500 mm Z+W = 800mm + 1000 mm
Table 1	W1=3500 mm Full B-axes with table size 2500 x 2000 mm
Table 2	W1=2000mm Full B-axis with table size 2000 x 2000 mm
Max Load	40 000 kg with centric load
ATC	120
Universal head	1 piece

3. CNC Machining Centre

3.1. Okuma MA600 HB



General	
Brand & Model	Okuma MA600 HB Space center
Control:	Okuma OSP 200 M
Capacity	
Axis	X = 1000 mm Y = 900 mm Z= 1000mm B=full nc axis
Tool Magazine	60 (BT50)
Table size	630 x 630 mm
Number of pallets	2 (630 x 630)
Additional information	Measuring Probe Programming of spindle position Tool length measuring Function for turning operations Equipment for key slotting

3.2. Doosan HM1000



General	
Brand & Model	Doosan HM1000
Control:	Fanuc 21
Capacity	
Axis	X = 2100 mm Y = 1250 mm Z=1250 mm B= Index 1 degree
Tool Magazine	120
Max. load	3000 kg
Number of pallets	2 1000 x1000 mm

3.3. Mori Seiki NHX8800



General	
Brand & Model	Mori Seiki NHX8800
Control:	Mitsubishi
Capacity	
Axis	X = 1000 mm / Y = 1000 mm Z= B axis =Full nc
Tool Magazine	120
Max. load	1500 kg
Number of pallets	2 800 x 800 mm

3.4. OKUMA MB8000HB



General	
Brand & Model	Okuma MB8000HB
Control:	OSP 300M
Capacity	
Axis	X = 1300 mm / Y = 1150 mm Z= 1250 B axis =Full nc
Tool Magazine	Matrix type 171 tools
Max. load	2250 KG
Number of pallets	Magazin with 6 pallets 800 x 800 mm

4. CNC Vertical Turning w/Drilling and Milling Unit

4.1. WMW Bacau VTM-22 CNC



General	
Brand & Model	WMW Bacau VTM-22 CNC
Control:	Siemens
Capacity	
Axis	X= Z=1750 C= Full NC
Max diameter	2300 mm
Max height	2000 mm
Max. load	25 000 kg
Tool Magazine	20 turning and 20 milling

4.2. Mori Seiki



General	
Brand & Model	Mori Seiki
Control:	Fanuc
Capacity	
Max diameter	1500 mm
Axis	X= Z= C0 full nc axis
Max height	1000 mm
Max. load	15 000 kg
Tool Magazine	120

5. CNC Turning center

5.1. WFL Miltturn 120



General	
Brand & Model	WFL Miltturn 120
Control:	Sinumeric 840C
Capacity	
Axis	Z = 5100 mm / X = 1000 mm Y = -250 mm to +250 mm C = Full nc axis B = +/- 100 degree angel
Tailstock	Pinol Ø 150 mm stroke mm
	Ø1200
Steadyrest	130- 510 mm
Tool Magazine	60

5.2. Okuma Multus B550



General	
Brand & Model	Okuma Multus B550
Control:	OSP 300
Capacity	
Axis	Z = 3100 mm / X = 1000 mm Y = -250 mm to +250 mm C = Full nc axis B = +/- 190/10 degree angel
Tailstock	Pinol Ø 150 mm stroke mm
Swing	Ø830 mm
Steadyrest	130- 510 mm
Tool Magazine	80

5.3. Okuma Multus U4000



General	
Brand & Model	Okuma Multus U4000
Control:	OSP 300L
Capacity	
Axis	Z = 2150 mm / X = 695mm Y = -150 mm to +150 mm C = Full nc axis B = -30 til +210 degree angel
Tailstock	Pinol Ø 150 mm stroke mm
Swing	Ø630 mm
Steadyrest	45- 320 mm
Tool Magazine	80

6. CNC Turning & Drilling

6.1. Puma 700



General	
Brand & Model	Puma 700
Control:	Fanuc
Capacity roterende verktøy pluss stedyrest bakdokka	
Axis	X = 950 mm Z (length): 3200 mm c-axis= full nc
Max weight	2000 kg
Turret	12 tools + rotating tool

6.2. Puma 700 LY



General	
Brand & Model	Puma 700 LY
Control:	Fanuc
Capacity	
Axis	X = 950 mm / Y = 100 mm Z (length): 3000 mm C= full nc
Max weight	2000 kg
Turret	12 tools+ rotating tool

6.3. Puma 400LM



General	
Brand & Model	Puma 400LM
Control:	Fanuc
Capacity	
Axis	X = 500 mm Z = 3000 mm C=full nc axis
Max weight	2000 kg
Turret	12 tools+ rotating tool

6.4. Gurutzpe B1400 CNC



General	
Brand & Model	Gurutzpe B1400 CNC
Control:	Fagor 8050
Capacity	Long boring bar 2 pices
Max diameter	1600 mm
Max length	10 000 mm
Inside turning damped boring bar	Ø200 L=1700 mm
Inside turning damped boring bar	Ø130 L=1200 mm
Steadyrest	2 x Ø 200- 1000 mm
Max weight	1500 kg

6.5. Puma SMX 3100

BILDE

General	
Brand & Model	xxx
Control:	xxx
Capacity	
Max diameter	600 mm
Max length	2500 mm
Controlled Tailstock	xxx
Controlled Steady rest SMW SLU 5.1	xxx

7. Manual Machining / Saw / Center Drill Shaft

7.1. Manual Milling Bacau AFP 105

Dimension: 1500 mm x 1500 mm

7.2. Magnet Tables

Dimension: Ø1200mm From Ø50 mm to Ø1250 mm

7.3. Manual Turning Machine

Dimension: Ø350 mm L = 8000 mm

7.4. Saw

Ø 1000 mm

7.5. Center Drill Shaft

Ø28/Ø125 mm Length: 3000 mm

8. CMM Machine

8.1. LK G90C



General	
Brand & Model	G90C 10.10.8
Style	Bench
Measurement Type	Touch Trigger
Frame Type	Moving Bridge
Control	LK micronDrive
Capacity	
Max Part Size	1981 mm x 1422 mm x 1067 mm
Table Size	1981 mm x 1981 mm
X Axis	1016 mm
Y Axis	1016 mm
Z Axis	813 mm
Maximum Rapid Rate	31
B89 Volumetric Accuracy	0,0099 mm