



Steel Belt Services

Incl. all service engineers and all material expenses. Travelling expenses excl.

Description	sc	price	unit
Steel Belt Welding of Press Belts (eg. 1650SM) Incl.: Preparation+Grinding+Polishing+Total time+All fees+Material exp.	S1	EUR 2840,-	seam
Steel Belt Welding of Standard Belts (eg. 1200SA) on process systems and similar plants as coolers, conveyors Incl.: Preparation+Grinding+Polishing+Total time+All fees+Material exp.	S2	EUR 1800,-	seam
Steel Belt Welding of Baking Oven Belts (eg. 1300C) Incl.: Prep.+Grinding+Pol.+Heating+Total time+All fees+Material exp.	S3	EUR 1940,-	seam
Steel Belt MT Hi-Q Welding Incl.: Entire precise measurement process + additional treatment (eg SP) Incl.: Preparation+Grinding+Polishing+Total time+All fees+Material exp.	S4	EUR 4200,-	seam
QuickDisc WeldingQ7 (MT Hi-Q PowerDisc) D=70mm Incl.: Preparation+Straightening process Incl.: Grinding+Polishing, total time, all fees + material expenses	Q7	EUR 1280,-	disc
QuickDisc WeldingQ14 (MT Hi-Q PowerDisc) D=140mm Incl.: Preparation+Straightening process Incl.: Grinding+Polishing, total time, all fees + material expenses	Q14	EUR 1580,-	disc
QuickDisc WeldingQ+ (MT Hi-Q PowerDisc) D=210mm+ Incl.: Preparation+Straightening process Incl.: Grinding+Polishing, total time, all fees + material expenses	Q+	EUR 1870,-	disc
Hymmen Belt Service, Steelbelt service on Hymmen Belt(s) Incl.: Total time for all service engineers (1-3), all tools fees and material expenses for 1 day (fees for fixtures excluded)	HS	EUR 1600,-	day
General Steel Belt Service, straightening and crack welding Incl.: Total time for all service engineers (1-3), all tools fees and material expenses for 1 day (fees for fixtures excluded)	GS	EUR 1500,-	day
Steel Belt Edge Services a) L<30m: Flat rate Cutting, grinding/polishing or shrinking, all material exp. and fees incl.	EA	EUR 1480,-	edge
b) L>30m: Flat rate Cutting, grinding/polishing or shrinking service, all material exp. and fees incl.	EB	EUR 2340,-	edge
Belt Length Measuring Service (Belt/Drum) MT Power Mätning, Finding out Length Differences on Belt or Drum	M	EUR 985,-	belt/drum



Flattening and Polishing service

Incl. all service engineers and all material expenses. Travelling expenses excl.

Description	sc	price	unit	
Flattening / Shot Peening of Standard Steel Belts eg. 1200SA/1300C conveyor/coolers/Baking oven Belts, L<40m Incl.: total time+all fees+material expenses (*not valid for substandard belts)	F1	EUR 2480,-*	belt	
Flattening / Shot Peening of Long Standard Belts eg. 1200SA/1300C conveyor/coolers/Baking oven Belts, L>40m Incl.: total time+all fees+material expenses (*not valid for substandard belts)	F2	EUR 2880,-*	belt	
Flattening / Shot Peening of Standard <u>Press Belts</u> 1.8-3.0mm thickness, L<100m Incl.: total time+all fees+material expenses (*not valid for substandard belts)	F3	EUR 3800,-*	belt	
Flattening / Shot Peening of Long <u>Press Belts</u> 1.8-3.0mm thickness, L>=100m (*not valid for substandard belts)	F4	EUR 4180,-*	belt	
Steel Belt Length Measuring Service (Belt/Drum) <i>MT Power Mätning</i> , Finding out Length Differences L/R	F5	EUR 985,-	belt/drum	
Local Shot Peening Shot Peening of Disc, local deformation, PZ or seam Incl.: total time+all fees+material expenses	F6	EUR 670,-	each pos.	
Local Straightening Service Mechanical Flattening of Local Regular Defo Incl.: total time+all fees+material expenses	F7	EUR 702,-	defo	
Steel Belt Grinding+Polishing of Steel Belt surfaces [w: width] [l: length] Tol: Ra=0.2-0.8				
• Steel Belt, L<20m	W<=1200mm	Pol1	EUR 2100,-	belt
	W>1200mm	Pol2	EUR 2880,-	belt
• Steel Belt, L=20-59m	W<=1200mm	Pol3	EUR 3180,-	belt
	W>1200mm	Pol4	EUR 4500,-	belt
• Steel Belt, L=60-99m	W<=1200mm	Pol5	EUR 5100,-	belt
	W>1200mm	Pol6	EUR 6300,-	belt
• Steel Belt, L>=100m	all widths	Pol7	EUR 6800,-	belt
• Steel Belt, L>=100m	all widths	Pol7	EUR 8500,-	belt
Local Steel Belt Polishing of damaged areas Removing scratches (locally) width=5-500 [mm] [w: width]				
• Local polishing of Steel Belts	L<60m	Pol8	EUR 2400,-	belt
• Local polishing of Steel Belts	L>=60m	Pol9	EUR 3800,-	belt



Drum Grinding

[mm] [w: width] [diam: diameter] Travelling exp. excl.(Hardness max. 450HV (460-600HV: Price +48%)

Description	sc	price	unit	
a) Drum, W<1000	diam < 1000	A1	EUR 4800,-	drum
	diam >= 1000	A2	EUR 5200,-	drum
b) Drum, W=1000-1500	diam < 2000	B1	EUR 4900,-	drum
	diam >= 2000	B2	EUR 6400,-	drum
c) Drum, W=1500-2990	diam < 2000	C1	EUR 7400,-	drum
	diam = 2000 - 2990	C2	EUR 8350,-	drum
	diam = 3000 - 4000	C3	EUR 9300,-	drum
	diam > 4000	C4	EUR 9940,-	drum
d) Drum, W>=3000	diam < 2000	D1	EUR 8700,-	drum
	diam = 2000 - 2990	D2	EUR 9870,-	drum
	diam = 3000 - 4000	D3	EUR 11400,-	drum
	diam > 4000	D4	EUR 14800,-	drum
Additional Drum Services				
Quick Surface Densification / Drum Shot Peening Drum Surface Densification (D<=2000mm) Drum Surface Densification (D>2000mm)	QSD	EUR 1800,-	drum	
	SD1	EUR 5580,-	drum	
	SD2	EUR 8670,-	drum	
Super Finish of Drum surface (after grinding)	SSF	EUR 1880,-	drum	
Manual Cleaning of Drum surfaces with cleaning solvent	MC	EUR 174,-	drum	
Welding of Dents (before drum grinding) remark: no warranty on drum weldings	DW	EUR 30,-	dent	
Drum Measuring Service (Belt/Drum) MT Power Mätning, Finding out Length Differences on Belt or Drum	PM	EUR 985,-	belt/drum	
Rotary Dryer, grinding of raceways Flat rate	DG	EUR 5800,-	raceway	
Roughening/Grinding (of Rubber Rolls / Drive Rolls) Flat rate	RS	EUR 2700,-	roll/drum	
Polishing Only (of Drum Surfaces) Flat rate Polishing process (removing dirt) Flat rate, Polishing process (smooth grinding) removing all scratches	SP	EUR 1870,-	roll/drum	
	RS	EUR 3280,-	roll/drum	
Drum Drive motor, Mobile drive unit, fee for non driven drums/rollers, fixed price for all types, incl. inst.	DM	EUR 870,-	drum	

Travelling- & other expenses

Description	sc	price	unit
SERVICE <ul style="list-style-type: none"> • Standard Service (time) • Waiting time • Fee "Emergency service" • Effective time for Shot Peening 	N W Nöd ES	EUR 87,- EUR 38,- EUR 1200,- EUR 137,-	man hour man hour service hrs
Machines + Fixtures <ul style="list-style-type: none"> • Fee AL800-1600 • Fee AL2600+ • Fee Grinding Machine BSM-I • Fee Grinding Machine BSM-II • Fee Grinding Machine BSM-7 • Fee Measuring Beam <i>MT V-Mät</i> • Fee CPSN • Fee Standard Welding Equipment • Fee Straightening Tool <i>PowerVac</i> • Fee Straightening Fixt. <i>FlatRoll</i> • Fee - " - <i>PowerStraight</i> • Fee QuickDress (edge rounding) • Fee EC China1 /Charge TypeEC 	AL1 AL2 M1 M2 M7 VM CPS WE PV FR PH QD EC	EUR 300,- EUR 400,- EUR2800,- EUR2300,- EUR2800,- EUR 280,- EUR 780,- EUR 178,- EUR 180,- EUR 270,- EUR 480,- EUR 280,- EUR 4700,-	belt belt belt/drum belt/drum belt/drum day belt belt belt belt belt belt service
TRAVELLING EXPENSES (hotel + road fee excl.) <ul style="list-style-type: none"> • time [hrs] • distance [km] car • distance [km] van/bus/truck • distance [km] trailer • daily allow. /man 	T km1 km2 km3 da	EUR 43,- EUR 0,7 EUR 0,75 EUR 0,1 EUR 40,-	man hour km km km day
MATERIAL <ul style="list-style-type: none"> • gas/grind/pol, disc /crack • total grinding+polishing expenses 		EUR 22,- EUR 114,-	disc/cr. seam
TRAINING** <ul style="list-style-type: none"> • MT PowerTraining-1 (1 day) standard crack welding, grinding • MT PowerTraining-2 (2 days) crack welding+grinding, surface treatm.,straighten. • MT PowerTraining-4 (4 days) crack welding+grinding, surface treatm.,straighten. <p>* Discount: 3 pers.: 10% discount, 4 pers.: 20% discount</p> <p>** Training incl.: total material expenses, total hotel expenses total food (excl. drinks)</p>	PT1 PT2 PT4	EUR 600,- EUR 1400,-* EUR 1970,-*	pers pers pers