

Comprising over 190 companies in 26 countries, Bodycote is the world's leading provider of thermal and thermochemical processes including heat treatment, surface technologies, hot isostatic pressing and material testing of the highest technical standard. Bodycote offers a wide range of processes for aerospace, power generation, automotive and tool industries.

Bodycote means quality, international standards, certificates, accreditations and numerous customers approvals. We work 24 hours a day, 7 days a week and guarantee the highest global standard of thermal processing services.

BODYCOTE HEAT TREATMENT

Bodycote Polska



Services offered in Poland

- Vacuum heat treatment
- Heat treatment in protective atmosphere
- Vacuum brazing
- Carburizing / carbonitriding
- Vacuum carburizing
- Gas nitriding
- Corr-I-Dur®
- Cryogenic treatment
- Ferritic Nitrocarburizing

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Partnership for Quality

Vacuum heat treatment

Heat treatment in protective atmosphere

Vacuum brazing

Carburizing / carbonitriding

Gas nitriding

Ferritic Nitrocarburizing

Corr-I-Dur®

Vacuum carburizing

Cryogenic treatment

BODYCOTE is one of the biggest, globally recognised providers of thermal and thermochemical processing services.

Choosing our company as your partner and competent provider of thermal processing services gives you access to a wide range of state of the art technologies of thermal and thermochemical treatment.

Bodycote offers an extensive scope of services including heat treatment, hot isostatic pressing, surface technologies and comprehensive material testing provided by a team of highly qualified and experienced specialists.

Bodycote aims at creating cooperation with leading manufacturers, characterised by constant improvement of products and high level of innovation.

Both global and local companies may benefit from our know-how, expertise and modern technologies.

Having decided to invest in basic production and outsource heat treatment, more and more companies are appreciating the benefits of such cooperation.

All of our plants providing services in thermal and thermochemical treatment have certificates of integrated management system for thermal treatment according to standards PN-EN ISO 9001:2008 and 14001:2004.



Bodycote – WARSZAWA

The services offered by the plant include:

Hardening and tempering in vacuum furnaces with high pressure gas quenching applied to hot and cold work tool steels, moulds parts, forging dies and high speed steel tools. **(Furnace sizes: Ø 1200x1200 mm, 1200x800x800 mm).**

Vacuum brazing and annealing of parts from structural, tool steel, such as automotive and machinery parts. **(Furnace sizes: Ø 1200x1200 mm, 1200x800x800 mm).**

Gas Nitriding Nitreg® applied to parts of injection and foundry moulds, aluminum extrusion dies, forging dies, cold work stamping and cutting steel tools, parts for machinery and automotive industries. **(Furnace size: Ø 1200x2500 mm).**

Corr-I-Dur®, carried out in order to obtain a hard, wear resistant surface without deforming the shape or changing the size of the treated part or detail. **Furnace size: Ø 1200x2500 mm).**

Vacuum carburizing and hardening (Low Pressure Carburizing) - clear, metallic surface, no LGO, optionally High Pressure Gas Quenching. Fully automated and reproducible process. **(Furnace size: 900x600x660 mm).**

Cryogenic treatment intended to remove residual austenite, resulting in hardness enhancing and size stabilisation. **(Wymiary komory: 600x1000x600 mm).**

Metallography laboratory investigate microstructure analysis, microhardness, hardness tests, layer thickness measurements obtained through thermochemical processes (CHD/Eht, NHD/Nht, CLT/VS).

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Bodycote – CZĘSTOCHOWA

The services offered by the plant include:

Gas Nitriding Nitreg® applied to parts of injection and foundry moulds as well as moulds for rubber injection, aluminum extrusion dies, forging dies, cold work stamping and cutting steel tools, machinery, automotive and mining industries. Processes are designed and carried out according to customers requirements. **(Furnace sizes: Ø 1000x1500 mm, Ø 800x2000 mm).**

Nitriding of austenitic steels **(Furnace size: Ø 1200x2500 mm).**

Corr-I-Dur®, carried out in order to obtain a hard, wear resistant surface without deforming the shape or changing the size of the treated part or detail. **(Furnace size: Ø 1200x2500 mm).**

Hardening and tempering one cycle in vacuum furnaces with high pressure in nitrogen quenching applied to hot and cold work tool steel, parts of moulds, forging dies, aluminum extrusion dies, hot work steel tools, high and middle alloyed steel for cold work stamp and cutting tools. **(Furnace sizes: 1000x700x650 mm, 900x600x600 mm).**

Solution treatment of stainless steels in vacuum furnace with nitrogen quenching. **(furnace size: 1000x700x650 mm).**

Metallography laboratory investigate microstructure analysis, microhardness, hardness tests, layer thickness measurements obtained through thermochemical processes (CHD/Eht, NHD/Nht, CLT/VS).

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Bodycote – CHEŁMNO

The services offered by the plant include:

Gas Nitriding Nitreg® applied to parts of injection moulds, stamping and cutting tools and parts from structural steel for machinery and automotive industries. **(Furnace size: Ø 1200x2500 mm).**

Nitreg® with post Oxidation with the control of nitrogen potential and phase composition of surface layer resulting in obtaining wear and corrosion resistant layer (matt black). **(Furnace size: Ø 1200x2500 mm).**

Carburizing, carbonitriding and oil quenching with carbon potential control, applied to parts from structural steel such as gear wheels, shafts and pins. **(Furnace size: 800x500x400 mm).**

Hardening and tempering in vacuum furnaces with high pressure nitrogen quenching applied to high speed steel tools as well as cold and hot work steel tools and elements. **Furnace size: 700x700x500 mm).**

Metallography laboratory investigate microstructure analysis, microhardness, hardness tests, layer thickness measurements obtained through thermochemical processes (CHD/Eht, NHD/Nht, CLT/VS).

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Bodycote – ZABRZE

The services offered by the plant include:

Carburizing (the thickness of the carburised layer up to 6 mm), **carbonitriding and toughening** in protective atmospheres, normalizing and annealing. All the processes are monitored and recorded by a computer system.

Heat treatment for mining, automotive, aerospace machinery and electromechanical industries. The plant specialises in the treatment of gear wheels, pins, shafts, cardan shafts, stamp tools, knives, cutting tools from low alloy steels etc.

Sizes of carburizing, annealing and normalizing furnaces **(pit furnaces: Ø 1250x2500 mm; chamber furnaces: 1100x800x750mm, 1100x800x900 mm).**

Carbonitriding furnace sizes **(chamber furnaces: 1100x800x750 mm, 1100x800x900 mm).**

Toughening furnaces **(pit furnaces: Ø 1250x2500 mm; chamber furnaces: 1100x800x750 mm, 1100x800x900 mm).**

We conduct quenching in special devices. Press hardening with the use of rotary furnaces (up to Ø 650 mm)

Cryogenic treatment intended to remove residual austenite, resulting in hardness enhancing and size stabilisation. **(Chamber size: 1100x800x750 mm).**

Metallography laboratory investigate microstructure analysis, microhardness, hardness tests, layer thickness measurements obtained through thermochemical processes (CHD/Eht, NHD/Nht, CLT/VS).

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Bodycote – ŚWIEBODZIN

The services offered by the plant include:

Low Pressure Carburizing In one cycle with quenching in oil or high pressure gas in nitrogen or helium (up to 23 Bar). Controlled cooling resulting in minimal distortions. Fully automated and reproducible process. Heat treatment for automotive, machinery, agriculture, electromechanical and aviation industries. **(Furnace sizes: 900x600x650 mm, 900x600x600 mm, 900x600x450 mm).**

Hardening and tempering in vacuum furnaces and high-pressure quenching in compressed nitrogen and helium (up to 23 Bar) as well as in oil. Heat treatment of parts for injection and foundry moulds, cold and hot work tool steel, high speed steel and structural elements for automotive, aviation, machinery and electrotechnical industries. **(Furnace sizes: 900x600x650 mm, 900x600x600 mm, 900x600x450 mm).**

ZeroFlow® gas nitriding applied to parts of injection and foundry moulds, aluminum extrusion dies, components of aircraft engines, as well as elements for tool, machinery and automotive industries. **(Furnace size: 900x600x650 mm).**

Vacuum brazing and annealing of parts from structural and tool steels. **(Furnace size: 900x600x450 mm).**

Cryogenic (subzero) treatment intended to remove residual austenite, resulting in hardness enhancing and size stabilisation. **(Chamber size: 1000x1000x1000 mm).**

Metallography laboratory investigate microstructure analysis, microhardness, hardness tests, layer thickness measurements obtained through thermochemical processes (CHD/Eht, NHD/Nht, CLT/VS).

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Bodycote – SIECHNICE

The services offered by the plant include: Automated process line controlled by a master system.

Gas Carburizing and carbonitriding. Processes conducted in chamber furnaces with controlled atmosphere with oil quenching in one cycle (sealed quench furnace). Additionally, the furnaces allow to conduct separate processes of quenching and annealing. **(Furnace size: 900x1200x900 mm).**

Vacuum carburizing. Low pressure carburizing in double chamber furnace with integral oil quenching system.

The facility is dedicated to conduct:
- vacuum carburizing in FineCarb® technology;
- high temperature carburizing in PreNitLPC technology;
- oil quenching. **(Furnace size: 900x1200x900 mm).**

Cryogenic (subzero) treatment dedicated to remove residual austenite, resulting in hardness enhancing and size stabilisation. The facility works in the temperature range of -150 °C do +300 °C. **(Chamber size: 900x1200x900 mm).**

Śrutowanie. Process utilize for surface cleaning from scale, surface oxides.

Metallography laboratory investigate microstructure analysis, microhardness, hardness tests, layer thickness measurements obtained through thermochemical processes (CHD/Eht, NHD/Nht, CLT/VS).

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