



**METAL FABRICATION, WELDING SERVICES AND  
ASSEMBLY SERVICES**

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# 1. Introduction

- **"AKTIVA" L.T.D. Stip, Republic of Macedonia** as one of the leading building companies with high reputation and undeniable legitimacy of segment in metal industry.
- The company was founded in 1999. Starting with mini-technologies and several employees in the course of our intensive work, adjusting to the modern dynamic trends to achieve further development and serve market needs, effectuate strong rise in production capacity in the metal industry.
- Our company is well positioned in the heart of the industrial region of Stip , Republic of Macedonia, where as a private company, first began to function in the part of metal industry involved in performance of commercial and business facilities. Equipped with a working plant of the highest standards , with full engineering coverage since the beginning, completely dedicated to the principle of quality products and highest level of respect to partners and customers, something which contributed to be held as the market leader.
- Company capacity of 1500 mt per month

# History & Company growth of **AKTIVA L.T.D**

- **AKTIVA** since 1999

	TURNOVER	EMPLOYEES
2000	1 M €	50
2010	5 M €	150
2015	21 M €	350
2018	25 M €	380
2019	30 M €	500
2022	38 M €	550



- In September, 2014 the new production plant became operational. Situated at **9000 m<sup>2</sup>** covered area it is part of the privately owned industrial zone area from **170 000 m<sup>2</sup>**. The plant produces welding and metal processing parts for automotive industry.
- The plant is fully equipped with brand new CNC machines for metal fabrication of parts.
- In 2017, **AKTIVA** has started working on extension of its existing facility and capacity for metal fabrication and welding services for additional **13 000 m<sup>2</sup>** and put in operation 30.08.2018
- In 2019-2020, **AKTIVA** has finished extension of its existing facility and capacity for metal fabrication and welding services for additional **14 000 m<sup>2</sup>**
- Total existing covered area **36 000 m<sup>2</sup>**.
- Possibility for extension to **100 000 m<sup>2</sup>** covered area

## 2. Activities & Services

### METAL FABRICATION SERVICES

- WELDING SUBASSEMBLY
- BEAM DRILLING AND SAWING LINE
- SHEET LASERCUTTING
- SHEET PLASMACUTTING
- TUBE LASERCUTTING
- BENDING
- MILLING
- TURNING
- SAWING AND DRILLING
- SPOT WELDING
- PUNCHING
- SHEARING

### COATING SERVICES

- TUNEL SANDBLASTING
- MANUAL SANDBLASTING
- POWDER COATING
- WET COATING
- ZINC PLATING
- KTL ( E-COATING)
  - AVAILABLE FROM 2024

### ASSEMBLY SERVICES

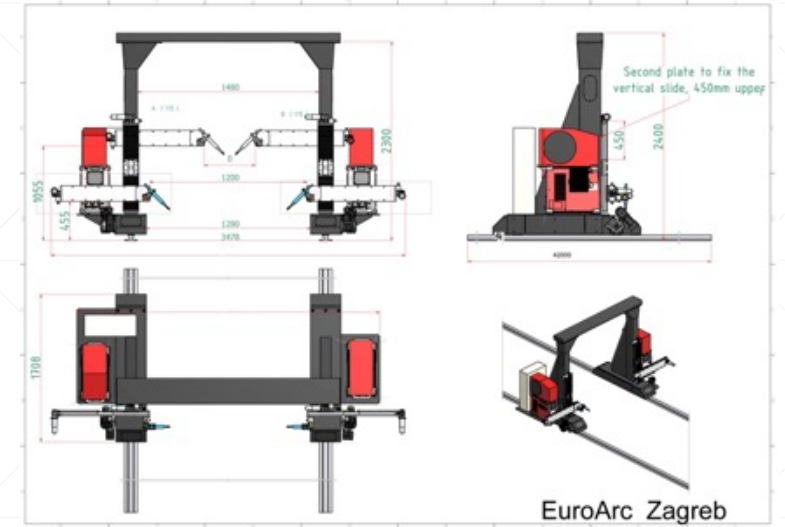
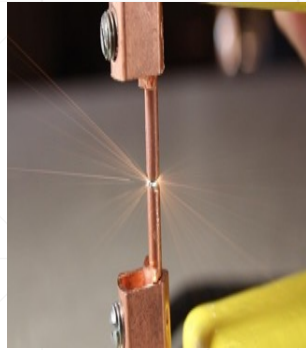
- Completely assembly services

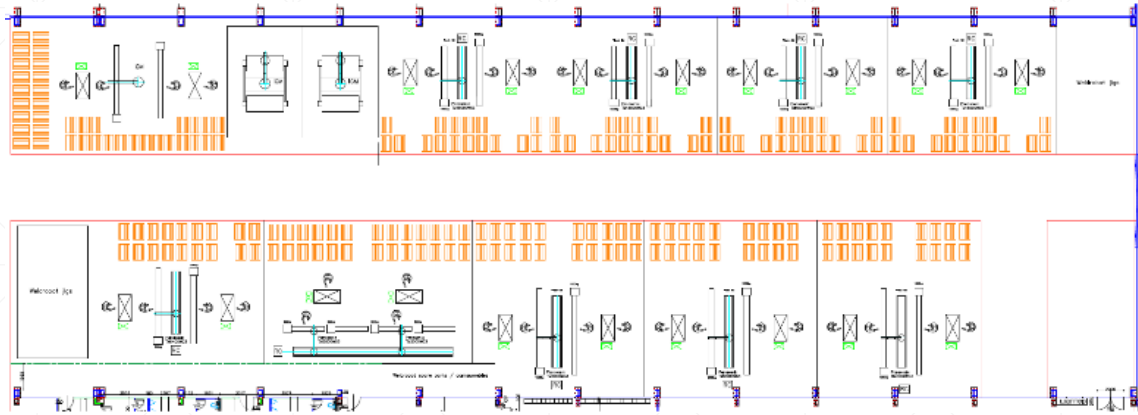
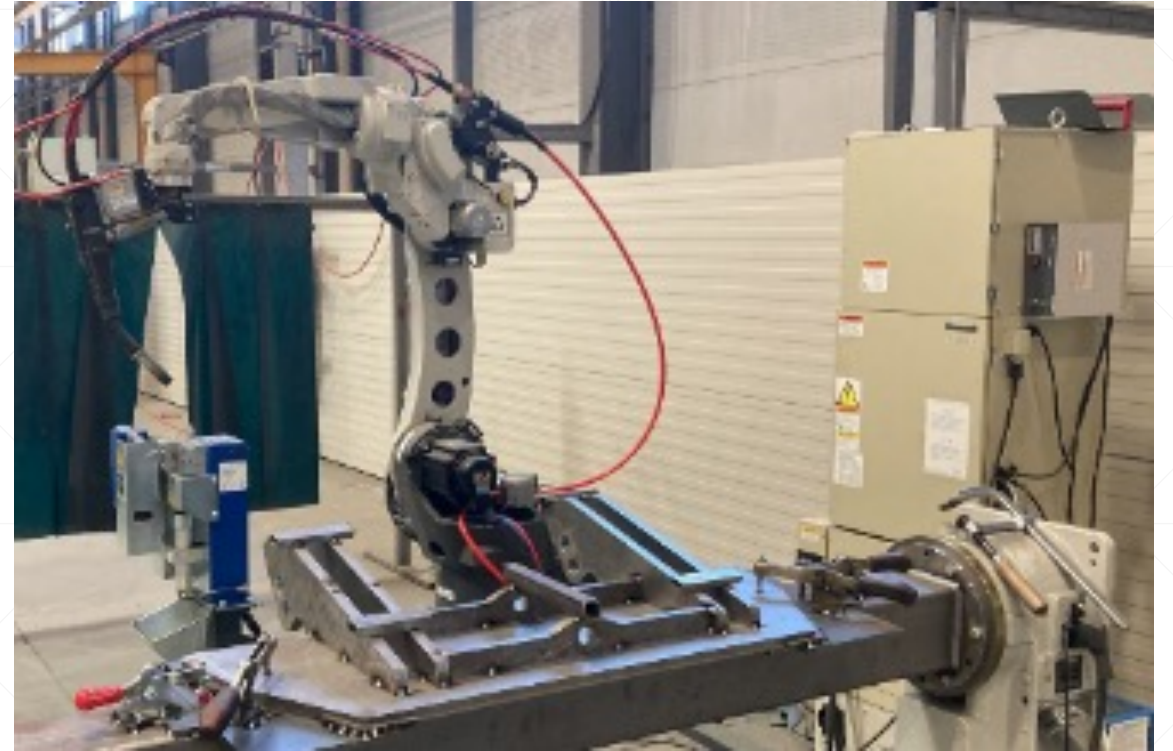
### MATERIALS

- MILD STEEL
- STAINLESS STEEL
- ALUMINIUM

## 2. Services

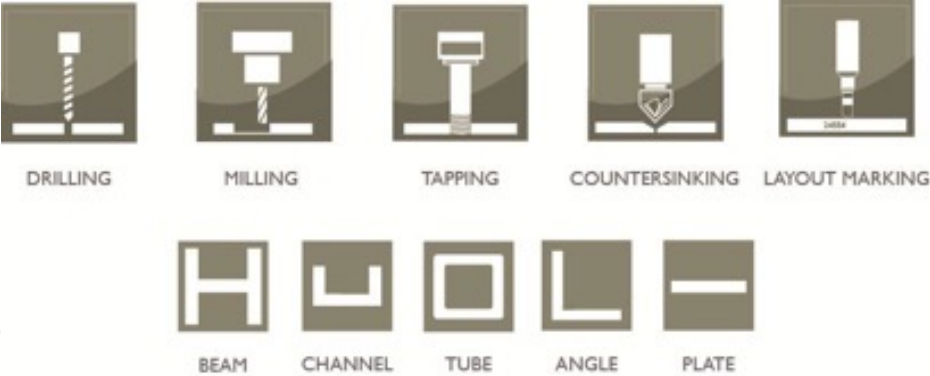
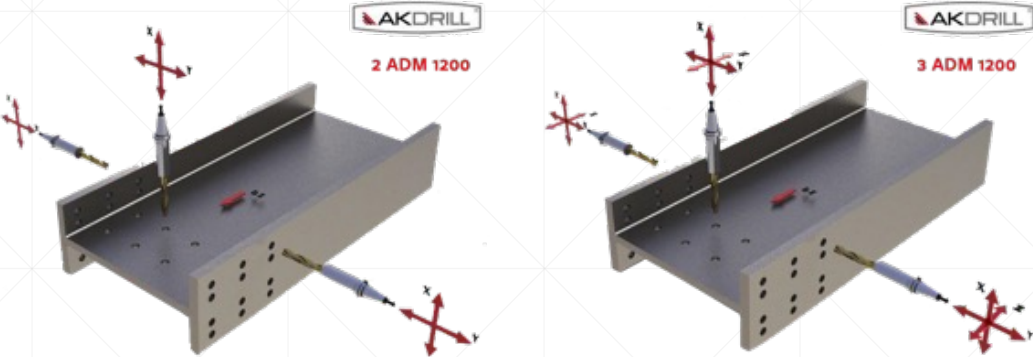
- WELDING ASSEMBLY
- ROBOTIC WELDING
- SPOT WELDING
- LINE WELDING





## 2. Services

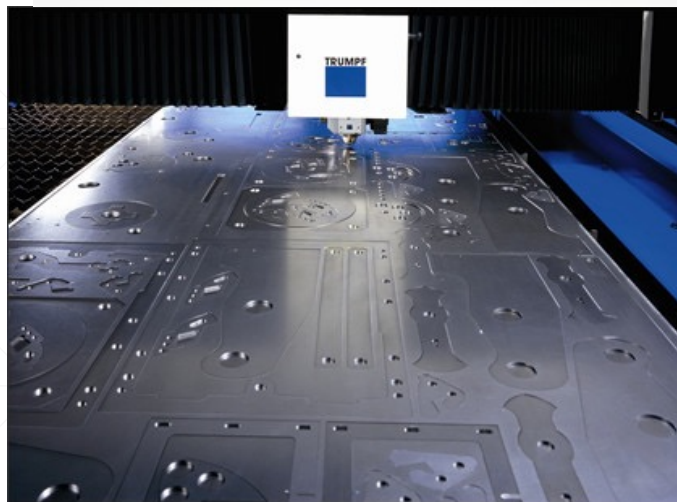
- BEAM DRILLING AND SAWING LINE



## 2. Services

### • SHEET LASERCUTTING

- 1500X3000 2/3/5/6 KW
- 2600X14000 10 KW



## 2. Services

### • SHEET PLASMACUTTING

	XPR300	
Maximum output power	63 kW	
100% duty arc voltage	210 V	
Cut chart thickness	mm	inches
Pierce capacity	Mild steel (argon-assist)	50 2
	Mild steel (standard O <sub>2</sub> )	45 1-3/4
	Stainless steel	38 1-1/2
	Aluminum	38 1-1/2
	Mild steel	80 3-1/8
Severance capacity	Stainless steel	75 3
	Aluminum	50 2



#### Cutting dimensions

Cutting width : 3200 mm  
Cutting length : 14200 mm

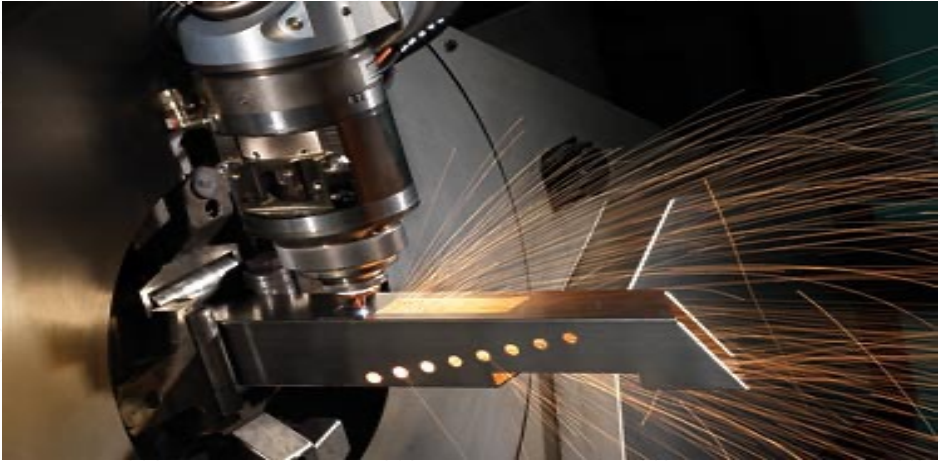
## 2. Services

- TUBE LASERCUTTING



### Technical Data

Round tube	12 mm - 220 mm
Square tube	200 x 200 mm
Tube loader options	6500 - 8500 mm
Bar Weight	max 35 Kg/m
Unloader length options	4500 - 6500 - 8500 mm
Source laser power	up to 3500W
Digital CNC	Siemens 840D Solution Line
Options	spoon, booster, weld seam detector, special tube shape, open profiles
Standard materials	steel - stainless steel - aluminium - other on request



## 2. Services

### • MILLING

#### Technical Description

<b>C-A3362</b> Vertical-Machining center	ecoMill 635 V with C-Frame-construction
<b>Traverse range:</b> Range:	X = 635 mm / 25 inch Y = 510 mm / 20,07 inch Z = 460 mm / 18,11 inch
Distance Spindle nose to Table: Clamping area:	120 up to 580 mm / 4,72 inch up to 22,83 inch 560 x 790 mm with 5 T-slots, T-slot-pitch 100 mm (middle T-slot 14H7 and 4 T-slot 14H12) 22,04 x 31,1 inch with 5 T-slots, T-slot-pitch 3,937 inch (middle T-slot 0,5511inch H7 and 4 T-slot 0,5511 H12)
<b>Maximal Table load:</b>	600 kg / 1322,77 lbs
<b>Main Drive:</b> Type of Drive: Speed range standard:	InLine spindle with hollow shaft of main drive 20 bis 12.000 r.p.m
Drive capacity:	13 kW (40% ED) / 17,43 hp 9 kW (100% ED) / 12,06 hp
<b>Max.Spindle torque:</b>	83 Nm (40% ED) / 61,21 ft lbs 57 Nm (100% ED) / 40,04 ft lbs
<b>Tool clamping force:</b> Tool taper:	8 kN / 1798 lbs SK40 DIN69871 Pneumatical unclamping unit for Pull-studs form DIN69872



## 2. Services

- TURNING 3 AXIS AND 5 AXIS MACHINE



## 2. Services

### • SPRINT TURNING

#### TECHNICAL DATA

##### MAIN SPINDLE

Max. machining diameter	32	mm
Stroke Z1	100	mm
	(240 with option I-C1045)	
Max spindle speed	8.500	rev/min
Nominal power S1	5,5	kW

##### COUNTER SPINDLE

Max. machining diameter	32	mm
Stroke Z2	200	mm
Max spindle speed	8.500	rev/min
Nominal power S1	2,2	kW

##### CNC CONTROLLED AXES

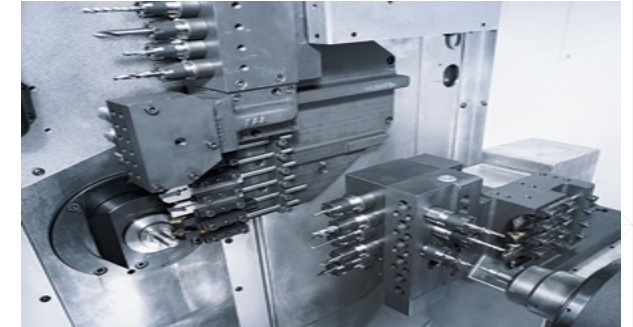
Rapid traverse X1, Z1, X2, Z2/Y1	40/30	m/min
Max axis acceleration	5	m/s <sup>2</sup>
Feeding force (S1) axes Z1, Z2, X1, X2	220	daN
Feeding force (S1) axis Y1	440	daN

##### SLIDE 1

Stroke X 1	70	mm
Stroke Y 1	405	mm
6 position 16X16 tool holder		
4 fixed tool holders Ø 25 mm for machining on main spindle and counter spindle		
4 driven tools with junction ESX20		

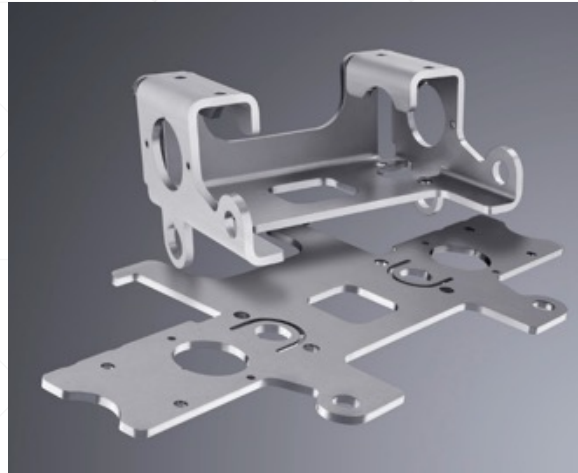
##### SLIDE 2

Stroke X 2	300	mm
Stroke Z 2	200	mm
4 fixed tool holders Ø 25 mm		



## 2. Services

- BENDING (sheets&tubes)
- PUNCHING
- SHEARING



## 2. Services

- TUNEL SANDBLASTING
  - W=1500 MM H=700 MM L =16 000 MM
- MANUAL SANDBLASTING
  - L=10 000 M H=5000 MM W= 3500 MM
- WET COATING
- MANUAL POWDER COATING
  - CABIN DIMENSION
  - L=10 000 M H=5000 MM W= 3500 MM



### 3. Quality & Certification

- Our company has invested in Quality Management Systems as we consider them as leading point for success and opportunity for opening new markets. These include the highest certificates in metal fabrication industry:

- EN ISO 9001:2015
- EN ISO 3834-2
- EN ISO 1090 EXC-4
- EN ISO 15085-2 CL2
- EN ISO 14001-2015
- EN ISO 18001-2007



# 3. Quality & Certification

ZERTIFIKAT • CERTIFICATE • CERTIFICADO • CERTIFICAT

**CERTIFICATE**

The Certification Body of TÜV SÜD Management Service GmbH certifies that

**AKTIVA**

**AKTIVA d.o.o. Štip**  
Bulevar Gaze Delčeva 50  
2000 Štip  
Republic of Macedonia

has established and applies an Environmental Management System for

Design and construction works within the domain of civil engineering construction and building engineering. Production of steel structures. Production of metal parts for the automotive industry, railway industry and other process equipment.

An audit was performed, Report No. 70767986. Proof has been furnished that the requirements according to

**ISO 14001:2004**

are fulfilled.

The certificate is valid from 20.10.2016 until 20.10.2018.

Certificate Registration No.: 12 104 52981 7985

*Dr. Holger*  
Peterl, Compliance Management  
Member, TÜV SÜD

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**CERTIFICATE OF CONFORMITY OF THE FACTORY PRODUCTION CONTROL**

Registration number 1017 – CPR – 07.553.868, Revision No. 1

In compliance with Regulation (EU) No 305/2011 of the European Parliament and Council of 9 March 2011 laying down harmonised conditions for the marketing of construction products and repealing Council Directive 93/68/EEC, this certificate is issued for the construction product:

Steel structures of execution class to EXC 3 according to EN 1090-2

produced by:

**AKTIVA d.o.o.**  
Gaze Delčeva br. 50, MK - 2000 Štip, Republic of Macedonia  
Company Registration No.: 5027000

and produced in the manufacturing plant:  
Gaze Delčeva br. 50, MK - 2000 Štip, Republic of Macedonia

This certificate attests that all provisions concerning the assessment and verification of conformity of performance in the context of the system in the series of Annex V, 1.2 of CPR and described in Annex ZA of the standard were assessed

**EN 1090-1:2009+A1:2011**

and certifies that

**the factory production control system fulfils all the designated requirements**

This certificate was first issued on 12.02.2015 and remains valid, as long as the test methods and/or factory production control requirements included in the harmonized standard, used to assess the performance of the declared characteristics, do not change and the product, under the manufacturing conditions and technological procedures in the plant are not modified significantly.

Start of validity: 12.02.2015

Note: The scope of validity is listed in an annex which is an inseparable part of this certificate.

Priloga: 31.03.2016

*Dr. Holger*  
Peterl, Head of Quality Department

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ZERTIFIKAT • CERTIFICATE • CERTIFICADO • CERTIFICAT

**CERTIFICATE**

The Certification Body of TÜV SÜD Management Service GmbH certifies that

**AKTIVA**

**AKTIVA d.o.o. Štip**  
Bulevar Gaze Delčeva 50  
2000 Štip  
Republic of Macedonia

has established and applies an Occupational Health and Safety Management System for

Design and construction works within the domain of civil engineering construction and building engineering. Production of steel structures. Production of metal parts for the automotive industry, railway industry and other process equipment.

An audit was performed, Report No. 70767986. Proof has been furnished that the requirements according to

**OHSAS 18001:2007**

are fulfilled.

The certificate is valid from 20.10.2016 until 20.10.2018.

Certificate Registration No.: 12 118 52981 7985

*Dr. Holger*  
Peterl, Head of Quality Department

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ZERTIFIKAT • CERTIFICATE • CERTIFICADO • CERTIFICAT

**ZERTIFIKAT**  
Schweißen von Schienenfahrzeugen und -fahrzeugteilen nach DIN EN 15085-2

Dem Betrieb: **AKTIVA d.o.o.**

Industrijska zona Štip  
2000 Štip  
Macedonien

wird bescheinigt, dass er gemäß der Schweißverfahren ausübungen für den Gefügebereich der  
Zertifizierungsstufe CL1 nach DIN EN 15085-2

Anwendungsbereich: • Hebel von Schienenfahrzeugen (mit Einlauf und Montage)

Gültigkeitsbereich:

Materialklasse	Werkstoffgruppen	Stresskategorie	Bemerkungen
CL1	1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100	1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100	

verantwortliche Schweißfachkompetenz: **Stane Miroslav (SME)** | geb. 10.11.1984  
gleichberechtigter Vertreter: **Zdravko Samardžić (ZSK) (jetzt)** | geb. 20.04.1973  
Vertreter: **Stane Miroslav**  
Bemerkungen: **Stane Miroslav**

Zertifikat Nr.: **TÜV SÜD/15085-2/15085-2/16**  
Gültigkeitsbereich: **schw 20.10.2016 bis 20.10.2018**  
Ausgestellt am: **09.03.2016**  
Auditor: **Dr. Holger Peterl**

*Stane Miroslav*  
Zertifizierungsgesellschaft  
Schweiß- und Schweißtechnik  
Lorenz-Str. 102

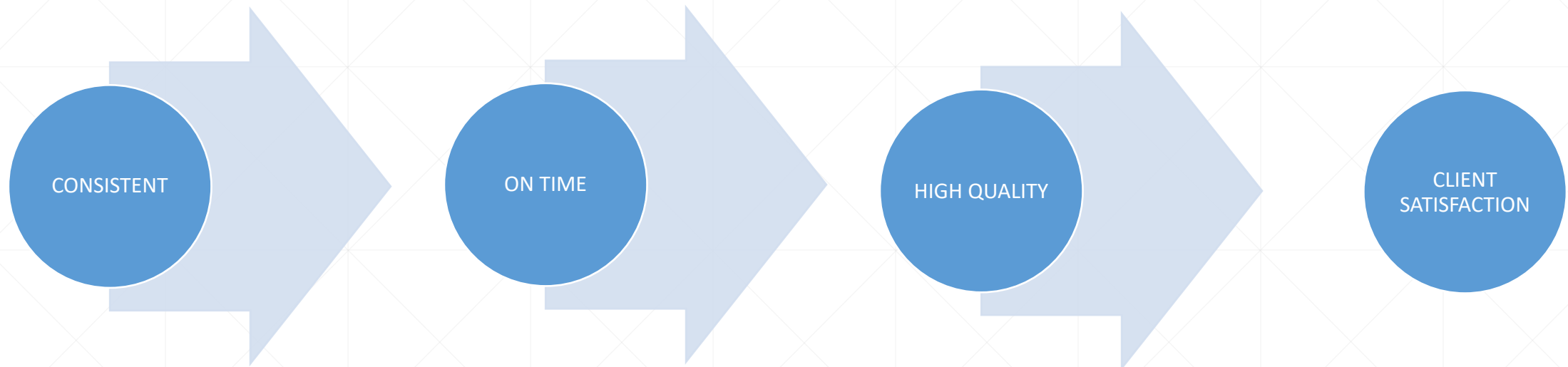
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## 5. Vision, mission ,values and sustainability

“Our vision is to become clients’ first choice through consistent and on time production of high quality products lead by the aspiration for improvement and development with continuous implementation of state of art technologies and positive technical standards.”

“Our mission is to create new values for our clients whose we consider as our long term partners through satisfying their highest needs, creating good working climate for our employees and building cooperation relationships based on trust with our suppliers.”



## 5. Vision, mission ,values and sustainability

Based on the fundamental values, the management acts according to the following principles of work:

- Clients satisfaction is the most important of all the priorities and the motto of the company;
- The company must continue to be reliable, virtuous and responsible member of the society;
- Continuous investment in company development through implementation of the newest technologies;
- To struggle always to be open to changes so that we could act proactively to achieve future prosperity;
- Through development and encouraging of the employees to build teams which will work as single group;
- The long-term focus, strategic thinking and sustainable acting are the main characteristics of our company;

## 5. Vision, mission ,values and sustainability

On sustainability company its build with energy efficient materials and complete and finish installation of renewable energy photovoltaic plant of 3.5 MWh .



## REFERENCE PARTNERS AND CLIENTS



thyssenkrupp



KLEEMANN