



STENHØJ

INTO THE FUTURE

Workshop Presses

Welcome to the world of Stenhøj



Flexibility



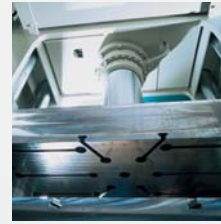
Progressiveness



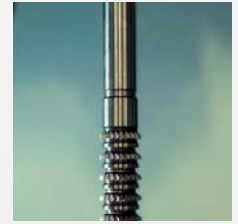
Effectiveness



Positivity



Reliability



Strength of will

STENHØJ HYDRAULIK A/S

- Part of a large international group.

Since its foundation in 1917 STENHØJ has manufactured and marketed advanced and innovative products for the automotive industry. Each year offers a new set of challenges, and we thrive on them. Fortunately we are not alone – as part of Stenhøj group with a worldwide staff of approx. 700 employees in more than 15 companies we have an excellent base, and so we are always ready to take on new challenges.

At Stenhøj Hydraulik A/S we specialize in the manufacture of hydraulic presses, electro-mechanical Broaching machines and special-purpose machines for the industry.

Our longstanding experience enables us to continuously develop improved and custom-engineered machines.

Our Mission is based on our ambition to optimize STENHØJ's position in the global market. We will fulfill our customers' needs for processing machines. We will provide market-adapted solutions supplying added value through competent counseling and excellent service.

Our Vision is to have continuous influence on market developments. We will continue to improve our customers' experience of the value of every single order and of the business relationship in general. Through enterprising, creative and proactive conduct of business, STENHØJ will be the preferred partner in the targeted market and product areas.

Our concept is based on expert knowledge; we have something to be proud of – competent and committed employees. Dedicated to finding solutions to the needs of our customers.

Hydraulic Workshop Presses

Since 1932, STENHØJ HYDRAULIK has manufactured hydraulic presses for workshops and industrial production. Since 1960, a substantial percentage of these presses have been delivered to export markets.

Our range of workshop presses has been developed over several years. Thanks to our longstanding experience we have delivered many custom-engineered solutions during the years; the challenge of every single one has been solved with our creative concepts. Our customers acknowledge this, and over the years we have built close relationships with our many customers throughout the world.

This program includes sizes between 25t – 500t and is available in three standard models: Classic, Flexi &

LuxPress We have produced numerous customized solutions based on the FLEXI model during the years, also based on the unique LuxPress for forces up to 1000t – still with focus on the customer's needs.

The times and also the globalization in general made it necessary to introduce a segmentation to be able to offer a strong product that would be useful to the professional manufacturer. Therefore, we maintain our high quality level. Apart from our standard models we produce an increasing number of semi-standards and customized solutions. For these applications we modify our standard components to fit even the most demanding purposes.

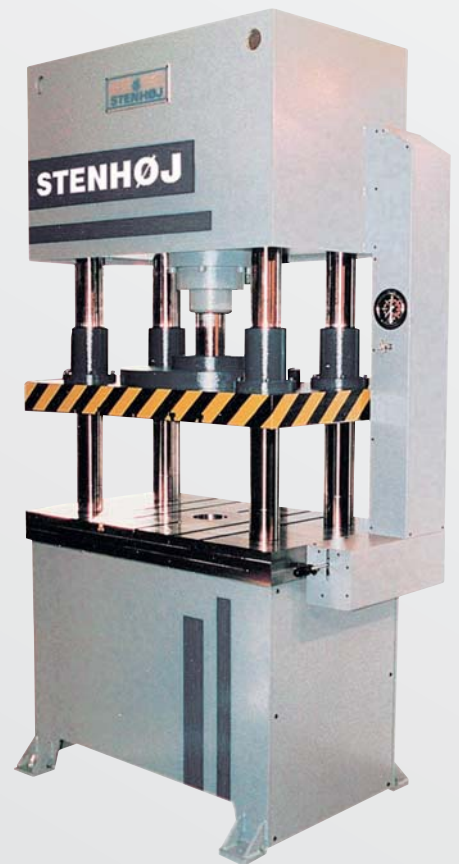
In addition we produce a wide and strong program of tools for these presses.

Our adaptability is our great strength.



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FlexiPress FP-Model, Standard

The modern workshop press

FlexiPress is our strong and reliable workshop press for all requests. All models are delivered with a generous workspace and a double-acting cylinder.

STANDARD EQUIPMENT

- Double-acting cylinder assembly mounted in the press frame
- Adjustment of press bed with the pressing cylinder
- Flanged piston rod end for tool mounting
- Replaceable nose cap
- 2 V-blocks/straightening blocks
- Hand pump or motorized pump unit
- Laterally moveable cylinder

Function and Operation

- Manual pump unit
 - The hand pump is a 2-stage model, equipped with double piston
 - Change-over between low/high pressure and return manually on the reverse valve
 - Return movement by means of pressure air, which gives a fast return movement
 - The press is connected to external compressed air supply

- Motorized pump unit
 - Operation of the press is via a single hand operated control valve allowing for infinite adjustment of the ram speed proportional to the control valve position
 - Press force is adjustable

OPTIONAL EXTRAS

- Press Bed with t-slot
- Press cylinder with increased stroke length
- Motorized pump unit for special applications
- Column guided press plate

Tools/accessories

The FlexiPress can, if required, be supplied with tooling for various applications, e.g.

- Tube bending tool
- Press Brake tool
- Pressing tool – arbor set
- Broaching fixture
- Clamping tool for fixing wire ends
- Tool Plate

FlexiPress Models

25t, 40t, 60t, 100t, 150t & 200t

Built in accordance with the latest EC regulations and CE labeled



FP-Model		FlexiPress Standard excl. pump unit						FlexiPress Wide excl. pump unit			
Model		FP25	FP40	FP60	FP100	FP150	FP200	FPW40	FPW60	FPW100	FPW200
Pressing force, max.	kN	250	400	600	1000	1500	2000	400	600	1000	2000
Stroke	mm	400	400	400	400	400	400	400	400	400	400
Daylight, min.	A mm	300	300	300	300	300	300	300	300	300	300
Daylight, max.	B mm	900	900	900	900	900	900	900	900	900	900
Table width between verticals	C mm	740	850	1010	1080	1150	1150	1300	1500	1500	1600
Frame width	D mm	920	1030	1270	1440	1510	1550	1480	1760	1860	2000
Clearance between verticals	F mm	160	245	290	360	460	460	245	290	360	460
Max. Floor space	H mm	580	610	760	800	1040	1040	610	760	800	1040
Overall height	K mm	1950	2050	2300	2550	2500	2500	2350	2500	2800	2800
Bed height, max.	L mm	1010	1045	1145	1245	1245	1245	1200	1245	1400	1400
Press bed adjustment	M mm	4x150	4x150	4x150	4x150	4x150	4x150	4x150	4x150	4x150	4x150
Moveable cylinder	P mm	250*	275*	330*	340*	320*	320*	500*	575*	550*	545*
Nose cap	S mm	Ø60	Ø65	Ø85	Ø100	-	-	Ø65	Ø85	Ø100	-
Hole pitch, press flange	T mm	Ø78	Ø86	Ø110	Ø130	Ø210	Ø210	Ø86	Ø110	Ø130	Ø210
Hole diameter, press flange	U mm	2xØ9	2xØ11	2xØ13	2xØ17	4xØ22	4xØ22	2xØ11	2xØ13	2xØ17	4xØ22
Thickness, press flange	V mm	25	30	40	45	52	52	30	40	45	52
Diameter, press flange	X mm	Ø98	Ø108	Ø134	Ø160	Ø260	Ø260	Ø108	Ø134	Ø160	Ø260
Weight Approx.	kg	250	460	770	1220	1800	2090	650	1000	1650	2650

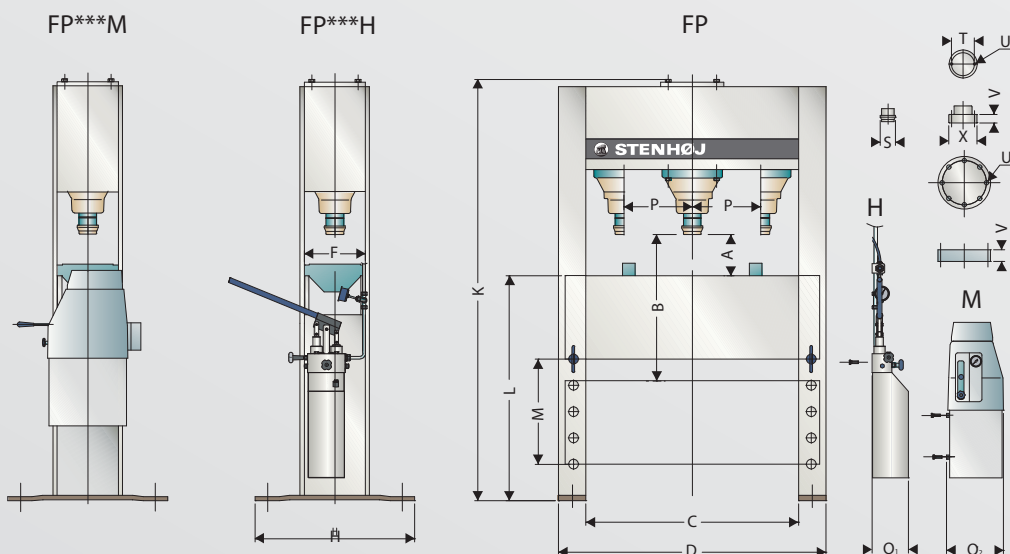
Hand pump unit for FlexiPress

Model		25H	40H	60H
Width	O ₁ mm	180	180	180
Piston move/pump stroke, LP/HP	mm	11/1,5	7/1	4,4/0,6
Return force at 5 bar air pressure	kN	2,5	4,5	7
Oil reservoir capacity	liter	14	14	14

Motorized pump for FlexiPress

Model		25M	40M	60M	100M	150M	200M	40M	60M	100M	200M
Width	O ₂ mm	280	280	280	280	280	280	280	280	280	280
Piston move/pumpe stroke, LP/HP	mm/s	10/10	9/9	10/5	8/3	10/3	10/3	9/9	10/5	8/3	10/3
Return speed	mm/s	16	13	14	11	13	13	13	14	11	13
Return force, max.	kN	30	30	30	30	200	200	30	30	30	200
Motor power 3x400V, 50Hz	kW	3	3	3	3	4	4	3	3	3	4
Oil reservoir capacity	liter	25	25	25	25	40	40	25	25	25	40

*) Reduceret tilladelig maksimal pressekraft i yderstilling



Ret til tekniske ændringer forbeholdes

FlexiPress FP-Model, Special

- Customized Workshop Presses

The press frame is designed as module welded construction. Therefore this STENHØJ press is a unique design for individual and customized solutions, from the simple modification up to engineered high tech presses, such as heating presses with control system.

Customized solutions

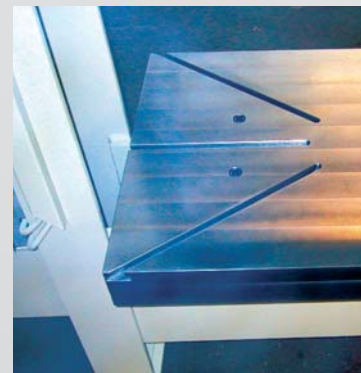
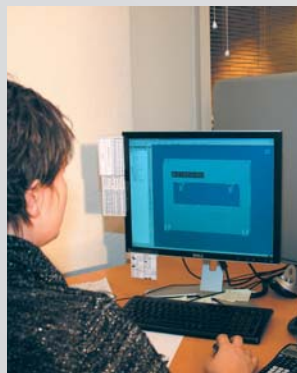
We can easily change daylight, table size, stroke or if you needs is a alternative control system on the electric or the hydraulic system, we can offer you that special solution.

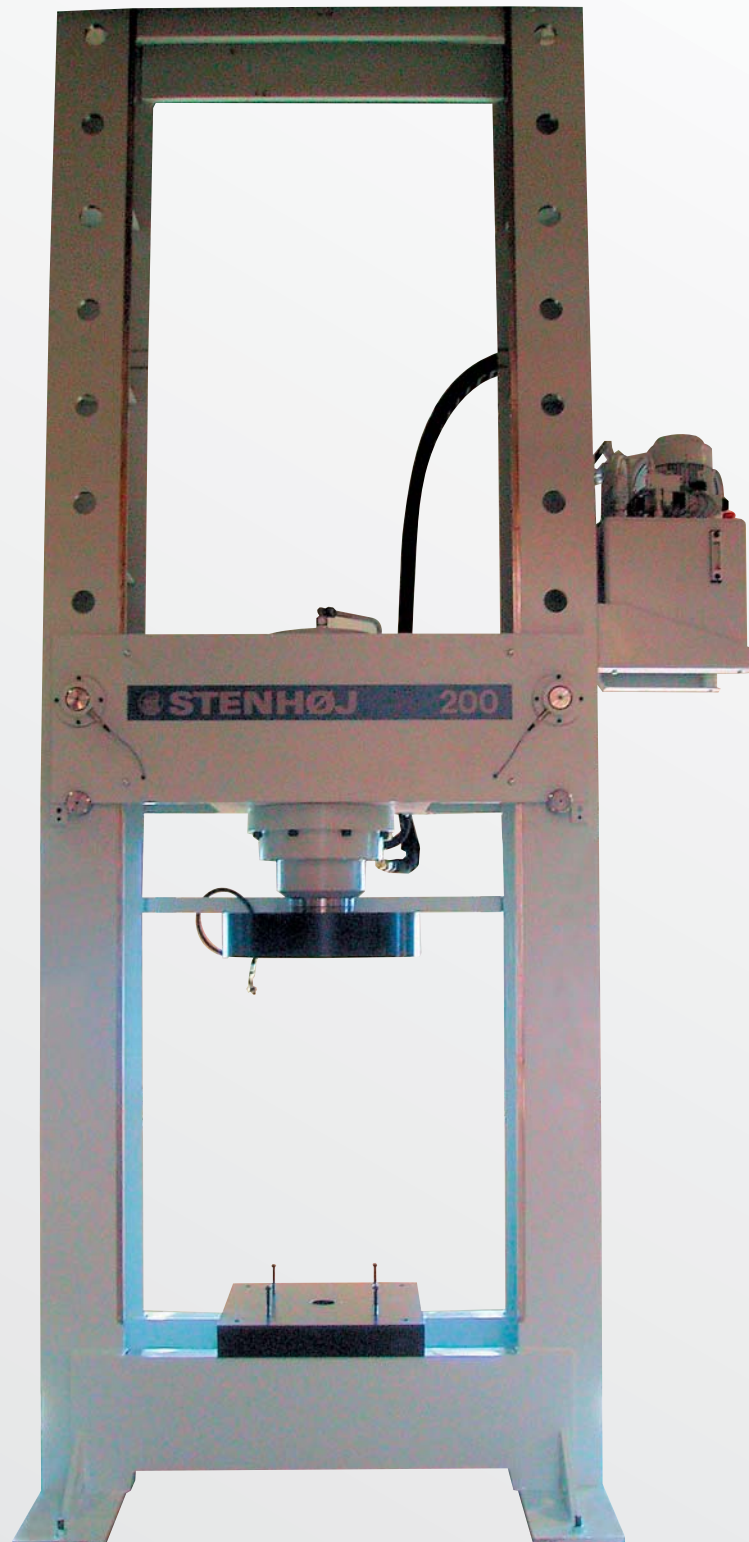
Used for

STENHØJ-presses are dedicated for production of small, middle and large series in deep draw, punching, bending, assembling, stamping, straightening, composite pressing, and hot pressing.

Used of

- Automotive- and sub supplier industries
- Electro- and house holding machines industries
- Metal- and plastic industries
- Steel- and sheet metal industries
- Tool shops- and toolmakers
- Forging industries
- Technical schools and university etc.





FlexiPress EP-Model, Standard

STENHØJ FlexiPress C-Model with full access from all 3 sides and simple operation the STENHØJ EP range is most versatile hydraulic C frame workshop press currently available for maintenance- and workshop applications



Motor pump unit

Operation of the press is via a single hand operated control valve allowing for infinite adjustment of the ram speed proportional to the control valve position. Additionally fine adjustment of the pressing force is available.

Standard equipment

- Double-acting cylinder
- Press flange for tool mounting
- Replaceable nose cap
- 2 V-blocks/straightening blocks
- Motorized pump unit

Optional extras

- T-slotted press bed
- Increased stroke length
- Motorized power units for special applications
- Foot control
- Electric top/lower stop

Tools/Accessories

The C-Frame Press can be supplied with tooling for various applications, e.g.

- Tube bending tool
- Press Brake tool
- Pressing tool – arbor set
- Broaching fixture
- Clamping tool for fixing wire ends
- Tool Plate

FlexiPress C-Model, Standard

25t – 40t – 60t – 100t – 150t & 200t

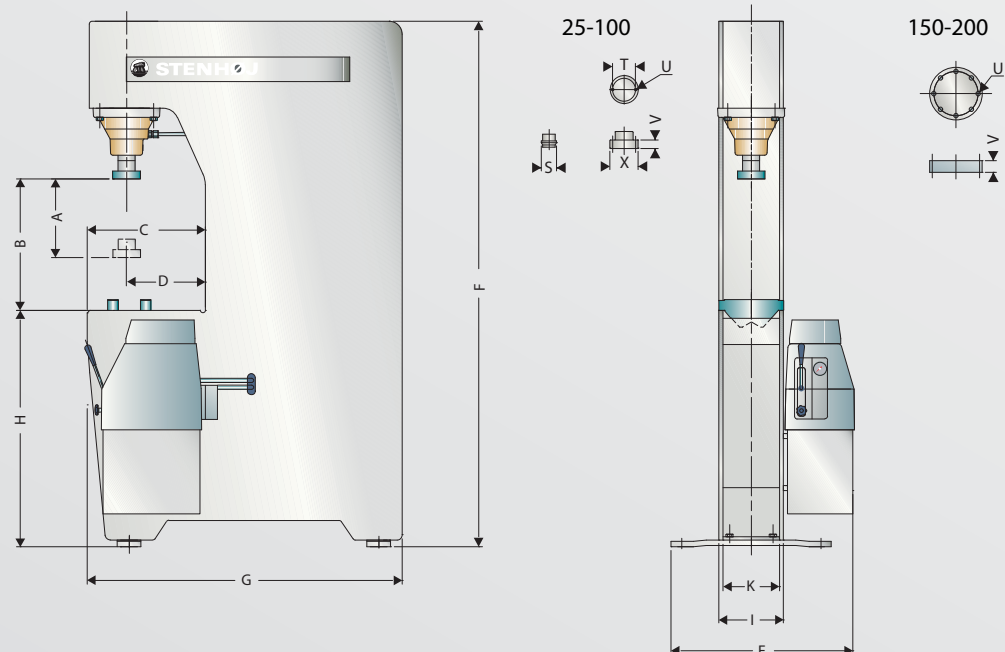
Built in accordance with the latest EC regulations and CE labeled

FlexiPress EP-Model, Standard

Model			EP25M	EP40M	EP60M	EP100M	EP150M	EP200M
Press force, max.		kN	250	400	600	1000	1500	2000
Stroke	A	mm	400	400	400	400	400	400
Daylight, max.	B	mm	600	600	600	600	600	600
Working depth (back to front)	C	mm	450	450	600	600	750	750
Throat depth	D	mm	300	300	400	400	500	500
Frame width	E	mm	645	693	787	820	970	1040
Overall height	F	mm	2200	2300	2400	2500	2600	2600
Total depth	G	mm	1100	1200	1400	1500	1700	1800
Bed height	H	mm	900	900	900	900	900	900
External frame width	I	mm	200	250	295	365	475	495
Internal frame width	K	mm	170	210	245	305	395	395
Nose cap diameter	S	mm	Ø60	Ø65	Ø85	Ø100		
Hole pitch, press flange	T	mm	Ø78	Ø86	Ø110	Ø130	Ø210	Ø210
Hole diameter, press flange	U	mm	2xØ9	2xØ11	2xØ13	2xØ17	4xØ22	4xØ22
Thickness, press flange	V	mm	25	30	40	45	52	52
Diameter, press flange	X	mm	Ø98	Ø108	Ø134	Ø160	Ø260	Ø260
Weight, approx.		kg	700	900	1400	2200	3700	4200

Motor pump unit

Pressing speed LT/HT	mm/s	10/10	9/9	10/5	8/3	10/3	10/3
Return speed	mm/s	16	13	14	11	13	13
Return load, max.	kN	30	30	30	30	200	200
Motor power 3x400V, 50Hz	kW	3	3	3	3	4	4
Oil reservoir capacity	liter	25	25	25	25	40	40



FlexiPress EP-Model, Special

- Customized Workshop Presses

The press frame is designed as module welded construction. Therefore this STENHØJ press is a unique design for individual and customized solutions, from the simple modification up to engineered high tech presses, such as heating presses with control system.

Customized solutions

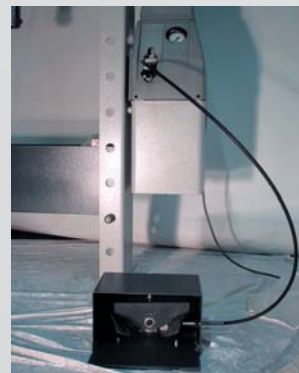
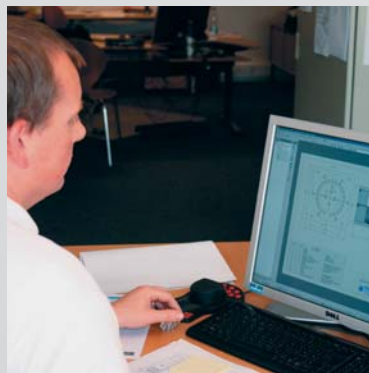
We can easily change daylight, table size, stroke or if you need an alternative control system on the electric or the hydraulic system, we can offer you that special solution.

Used for

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Used of

- Automotive- and sub supplier industries
- Electro- and house holding machines industries
- Metal- and plastic industries
- Steel- and sheet metal industries
- Tool shops- and toolmakers
- Forging industries
- Technical schools and university etc.





BenchPress BP-Model, Standard

For service- & repair shops

The STENHØJ BenchPress is with its functional design and simple operation considered the most up-to-date and versatile press on the market for service- and repair shops.

Hand pump unit

The hand pump is a 2-stage model, which is equipped with high-/low pressure. Automatic change-over from low pressure to high pressure. Change-over to return with hand operated valve.

Motor pump unit

Operation of the press- and return movement via a single hand operated control valve with infinite regulation of the press speed. The press force is adjustable.

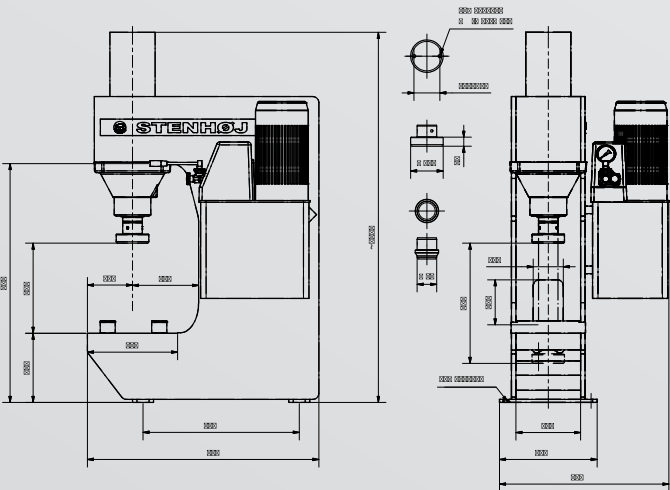
Standard equipment

- Single-acting cylinder
- Pressure gauge
- Replaceable nose cap
- 2 pcs. V-blocks/straightening blocks
- Table console
- Motorized pump unit



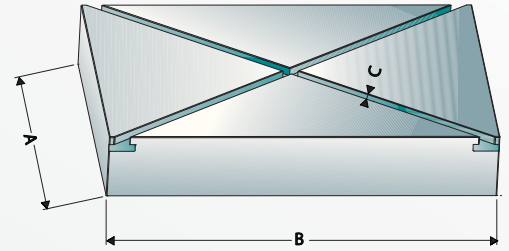
Technical Data		BP20H	BP20M
Pressing force, max.	kN	200	200
Stroke	mm	300	300

Motor pump unit			
Width	mm	180	275
Pressing speed	mm/s	7/1	9
Return speed	mm/s	4,5	13
Motor power, 3x400V, 50 Hz	kW	-	3
Oil Reservoir capacity	l	14	25
Weight Approx.	kg	300	300



Press bed

One of the accessories for all FlexiPress H-model and C-model is our press bed produced in high quality machined steel, the press bed/press plate is machined on all sides and equipped with T-slots in an X (see picture).



Press bed for FP og EP

		25/40T	60/100T	150/200T
Depth	A	300	400	500
Width	B	500	600	700
T-slot	C	14	14	18

Tool Program



Clamping tool for fixing wire ends

Tool is made at Stenhøj.
It consists of a tool rig + 3 different dies available for wire diameters Ø6, Ø8 & Ø10mm.
Observe max pressing force: 40t.

Pressing tool – arbor set

With 8 different sizes of arbors Ø12, 14, 16, 18, 20, 22, 25 & 30mm. and adaptor for mounting the arbors to the cylinder head, plus a bracket (holder) to hang the arbors on the press frame side. Observe that there are 4 different adaptors.



Broaching fixture

It is the console only to hold the ring and make it easier for the process to get access to the needle. The customer provides the matrix and ring, which are individual for the various parts to make.

Tube bending tool

Used for pipe/tube bending with 6 different sizes matrixes – 3/8", 1/2", 3/4", 1", 5/4", 1 1/2" and 2 support blocks



Tool plate

With kidney-shaped hole. This is mostly used with ClassicPress & BenchPress for pressing out bearings (auto repair shops).

Guided Press brake attachment for bending of sheet metal

Suitable for FP40t up to 200t.
working width of 835mm. the lower of this tool has got 4 different tracks 16, 25, 45 & 65mm., wedge angel of 90°, for sheet metal from 0,5 to 6mm.



Modules for workshop presses FP-Model



Modules for workshop presses EP-Model



LuxPress FP-Model, Standard

Heavy duty Motorized Press from STENHØJ

The STENHØJ motorized press Model LUX has infinitely adjustable pressing force and infinitely variable speed. The press is well suited for applications requiring large pressing force and precise guiding of the pressing operation.

Power Unit and Press Cylinder

The power unit is of 2-stage design consisting of a high-pressure pump integrated with a low-pressure pump ensuring rapid downward movement of the press piston to the work piece. The low-pressure pump is automatically disengaged at a pressure corresponding to 10% of the maximum pressure. The press cylinder is bored and honed inside. The piston rod is ground and hard-chrome plated. The piston head is precision guided, with recognized long-life high-pressure seals being used.

Press Frame – Adjustable Bed

The press frame is all-welded with accurately machined table. By means of the press ram the table can be raised and lowered hydraulically, and is located by steel pins at the required position. The press frame has a large maximum daylight and is accessible from all sides.

Press Frame – Fixed Bed

The press frame is all-welded with accurately machined table. The press is accessible from all sides.

Operation

The advanced control valve has an in-built flow control facility which enables infinite adjustment of the ram speed proportional to hand-lever position. The pressure is infinitely adjustable from 0 to maximum by the pressure setting valve, and the pressing force is registered setting valve, and the pressing force is registered on a gauge graduated in tons and kN.

Optional extras

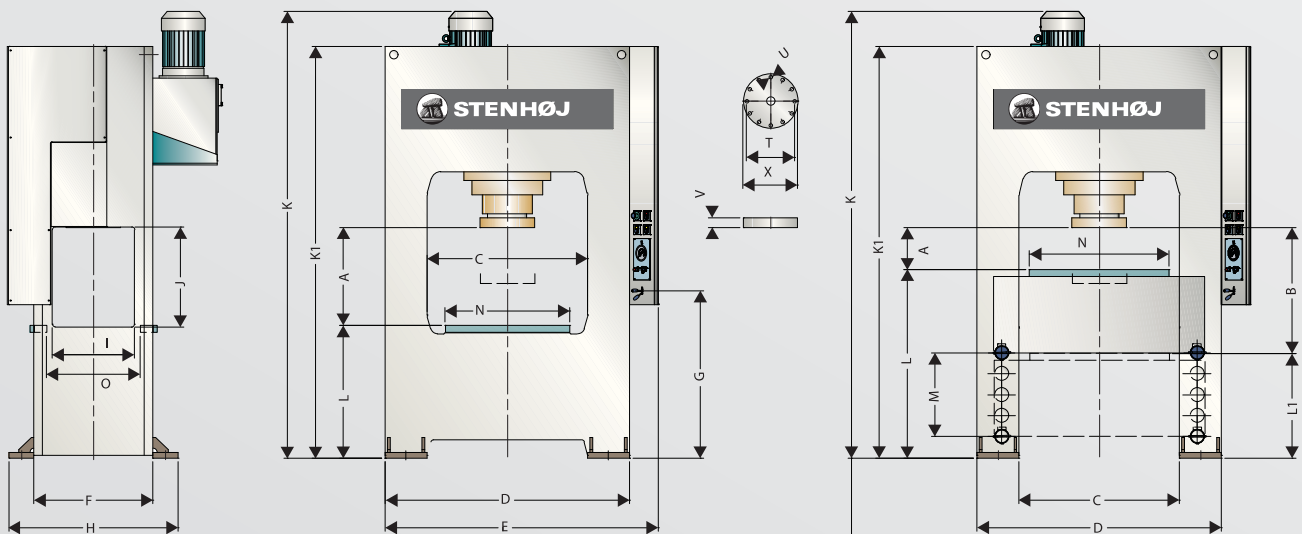
- 2 V-blocks/straightening blocks
- Press Bed
- Column guided ram (press plate)
- Electrical Top and lower stop

Built in accordance with the latest EC regulations and CE labeled



LuxPress H-Model, Standard

		Fixed Bed				Adjustable Bed			
Model		200T	300T	400T	500T	200T	300T	400T	500T
Pressforce, max.	kN	2000	3000	4000	5000	2000	3000	4000	5000
Stroke	mm	400	400	400	400	400	400	400	400
Daylight, min.	A mm	700	700	700	700	300	300	300	360
Daylight, max.	B mm					900	900	900	900
Width between verticals	C mm	1150	1150	1150	1150	1150	1150	1150	1150
Fram width	D mm	1550	1650	1750	1750	1550	1650	1750	1750
Width incl. El-Cabinet	E mm	1760	1860	1960	1960	1760	1860	1960	1960
Frame depth	F mm	680	750	850	850	680	750	850	850
Joystick height	G mm	1200	1200	1200	1200	1100	1150	1200	1200
Depth at foot	H mm	1040	1110	1210	1210	1040	1110	1210	1210
Side windows, width	I mm	420	490	590	590	420	490	590	590
Side windows, height	J mm	715	715	715	715	715	715	715	715
Total height	K mm	3090	3130	3200	3240	2990	3080	3200	3240
Frame height	K1 mm	2790	2830	2950	2985	2690	2780	2950	2985
Bed height, max.	L mm	950	950	950	950	1250	1300	1350	1290
Bed height, min.	L1 mm					650	700	750	750
Press bed adjustment	M mm					4x150	4x150	4x150	3x180
Bed, width	N mm	890	890	890	890	1060	1060	1000	1000
Bed, depth	O mm	540	590	670	530	540	590	670	530
External bed depth	P mm	800	850	990	1000	740	810	910	910
Pitch diameter	T Ømm	210	315	345	360	210	315	345	360
Hole diameter, press flange	U mm	8XØ21	8XØ25	12XØ25	12XØ25	8XØ21	8XØ25	12XØ25	12XØ25
Thickness, press flange	V mm	55	60	70	80	55	60	70	80
Diameter, press flange	X Ømm	250	360	390	420	250	360	390	420
Weight Approx.	kg	3800	5000	6800	9400	3600	4800	6750	9300
Motorpumpeanlæg									
LT-speed	mm/s	10,0	10,0	10,0	10,0	10,0	10,0	10,0	10,0
HT-speed	mm/s	2,4	2,3	3,0	2,5	2,4	2,3	3,0	2,5
Return speed	mm/s	20,0	18,0	20,0	18,0	20,0	18,0	20,0	18,0
Motor power	kW	5,0	7,5	11,0	11,0	5,0	7,5	11,0	11,0



LuxPress Special

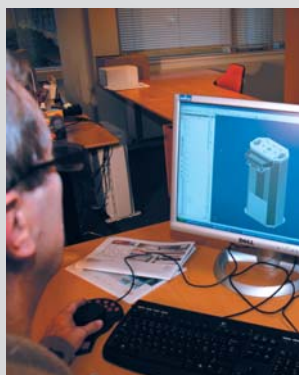
- Customized Workshop Presses

As base in a LuxPress with its extraordinary strong design press frame for heavy duty press operation, and for high tonnage, we have through all the years manufactured a large number of custom designed LuxPress to the customer's needs.

LuxPress are manufactured up to 1000 ton press force. We can build in alternative control system developed

for the specific project. Below is an example on a project with a 1000 ton LuxPress with a semiautomatic control system for high precision straightening of gear axles up to 340mm in diameter using almost 1000 ton.

That is just one of the possibilities to redesign our standard LuxPress through Stenhøj Hydraulik's technical creativity.





4-Column Tool Test Press, Standard (VWP & VWPK)

Tool Test Press Benefits

- Timely tool fixing
- No unnecessary finishing
- Production press are relieved therefore no production stop.
- Secure test of tools before they go into production.

Design

Tool Test Press is performed in a strong, stiff and stable steel construction.

A highly accurate machining of the components with the required precision and parallelism.

The 4-column construction allows optimum access to the tool from all sides, both before and during the test.

Stroke and Press force adjustment

The hydraulic control system is designed for tool testing. The control valve is an integrated proportional volume control valve, which gives accurate control of the ram and a infinitely controlling of speed.

The maximum press force is present on the full speed area.

STANDARD EQUIPMENT

Electrical

The Tool Test Press VWP is equipped with motor protection, circuit breaker and undervoltage releaser.

Press ram

We can offer two different press ram designs.

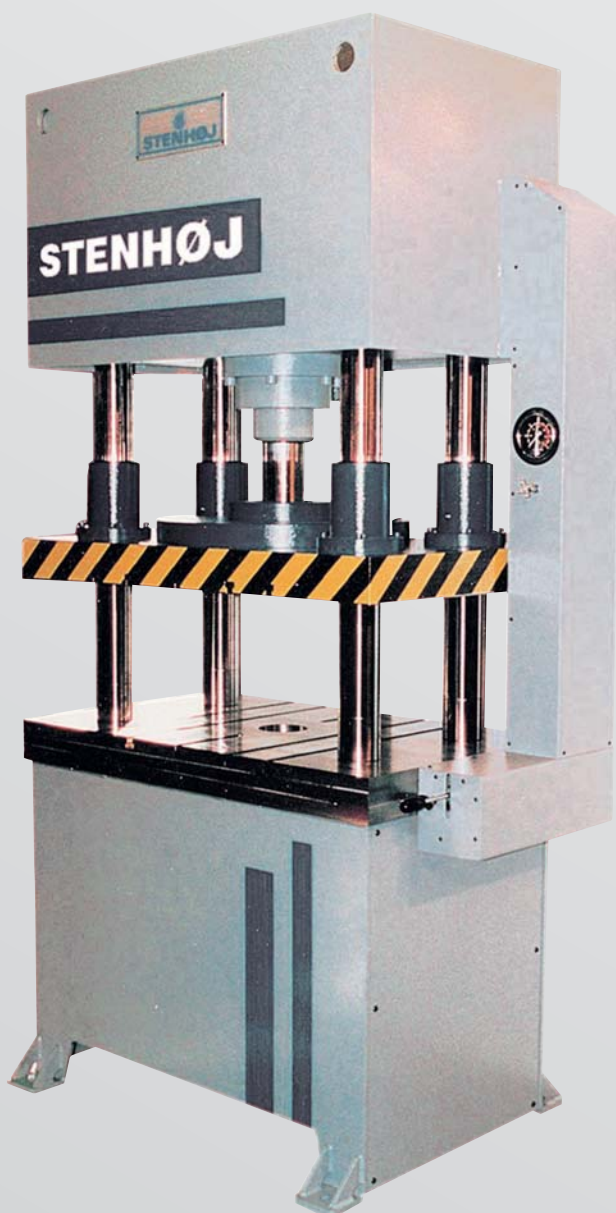
As standard the press is equipped with a flat ram (VWP).

Alternative we can offer a welded box construction special for off center load tools (VWPK).

The strong press designed press ram is as the ram equipped with T-slots for mounting the tool.

Optional

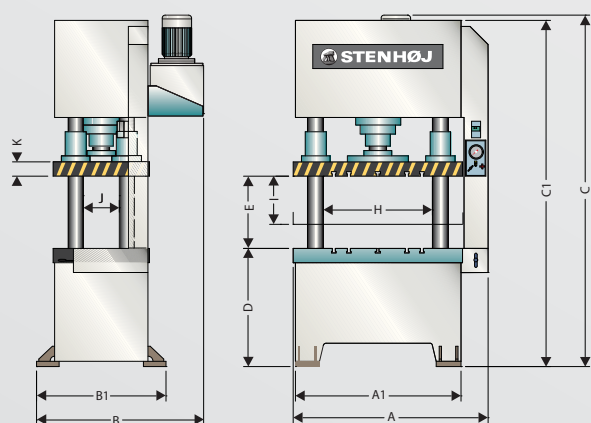
- Cushion or ejector with separate control valve, pump unit and infinitely force adjustment.
- Integrated cylinder in the ram as ejector or cushion with separate control valve, pump unit and step less force adjustment.
- Infinitely electrical adjustment of the stroke length (top- and lower stop position).
- Performed with hydraulic and safety control as a production press.



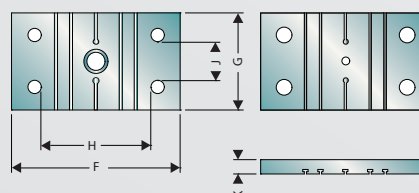
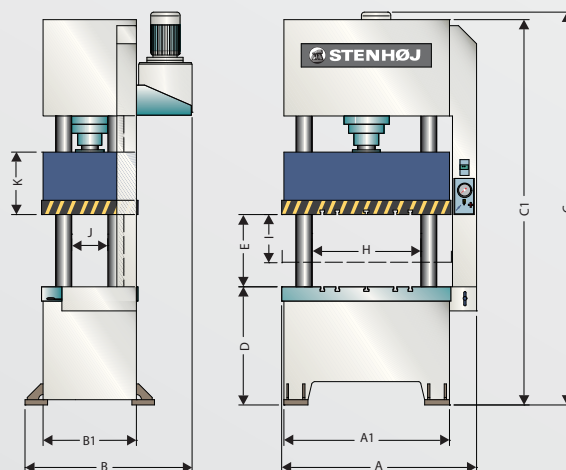
4-Column Tool Test Press, Standard (VWP og VWP-K)

Model			VWP 60T	VWP-K 60T	VWP 100 T	VWP-K 100 T	VWP 150T	VWP-K 150 T	VWP-200T	VWP-K 200T
Press width	A	mm	1310	1310	1650	1650	1750	1750	1750	1750
Frame width	A1	mm	1200	1200	1400	1400	1550	1550	1550	1550
Press depth	B	mm	1350	1350	1400	1400	1550	1550	1550	1550
Frame depth	B1	mm	750	750	800	800	950	950	950	950
Press height	C	mm	2800	3100	2950	3300	3200	3550	3200	3600
Frame height	C1	mm	2650	2950	2900	3200	3200	3550	3200	3600
Table height	D	mm	975	975	975	975	975	975	975	975
Daylight	E	mm	500	500	600	600	700	700	700	700
Bed width	F	mm	1200	1200	1400	1400	1550	1550	1550	1550
Bed depth	G	mm	750	750	800	800	950	950	950	950
Between column (front)	H	mm	750	750	900	900	1010	1010	1010	1010
Stroke	I	mm	400	400	400	400	500	500	500	500
Between column (side)	J	mm	300	300	300	300	400	400	400	400
Ram height	K	mm	105	505	115	515	130	630	150	650
Column diameter		mm	100	100	130	130	150	150	150	150
Press force		kN	600	600	1000	1000	1500	1500	2000	2000
Return force		kN	315	315	510	510	750	750	980	980
Press speed		mm/s	10	10	10	10	10	10	10	10
Return speed		mm/s	19	19	21	21	18	18	19	19
Motor power		kW	5,5	5,5	11	11	15	15	18,5	18,5
Weight Approx.		kg	3500	6000	6000	6600	7500	8700	9000	10600

VWP



VWP-K

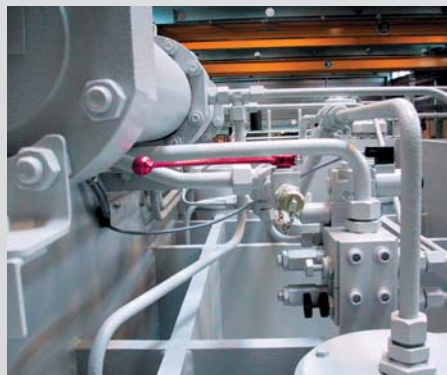
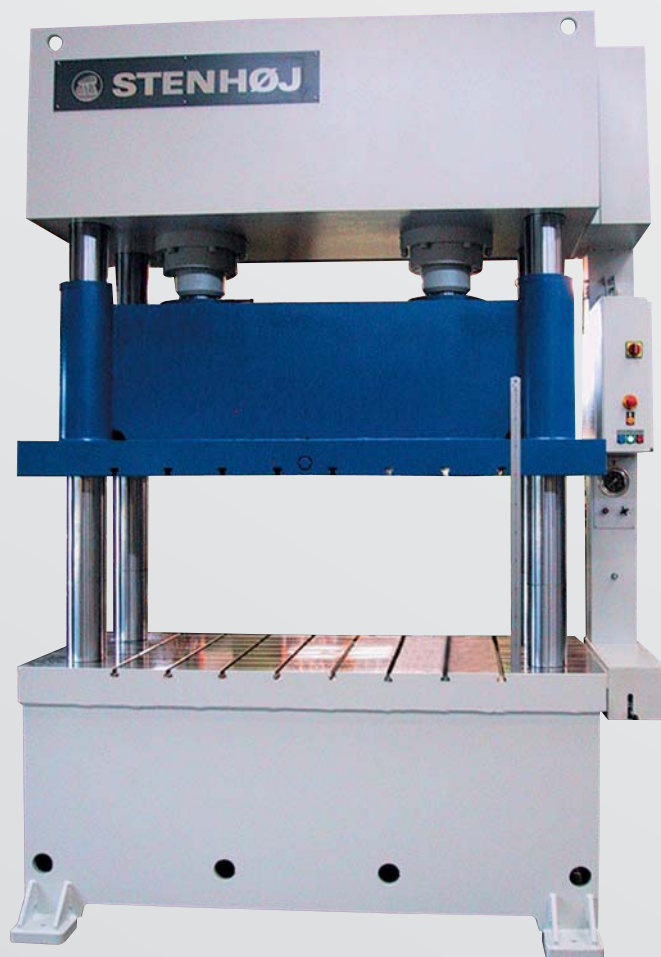
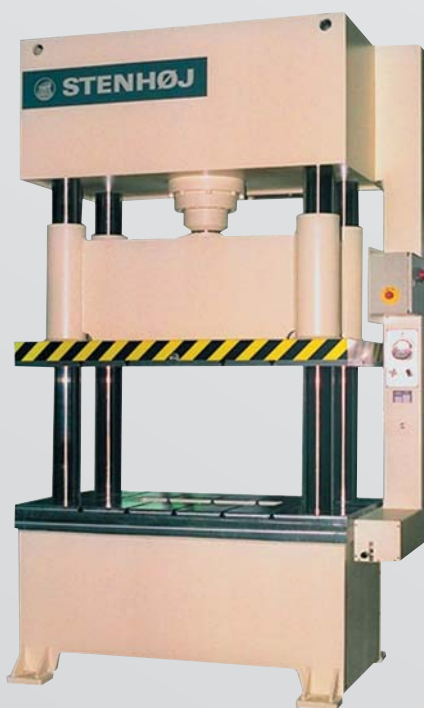


4-Column Tool Test Press, Special (VWP og VWPK)

- Customized Workshop Presses

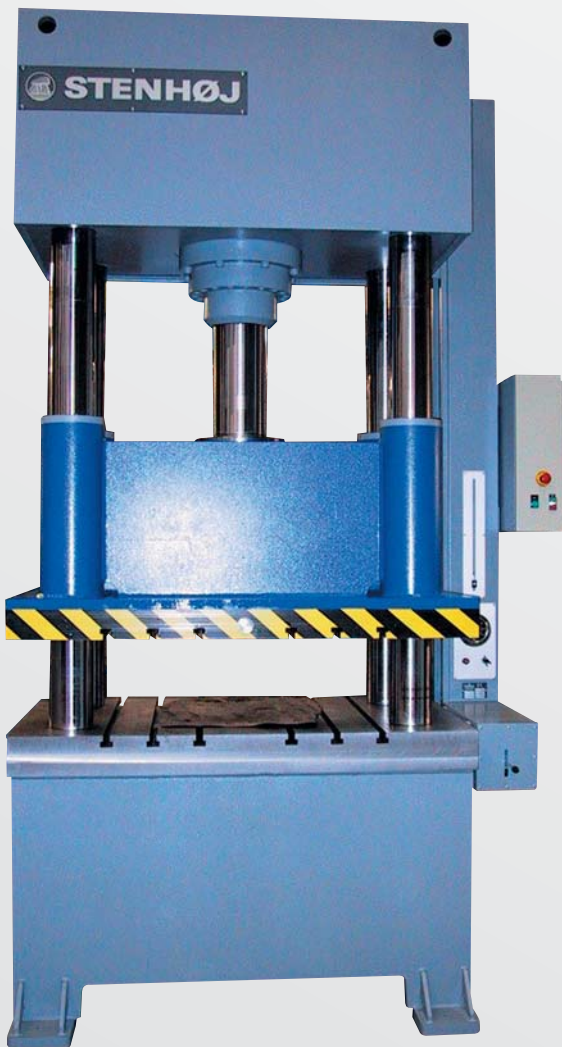


As base in a VWP with its extraordinary strong designed press frame for tool testing press operation, and for high tonnage, we have through all the years manufactured a large number of custom designed Tool Test Presses to the customer's needs. Tool Test Press is manufactured up to 800 ton press force. We can build in alternative control system developed for the specific project. Below is an exsample of some of the project we have delivered, we design the press to your specification



and together with our know-how we find the absolute best solution. This is just some of the possibilities to redesign our standard Tool Test Press through Stenhøj Hydraulik's technical creativity.

The Tool Test Press is designed up to 800 ton with die cushion and in 2 or 4 column design, some customers are using this concept as production press, just with another pump solution.



Hydraulic Production Presses

Since 1932, STENHØJ HYDRULIK has manufactured hydraulic presses for workshops and industrial production. Since 1960, a substantial percentage of these presses have been delivered to export markets. Our range of production presses has been developed over several years. Thanks to our longstanding experience we have delivered many custom-engineered solutions during the years. The challenge of every single one has been solved with our creative concepts. Our customers' acknowledge, and over the years we have built close relationships with our many customers throughout the world.

Our standard program range from 25t to 500t in H-frames or C-frames. Customized Presses are available

in many different sizes from 1t – 2000t and with different features. Our solutions always focus on the customers' needs.

For many years we have developed some of the world's best production presses – and we intend to keep on doing that!

Our production presses are used for series production. In co-operation with our customer. We identify the production purpose, and on the basis of that we design the perfect solution, standalone presses, and production cells with handling equipment or special hydraulic machines. It goes without saying that we provide training in using the individual machines to ensure that our customer is well prepared to operate them.





Production Cell



Technician working on the press



Hydraulic pump unit



Adjusting Press bed



Building the Electrical cabinet

24-7-365 World Wide Service

SERVICE LEVEL – a giant network

We always strive to be the best. To retain this position we have built a unique service and support network. We are represented all over Europe with a strong concentration in Northern Europe.

Our extensive networks of dealers with their wide experience in our special products cooperate in representing our local competences and are capable of providing the necessary service support of the

products. Our dealers go through an intensive hands-on training program conducted by our own experienced supervisor. In this way we ensure optimum local support for our customer who can obtain round-the-clock support from STENHØJ.

To us a deal is a deal, and therefore we make a virtue of ensuring that our machines work again within 24 hours.

We hope that this presentation has given you an insight into the exciting world that we, at Stenhøj Hydraulik A/S, are engaged in.



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