

MADORA



POLISH MANUFACTURER OF DEBURRING MACHINES

MADORA

GP 300 B Deburring Machine

The Madora GP300 B series deburring machine is a compact and versatile machine designed for processing mild steel sheet metal parts. The machine has a working width of 300 mm and offers two operating functions, making it suitable both for removing slag generated during plasma cutting and for deburring. The device effectively removes scale, burrs, and sharp edges, improving surface quality and ensuring safety during further processing or assembly. Thanks to its design, the GP300 B deburring machine enables fast and uniform finishing of parts, increasing productivity in workshops and manufacturing plants. This model is particularly useful for small parts no wider than 300 mm. In the processes of preparing parts after plasma cutting, ensuring clean edges and an aesthetically pleasing finish on edges and holes.

SPECIFICATIONS

MACHINE FUNCTIONS		
Slag Removal		YES
Deburring		YES
Edge Rounding		YES
Oxide Removal		NO
TFT Control Panel		NO
OPERATING PARAMETERS		
Feed rate	m/min	0,5-2
Thickness range for machining	mm	0,5-100
Maximum workpiece width	mm	300
Number of machining units	pcs	1
Number of machining tools	pcs	1
MACHINE DIMENSIONS		
Width	mm	800
Length	mm	1100
Height	mm	1800
Weight	kg	300
OPTIONAL EQUIPMENT		
Magnetic Table		YES
Table with a vacuum system		NO
R-Type unit		NO
Filter fan		YES
Belt conveyor		YES
Roller conveyor		YES
Central lubrication system		NO
POWER SUPPLY		
Rated current	A	15
Machine power	kW	4,3
CONTROL		
Manual operation via the control panel		

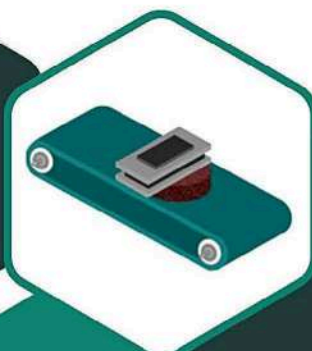
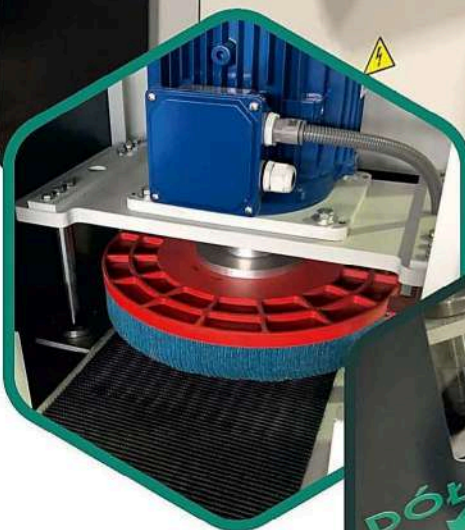
SCRAPING DISC
FOR REMOVING SCALE



DEBURRING AND EDGE-
ROUNDING DISC



The GP 300B is equipped with a single machining unit featuring a single-purpose tool with a diameter of 400 mm. The machine is capable of changing tools, which in turn allows for changes to the machining process. The 700 tool has a two-speed rotation range of 700 and 1,500 rpm, depending on the process.



Deburring Machine GP 600 2Z / GP 600 4Z



The GP600 2Z is a modern, high-performance two-unit machine for processing sheet metal edges, offering high productivity and precision. The machine is equipped with electronic positioning of the units and stepless adjustment of the material feed, which allows for precise adjustment of the parameters to the type of workpiece being machined. Thanks to manual tool wear compensation, the operator has full control over the quality of the machining.

The machine has a two-speed range for tool rotation—700 and 1,500 rpm—and each unit is controlled independently and equipped with four machining tools. This solution ensures a high degree of process flexibility and high machining efficiency.



The GP600 2Z is equipped with two "Z"-type processing units operating in rotary-oscillating mode. Each unit is equipped with four tools in a single row. Thanks to the two-speed speed control, we can freely select the machining processes.

The GP600 2Z is designed to clean sheet metal after plasma and laser cutting. It enables the removal of scale and burrs, as well as light and heavy edge rounding, thereby improving the quality and safety of further processing of the components.

Depending on the technological requirements, the machine can be equipped with a magnetic table for ferromagnetic sheets or a vacuum table designed for processing non-magnetic sheets (stainless steel, aluminum, copper, and others).

SPECIFICATION

GP 600 2Z | GP 600 4Z

MACHINE FUNCTIONS			
Scale removal		YES	YES
Deburring		YES	YES
Edge rounding		YES	YES
Oxide removal		NO	NO
TFT control panel		NO	NO
OPERATING PARAMETERS			
Feed rate	m/min	0,5-2	
Thickness range for machining	mm	0,5-100	
Maximum workpiece width	mm	600	
Number of machining units	pcs	2	4
Number of machining tools	pcs	4	
MACHINE DIMENSIONS			
Width	mm	1220	1220
Length	mm	1380	1380
Height	mm	1800	1800
Weight	kg	880	1100
OPTIONAL EQUIPMENT			
Magnetic Table		YES	
Table with a vacuum system		YES	
R-Type Unit		NO	
Filter Fan		YES	
Belt Conveyor		YES	
Roller conveyor		YES	
Central lubrication system		NO	
POWER SUPPLY			
Rated current	A	24	42
Machine power	kW	7	13
CONTROL			
Manual operation via the control panel			



The GP600 2Z is equipped with two "Z"-type processing units operating in rotary-oscillating mode. Each unit is equipped with four tools in a single row. Thanks to the two-speed speed control, we can freely select the machining processes. Each unit is controlled independently.



Deburring Machine GP 1000 2Z / GP 1500 2Z

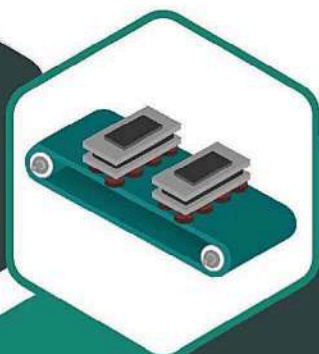


The GP1000 2Z and GP1500 2Z series deburring machines are excellent multifunctional machines for cleaning sheet metal after various cutting processes. Machines equipped with two machining units, 1,000 mm and 1,500 mm wide, equipped with nine or fourteen machining tools, respectively. With the appropriate tools, the machine can remove slag, deburr and round edges, remove oxides, and perform heavy-duty grinding. Standard equipment includes a TFT control panel that allows for full, real-time control of all machining parameters, such as the height of the workpieces, feed rate, and tool speeds.

SPECIFICATION

GP 1000 2Z | GP 1500 2Z

MACHINE FUNCTIONS			
Scale removal		YES	YES
Deburring		YES	YES
Edge Rounding		YES	YES
Oxide Removal		YES	YES
TFT control panel		YES	YES
OPERATING PARAMETERS			
Feed rate	m/min	0,5-2	
Thickness range for machining	mm	0,5-100	
Maximum workpiece width	mm	1000	1500
Number of machining units	pcs	2	
Number of machining tools	pcs	9	14
MACHINE DIMENSIONS			
Width	mm	1600	2100
Length	mm	2250	2250
Height	mm	2070	2070
Weight	kg	2200	2700
OPTIONAL EQUIPMENT			
Magnetic Table		YES	
Table with a vacuum system		YES	
R-Type unit		YES	
Filter fan		YES	
Belt conveyor		YES	
Roller conveyor		YES	
Central lubrication system		YES	
POWER SUPPLY			
Rated current	A	57	90
Machine power	kW	17	33
CONTROL			
TFT control panel		YES	YES



The GP1000 2Z and GP1500 2Z series deburring machines are equipped with two "Z"-type oscillating-rotary processing units. Each unit is mounted on four automatically adjustable columns, allowing it to operate with material thicknesses ranging from 0.5 to 100 mm. The standard units are equipped with inverters that provide continuous speed control of the tools.

Deburring Machine GP 1000 3Z / GP 1500 3Z



The GP1000 3Z and GP1500 3Z series deburring machines are excellent multifunctional machines offering even greater capabilities for cleaning sheet metal after various cutting processes. Machines equipped with three machining units, 1,000 mm and 1,500 mm wide, equipped with nine or fourteen machining tools, respectively. With the appropriate tools, the machine can remove slag, deburr and round edges, remove oxides, and perform heavy-duty grinding – all in a single pass. Standard equipment includes a TFT control panel that allows for full, real-time control of all machining parameters, such as the height of the workpieces, feed rate, and tool speeds.



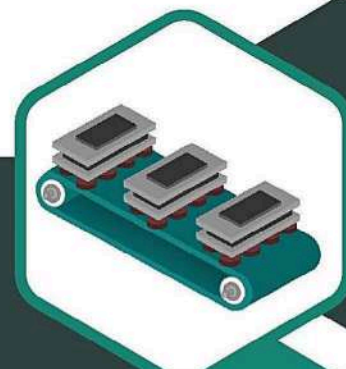
SPECIFICATION

GP 1000 3Z | GP 1500 3Z

MACHINE FUNCTIONS			
Scale removal		YES	YES
Deburring		YES	YES
Edge Rounding		YES	YES
Oxide Removal		YES	YES
Surface grinding		YES	YES
OPERATING PARAMETERS			
Feed rate	m/min	0,5-2	
Thickness range for machining	mm	0,5-100	
Maximum workpiece width	mm	1000	1500
Number of machining units	pcs	3	
Number of machining tools	pcs	9	14
MACHINE DIMENSIONS			
Width	mm	1600	2100
Length	mm	2850	2850
Height	mm	2070	2070
Weight	kg	2800	3300
OPTIONAL EQUIPMENT			
Magnetic Table		YES	
Table with a vacuum system		YES	
R-Type unit		YES	
Filter fan		YES	
Belt conveyor		YES	
Roller conveyor		YES	
Central lubrication system		YES	
POWER SUPPLY			
Prąd znamionowy	A	59	104
Moc maszyny	kW	25	57
CONTROL			
TFT control panel		YES	YES

SCRAPING DISC FOR REMOVING SCALE	DEBURRING AND EDGE-ROUNDING DISC	HEAVY-DUTY EDGE-ROUNDING DISC	GRINDING DISC	OXIDE REMOVAL DISC	3M GRINDING DISC

The GP1000 3Z and GP1500 3Z series deburring machines are equipped with three "Z"-type oscillating-rotary processing units. Each unit is mounted on four automatically adjustable columns, allowing it to operate with material thicknesses ranging from 0.5 to 100 mm. The units are equipped as standard with inverters that provide continuous speed control for the tools. Three units arranged in a row ensure excellent edge and surface finish in a single pass.



Deburring Machine GP 1000 4Z / GP 1500 4Z

The GP1000 4Z and GP1500 4Z deburring machines are excellent multifunctional machines for cleaning sheet metal after various cutting processes. Equipped with as many as four "Z"-type processing units, they offer exceptional versatility and high processing efficiency. What does this mean in practice? The fact that it can perform as many as four operations simultaneously means that it can be used for more than just removing scale after plasma cutting.

The machine also enables deburring and edge rounding of parts after laser cutting in a single pass. A wide range of machining thicknesses and widths up to 1000 mm/1500 mm allows for the machining of both small and large workpieces.

When used with the appropriate tools, the machine is also suitable for heavy-duty edge rounding, as well as for removing oxides and heavy-duty surface grinding.



SPECIFICATION

GP 1000 4Z | GP 1500 4Z

MACHINE FUNCTIONS

Scale removal		YES	YES
Deburring		YES	YES
Edge Rounding		YES	YES
Oxide Removal		YES	YES
Surface grinding		YES	YES

OPERATING PARAMETERS

Feed rate	m/min	0,5-2	
Thickness range for machining	mm	0,5-100	
Maximum workpiece width	mm	1000	1500
Number of machining units	pcs	4	
Number of machining tools	pcs	9	14

MACHINE DIMENSIONS

Width	mm	1600	2100
Length	mm	3480	3480
Height	mm	2070	2070
Weight	kg	3580	4700

OPTIONAL EQUIPMENT

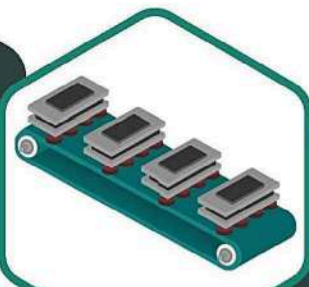
Magnetic Table		YES	
Table with a vacuum system		YES	
R-Type unit		YES	
Filter fan		YES	
Belt conveyor		YES	
Roller conveyor		YES	
Central lubrication system		YES	

POWER SUPPLY

Prąd znamionowy	A	71	140
Moc maszyny	kW	33	66

CONTROL

TFT control panel		YES	YES
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The GP 1000 4Z is equipped with four "Z"-type oscillating-rotary units. Each unit is mounted on four automatically adjustable columns, allowing for machining in the range of 0.5 mm to 100 mm (150 mm optional). "Z" series power units can also be equipped with an inverter, which allows us to smoothly adjust the tool's rotational speed to achieve the desired machining result. Each unit can be controlled independently, which means that the operator decides which machining processes to apply to the workpiece.

It's good to know that ...

Each machine in the GP1000 and GP1500 series can be equipped with additional options and adapted to the specific type of sheet metal being processed.



The "R"-type rotary machine is an excellent solution for creating sharp edge radii; thanks to the rotary-rotational-oscillating technology of the cutting tool, we achieve larger and smoother radii.



"VACUUM" vacuum table – used for working with parts that are not attracted to magnets, such as stainless steel, aluminum, copper, and other "non-ferrous" metals. Each deburring machine equipped with a vacuum table is fitted with pressure rollers at each processing unit.

Customize it however you need

OP 2000



Filter-ventilators



OP 3000



Central lubrication system



Layout of the workpiece return tables for the RTA-B operator



Automatic loading and unloading tables



Roller loading and unloading buffers

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