

## Mehrstufenpressen für Schrauben und Formteile

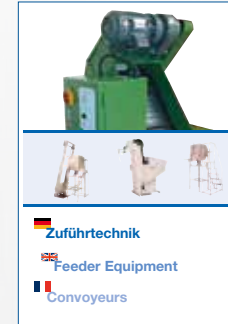
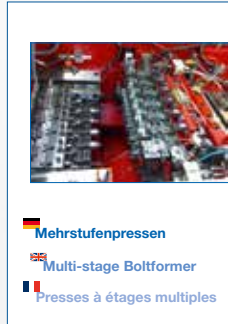


## Multi-stage boltformer for Screws and Forming Parts




## Presses à étages multiples pour vis et pièces moulées






### Unsere Service-Philosophie

 Wir stehen Ihnen als unserem Kunden gerne persönlich vor und auch nach dem Kauf zur Verfügung! Diesen „Vor-Ort-Service“ bieten wir Ihnen in ganz Europa.


Unsere Philosophie ist es, Kundenwünsche stets ehrlich und fair unter den Gesichtspunkten Service, Termintreue, Qualität, Leistungs- und Kostenbewusstsein in Lösungen umzusetzen.

### Our service philosophy

 We make ourselves available to you - our customers - with pleasure and personally not only before but also after a purchase! And we offer you this „on-the-spot“ service throughout the whole of Europe.

Our philosophy is always to convert customer wishes into solutions in an honest and fair manner under the standpoints of service, adherence to schedules, quality, performance and cost-consciousness.

### Notre philosophie du service

 Nous sommes à votre disposition avant et après une acquisition et nous vous offrons ce service « sur place » dans toute l'Europe.

Notre philosophie est de transformer avec honnêteté et loyauté vos souhaits en solutions, en respectant le service, les délais, la qualité, la performance et une conscience du coût.



# BRUNE GmbH

## Ihr Partner für Maschinen aus Taiwan



Sie möchten in Ihren Maschinenpark investieren und suchen eine günstige und qualitativ hochwertige Alternative aus Taiwan? Dann sind wir der richtige Partner für Sie! Bauen Sie auf eine Erfahrung in diesem Bereich von fast 15 Jahren und setzen Sie auf eine ständige Präsenz Ihres Partners in dem taiwanesischen Markt!

Die Produktpalette umfasst unter Anderem Doppeldruckpressen, Mehrstufenpressen, Gewindewalzmaschinen und Mess-, Prüf- und Sortiermaschinen. Seit 1996 bieten wir, die BRUNE GmbH, Maschinen aus Taiwan an und sind ständig direkt vor Ort vertreten.

Dies ermöglicht es uns, für Sie den Markt und die Entwicklungen im Bereich Maschinenbau kontinuierlich zu beobachten und in Teilen auch mitzugestalten. Dies ist die wesentliche Grundlage für die Wahl der richtigen Produktpartner.

Ein weiterer Vorteil für Sie ist die Qualitätssicherung während der Bauphase Ihrer Maschine. Unsere Mitarbeiter vor Ort überwachen die Prozesse von der Produktion bis zur Verschiffung. Vertrauen ist gut – Kontrolle ist besser!

Je nach Produkt nehmen Sie die Maschine direkt in Taiwan ab oder wir übernehmen dies für Sie. Für die gute Unterbringung und Betreuung während Ihres Aufenthaltes ist selbstverständlich gesorgt.

Für alle Maschinen erhalten Sie 12 Monate Herstellergarantie und einen Service von Deutschland aus. Die wesentlichen Ersatz- und Verschleißteile sind in unserem Lager in Drolshagen und Schwabach, bei Nürnberg, verfügbar. Sollte einmal eine Störung eintreten so sind wir innerhalb von 48 Stunden vor Ort bei Ihnen. Sollten Sie eine taiwanesisches Maschine einmal überholen wollen, so bieten wir Ihnen diesen Service ebenfalls innerhalb Europas an.

Bauen Sie auf Erfahrung und Präsenz vor Ort! Profitieren Sie von einem außergewöhnlichen Preis-Leistungsverhältnis mit deutschem Service! Überzeugen Sie sich von unseren gemeinsamen Möglichkeiten! Lassen Sie uns über Ihre persönlichen Anforderungen sprechen und wir unterbreiten Ihnen gerne ein individuelles Angebot!

Mit freundlichen Grüßen

Ihre Team BRUNE GmbH



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# BRUNE GmbH

## Your partner for machines from Taiwan



You would like to invest in machinery and are looking for an attractive and high quality alternative from Taiwan? In this case, we are the partner you are looking for! Rely on experience of almost 15 years in this area and know that your partner maintains a constant presence on the Taiwanese market!

Among other things, the product range includes double- and multi-station headers, thread rolling machines and measuring, testing and sorting machines. Since 1996, BRUNE GmbH has marketed machines from Taiwan and is permanently and directly represented on the spot.

This enables us on your behalf to keep a constant watch on the market and developments in the field of mechanical engineering and also to influence these to a certain extent. This is the essential basis for the choice of the right product partner.

Another advantage for you is the quality assurance during the construction phase of your machine. Our staff on the spot monitor the process from production to shipment. Trust is good, control is better!

Depending on the product, you carry out acceptance of the machine directly in Taiwan or we do this for you. We naturally arrange for good accommodation and support during your stay.

All machines carry a 12 months' manufacturer's guarantee and are supported by service from Germany. Major spare and wearing parts are stocked in our stores at Drolshagen and Schwabach near Nuremberg. If ever a fault occurs, we are on the spot at your place within 48 hours. If you ever want to have a Taiwanese machine overhauled, we can offer this service, also within Europe.

Rely on experience and an on-the-spot presence! Profit from an exceptional price/ performance ratio with German service! Take a hard look at the possibilities for each of us! Tell us about your personal requirements and we will be happy to give you an individual quote!

With best regards

Your BRUNE GmbH team



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# Entreprise BRUNE

## Votre partenaire pour machines de Taïwan



Vous souhaitez investir dans votre parc de machines et vous recherchez des produits d'excellent rapport qualité/prix provenant de Taïwan? Alors nous sommes le partenaire idéal pour vous! Faites construire votre machine avec une expérience de près de 15 ans dans ce domaine et reposez-vous sur la présence constante de vos partenaires sur le marché taïwanais!

La palette de produits comprend entre autres des presses à double frappe, presses à étages multiples, machines à rouler les filets et des machines de mesure, contrôle et tri. Depuis 1996, l'entreprise BRUNE propose des machines de Taïwan où nous sommes représentés sur place.

Cela nous permet de suivre pour vous les développements dans le domaine de la construction de machines et d'y contribuer en partie. Ceci est la base essentielle pour le choix des bons fournisseurs.

L'assurance qualité de la phase de production de votre machine est un autre avantage. Nos collaborateurs sur place surveillent le process de la production jusqu'à l'embarquement. La confiance n'exclut pas le contrôle!

Selon le produit, vous pouvez réceptionner la machine directement à Taïwan ou nous pouvons nous en charger. Nous prenons bien sûr en charge votre hébergement et votre accompagnement sur place lors de votre séjour.

Toutes les machines ont une garantie-constructeur de 12 mois et le service après-vente est assuré de l'Allemagne. Les principales pièces détachées sont disponibles dans nos entrepôts de Drolshagen et de Schwachbach, près de Nuremberg. En cas de panne, nous pouvons intervenir sur place dans les 48 heures. Si vous souhaitez remettre en état une machine taïwanaise, nous vous proposons notre service après-vente dans toute l'Europe.

Construisez avec l'expérience et la présence sur place ! Profitez de notre rapport qualité:prix hors du commun avec le service après-vente allemand ! Vous pouvez vous assurer de notre entière collaboration. Venez vous entretenir avec nous de vos demandes particulières et nous vous proposerons une offre personnalisée !

Cordialement,

L'équipe de l'entreprise BRUNE



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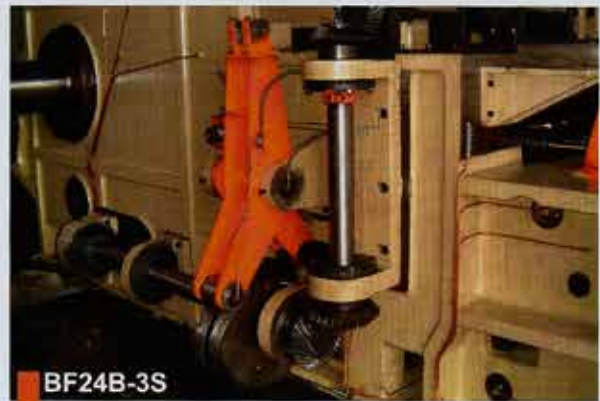
# 3 STATION BOLT FORMER | BF-SERIES



**BF10B-3S**

**A FEEDING & CUT OFF MECHANISM:**

Technical feeder to control the length of feeder is accurate & smooth, it helps feeder's gear last longer. S-Cam cut off is the same as the center line of main shaft, can bear more force.



**BF24B-3S**

**B TRANSFER MECHANISM:**

The reciprocal motion of the finger is guided by both bevel gear and conjugate cam. (or single cam)



**BF13B-3S**

**C TRANSFER FINGER MECHANISM:**

Spring type transfer system to control the clamping motion will transfer the blank to each station steadily and precisely.



**BF17B-3S**

**D P.L.C ELECTRICAL CONTROL:**

All the electrical control and safety device are monitored by P.L.C (programmable logical control), so it's easy to maintain electrical system & revise logical control.



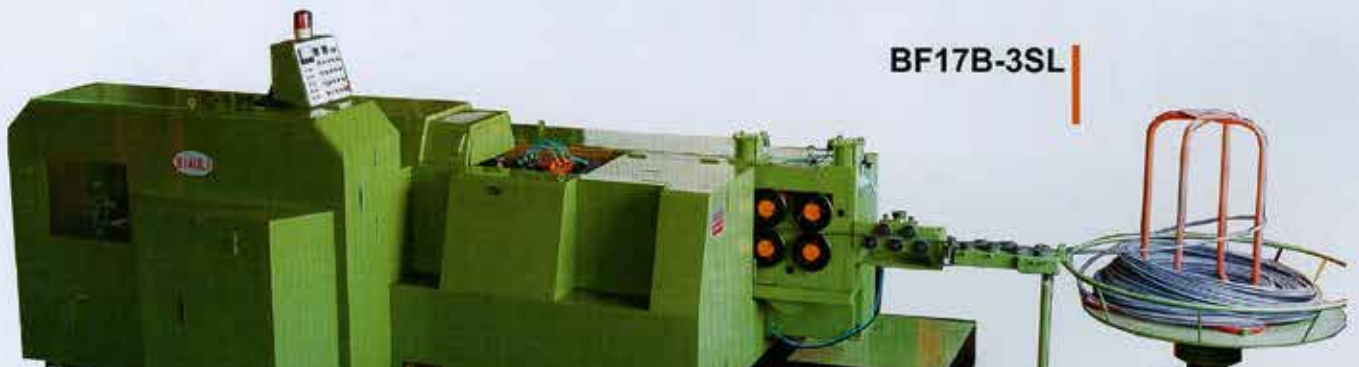
**E TRANSMISSION MECHANISM:** 4/8 (6) pole A-C main motor with 3 step gear box and it could provide total 6 different production speed. (total 6 step speed)



**BF13B-3S**

**F MAIN SLIDE & P.K.O SYSTEM:**

Easy in punch adjusting, also can be adjusted the timing of punch position forward or backward which is based on customer's need.



**BF17B-3SL**



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## 3 STATION BOLT FORMER BF-SERIES

SPECIFICATION / MODEL	BF7B-3S	BF10B-3S	BF13B-3S	BF13B-3SL	BF17B-3S	BF17B-3SL	BF19B-3S	BF19B-3SXL	BF19B-3SUL	BF24B-3S	BF30B-3S	BF50B-3S	
FORGING STATION	3	3	3	3	3	3	3	3	3	3	3	3	
CUT-OFF DIA. (MAX) (MM)	5	8	10	10	12	12	15	15	15	18	23	44	
CUT-OFF LENGTH (MAX)(MM)	55	70	94	130	105	180	140	240	350	185	260	380	
KICK-OUT LENGTH (MAX)(MM)	45	55	70	115	80	175	105	230	310	175	220	360	
PUNCH KICK-OUT LENGTH (MAX) (MM)	10	12	16	30	20	35	25	40	60	30	35	60	
CUT-OFF QUILL (DIA x LENGTH) (MM)	20x30	28x46	35x56	38x79	40x66	40x80	46x80	46x80	65x110	60x100	75x120	138x165	
MAIN DIE (DIA x LENGTH)(MM)	38x60	50x65	60x85	70x135	70x95	80x185	80x123	93x240	93x350	100x190	125x240	230x390	
CENTER DISTANCE BETWEEN DIES (MM)	48	60	87	87	93	93	114	114	114	126	138	240	
PUNCH HOLE (DIA x LENGTH) (MM)	32x60	40x77	45x87	45x111	50x102	50x132	60x121	60x200	65x192	75x185	90x197	146x245	
RAM STROKE (MM)	100	120	140	200	160	250	200	340	460	280	360	520	
FORGING POWER (TON)	15	20	40	40	60	65	80	90	100	140	200	520	
PRODUCTS	SIZE	3/16"(M4)	1/4"(M6)	5/16"(M8)	5/16"(M8)	3/8"(M10)	3/8"(M10)	1/2"(M12)	1/2"(M12)	1/2"(M12)	5/8"(M16)	3/4"(M20)	1 3/8"(M33)
	MAX LENGTH HEX	40mm	50mm	65mm	100mm	75mm	150mm	100mm	200mm	300mm	150mm	200mm	300mm
	MIN HEX	10mm	12mm	14mm	20mm	16mm	30mm	20mm	50mm	100mm	25mm	40mm	100mm
	LENGTH SOCKET	12mm	16mm	20mm	25mm	20mm	40mm	25mm	50mm	100mm	35mm	60mm	100mm
OUTPUT PCS/MINUTE (MAX)	300	250	210	180	180	150	150	115	70	100	80	45	
MAIN MOTOR (HP)	7 1/2	10	15	20	20	30	40	50	75	75	100	150	
LUBRICATING MOTOR (HP)	1	1	1	1	1	1	1	2	2	2	2x2	2x2	
COOLING MOTOR (HP)	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1	1	1	1	1	
LUBRICANT (L)	120	120	180	180	200	200	300	325	500	400	400	600	
COOLANT (L)	180	180	220	220	300	300	400	450	600	500	500	600	
APPROX. WT (KG)	3,500	6,000	9,000	13,000	13,000	18,000	20,000	35,000	43,000	43,000	58,000	180,000	
FLOOR AREA REQUIRED (LENGTH x WIDTH) (M <sup>2</sup> )	2.1x1.1	4.5x3.5	5x4	6.5x4	6.3x4.5	7x4.5	7.5x5	9.5x5	11x6	8.5x5.5	10x6	17x9	

\* THE FLOOR AREA MENTIONED DOES NOT INCLUDE THE WIRE STAND.  
 \* WE RESERVE THE RIGHT TO CHANGE THE DESIGNS & SPECIFICATIONS WITHOUT NOTICE.

### Forming Process



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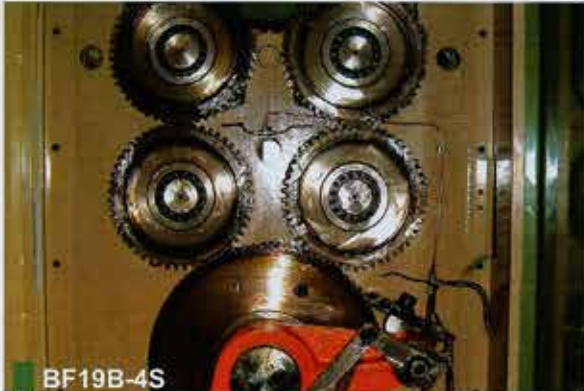
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# 4 STATION BOLT FORMER | BF-SERIES



**BF19B-4S**

**A FEEDING:**

4 wheel feeding roller-guide. Power Ring locking instead of conventional key-way design.



**BF19B-4SUL**

**B I-TYPE CHUCK FINGER:**

With pneumatic cylinder device to fasten the blank, which is simple & quick to adjust the transfer chuck fingers into the die center position.



**BF19B-4SUL**

**C HORIZONTAL - TYPE K.O**

K.O main rod and K.O. force are in the same force center line. (design for long stroke model)



**BF30B-4S**

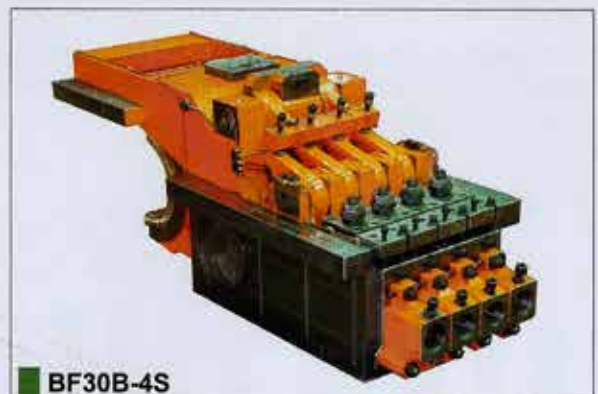
**D KICK-OUT MECHANISM:** Made by SKD11 with HRC58. The opposite moving direction of main slide and K.O cam is self momentum balancing. The last station can be used for trimming.



**BF30B-4S**

**E MACHINE BODY:**

FCD45(JIS)High tension, with firm main body can help the parts forming precision.



**BF30B-4S**

**F OVER ARM MAIN SLIDE & P.K.O SYSTEM:**

(RAM) with P.K.O for long stroke or higher precision parts required model use.



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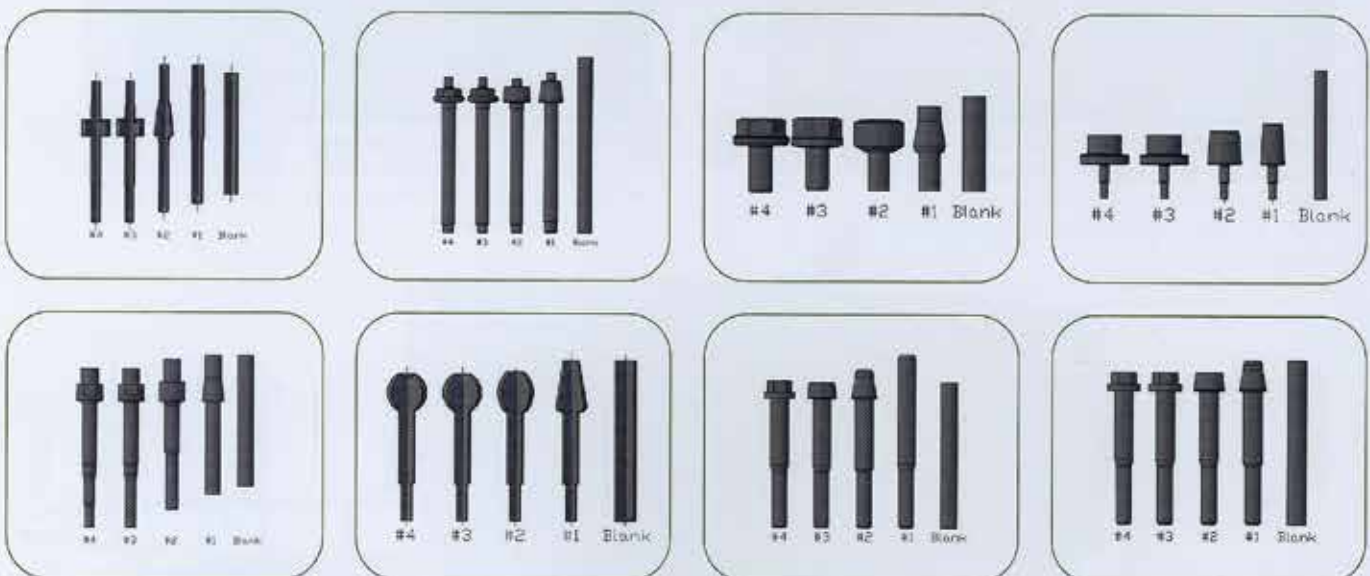
# 4 STATION BOLT FORMER BF-SERIES

SPECIFICATION / MODEL	BF10B-4S	BF13B-4S	BF17B-4SL	BF19B-4S	BF19B-4SXL	BF19B-4SUL	BF24B-4S	BF30B-4S	BF30B-4SXL	BF36B-4S	BF45B-4S
FORGING STATION	4	4	4	4	4	4	4	4	4	4	4
CUT-OFF DIA. (MAX) (MM)	10	12	12	15	15	15	18	23	23	29	44
CUT-OFF LENGTH (MAX)(MM)	94	105	180	140	240	400	185	260	430	320	450
KICK-OUT LENGTH (MAX)(MM)	70	80	175	105	230	340	175	220	400	280	390
PUNCH KICK-OUT LENGTH (MAX) (MM)	16	20	30	25	40	60	30	35	20,40,60	60	60
CUT-OFF QUILL (DIA x LENGTH) (MM)	28x46	35x56	40x80	46x80	46x80	65x110	60x100	75x120	75x120	90x140	132x165
MAIN DIE (DIA x LENGTH)(MM)	50x85	70x95	80x185	80x123	93x240	93x400	100x175	125x240	125x430	160x294	185x400
CENTER DISTANCE BETWEEN DIES (MM)	60	87	93	114	114	114	126	138	138	174	195
PUNCH HOLE (DIA x LENGTH) (MM)	40x77	45x87	50x132	60x121	60x200	65x192	75x165	90x197	95x250	105x232	138x240
RAM STROKE (MM)	140	160	250	200	340	500	280	360	560	440	520
FORGING POWER (TON)	40	60	85	100	120	120	180	220	320	320	520
PRODUCTS	SIZE	1/4" (M6)	5/16" (M8)	3/8" (M10)	1/2" (M12)	1/2" (M12)	5/8" (M16)	3/4" (M20)	3/4" (M20)	1" (M24)	1 1/8" (M33)
	MAX LENGTH MM	65mm	75mm	150mm	100mm	200mm	330mm	150mm	200mm	380mm	360mm
	MIN HEX LENGTH SOCKET	12mm	14mm	30mm	20mm	50mm	100mm	25mm	40mm	100mm	60mm
OUTPUT PCS/MINUTE (MAX)	210	180	150	120	90	70	100	80	60	60	40
MAIN MOTOR (HP)	15	20	40	50	75	75	75	100	125	125	200
LUBRICATING MOTOR (HP)	1	1	1	1	2	2	2	2	2	2 x 2	2 x 2
COOLING MOTOR (HP)	1/2	1/2	1/2	1/2	1	1	1	1	1	1	1
LUBRICANT (L)	180	200	200	300	350	500	500	500	600	500	600
COOLANT (L)	220	300	300	400	450	600	600	600	600	600	600
APPROX. WT (KG)	9,000	13,000	20,000	25,000	37,000	48,000	45,000	66,000	75,000	110,000	180,000
FLOOR AREA REQUIRED (LENGTH x WIDTH) (M <sup>2</sup> )	5x4	6.3x4.5	7x5	7.5x5.5	9.5x6	12x6.5	8.5x6	10x6.5	13x7	15x8	17x9

\* THE FLOOR AREA MENTIONED DOES NOT INCLUDE THE WIRE STAND.

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## Forming Process



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**BP19B-5S**

**A. TRANSFER CHUCK FINGER MECHANISM:**  
2 types of transfer can be changed independently. (translation or rotation finger clamping motion)



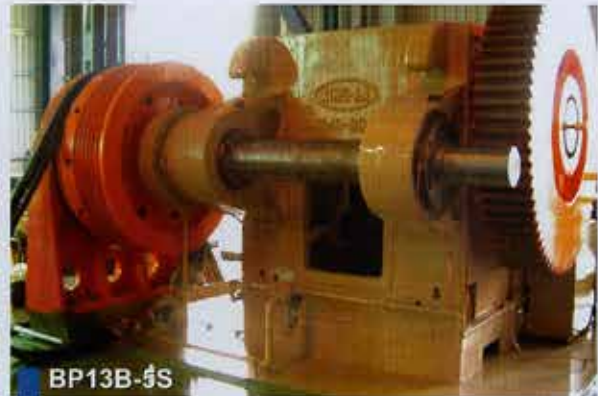
**BP19B-5S**

**B. AIR CLUTCH / BRAKE SYSTEM**  
Air clutch and air brake both available according to customer's need. (Optional)



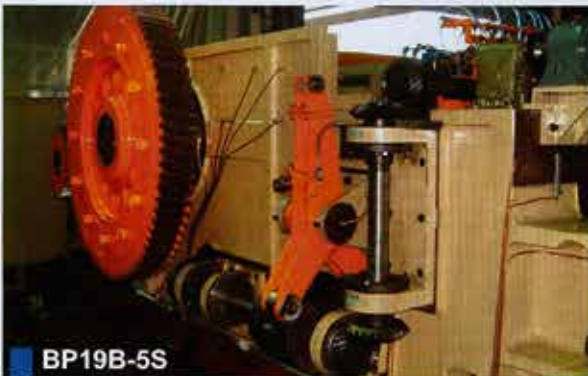
**BP13B-5S**

**C. P.K.O MECHANISM:**  
According to customer's need, P.K.O. stroke can be individually adjusted & simply setting P.K.O. cam in the 3 position; tools change can be done in short time.



**BP13B-5S**

**D. MAIN CRANKSHAFT & BACKSHAFT:** Power ring assures firmly connected between crankshaft and flywheel, allow safety slipping to prevent any damage when accident happen. Additional Backshaft device for large-sized former; with protection against possible overloads system in gear motion.



**BP19B-5S**

**E. TRANSFER HOUSING ADJ SYSTEM:**  
The transfer housing up/down adjustment by lever way to control easily. Some of the model with motor adjusting device, which is more easy to operate.



**BP19B-5S**

**F. FEEDING & CUT-OFF MECHANISM:**  
By 4 wheel feeding roller-guide to feed the material smoothly into the machine. S-Cam cut off is the same as the center line of main shaft, can bear more force.



**BP13B-5S**



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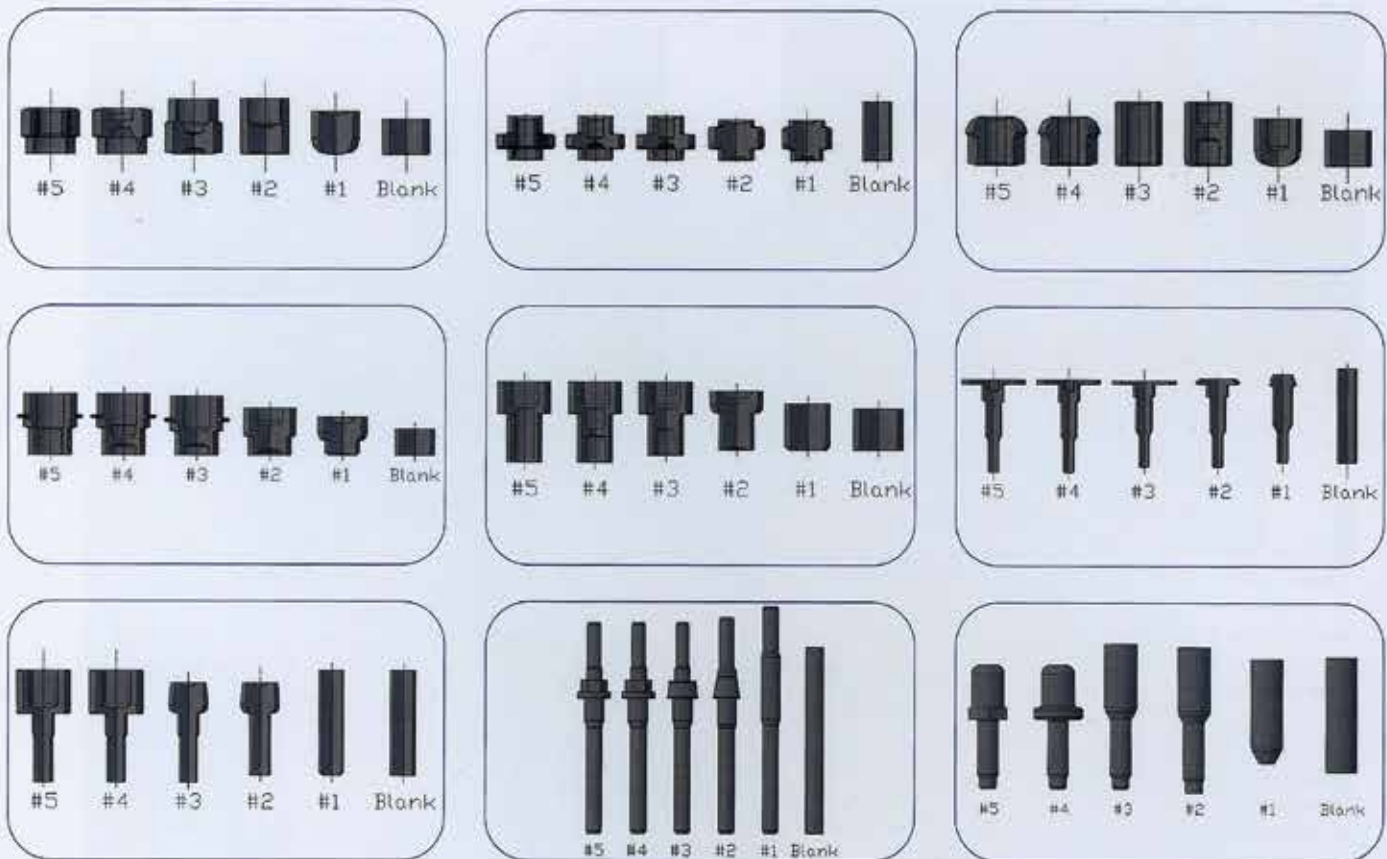
# 5 STATION SPECIAL BOLT PART FORMER BP-SERIES

SPECIFICATION / MODEL	BP10B-5S	BP13B-5S	BP19B-5S	BP24B-5S	BP30B-5S	BP33B-5S	BP36B-5S
FORGING STATION	5	5	5	5	5	5	5
CUT-OFF DIA. (MAX)(MM)	12	16	18	23	30	33	34
CUT-OFF LENGTH (MAX)(MM)	105	130	190	205	270	320	410
KICK-OUT LENGTH (MAX)(MM)	80 (40)	100 (40)	150 (50)	190 (60)	220 (80)	280 (120)	370 (170)
PUNCH KICK-OUT LENGTH (MAX)(MM)	20	20,35,50	35	40	45	50	50
CUT-OFF QUILL(DIA x LENGTH) (MM)	35x56	46x80	60x100	80x100	95x120	105x140	110x155
MAIN DIE(DIA x LENGTH) (MM)	50x95	75x130	90x170	115x205	125x240	145x300	150x400
CENTER DISTANCE BETWEEN DIES (MM)	65	87	114	126	138	156	174
PUNCH HOLE (DIA x LENGTH) (MM)	40x95	60x120	60x122	90x164	90x220	110x250	120x290
RAM STROKE (MM)	160	190	260	320	360	440	520
FORGING POWER (TON)	60	80	120	200	300	400	500
OUTPUT (PCS/MIN) (MAX)	150	130	110	90	70	65	60
MAIN MOTOR (HP)	20	30	50	100	125	150	150
LUBRICATING MOTOR (HP)	1	1	2	2	2	2x2	2x2
COOLING MOTOR (HP)	1/2	1	1	1	1	1	1
LUBRICATION (L)	200	200	300	500	600	800	950
COOLANT (L)	300	300	400	600	700	800	950
APPROX. WT (KG)	13,000	18,000	42,000	58,000	80,000	100,000	125,000
FLOOR AREA REQUIRED (LENGTH x WIDTH) (M <sup>2</sup> )	6.3x4.5	6.8x4.5	7.5x5.5	9x5.5	11x6.5	12X7.0	12x7.5

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## Forming Process



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**BRUNE**  
MACHINERY

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**BP19B-6S**

**A. P.K.O MECHANISM:**

Newly patented design; P.K.O stroke can be individually adjusted simply setting on each station, the P.K.O cam with 3 positions, tools change can be done in short time.



**BP19B-6S**

**B. TRANSFER CHUCK FINGER MECHANISM:**

I-TYPE transfer housing combine with Rotation type, the chuck finger enables to turn 180° or not. In this system, it can be used lifting type finger for large head parts produce.



**BP19B-6S**

**C. KICK-OUT MECHANISM:**

According to customer's need, K.O. length position can be adjusted by hand wheel system or motor control. (Optional)



**BP19B-6S**

**D. PFAS MECHANISM :**

PFAS (Parts Forming Assist System) has been developed for secure transfer support of blanks like short shank parts which are difficult to chuck properly .



**BP19B-6S**

**E. CONVEYOR:**

Adding the 7th chuck finger to clamp the formed blank on specific conveyor, it prevent the damage in surface of the parts.



**BP19B-6S**

**F. TRANSMISSION:**

A-C main motor with transistor inverter, it helps to reach the production speed in the position which can reduce production costs.

**G. FEED LENGTH ADJUSTING SYSTEM:**

According to customer's need, feed length can be adjusted by the servo motor adjusting system. (Optional)



**H. STOPPER LENGTH MECHANISM:**

According to customer's need, stopper length can be adjusted by the servo motor system. (Optional)



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## 6 STATION SPECIAL BOLT PART FORMER BP-SERIES

SPECIFICATION / MODEL	BP13B-6S	BP19B-6S	BP24B-6S	BP30B-6S	BP33B-6S	BP36B-6S
FORGING STATION	6	6	6	6	6	6
NO. OF FINGER'S	7	7	7	7	7	7
CUT-OFF DIA. (MAX)(MM)	φ 16	φ 23	φ 30	φ 34	φ 38	φ 41
CUT-OFF LENGTH (MIN)(MAX)(MM)	19 / 135	15 / 165	30 / 200	40 / 270	45 / 330	50 / 410
KICK-OUT LENGTH (MIN)(MAX)(MM)	100 / 40	120 / 50	160 / 80	220 / 80	280 / 100	370 / 170
PUNCH KICK-OUT LENGTH (MIN)(MM)	20 / 35 / 50	20 / 35 / 50	20 / 40 / 60	25 / 50 / 75	25 / 55 / 80	30 / 60 / 90
CUT-OFF KNIFE (DIA x LENGTH) (MM)	φ 49 x 18L	φ 73 x 28L	φ 85 x 35L	φ 95 x 35L	φ 105 x 37L	φ 115 x 37L
CUT-OFF QUILL (DIA x LENGTH) (MM)	φ 46 x 80L	φ 68 x 100L	φ 95 x 120L	φ 100 x 120L	φ 105 x 140L	φ 115 x 155L
MAIN DIE (DIA x LENGTH) (MM)	φ 75 x 130L	φ 100 x 165L	φ 116 x 184L	φ 125 x 240L	φ 145 x 300L	φ 160 x 400L
CENTER DISTANCE BETWEEN DIES(MM)	87	114	126	138	156	174
PUNCH HOLE (DIA x LENGTH) (MM)	φ 60 x 120L	φ 75 x 142L	φ 95 x 176L	φ 100 x 220L	φ 110 x 250L	φ 120 x 290L
RAM STROKE (MM)	190	260	320	360	440	520
FINGER OPEN UP-SETTING (MAX)(MM)	φ 29 (14.5)	φ 33 (16.5)	φ 43 (21.5)	φ 47 (23.5)	STD. φ 50 UP-SETTING φ 55	STD. φ 50 UP-SETTING φ 55
FORGING POWER (TON)	100	220	280	400	500	600
DIAM. STD BOLT (MAX)	DIN931 M10x100L	DIN931 M18x110L	DIN931 M20x150L	DIN931 M24x200L	DIN931 M27x250L	DIN931 M30x370L
OUTPUT PCS/MINUTE (MAX)	130	90	90	70	60	50
MAIN MOTOR (HP)	40	75	100	125	150	175
LUBRICATION MOTOR (HP)	1	2	2	2	2 x 2	2 x 2
COOLING MOTOR (HP)	1	1	1	1	1	1
LUBRICATION (L)	200	800	800	900	950	1,000
COOLANT (L)	300	600	600	700	700	800
APPROX. WT (KG)	20,000	52,000	65,000	95,000	115,000	145,000
FLOOR AREA REQUIRED (LENGTH x WIDTH) (M <sup>2</sup> )	6.8 x 4.7	9.5(14.0) x 5.5	10.5(15.0) x 6.5	14.0(19.0) x 7.5	16(22.0) x 8.5	19(25.0) x 9.5

\* THE FLOOR AREA MENTIONED DOES NOT INCLUDE THE WIRE STAND.

\* WE RESERVE THE RIGHT TO CHANGE THE DESIGNS & SPECIFICATIONS WITHOUT NOTICE.



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