

We manufacture welded, coated and assembled steel and stainless assemblies for European equipment manufacturers. Work arrives as a drawing and leaves as a finished part — laser cutting, tube cutting, bending, welding, surface finishing and assembly all take place in our own facilities. Around 75% of our output is delivered to customers inside the EU.

1991 Established	54 Employees (48 production)	7,300 m² Production area, two plants	48 h Standard quotation turnaround
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LASER CUTTING — SHEET

MACHINE	TABLE	SOURCE	MAX. THICKNESS
DURMA HD-F 3015 ×1	3000 × 1500 mm	IPG 6 kW	Mild steel 25 mm · Stainless 15 mm · Aluminium 20 mm
DURMA HD-F 3015 ×1	3000 × 1500 mm	IPG 4 kW	Mild steel 20 mm · Stainless 10 mm · Aluminium 12 mm
GWEIKE LF3015GA ×3	3000 × 1500 mm	IPG 3 kW	Mild steel 18 mm · Stainless 8 mm · Aluminium 8 mm

Five sheet lasers in total. Positioning accuracy ±0.05 mm. Automatic nesting from DXF/DWG or STEP.

LASER CUTTING — TUBE AND PROFILE

MACHINE	SECTION	LENGTH	NOTES
GWEIKE GKS-6024TG ×1	Ø20-240 mm round 20-240 mm square / rectangular	up to 6,500 mm	6 kW · bevel cutting ±45° · tube weight to 300 kg · 100 mm minimum offcut

BENDING AND PUNCHING

PRESS BRAKE	FORCE	LENGTH	CNC PUNCHING	FORCE	SHEET
DURMA AD-R 25100 ×3	100 t	2,550 mm	DURMA TP 123 ×1	30 t	2,500 × 1,250 mm
DURMA AD-ES 1240 ×1 servo	40 t	1,250 mm	28 tool stations, indexable. Mild steel to 6 mm, stainless to 3 mm. In-house tool & die shop for eccentric presses keeps repeat-part lead times short.		
HARRIS HPBS-30/1300 ×1	30 t	1,300 mm			

WELDING

ROBOTIC CELLS	QTY	MANUAL WELDING	QTY
6-axis, 1,982 mm reach, ±0.08 mm repeatability Megmeet CM350, air-cooled torch	3	MIG / MAG TIG	5 stations
6-axis, 1,982 mm reach, ±0.08 mm repeatability Megmeet CM500, water-cooled torch	2	Laser welding Spot welding and stud welding also available.	

SURFACE FINISHING

LINE	MAX. PART SIZE	PROCESS
Automatic powder coating	1,600 × 1,700 × 300 mm	Conveyorised, with phosphating, washing and drying pre-treatment
Manual powder coating	3,000 × 1,200 × 400 mm	Larger and low-volume parts, RAL to customer specification
Wet painting	—	For welded steel structures and parts outside powder line dimensions
Hot-dip galvanizing partner	—	Long-term corrosion protection for outdoor or aggressive environments — through established galvanizing partners, managed and scheduled by us
Cold galvanizing partner	—	Zinc-rich coating for repairs, weld seams and touch-up after fabrication

MACHINING AND ASSEMBLY

MACHINE	CAPACITY	ASSEMBLY
HARRIS VMC 966 Linear ×1	Milling 1,000 × 550 mm, 24 tools, Siemens 808D	Assembly stations
		Radial riveting to Ø12 mm
HARRIS SM 205 Swiss-type ×2	Turning to Ø25 mm, 6,000 rpm	Sub-assemblies delivered complete, packed to customer specification.
Eccentric presses ×20+	10-90 t, 4 coil-fed lines	

MATERIALS

Carbon & structural steel	S235JR, S355, DC01-DC04, HR and CR sheet
Stainless steel	1.4301 / AISI 304, 1.4404 / AISI 316L
Aluminium	AlMg3 and equivalent alloys
Coated	Hot-dip and electro-galvanised sheet

Working with us

How enquiries are handled, what we take on, and what we don't

HOW AN ENQUIRY RUNS

STAGE	WHAT WE NEED	WHAT HAPPENS
Enquiry	DXF, DWG or STEP; material, finish, annual volume	We confirm within one working day whether the part is a fit for our equipment. If it isn't, we say so rather than quote around it.
Quotation	—	Costed quotation within 48 hours for standard parts. Where a drawing would be cheaper to make with a small change, we say that too.
Sample	Approved drawing	First article produced and dimensionally checked before series release.
Series	Purchase order or call-off schedule	Scheduled production with agreed batch sizes and delivery windows.

WHERE WE FIT — AND WHERE WE DON'T

A GOOD FIT	NOT A FIT — WE WILL TELL YOU
- Welded frames, chassis and bases - Enclosures, cabinets, covers and guards - Machine panels and structural sub-assemblies - Tube and profile structures with bevelled joints - Painted or powder-coated assemblies delivered ready to fit - Series from a few hundred to several thousand pieces per year - Repeat parts with call-off scheduling	- High-precision machined parts with tolerances tighter than our turning and milling range - Single prototype pieces with no series intent - Sheet thicker than 25 mm or sheets larger than 3,000 × 1,500 mm - Castings, forgings and plastics - Parts requiring processes we do not run in-house <i>A clear "no" costs you a day. A quote we can't deliver on costs you a quarter.</i>

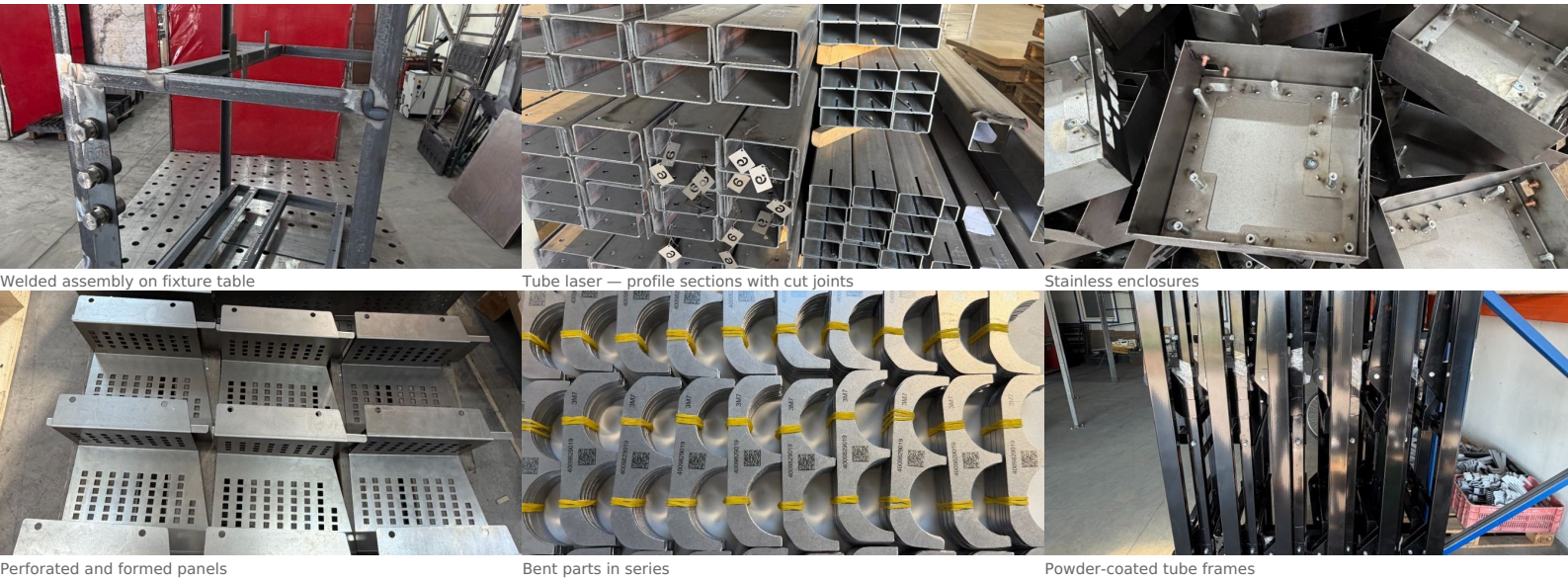
QUALITY

Quality management	ISO 9001:2015 — certificate No. BG/1040Q/0989, issued by International Technical Alliance I.T.A. S.r.l. (IAF 17). First certified 2023, current cycle valid to April 2029.
Measurement	Hexagon TIGO SF coordinate measuring machine (2016), installed on the shop floor rather than in a separate climate room — parts are checked where they are made
Inspection	In-house quality control, first-article inspection on all new parts
Engineering support	Two engineers on staff for design-for-manufacture feedback on customer drawings

CAPACITY AND LOGISTICS

Production staff	48 across two plants	Delivery to Western Europe	Typically 3–5 days by road
Office & engineering	6 — quality, planning, engineering	Export share	Approximately 75% of output
Shift pattern	One shift, second shift available on volume	Energy	200 kW of on-site solar generation

SELECTED WORK



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