Partner for Complex Chassis and Components

Dedicated Production Islands for High-variant Manufacturing

Integrated Process: From precision 2D laser cutting to final welded assembly

Production Islands: Dedicated areas for high-variant chassis and components

Scalable Series: Optimized for medium and large-scale industrial volumes

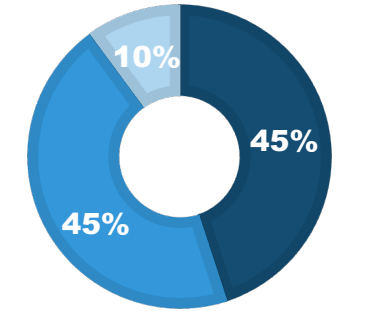
Core Industries: Strategic partner for Material Handling, Automotive and other key industries

CASTA carpenteria meccanica · STAMIN Stampaggi Industriali · acier plus

Company Profiles

GROUP

Casta

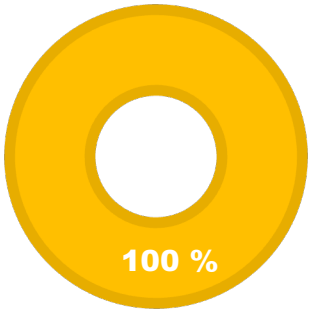


Chiara Cazzolla

Andrea Cazzolla (CEO)

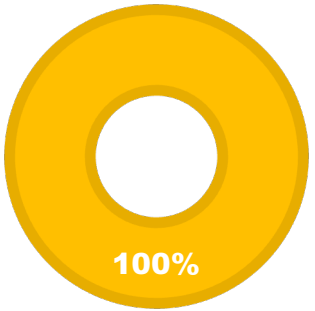
Anna Calogiuri

Stamin



Angelo Cazzolla (CEO)

AcierPlus



Angelo Cazzolla (CEO)

Company Profiles

GROUP

NUMBER OF LOCATIONS

LECCE (IT)
SURBO (IT)
ANCENIS (FR)
HÉRICOURT (FR)

NUMBER OF EMPLOYEES

CASTA	52
STAMIN	20
ACIERPLUS	18

DIRECT WORKERS

CASTA	145
STAMIN	88
ACIERPLUS	46

INDIRECT WORKERS

CASTA	29
STAMIN	20
ACIERPLUS	26

PRODUCTS / VARIANTS NUMBER

VARIANTS	970
PRODUCTS	5.963.500

ANNUAL 2025 TURNOVER € MILLION

CASTA	€ 40,1 MIO
STAMIN	€ 10,2 MIO
ACIERPLUS	€ 14,2 MIO

CASTA carpenteria meccanica STAMIN Stampaggi Industriali acierplus

History

1980-2026

1980
Foundation of Stamin

1992
Foundation of ACIERPLUS

2005
Foundation of CASTA

2006
Enter new buisness

2017
NEW clients / sectors

2018
First Trumpf Laser center

2019
Takeover AcierPlus

2021
Casta: 44,9 million €
Stamin: 7,6 million €
AcierPlus: 14,5 million €

2022
- Implement 2 CNC centers
- Robot area with visual Kanbansystem
- IWI / Welding teacher

Casta: 54,9 million €
Stamin: 8,3 million €
AcierPlus: 18,6 million €

2023
- 3D Laser
- 6 axis CNC Center
- Sandblasting machines
- New Storage with ERP Warhouse Management

Casta: 52,1 million €
Stamin: 9,2 million €
AcierPlus: 17,9 million €

2024
- Start with Lean production
- 5040 Trumpf Laser

Casta: 40,3 million €
Stamin: 7,5 million €
AcierPlus: 13,3 million €

2025
- Fully automatic pressline
- Grinding Robot
- 2 new Welding Robot areas with visual Kanbansystem

Casta: 40,1 million €
Stamin: 10,2 million €
AcierPlus: 14,2 million €

Quality

Certifications

IATF 16949 (Automotive)	CASTA - STAMIN
ISO 9001	CASTA - STAMIN - ACIERPLUS
ISO 14001 (Environment)	CASTA - ACIERPLUS
ISO 45001 (Safety)	CASTA - STAMIN - ACIERPLUS
Ecovadis	CASTA - ACIERPLUS
UNI EN ISO 3834-2 (Welding)	CASTA - STAMIN - ACIERPLUS
UNI EN ISO 15085-2 (Railway)	CASTA - STAMIN - ACIERPLUS
ISO 9606-1 (Welding)	CASTA - STAMIN - ACIERPLUS
Marking transfer	ACIERPLUS
Welding	CASTA (IWE / IWI)
Welding	STAMIN (2x IWI)
Welding	ACIERPLUS (2x IWT)
UNI EN ISO 9712 VT (Welding)	CASTA (8) - STAMIN (4)
UNI EN ISO 9712 PT (Welding)	CASTA (4) - STAMIN (3) - ACIERPLUS (2)
UNI EN ISO 9712 MT (Welding)	CASTA (5) - STAMIN (2) - ACIERPLUS (2)
UNI EN ISO 9712 UT (Welding)	CASTA (1) - ACIERPLUS (2)
UNI EN ISO 9712 RT (Welding)	CASTA (1)

Production Quality and Measurement

Metrology and Control Room

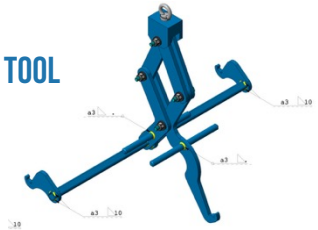
- **Advanced metrology:** Utilizing portable and automatic machines for precise component verification
- **Specialized testing:** Dedicated equipment for magnetic tests and macrographic weld examination
- **Data analytics:** Integrated software for statistical measurement and continuous quality tracking

Engineering, Tooling & Custom Logistics

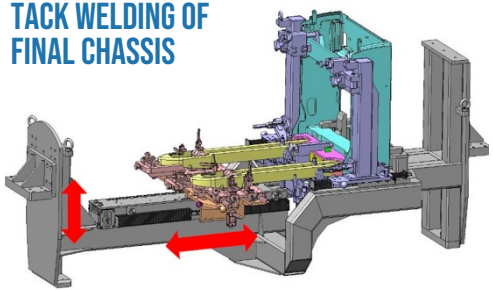
From Feasibility Studies to Customized Logistics & Handling

- **Expert team:** 28 engineers and 20 mechanical experts focused on jig design and prototype industrialization
- **Design software:** Integrating industry-standard tools including AutoCAD, Solid Edge, and Pro/Engineer
- **Certified solutions:** Developing specialized lifting tools and final chassis welding jigs
- **Automated systems:** High-level jigs with integrated sensors for automatic program selection and variant detection

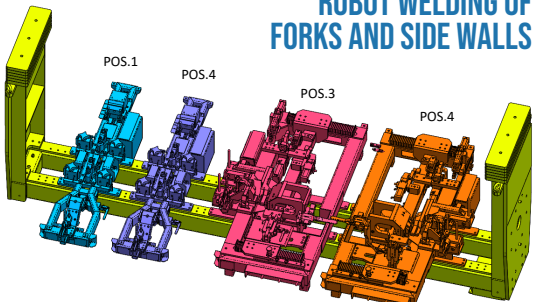
CERTIFIED LIFTING TOOL



TACK WELDING OF FINAL CHASSIS



ROBOT WELDING OF FORKS AND SIDE WALLS

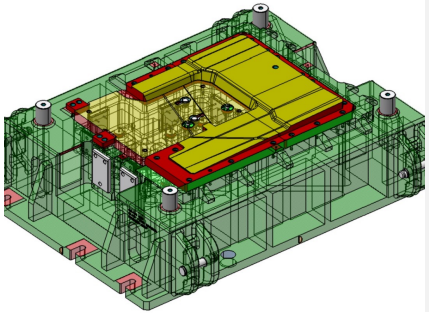


Engineering, Tooling & Custom Logistics

From Feasibility Studies to Customized Logistics & Handling

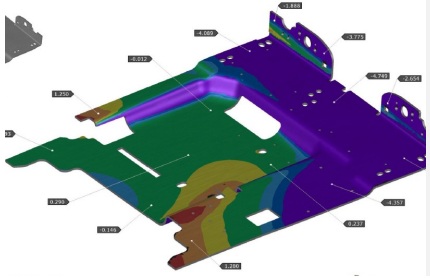
Stamping Die Design & Construction:

In-house expertise for the development and manufacturing of high-precision stamping dies



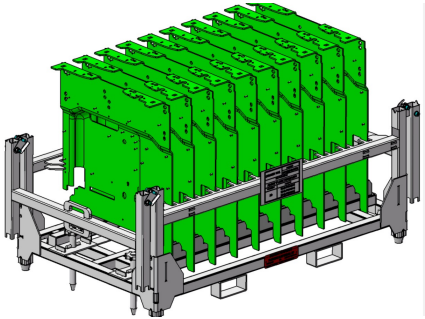
Process Optimization:

Ensuring long term tool life and consistent part quality by tool inserts



Feasibility Study:

Advanced simulation and analysis to optimize part geometry and material usage during tool design



Specific Rack Design:

Development of transport and storage racks, specifically engineered for complex geometries and automatic handling

Workforce Training and Development

Comprehensive Education Program for 2023–2026

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Introducing Lean Production

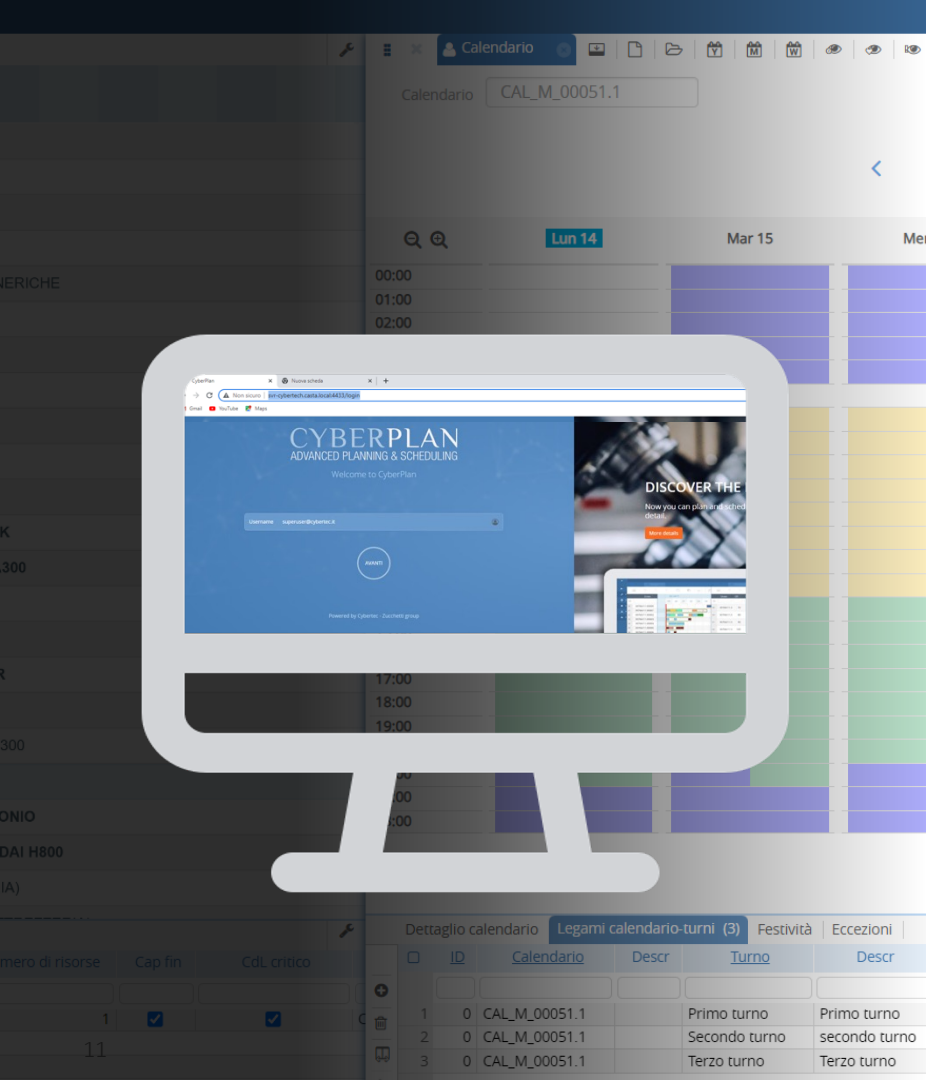
Implementing Core Elements of Continuous Improvement

We started with Lean production

- **5S Methodology:** Organizing the workspace to improve safety, efficiency, and visual clarity
- **Process Standardization:** Establishing clear standards to ensure consistent and repeatable quality
- **Kaizen Method:** Promoting a culture of continuous, incremental improvements across all operations
- **Lean Logistics:** Optimizing storage and material flow to reduce waste and lead times

Advanced Planning and Scheduling

Strategic Simulation and Production Optimization



- **Optimized production flow:** High-capacity processing designed for maximum throughput and efficiency
- **Strategic Simulation and Production**
- **Process standardization:** Streamlining the end-to-end planning and scheduling workflow
- **Capacity management:** Analyzing production across all terms to identify and resolve bottlenecks
- **Impact simulation:** Modeling disturbances like machine downtime or material shortages in real time
- **Proactive solutions:** Developing data-driven proposals to maintain consistent production flow

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Customer Portfolio and Sector Expertise

Strategic Partnerships across Leading Global Industries

FORKLIFT

STILL
TOYOTA
FENWICK
Linde Material Handling Linde
JUNGHEINRICH
carer Electric Forklift Trucks
MANITOU GROUP
Stöcklin Home of Intralogistics
FRITZMEIER Group

AGRICULTURE

KUHN
CNH INDUSTRIAL
YANMAR
kverneland group
RAUCH

PAVING/LIFTING

BOMAG FAYAT GROUP
MAGNI TELESCOPIC HANDLERS
HYVA We move your world
cmc THE SPECIALIFT
RUTHMANN
OIL&STEEL Valla MANITEX INTERNATIONAL

RAILWAY

ALSTOM
vossloh
mermec AN ANGEL COMPANY
TESMEC RAIL

AUTOMOTIVE

BAOWU BAOMARC
STELLANTIS

OTHERS

LECTRA
TRUMPF
RAIGI

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STAMIN Stampaggi Industriali
acier plus

Customers and Transport in Europe

Map

GERMANY

STILL	Hamburg
LINDE	Aschaffenburg
Jungheinrich	Moosburg
Boomag	Boppard

FRANCE

MANITOU	Beaupréau
FENWICK	Cenon
KUHN	Saverne
Alstom	Saint-Quen
Toyota	Vaucresso
Lectra	Cestas
Vossloh	Reichshoffen

GREAT BRITAIN

CNH	Basildon

TURKEY

A.S	Balikesir

ITALY

STILL	LUZZARA
CARER	Cotignola
CNH	Modena
Marini	Alfonsine
Magni	Castelfranco
CMC	Bari
HYVA	Poviglio

CZECH REP.

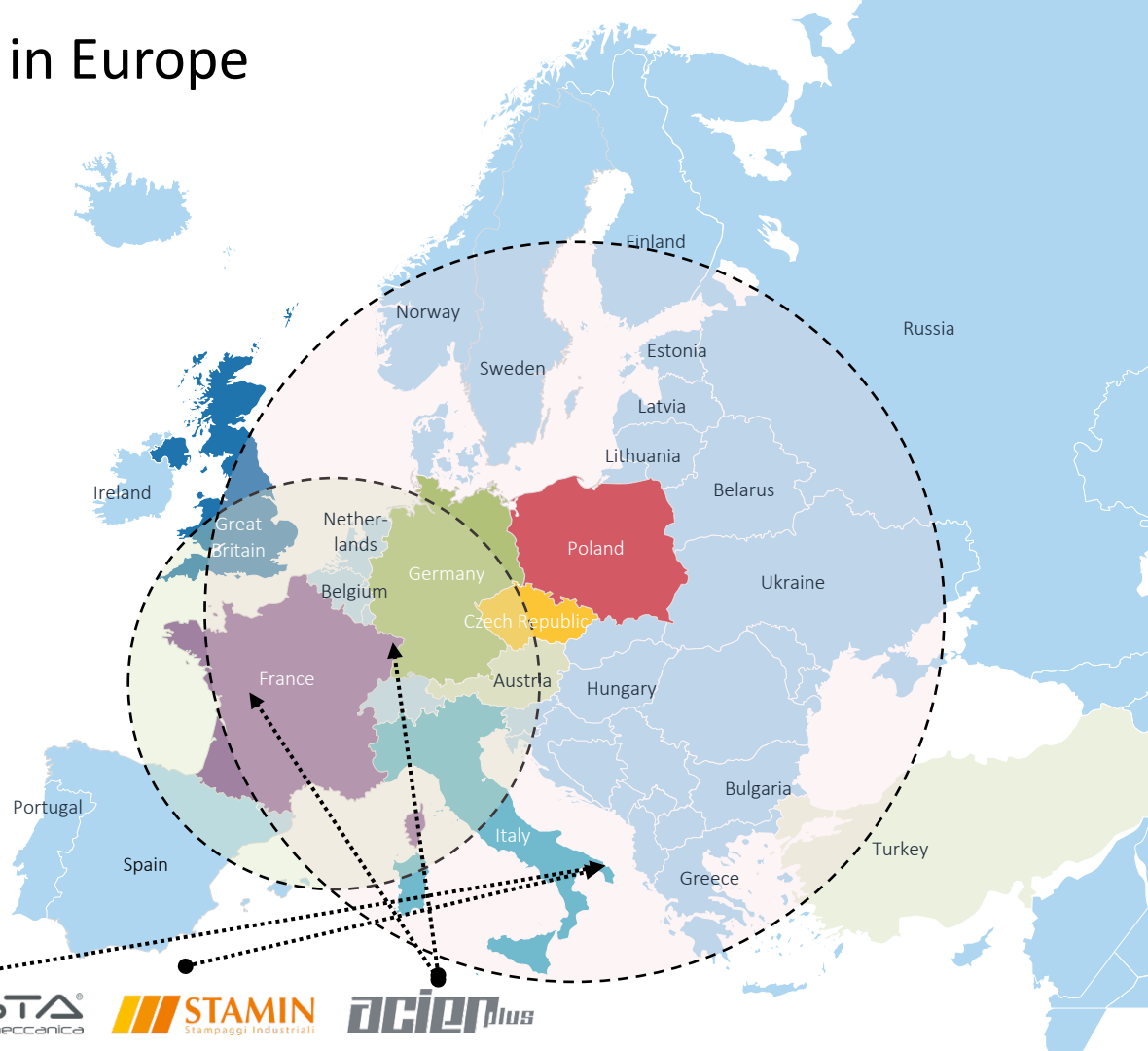
Fritzmeier	Vyskov
Linde Pohony	Stribro

POLAND

KION	Kolbaskowo

BELGIUM

CNH	Zedelgem



2D Laser Cutting Center

Integrated Cutting and Automated Storage Solutions

- **High-performance laser systems:** Trumpf fiber and CO2 technology reaching up to 12 kW
- **Automated material handling:** LiftMaster and SoftMaster systems for seamless, 24/7 operation
- **Intelligent storage solutions:** Automated warehouse with 413 drawers for raw and semi-finished stock
- **Optimized production flow:** High-capacity processing designed for maximum throughput and efficiency

Fully Automated High-tonnage Stamping

Maximum Power & Robotic Precision

Heavy-Duty 1,600 t Hydraulic Press

- **Massive Force:** Capable of forming large-scale parts and high-strength materials
- **Precision Performance:** Advanced hydraulic control for complex geometries and consistent quality

Advanced 4-Robot Handling System

- **Efficiency:** 2 Loading Robots with floating functionality for precise positioning
- **Seamless Extraction:** 2 Unloading Robots for high-speed part removal and organized stacking
- **Fully Synchronized:** Real-time communication between the press and all 4 robots for an optimized cycle time

Minimized Downtime & Setup

- **Rapid Die Change:** Double pallet system allowing for ultra fast tool changes and maximum machine utilization
- **High-Volume Ready:** Engineered for high-speed series production with minimal manual intervention

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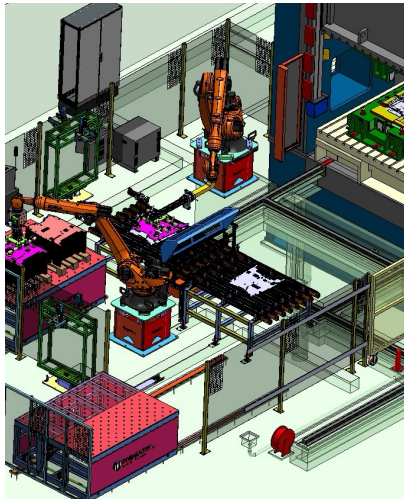
Fully Automated High-tonnage Stamping Line

Maximum Power & Robotic Precision

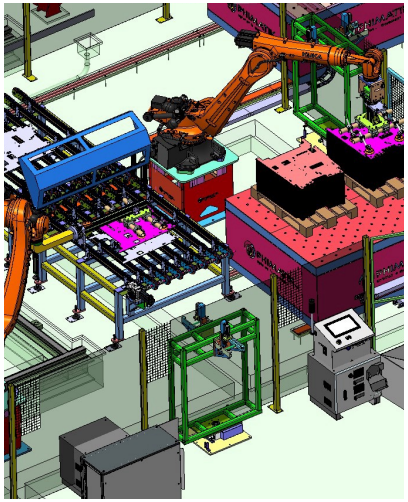


Automated workflow design:

Seamless layout for 2 loading and 2 unloading robots to ensure maximum throughput

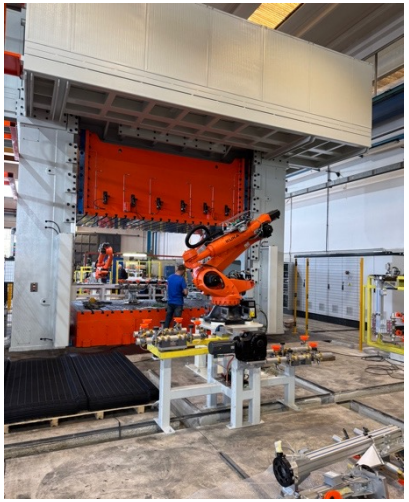
Heavy press integration:

1,600 t hydraulic press center, fully synchronized with automated handling



Fully automated cycle:

Zero manual intervention from blank loading to finished part stacking



Rapid changeover:

Double pallet system for minimized downtime during die changes

Advanced 2D & 3D Laser Cutting

Precision Contours for Complex Geometries

High-Performance 3D processing

- **Complex geometries:** Precision trimming and hole patterns in preformed or deep drawn components
- **Ultimate flexibility:** Rapid processing of complex 3D contours without the need for expensive mechanical cutting dies
- **Series:** medium and high-volume series production

Before

After 3D cut

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Smart Manufacturing & Lean Production Excellence

High complexity Assemblies | Lean Standards

Lean production & High efficiency flow

- Dedicated production islands
- One piece flow
- Variants management by flexible jigs
- No stock of subassemblies in warehouse
- Parts supply in kanban from warehouse
- Fast throughput time (1 day for all series variants)

Intelligent robotic welding & Jig technology

- Smart variant recognition
- Error proofing (Poka yoke)

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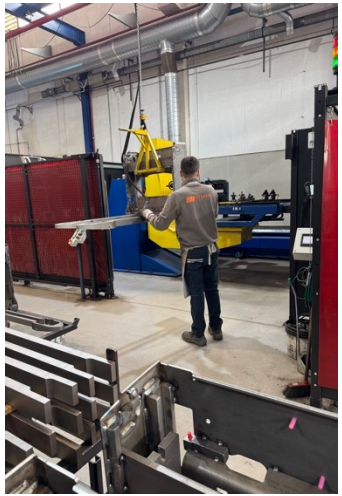
Smart Manufacturing & Lean Production Excellence

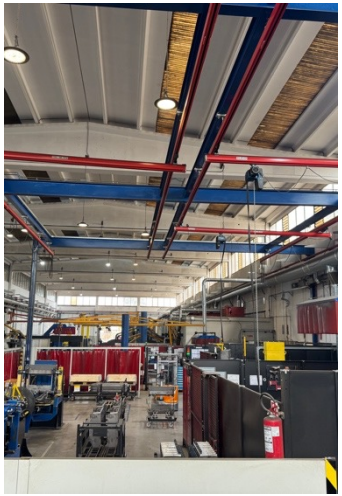
Lean Production & High efficiency Flow



- Integrated **KBK systems** and custom-engineered lifting tools for maximum efficiency and safety

- Continuous improvement driven by **5S, TPM, and lean production** principles

- **Optimized layouts** for complex chassis and welded assemblies



- Demand driven supply via **Supermarket & KANBAN** systems

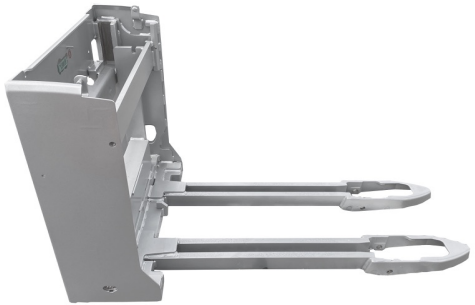
- High-level jigs with **integrated sensors for automatic program selection** and variant detection

Complex welded Assemblies & Chassis Structures

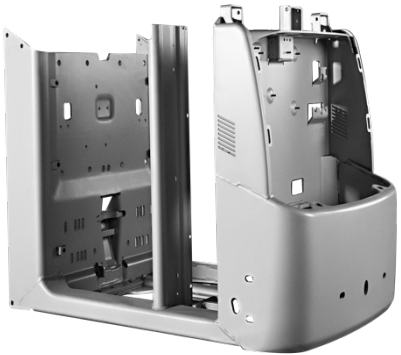
Quality driven Production of Critical Welded Components

Expertise in complex welding

- **Full chassis:** Specialized in the production of high strength chassis frames for material handling and industrial vehicles
- **Components:** Precision welding of safety critical parts or complex geometries



- Mobile Chassis



- Chassis

- Chassis

- Tiller arm

Precision Robotic Grinding & Surface Finishing

Automated Grinding for Aesthetic Components

Smart surface processing

- **Automated grinding cabin:** Fully enclosed robotic cell for consistent, high-quality surface finishing
- **Integrated measurement system:** High precision sensors calculate the exact material removal required for a perfect finish and dimensional precision

Aesthetic & Quality focus

- **Surface finish:** Ideal for components with high aesthetic requirements
- **Perfect paint preparation:** Ensures a flawless surface for subsequent coating and painting processes
- **100% Consistency:** Eliminates the variability of manual grinding, ensuring every part meets the exact same standard

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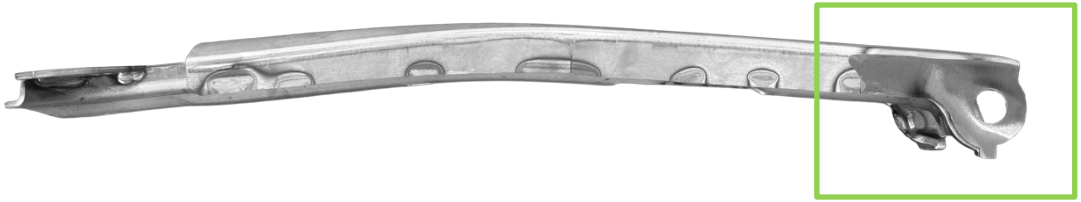
Precision Robotic Grinding & Surface Finishing

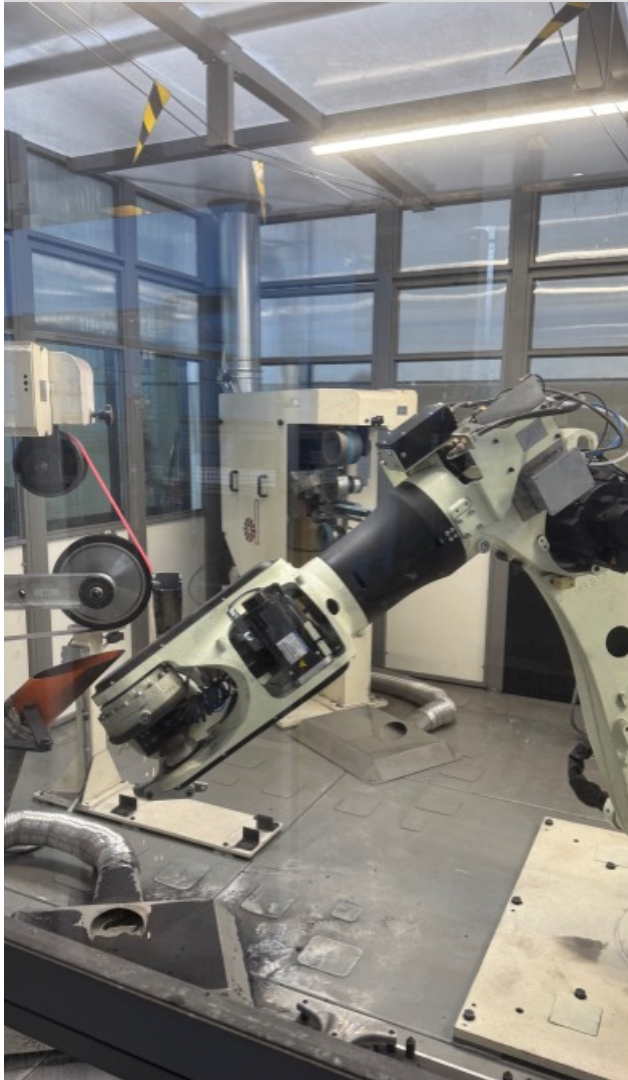
Automated Grinding for Aesthetic Components

Delivering 30.000 units per year

Tiller arm: Before grinding

Tiller arm: After grinding





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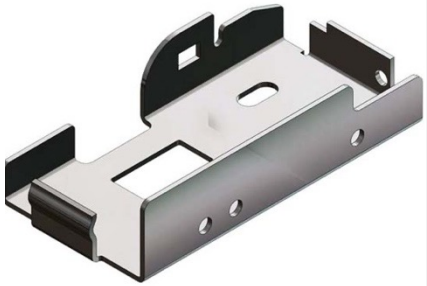
Advanced Bending and Robotic Automation

Precision Forming from Manual Work to Fully Automated Solutions



- **Manual flexibility:** A fleet of six manual machines for specialized and versatile processing

- **CNC rolling:** Precision rolling up to 3 m widths utilizing the Easy Roll system

- **Bending Trumpf Machine** automatic change punch and die **+ KUKA Robot** for bending

- **Heavy-duty capacity:** High-force bending up to 1,600 tons and 13 m in length

CASTA carpenteria meccanica STAMIN Stampaggi Industriali acier plus

Plasma and Flame Cutting

High-capacity Processing for Material up to 250 mm

- **Versatile grades:** Certified processing for steel from S235 up to high-strength 1100QL

- **Plasma technology:** Dual 3D heads for precision chamfering on 36 x 5 m sheets

- **Large-scale capacity:** Optimized for large-format components and complex edge preparation

- **Flame cutting:** Eight-head configuration for heavy plates up to 250 mm thick

High Precision CNC Machining

Ensuring Perfect Fit for Complex Assemblies

Technical excellence

- **Integrated processing:** Multi-axis CNC milling and turning for welded structures
- **Clamping:** Tower clamping to reduce cutting tool change time
- **Efficiency:** Pallet system or double workstations

Advantages

- **Vertical integration:** Full control of the value chain and flexibility
- **Assembly ready**: Components are delivered 100% ready for final assembly line
- **Time savings:** Reduced lead times through inhouse mechanical finishing

Calibration and System Precision

Maximizing Accuracy in Large-scale Fabrication

- **Precision drilling:** High-accuracy control for 6,000 x 2,400 mm components
- **Roller leveling:** Eliminating material stress to achieve superior flatness
- **Hydraulic adjustment:** Fine-tuned leveling utilizing advanced actuator technology
- **Quality assurance:** Ensuring consistent tolerances through rigorous calibration

Advanced Warehouse Management & Smart Logistics

Digital Integration & ERP Connectivity

Scan-to-track: reliable barcode integration in every step.

- **Real time synchronization:** Full integration between our ERP and Warehouse management system for seamless data flow
- **Smart inventory tracking:** Automated control of all stock movements, ensuring 100% material availability for production

Vertical storage & KLT management

- **Vertical storage:** High density storage to maximize space and ensure a clean, organized warehouse
- **KLT integration:** Systematic storage of small parts and components in standardized (KLT) for optimized handling and transport

Operational benefits

- **Full traceability:** A complete digital footprint of every component from receipt to final assembly
- **Efficiency & Speed:** Faster retrieval cycles through "goods-to-person" technology, reducing internal lead times

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Key Technology

Strategic Providers

CASTA

- 2D laser cutting
- Robot and manual bending
- Machining up to 6 axis
- Robot welding
- Manual welding
- Tank production and assembly
- Jig design / construction

STAMIN

- Stamping up to 1600t
- Manual bending
- 3D laser cutting
- Machining up to 6 axis
- Robot welding
- Manual welding
- Robot grinding
- Stamp /Jig design & construction

Acierplus

- Flame cutting
- Plasma cutting
- 2D laser cutting up to 13m
- Bending up to 13m
- Machining up to 5 axis
- Robot welding
- Manual welding
- Calibration

Thanks for Your attention!

Stay tuned

Agile methodology promotes an environment of **adaptation, teamwork, self-organization** and rapid delivery that allows for a high level of customer involvement early in project planning

Winston Churchill (Former British Prime Minister)

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