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MACHINERY: AMMO LINE: TOOLING



About Us

Atesci is a manufacturer of ammunition production machines. Atesci has been in ammunition machinery business for over 17 years. In the early years Atesci started by manufacturing lead-based products for the hunting industry. Its first products were lead shots, buckshot and slugs and it commercialized these products in domestic and international markets. Besides all these Atesci has designed and developed a lead processing plant of its own, for the main material of hunting ammunition is lead wire. Lead wire extrusion plant was among the first machinery that led Atesci into being a machine producer. With its unique design of lead shot production plant Atesci enjoyed the taste of being an inventor and a designer. This success was followed by other machinery used in the production of hunting ammunition.

Realizing the surge of demand for machinery in the ammunition production industry, Atesci focused its attention towards designing and manufacturing those machinery. Considering the lead-based component demands of the Defence Industry, Atesci diversified its product range with a series of ammunition machinery such as Lead Core Press, Case Grooving and Trimming machines. Accumulating experience over time Atesci steered itself towards designing a more complicated machine of Full Metal Jacket (FMJ) press of its own which contributed a lot to Atesci's machinery inventory. Subsequently, Atesci took part in the production of ammunition components such as FMJ bullets based on the demand in the market.

Meanwhile Atesci designed, manufactured and supplied many individual machines from its early inventory to all around the world including USA, Canada and European countries. Atesci machines are now running in various companies in Indiana, Wisconsin, Idaho, Arkansas and Utah in the USA and also in Canada, Italy, Russia, Pakistan, Bosnia Herzegovina, Hungary, Philippines, India, Kazakhstan, Lebanon, El Salvador and Namibia.

In the course of time accumulating all and necessary competence, Atesci indulged more in designing and building other machines that an ammunition production line is composed of. First machines to follow the FMJ press were loading machines, annealing and washing units. In 2016 Atesci has completed the 9x19 mm cartridge line

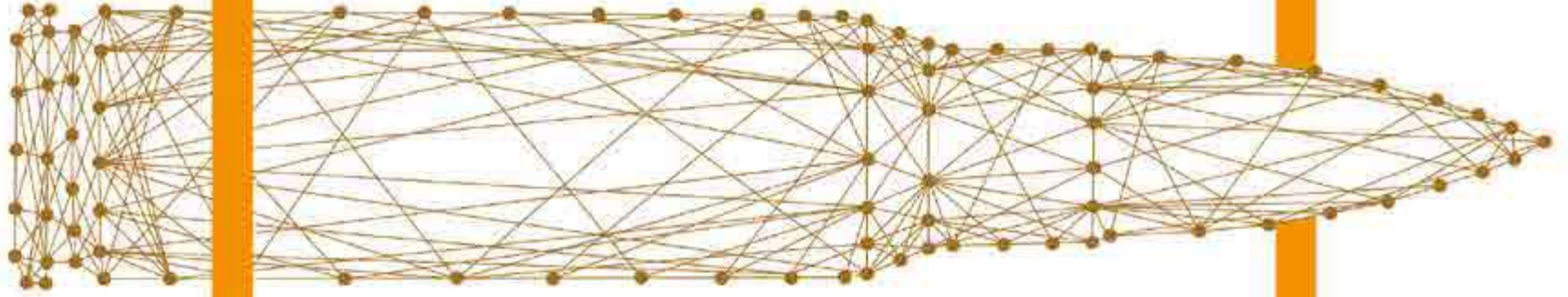
including case, FMJ and loading sections with all their machinery as its own design and production. Atesci presently has the capacity to build interlinking ammunition lines by manufacturing all the machinery, presses and automated machines as well as the mould and punch sets that are part of those machinery.

Since 2017 Atesci has concentrated on turn-key projects for ammunition production lines. Being a relatively new member of an old established ammunition industry of the 19th century, Atesci is in the market now competing with prominent fellow companies in all respects by taking advantage of its internal dynamism, design superiority and being located in the heart of Turkey's defence industry in Ankara. In addition to affordable costs and reliable quality with shorter lead times Atesci added one more aspect to this competition by designing and developing all the machinery of an ammunition production line. This capability provides a potential customer to acquire everything required to start ammunition production from only one supplier including supporting machinery which are usually outsourced such as 100% Inspection Unit, Mouth Annealing Unit, Tip painting Unit, Eye Inspection Unit, Packaging Unit etc. All these advantages enable Atesci to offer faster and cost-effective solutions in comparison to its competitors. Atesci keeps a close eye on the market and is well aware of the current needs and requirements in the sector.

Atesci participates in defence exhibitions of IDEF in Istanbul, DSEI in London, Eurosatory in Paris and DSA Kuala Lumpur once every two years and every year in the exhibitions of Shot Show in Las Vegas and IWA in Germany and exhibits its machinery for visitors in a close follow-up on the latest developments and progresses. Atesci also attends to international trade shows of the Defence and Weapons Industry.

With the progress Atesci is accomplishing every year and relying on its creativity and dynamic design capabilities it is aiming for the sky. So, Atesci intends to take a better stance in the ammunition sector by evolving into a versatile, multifaceted and multidisciplinary company. This means that Atesci displays this new approach of being a provider of complete lines in all aspects. Coupling with the Integrated Project Approach or Holistic Approach all these will develop the company into a solution partner in provision of all other elements in addition to machinery.

We proceed with science



We have been growing with
the power of science for 19 years,
we are building ammunition
production lines in national and
international environments with
the integrated technologies
we have developed.

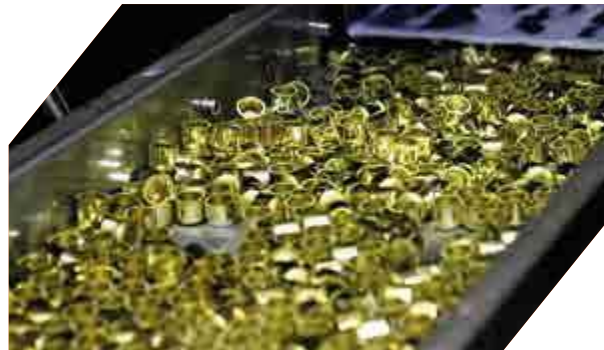
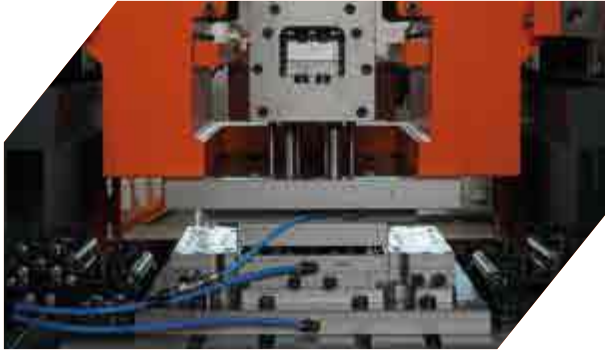
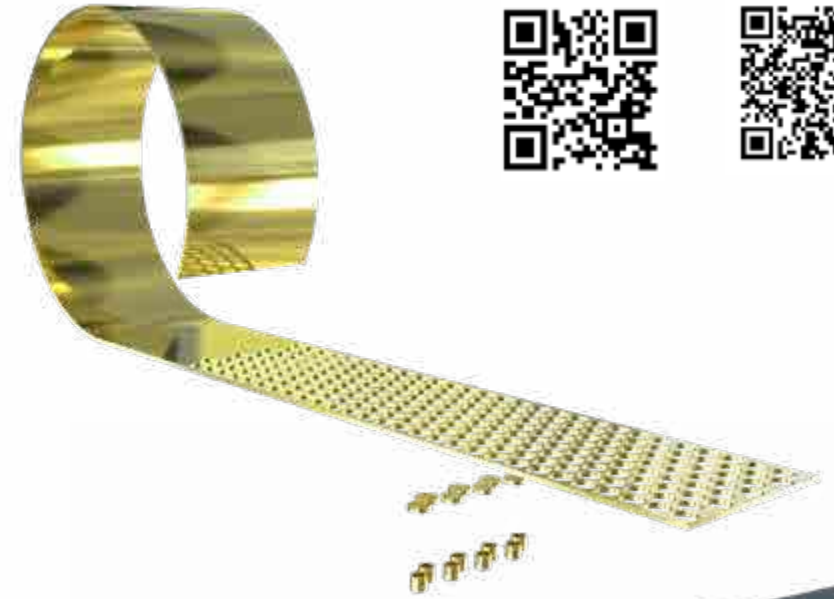
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BLANKING AND CUPPING PRESS

This press is a vertical double action press which cuts and turns metal strip into metal cups. There are two nested eccentrics in the press enabling two actions in one stroke. Just after metal discs are cut out in the first action, the second action swages these discs into cups. The 4 Guides Slide System is designed not to lose accuracy even under extreme conditions. It is a fully automated PLC controlled machine. The machine is equipped with different types of sensors placed on various points. In this way it runs in synchronized with Strip Straightener and Coil Winder. The user-friendly touch LCD screen not only monitors the performance of the machine but also enables operator to control and configure the production.



The capacity of the press depends upon the number of tools which vary by different calibers.



STRIP DE-COILER

Coil Driver is used for decoiling and driving metal strip into strip straightener. It is equipped with sensors enabling it to run synchronized with Strip Straightener and Double Action Press.



STRIP STRAIGHTENER

Strip Straightener rectifies metal strip and feeds it into Double Action Press.



STRIP WINDER

Coil Winder is used for winding scrap strip coming from cupping press. It facilitates recycling process of scrap strip.

Technical Specifications

Capacity	80	RPM
Power	20	kW
Voltage	380	VAC
Air Pressure	6	BAR
Tonnage	100	Metric Tons
Dimensions (WxDxH)	2350x2800x3870	mm
Weight (Appox.)	13500	KG
Overload Prevention	Hydraulic and Pneumatic	
Clutch Brake System	Pneumatic	
Mold Cooling	Coolant-Recirculated	
Mechanical Lubrication	Liquid Oil-Recirculated	
Heat Treated Steel Body		
Safety Guard		
4 Guides Slide System		

CASE PRESSES

Case Press is a vertical H type press which is used for production of cartridge cases. It is capable of drawing, length-cutting, indenting, firehole piercing, stamping, tapering and necking of cases depending on the sequence of operation or the caliber to be produced. The 8 Guides Slide System is designed not to lose accuracy even under extreme conditions. It is a fully automated PLC controlled machine. The machine is equipped with different type of sensors placed on various points. The user-friendly touch LCD screen not only monitors the performance of the machine but also enables operators to control and configure the production.

Technical Specifications for Pistol Calibers

Capacity	100	RPM
Power	20	kW
Voltage	380	VAC
Air Pressure	6	BAR
Tonnage	75	Metric Tons
Dimensions (WxDxH)	4110x4190x3190	mm
Weight (Appox.)	13500	KG
Clutch Brake System	Pneumatic	
Mold Cooling	Coolant-Recirculated	
Mechanical Lubrication	Liquid Oil-Recirculated	
Heat Treated Steel Body		
Safety Guard		
4 Guides Slide System		



Case Press for pistol calibers



Technical Specifications for Case Drawing Press

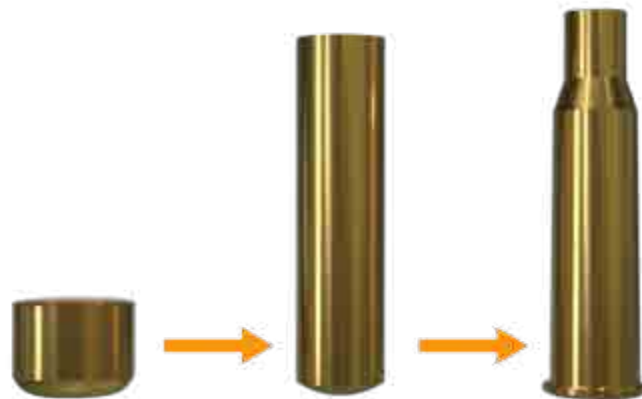
Capacity	100	RPM
Power	20	kW
Voltage	380	VAC
Air Pressure	6	BAR
Tonnage	80	Metric Tons
Dimensions (WxDxH)	3865x4190x3190	mm
Weight (Appox.)	13000	KG
Clutch Brake System	Pneumatic	
Mold Cooling	Coolant-Recirculated	
Mechanical Lubrication	Liquid Oil-Recirculated	
Heat Treated Steel Body		
Safety Guard		
4 Guides Slide System		

Technical Specifications for Case Forming Press

Capacity	100	RPM
Power	19	kW
Voltage	380	VAC
Air Pressure	6	BAR
Tonnage	80	Metric Tons
Dimensions (WxDxH)	4050x3040x3190	mm
Weight (Appox.)	13000	KG
Clutch Brake System	Pneumatic	
Mechanical Lubrication	Liquid Oil-Recirculated	
Heat Treated Steel Body		
Safety Guard		
4 Guides Slide System		



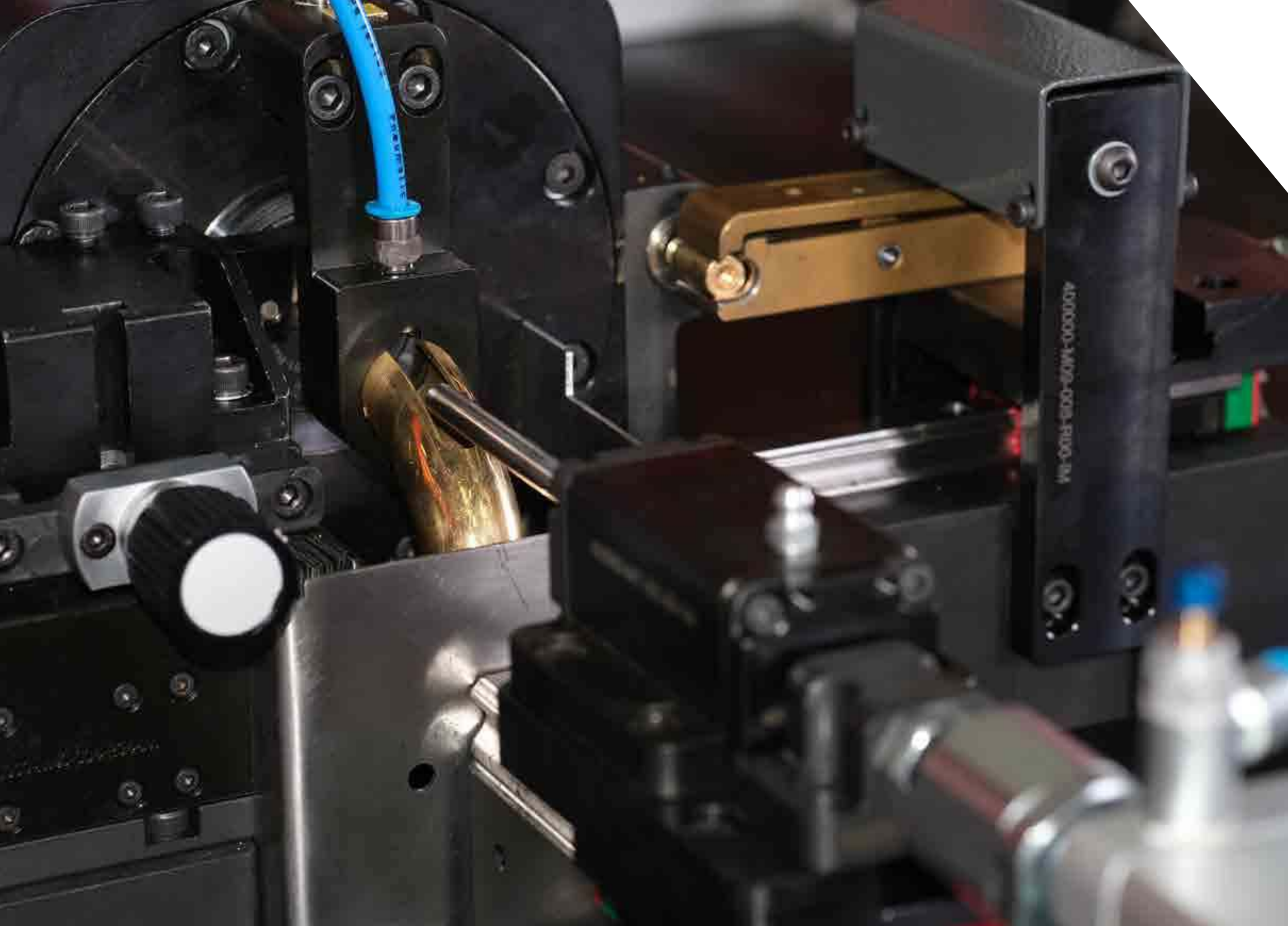
Case Press for rifle calibers



Drawing Press

Forming Press



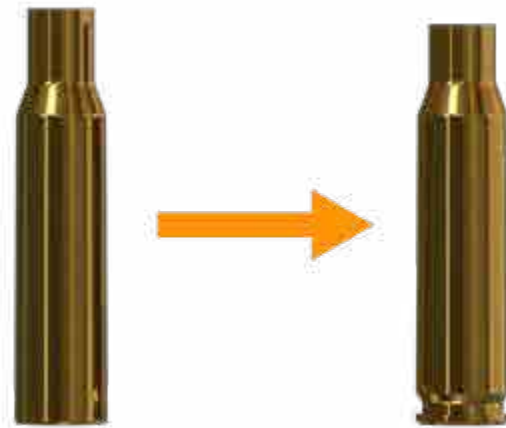


HEAD TURNING & FINISH TRIMMING MACHINE

Head Turning and Finish Trimming Machine is an automatic lathe dedicated for trimming and grooving of cartridge cases. The machine is fitted with a collar loading the semi-finished cases into the feeding chute and they are carried one by one onto rotating spindle by means of a gripper. The cases are fixed with a collet and both trimming and grooving operations are carried out simultaneously here. The cases are rotated in a slotted drum to be separated from chips and shavings.

Technical Specifications for Head Turning & Finish Trimming Machine

Capacity	70 RPM
Power	3,2 kW
Voltage	380 VAC
Air Pressure	6 BAR
Dimensions (WxDxH)	1870x1720x2600 mm
Weight (Appox.)	1500 KG
Servo and or Pneumatic Driven Parts	
Chips Separation Drum	



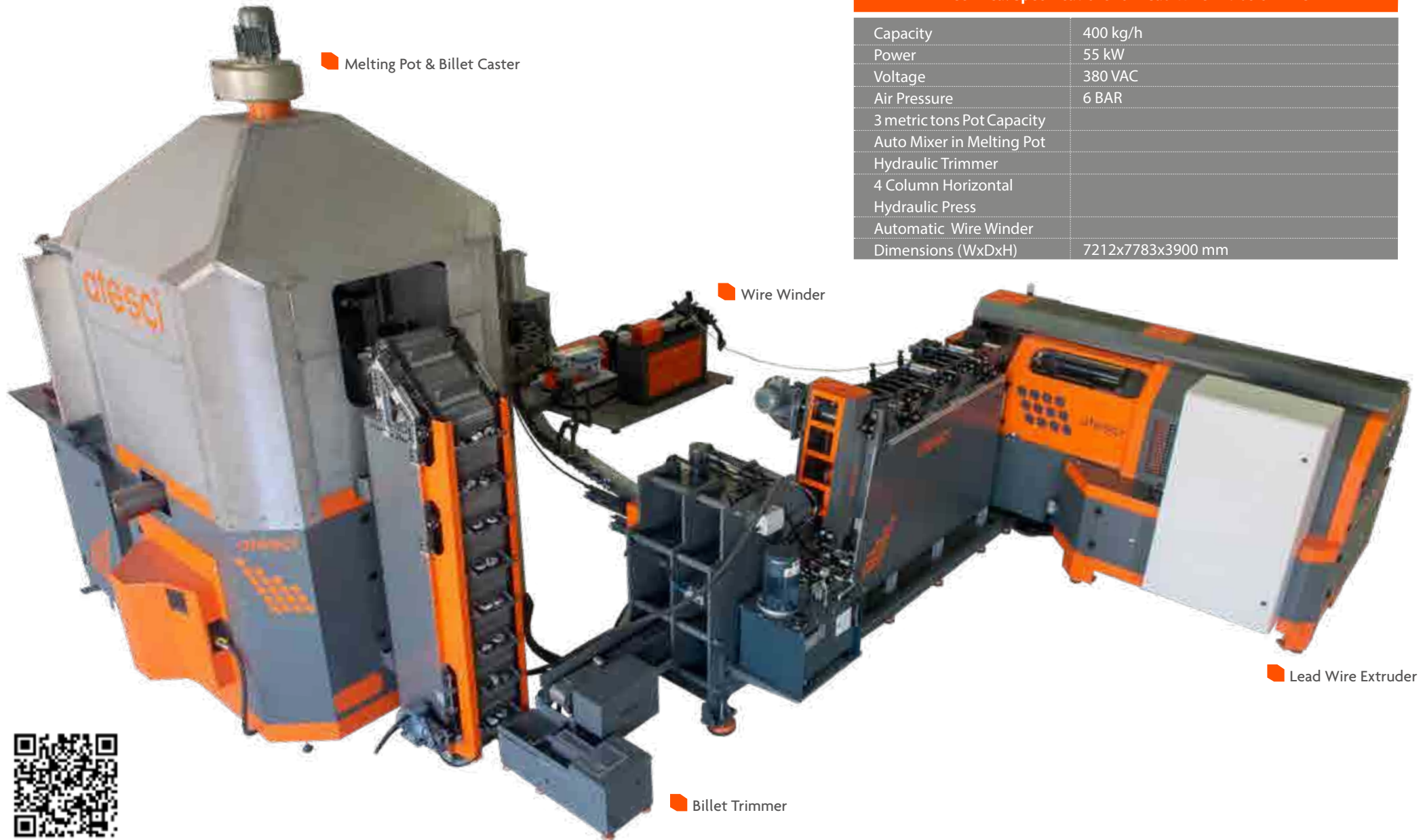
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LEAD WIRE EXTRUSION LINE

Lead Wire Extrusion Line is designed only for smelting lead, casting lead billets, extrusion and winding of lead wire. Lead ingot or scrap lead is fed into the Melting Pot by means of a forklift or/and a crane. After melting lead alloy in the pot, liquid lead is cast into cylindrical molds and ejected onto a conveyor via a pneumatic piston.

The billets are automatically carried to the Trimmer and after resizing operation they continue their movement towards the Extruder. In the Extruder they are converted into lead wire ending up on the spool of the Winder. Scrap lead from Trimmer conveyed to the Melting Pot to be recycled.



Technical Specifications for Lead Wire Extrusion Line

Capacity	400 kg/h
Power	55 kW
Voltage	380 VAC
Air Pressure	6 BAR
3 metric tons Pot Capacity	
Auto Mixer in Melting Pot	
Hydraulic Trimmer	
4 Column Horizontal Hydraulic Press	
Automatic Wire Winder	
Dimensions (WxDxH)	7212x7783x3900 mm



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10000-M25-010-R00-IM

Ø8 mm WIRE DRIVE REEL

10000-M03-017-R00-IM

Ø6 mm WIRE DRIVE REEL

10000-M03-017-R00-IM

10000-M10-003-R00-IM

10000-M03-017-R00-IM

10000-M03-017-R00-IM

LEAD CORE PRESS

Lead Core Press is a single station horizontal press which forms lead wire into lead cores to be used in FMJ or plated bullet production. Molds of the press can be changed depending upon caliber requirements. It has an automatic lubrication system which extends both machine lifetime and maintenance period. After the lead wire is fed into driving pulleys of the press by hand for the first time, it can run without manpower until it runs out of lead wire on the spool.

Lead core press basically cuts lead wire into lead pieces and pushes each piece into a mold and finally ejects the shaped lead cores / bullets. There is an evacuation hole on the mold where the residual scrap lead is evacuated. This hole provides the weight calibration of projectiles. The machine is capable of pulling lead wire automatically.

The larger version of this machine named Slug Press is designed for medium caliber bullets and shotgun slugs.



Technical Specifications (Slug Press)

Theoretical production capacity	100ppm
Power	12 kW
Voltage	380 VAC
Air Pressure	6 BAR
Dimensions (WxDxH)	3061x1815x1544 mm
Weight (Appox.)	3850 KG

Technical Specifications (Lead Core Press)

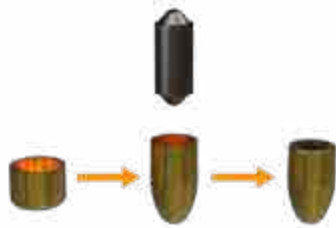
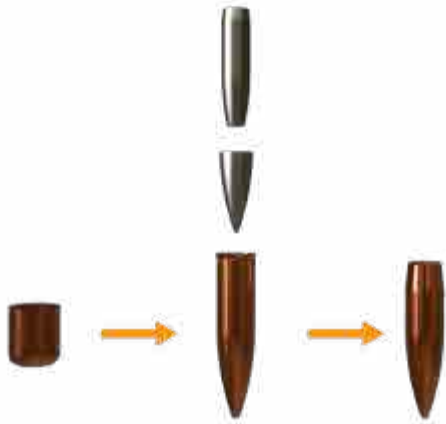
Theoretical production capacity	240ppm
Power	2,5 kW
Voltage	380 VAC
Air Pressure	6 BAR
Dimensions (WxDxH)	1770x1050x2400 mm
Weight (Appox.)	700 KG





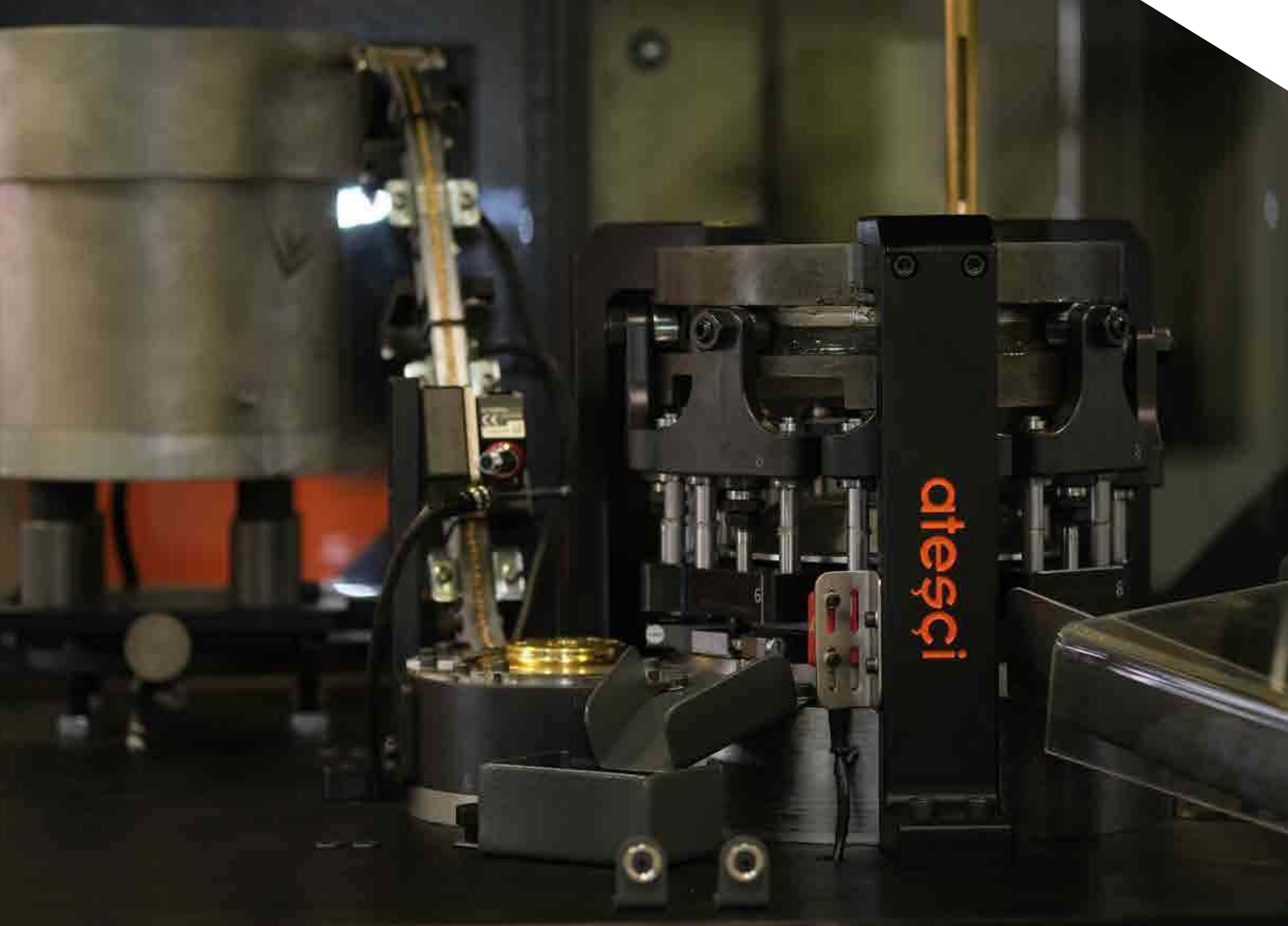
FMJ TRANSFER PRESS

FMJ Transfer Press is a vertical H Type Press which assembles FMJ Cups, lead cores and other necessary components. The components are carried from one station to another by means of grippers placed on a transfer slide. There are some sensors inside the feeding channels to check presence of necessary components. Each station bears a control system to ensure that machine works properly. In case of any problem the machine stops immediately.



Technical Specifications for FMJ Transfer Press

Capacity	100	RPM
Power	20	kW
Voltage	380	VAC
Air Pressure	6	BAR
Tonnage	70	Metric Tons
Dimensions (WxDxH) Pistol	4110x3040x3190	mm
Dimensions (WxDxH) Rifle	3600x2980x3120	mm
Weight (Appox.)	12500	KG
Clutch Brake System	Pneumatic	
Mold Cooling	Coolant-Recirculated	
Mechanical Lubrication	Liquid Oil-Recirculated	
Heat Treated Steel Body		
Safety Guard		
4 Guides Slide System		

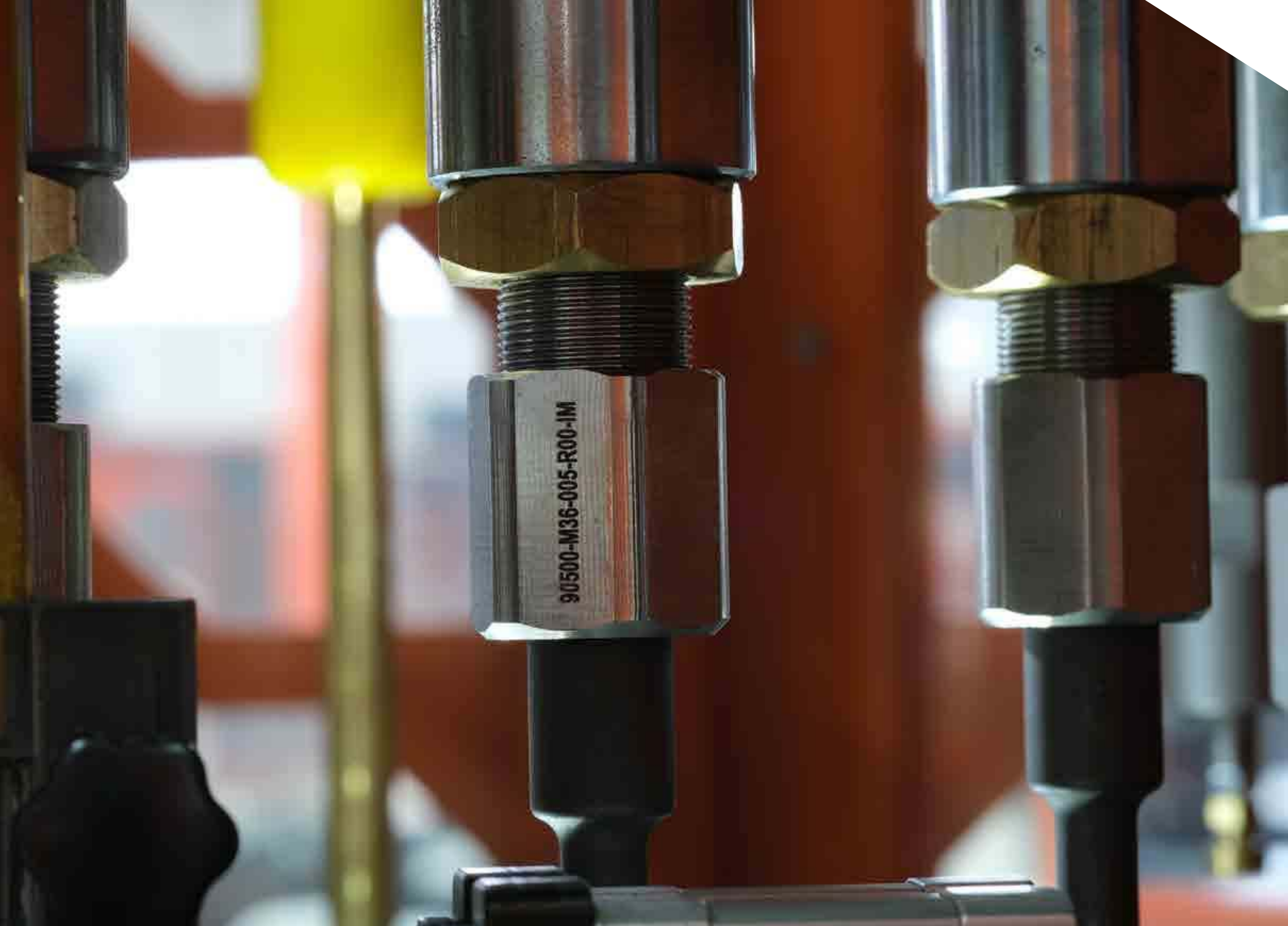


PRIMING MACHINE

The primers are fed onto primer table by vibratory bowl and cases are collated onto case table from rotary collator. Both tables convey these components into the main table and here the primers are inserted into cartridge cases in a continuous way by means of a cam-driven system. In the final stage primed cases are collocated on a chute for primer depth check and non-conforming products are separated by the servo motor actuator.

Technical Specifications for Priming Machine	
Capacity	120 ppm
Power (Total)	4kW
Voltage	380 VAC
Dimensions (WxDxH)	1800x1000x2600 mm
Weight (Appox.)	800 KG
Fire Hole Check	High Precision Camera
Inverted Primer Check	High Precision Camera





90500-M36-005-R00-IM

LOADING MACHINE

This is a rotary motion loading machine used for assembling primed cases, gunpowder and cartridge cases. It makes double production at each stroke for pistol and small arms calibers whereas single production for medium calibers. Its movable parts are driven by servo motors or pneumatic components. Every operational station is followed by a check station to inspect the performance of the previous operation. Non-conforming products are segregated by a pneumatic actuator without stopping the machine.

Technical Specifications for Pistol Calibers	
Capacity	120 ppm
Power (Total)	9kW
Voltage	380 VAC
Air Pressure	6 BAR
Dimensions (WxDxH)	3210x1770x3580 mm
Weight (Appox.)	3050 KG
Feeding by Automatic Elevators	



SEALING UNIT

This machine is used for sealing primer seams and case mouths. After loading operation cartridges are transported to the conveyor of the varnishing machine by a feeding elevator. Both primer seam and case mouth are dispersed consecutively. In the final stage cartridges are exposed to UV light to be dried.

Technical Specifications for Pistol Calibers

Capacity	120 ppm
Power (Total)	4kW
Voltage	380 VAC
Dimensions (WxDxH)	2780x1310x1995 mm
Weight (Appox.)	650 KG





Rifle Packing



PACKING MACHINES

There are two main designs for cartridge packing. For pistol calibers, the cartridges are collocated onto the conveyor belt and aligned with servo pusher. Each tray is filled with 5 rows of ten cartridges until it has 50 rounds. As for rifle calibers, cartridges are collocated onto the conveyor and a robotic arm picks and put them into the cardboard box which is also folded by the same machine.

Technical Specifications for Pistol Calibers	
Capacity	120 ppm
Power (Total)	1,5kW
Voltage	380 VAC
Air Pressure	6 BAR
Dimensions (WxDxH)	1260x1600x1900 mm
Weight (Appox.)	300 KG

Technical Specifications for Rifle Calibers	
Capacity	120 ppm
Power (Total)	5,6kW
Voltage	380 VAC
Air Pressure	6 BAR
Dimensions (WxDxH)	2600x1370x2000 mm
Weight (Appox.)	3800 KG

Pistol Packing





SEMI ANNEALING UNIT

Semi-annealing unit is used for annealing mouth side of cases by partially heating them. They are conveyed through inductors for induction annealing and only mouth side is heated. Chiller unit is the integral part of this system.



Technical Specifications

Capacity	240 ppm
Power (Total)	110kW
Voltage	380 VAC
Frequency	10-15 kHz
Dimensions (WxDxH)	3900x1280x1180 mm
Weight (Appox.)	2300 KG
Cooling System (Chiller Unit)	Circulated Water

Technical Specifications

Capacity	250 kgs/h (200ppm)
Power (Total)	180kW
Voltage	380 VAC
Heating Range	500-850 Celsius
PID Heat Control System	
High insulated with special material which could stand 1000 Celsius	
Dimensions (WxDxH)	13500x2500x2800 mm
Weight (Appox.)	14000 KG
Cooling System	Fan

ANNEALING UNIT

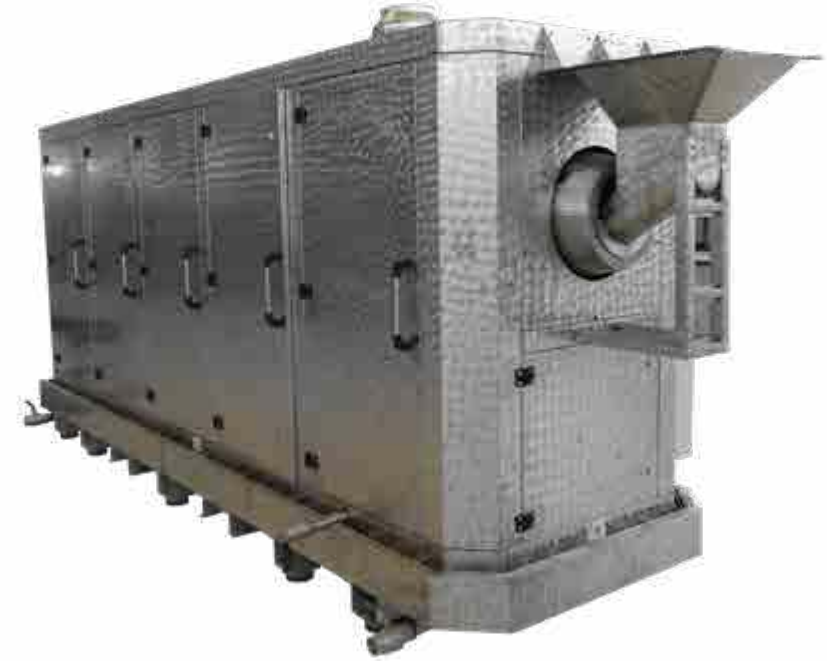
Annealing Unit is designed for strengthening of components to prepare them for drawing operations in case production. The tension of the metal conveyor is adjustable in order to prevent it from loosening because of expansion. The speed of the conveyor line and the temperature of the system are adjustable as well. Cups are annealed by means of PID controlled electrical resistances which are supported by ceramic pipes and keep the internal temperature consistent. The furnace has different heating chambers and in the last chamber components are cooled down by cold air.



DEGREASING UNIT

Degreasing Unit is designed to remove oil from semi- finished components. These components are exposed to oil in production presses and cannot be heated before degreasing process. It is a fully automated PLC controlled machine. The machine is totally made of 316L Stainless Steel. The rotary helical conveyor provides a continuous transfer. The components are degreased, rinsed and finally dried by hot air.

Technical Specifications	
Capacity	250 kgs/h (200ppm)
Power (Total)	80kW
Voltage	380 VAC
Special Stainless Steel	
Overflow chutes with water level sensors	
55 cm Rotary Drum	
Dimensions (WxDxH)	6300x2090x2500mm
Weight (Appox.)	3000 KG
Drying System	Fan



PICKLING UNIT

Pickling unit is dedicated for washing semi-finished components by acid to remove oxidization created by annealing /normalization operations in previous machines. It is a fully automated PLC controlled machine. This machine is totally made of 316 L Stainless Steel. The rotary helical conveyor provides a continuous transfer. The components are pickled with acid, soaped, rinsed with hot water and finally dried by hot air.

Technical Specifications	
Capacity	250 kgs/h (200ppm)
Power (Total)	100kW
Voltage	380 VAC
Special Stainless Steel	
Overflow chutes with water level sensors	
55 cm Rotary Drum	
Dimensions (WxDxH)	7300x2090x2500mm
Weight (Appox.)	4000 KG
Drying System	Fan



OPTICAL INSPECTION

The machine is designed to inspect quality of ammunition components and full cartridges with high technology cameras and laser sensors. It provides ammunition inspection in a 3-Dimensional system. Components/ Cartridges are fed into the collator of the machine. The components are placed onto a transparent rotary table which visits various optical inspection stations. All necessary dimensions, surface quality, dents, cracks and scratches are checked in these stations. Components are accurately measured through precision split/narrow laser beams and multi laser velocity gauges and their specifications and tolerances are printed. Even defects on one side are detected through 3-D information from multiple laser beams. It inspects 360 degrees to ensure all sides meet tolerances and free from damage to guarantee zero defects. At the end, non-conforming products are separated by means of an air nozzle or a pneumatic actuator. The machine has several versions to inspect different type of products such as bullet/case cups, cartridge cases, bullets and cartridges.



Technical Specifications	
Capacity	200ppm
Power (Total)	8kW
Voltage	380 VAC
Air Pressure	6 BAR
Checking System	Rotary system with high precision cameras and micrometers
Dimensions (WxDxH)	1875x1875x2065mm
Weight (Appox.)	1200 KG





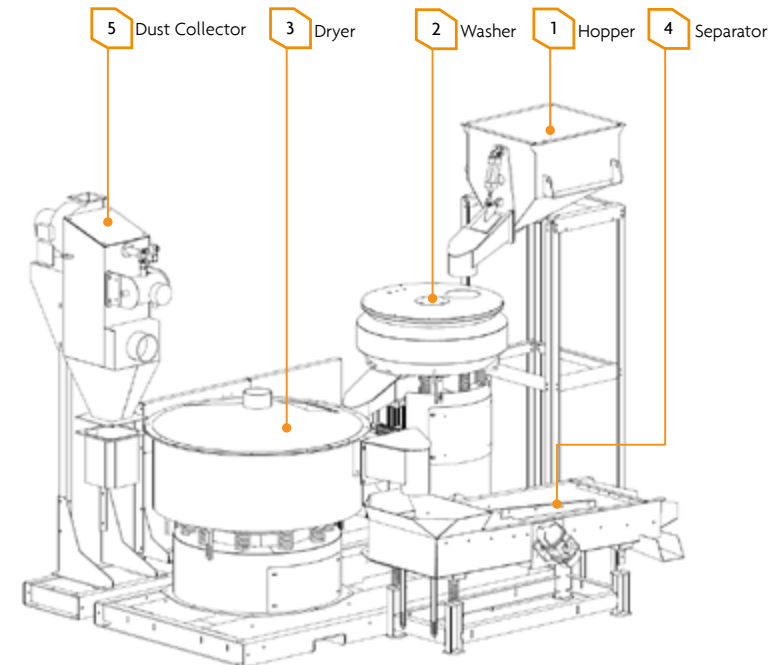
POLISHING UNIT

This machine is designed for degreasing and polishing brass cases and bullets. In the first drum, the components are washed in two steps with two different chemicals. In the second drum, the components are dried by hot air and/or corn grains. The successive steps of the machine are performed in turn by the drums able to operate concurrently, so that washing of a component group can be initiated before drying of the previous one is finished.

The system has been projected to work for degreasing/polishing/rinsing/drying the surface finished materials, for precise level of finishing of the work pieces. The system uses some compounds and water for degreasing/polishing/rinsing section. In this section the system can use chips depend on process type. For drying section the system uses a drier machine that use heated granule for drying proces. Drying machine use the movement of the granules to finish the surfaces of the parts. Also granules dust collected by a dust collector. In third section, system uses a vibrotary screen for seperating residual granule from the parts.

Technical Specifications

		Hopper	Washer	Dryer	Seperator	Dust Collector
Volume	Lt.	120	76	213	--	--
Screen Area	m ²	--	--	--	0.7	--
Flowrate	m ³ /h	--	--	--	--	750
Engine Power	Kw	0.20	1.1	1.9	0.20x2	0.16
Voltage	V/Hz.	400/50	400/50	400/50	400/50	230/50
Motor Speed	Rpm	1500	1500	1500	1500	1500
Pu Thickness	mm	2-4	15-25	2-4	2-4	2-4
Heater Power	W	--	--	1800	--	--



TIP PAINTING UNIT

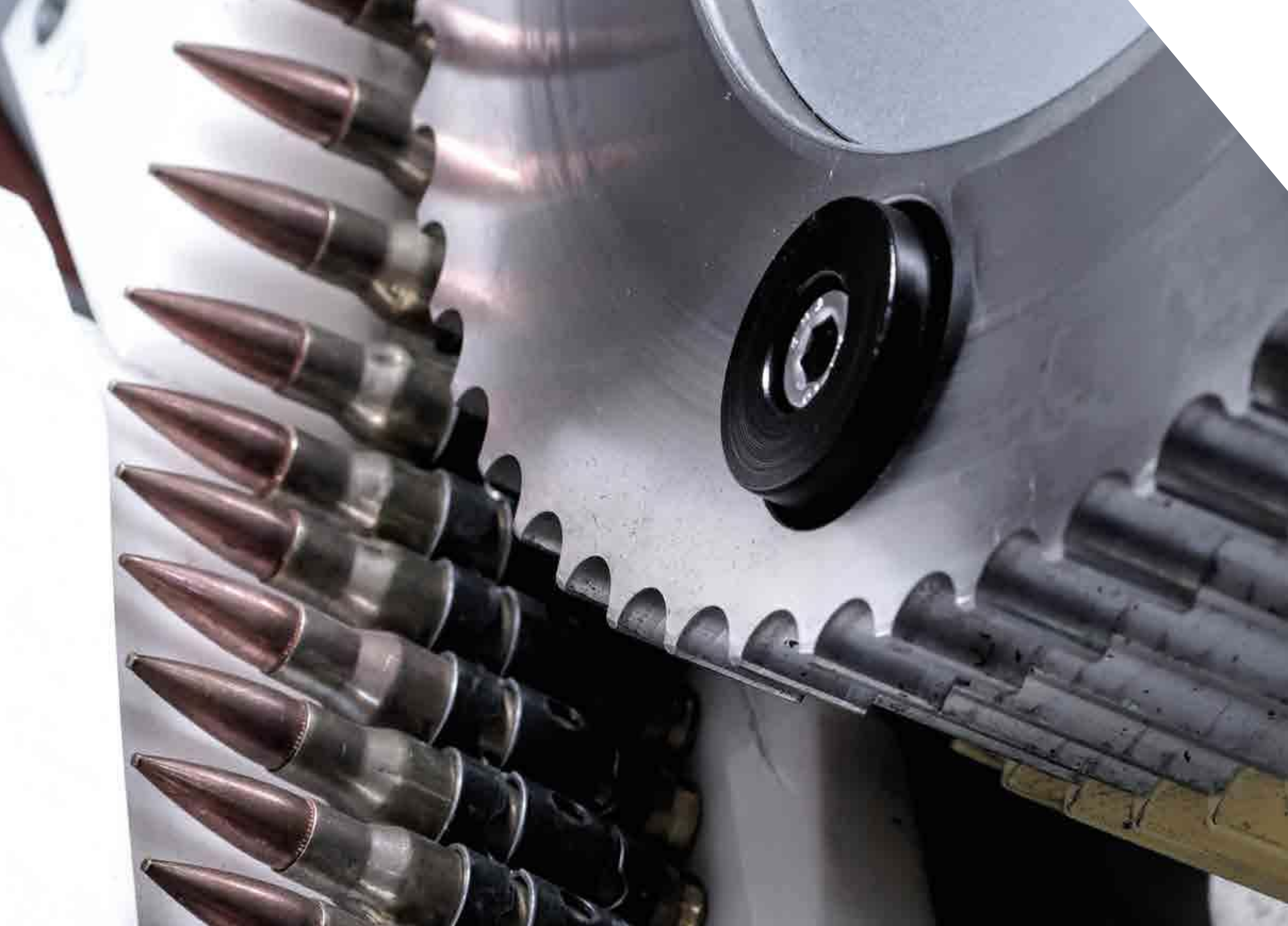
Tip Painting Unit is used for painting tip of the bullets. Cartridges are first collated and placed into trays in groups by fixing their positions in sitting holes for a consistent and identical painting. Then tips of the cartridges are dipped into a painting cup. After UV drying operation the tray is turned upside-down to drop down the cartridges and gets ready for new cartridges.



Technical Specifications

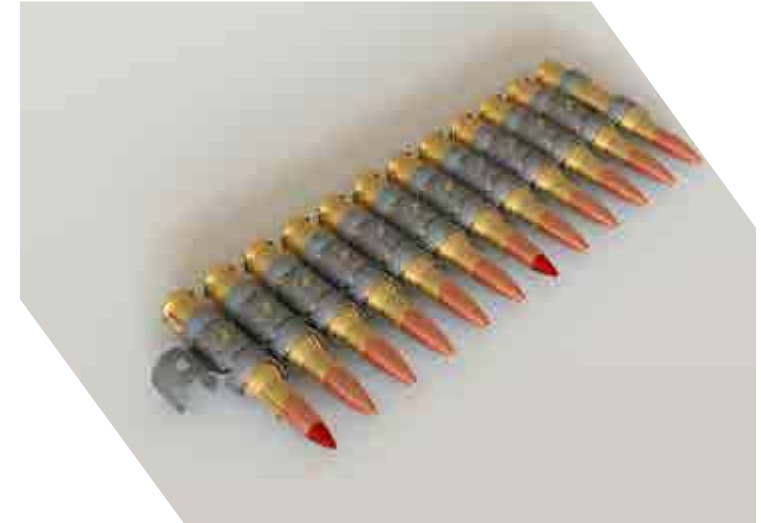
Capacity	120 ppm
Power (Total)	3,5kW
Voltage	380 VAC
Air Pressure	6 BAR
Drying System	Resistance
Dimensions (WxDxH)	3040x1665x2170mm
Weight (Appox.)	950 KG





LINKING MACHINE

Linking machine is fully automated and designed for connecting links and cartridges in a continuous belt. There are two cartridge collators so that tracer and regular cartridges can be belted at the identified rates. The links are collated by means of a vibratory bowl. The number of the cartridges in a belt can be adjusted on touch screen.



Technical Specifications

Capacity	120 ppm
Power (Total)	3kW
Voltage	380 VAC
Air Pressure	6 BAR
Dimensions (WxDxH)	4080x2592x2262mm
Weight (Appox.)	1940 KG



VISUAL INSPECTION MACHINE

This machine enables operators to check the conformity of ammunition components on a continuous conveyor line in terms of visual appearance. The components are revolved around by the chain conveyor and by means of mirrors and lights operators are able to see the imperfections on the surface of the parts. Since optical inspection units are too sensitive, some components or products can be segregated due to acceptable or negligible visual defects. This unit also allows operators to find permissible components among rejected ones.



Technical Specifications	
Capacity	120 ppm
Power (Total)	2,5kW
Voltage	380 VAC
LED Lights and Mirror System	
Dimensions (WxDxH)	2670x651x1740mm
Weight (Appox.)	450 KG



WEIGHING MACHINE

The weighing machine is designed for detecting if the weight of bullets is in the specified tolerances. Bullets are fed by two collators. There are 10 identical stations consisting of slots to fix the bullets on the belt. Every ten bullets are picked and carried onto linearly aligned discrete load cells by the grippers connected to the pneumatic driven robotic lever to be weighed in a fixed position. Afterwards, the same lever picks up and carries them to the conforming and non-conforming containers respectively. The grippers on the lever release the components into either of containers depending on the figures measured on the related load cells.

Technical Specifications	
Capacity	120 ppm
Power (Total)	1,5kW
Voltage	380 VAC
Air Pressure	6 BAR
Weigh Checking System	Dedicated Loadcells
Dimensions (WxDxH)	2250x1200x1950mm
Weight (Appox.)	850 KG



“LITTLE GIANT” LOADING MACHINE

It's a rotary transfer loading machine to assemble primed cases, gunpowder and bullets into cartridges. All its moveable parts are driven by cam mechanisms. Every operational station is followed by a check station to inspect the performance of the previous operation. Due to its simple design and low maintenance cost it is ideal for small and medium sized enterprises and reloaders.

Technical Specifications for Pistol Calibers	
Capacity	70 ppm
Power (Total)	3kW
Voltage	380 VAC
Dimensions (WxDxH)	1220x950x1900 mm
Weight (Appox.)	900 KG



PRIMER SENSITIVITY TEST UNIT

The Primer Sensitivity Test Unit is a multifunctional measuring device designed for testing firing sensitivity of small arms ammunition primers as per international standards. Primers are tested in appropriate cartridge cases. A certain number of identical steel balls are released from variable heights onto a firing pin adjacent to an upside down primed case and threshold force to ignite primers are observed and measured.

Technical Specifications

Suitable for caliber conversion
High precision measurement of release height
Easy and accurate leveling



WATER TIGHTNESS TEST UNIT

This unit is designed to test if there is a leakage on sealing of cartridges under certain pressure conditions.

BULLET EXTRACTION FORCE TEST UNIT

This equipment is designed to determine minimum required force to extract bullets from cartridge cases and consists of three main units: Force Measurement Device, Fixture and Motorized Test Stand. The cartridge to be tested is placed into the fixture in a way that aligns with the gripper connected to the measurement device. The bullet is held and tightened with this gripper and extracted from the case with the linear movement of the test stand to monitor the force required for extraction.



CONVEYORS & HOPPERS

Atesci provides interlinking ammunition production lines. In other words, the components are transferred from one unit to another by means of conveyors. Hoppers are designed to collect the components when needed. Hoppers and conveyors are connected to the PLC of the corresponding machines and whenever the ultrasonic sensors detect shortage of components in the collators they automatically run to transfer some components.



AUTO GAUGING MACHINE

The machine is designed for gauging of cartridges cases in an automatic manner. The cases are collated onto the linear transfer system and shifted to each station four by four since every station has four identical gauging/measuring units. Linear motions detected by the linear variable differential transformers are converted into electrical signals and sent to PLC unit. As per these processed data non-conforming components are segregated by the corresponding stations into certain containers. Acceptable component tolerances, can be set by the operator on the HMI screen.



Technical Specifications for Pistol Calibers

Capacity	120 ppm
Power (Total)	4kW
Voltage	380 VAC
Air Pressure	6 BAR
Dimensions (WxDxH)	3755x2010x2230mm
Weight (Appox.)	2200KG
Checking System	LVDT





REMOTE POWDER DRUM

Remote Powder Drum automatically feeds the machine with powder when needed.

Technical Specifications	
Capacity	6000 pcs/h (plastic wad-star closure)
Power (Total)	6kW
Voltage	380 VAC
Caliber	12,16,20,24,28,32,36,40
Case Type	Plastic and Paperboard (50mm-90mm)
Closure	Star, Star Welded, Round
Lead Shot	1,3mm-5mm
Steel Shot	1,3mm-5mm
Buck Shot	5,6mm-8,6mm
Packing	10pcs, 25pcs
Slug	All Types
Dimensions (WxDxH)	3040x1665x2170mm

SHOTGUN SHELL LOADING LINE

Shotgun shells in different calibers are loaded with Cartridge Loading Machine through a single transport line. Lead shot, steel shot, buck shot and slugs can be loaded by using this machine. It can be operated with plastic and paperboard cases ranging from 50 mm to 90 mm.



PACKING UNIT

It is a semiautomatic boxing tool. It packages 10 pieces in two layers or 25 pieces in 5 layers into a box.

PRINTER FOR CARTRIDGES

For printing automatically loaded cartridges in different heights. It can be adjusted depending on cartridge height and caliber.



BUCKSHOT MACHINE

Buckshot machine is designed for the production of buckshot by processing lead wire by cold pressing method. Standard production sizes are 4.5 mm, 5 mm, 6.2 mm, 7.8 mm, 8 mm, 8.43 mm and 8.60 mm. It is also possible to produce other diameters by changing the machine's tooling.



Technical Specifications

Power (Total)	7 kW
Voltage	380 VAC
Production Rate as per Caliber	
Shot Dia. (mm)	Production Capacity (kg/h)
4,00	250
4,50	375
6,09	500
6,83	560
7,62	625
8,43	625
9,14	750
9,65	875
Dimensions (WxDxH)	10000x10000x1800mm



SHOT CASTING MACHINE

Shot production with the highest level of sphericity is carried out with Shot Casting Machine. Depending on customer's requirement, energy supply of melting tank is designed to be compatible with natural gas, fuel oil or electricity.

This machine, in which heat insulation is attained at the highest level, provides reasonable and optimum level of energy efficiency. By keeping the sphericity and size of the lead shots under control in every stage, it yields products with high quality and identical features. Those shots with non-conforming sphericity are taken back to the melting pot automatically by means of the carriers that are available in every stage.



Technical Specifications

Power (Total)	90 kW
Voltage	380 VAC
Production Rate as per Caliber	
Shot Dia. (mm)	Production Capacity (kg/h)
3,5 +0,10	650
3,25 +0,10	650
3,00 +0,08	620
2,75 +0,08	570
2,50 +0,05	490
2,40 +0,05	440
2,25 +0,05	440
2,00 +0,05	390
1,75 +0,05	200
Dimensions (WxDxH)	13900x5200x4600mm



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TOOLING

As an ammunition line manufacturer, Atesci has the capability of designing and producing high quality tooling sets such as hard metal steel and carbide molds, blades, punches, collets, transfer slides and grippers for cold-forming production. With this capacity, Atesci has not only skilled personnel but also necessary technical infrastructure to design, manufacture, polish and test the tooling sets for ammo production machinery.

Swaging Mold Sets,
Restriking Mold Sets
Tooling Sets FMJ Transfer Press
Tooling Sets for Brass Cup and Case Production
Extrusion Dies
Grooving and Mouth Trimming Knives
Reduction Dies
Heading Dies
Profile Dies
First Blow Dies
Segmented Dies
Profile Reduction Dies

DESIGN



MANUFACTURE



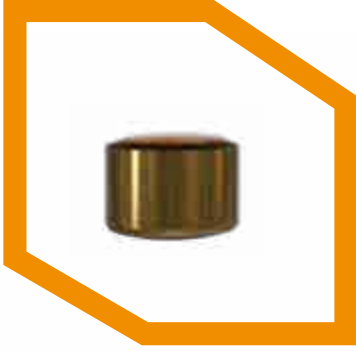
POLISHING



TEST / QUALITY CONTROL



AMMO LINES



Cup Production Line



Lead Wire Production Line



Cartridge Production Line







QUALITY CERTIFICATES



QUALITY POLICY

- Atesci has developed its expertise since its establishment and its aim is to achieve a high standard of manufacturing and service to its customers.
- Quality of Atesci is to supply customers' request in time and to achieve customer satisfaction above their needs. It also provides the best quality products and the latest upgrades in production.
- The policy is to follow the legal regulations and it keeps manufacturing with occupational health and safety rules.
- All personnel of the company are responsible for the quality of their work. The company provides training for all the employees and performs the best information security management system.
- Atesci is committed to achieving high quality management and continuous improvement with PDCA cycle. (Plan, Do, Control, Act)



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MACHINERY: AMMO LINE: TOOLING