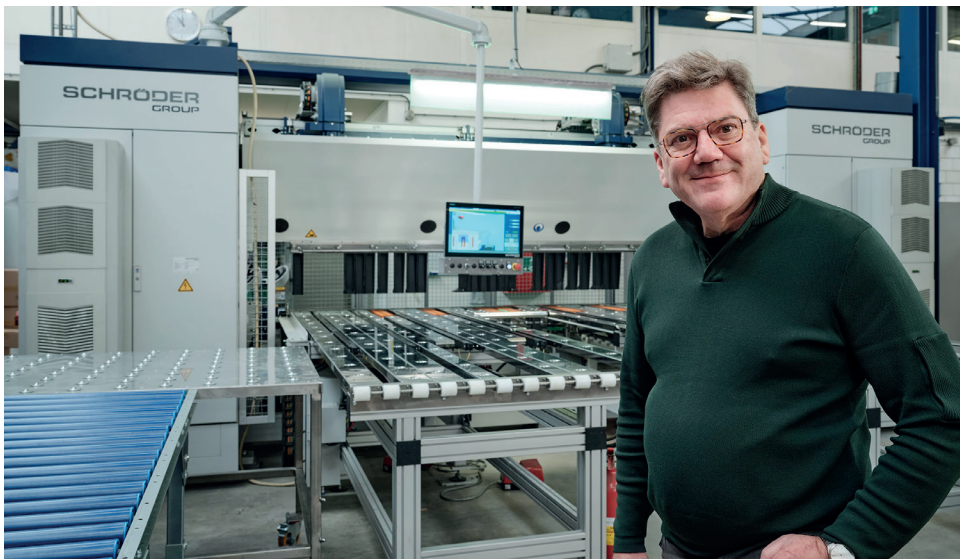


# Precision opened up unexpected possibilities

Staka Metallics B.V. uses Schröder's MAK4 Evolution UD folding machine



## Customer

Staka develops and manufactures high-quality control cabinets and flat-roof access hatches made of stainless steel. A comprehensive program launched in 2024 was designed to boost efficiency, quality, and on-time delivery, and to drive healthy growth for the Oosterhout-based company in North Brabant. A key role in this is played by the precision swivel-bending machine MAK4 Evolution 3200 x 6 UD, affectionately nicknamed "Heidi" by its operators. (<https://staka-schakelkasten.nl/>)

## Success

Staka control cabinets and flat roof access hatches are made of high-quality, stainless steel and are available with various coatings depending on specific requirements. This allows them to be flexibly adapted to different applications and aesthetic needs. They are specifically designed for long-term use in extreme weather conditions and offer reliable protection against corrosion, vandalism, and mechanical wear. Thanks to their robust construction and high-quality workmanship, they have a service life of approximately 20 years, making them a sustainable and cost-effective solution for a wide range of applications in industry and building services engineering.

## Machine in use

### MAK 4 Evolution UD

- Folding machine for sheet thickness up to 6.0 mm
- 3200 mm working length
- Graphic control POS 3000 3D
- Folding beam adjustment 180 mm
- Clamping beam stroke 1090 mm
- Up-and-Down folding beam
- Fully automatic tool changer: Tool change portal for clamping beam tools with hydraulic clamping
- Suction plates in gauge table
- Remote maintenance

Rework for quality control led to inconsistent delivery reliability at Staka—a critical factor, since control cabinets are custom-configured and roof access hatches are installed based on weather conditions and crane availability. One of the causes was an outdated swivel-bending machine operating at the limit of its capacity. A clear principle guided the new investment: “The operator must be convinced, and so must the work planner—only then will we invest,” said COO van Vorstenbosch. Both perspectives were consistently taken into account.

### Selection Process and Decision

Two manufacturers were under consideration. During a visit to Hans Schröder Maschinenbau in Bavaria, the MAK4 Evolution quickly became the preferred choice. The full operating team tested it with real Staka parts. The machine impressed with simple programming, intuitive operation, 800 mm clearance (vs. 500 mm), and strong performance reserves, including processing up to 4 mm stainless steel in continuous operation. Key advantages were the bidirectional bending beam with vacuum plate stop (no manual turning) and the automatic tool changer, reducing setup times and improving ergonomics. Nicknamed “Heidi,” the machine runs in two shifts with 13–14 hours of production daily. Customers benefit from ready-to-install deliveries, reducing installation time and costs..

„The folding machine from Schröder is powerful, intelligent, and highly precise. It plays a key role in our improved processes and has helped us further enhance our quality.“

Richard van Vorstenbosch  
COO  
Staka Metallics B.V.

### On the Path to Success

Since OxGreenfield joined the company in late 2022, Staka has been optimizing its processes, organizational structure, and employee development. The focus is on motivation, professional development, and the flexible deployment of the 67 employees (55 of whom work in production). The goal is to have employees work at a minimum of three stations. At the same time, lean production principles have been introduced. The MAK4 Evolution is firmly integrated into the new layout between laser cutting,

welding, assembly, and powder coating. Today's priorities are safety, personnel, quality, and delivery times over costs. The results are more stable processes without bottlenecks and approximately 10% higher revenue with the same workforce.

### Precision Led to a New Product Line

Staka has developed new coatings based on natural resins with lower curing temperatures. The high precision of the MAK4 Evolution is key: a tolerance of  $\pm 0.5$  mm enables better fits and welds. This quality opened up a new business segment: burglar-proof enclosures. The WK4 certification according to DIN 18106:2003-09 was successfully tested by the Dutch military police and passed on the first attempt—opening up new markets for Staka.

### “Heidi” in Daily Operations

The “Heidi” folding machine is fully integrated into production and handles custom orders, often in single-unit batches. It manufactures components for skylights and control cabinets on a daily basis and stands out for its automation, ease of use, and fast tool changes. The digital control system optimizes folding programs and compensates for springback. The Schröder Group's remote support further ensures process stability. The machine contributes significantly to quality improvement and achieves up to 98% on-time delivery.



## Schröder Group

The Schröder Group consists of Hans Schröder Maschinenbau GmbH, which is located in Wessobrunn, Germany, SCHRÖDER-FASTI Technologie GmbH, located in Wermelskirchen, Germany and the SMU GmbH, located in Leinburg-Weißenbrunn.

Founded in 1949, Hans Schröder Maschinenbau GmbH unifies traditional and modern approaches in machine building: Successfully managed as a quality and customer-oriented, family-owned company, Hans Schröder Maschinenbau is specialized in the development of modern machine concepts for bending and cutting sheet metal.

The successful integration of the Fasti Company in 2006 and its worldwide presence make the Schröder Group one of today's leading providers of machines for bending, cutting, beading, flanging, and circular bending all types of sheet metal. The company's precision machines range from proven solutions for craftsmen to innovative, high-performance machines for automatic industrial production processes. 2021 the Schröder Group was expanded by the tool manufacturer SMU GmbH. Overall, the Schröder Group currently employs more than 300 people at various locations at home and abroad.

**SCHRÖDER**  
GROUP

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