CRENO has been developing innovative machining solutions, combining machines and processes, since its foundation in 1978 in Annecy, France.

For the last fifteen years, the company has been focusing on specific processes in the aeronautics sector for which we have designed highly differentiated solutions.

We are currently working with major aeronautics stakeholders mainly in Europe, North America and Asia.

Going beyond our initial expertise in highly accurate robust, multi axis CNC machines – with 3, 5, or more axis – dedicated to “soft” materials such as aluminum or composites, we have developed advanced and efficient innovative processes, specifically for:

- Multi-drilling “acoustic drilling” of composite nacelles
- Machining and Ultrasonic Cutting of Honeycomb
- Milling of composite parts
- Reaming and drilling aluminum sheet stacks
- To provide an answer to our customer and market evolution we have developed machining robot cells able to carry all our processes.

Our Core Values

- Customized and Turnkey Solutions
- A Committed Team
- A Long-Term Relationship
CRENO, Pioneering with You and for You

Providing pioneering turnkey machining and robotic systems for the aeronautics, aerospace and composite industry since 1978, CRENO offers innovative and robust solutions worldwide on multi-axis CNC machines and industrial robots.

Its mission is to guarantee its customers to stay one step ahead of their competitors with a customized machine/process combination, its reliability and integration into physical and numerical industrial workflows.

Some key dates in CRENO’s history

<table>
<thead>
<tr>
<th>Year</th>
<th>Event</th>
</tr>
</thead>
<tbody>
<tr>
<td>1978</td>
<td>Foundation of “Le Créneau Industriel” in Annecy-le-Vieux, France, designer and manufacturer of CNC machine tools</td>
</tr>
<tr>
<td>1980</td>
<td>First CNC machine for the composites market</td>
</tr>
<tr>
<td>1984</td>
<td>First 5-axis CNC machine</td>
</tr>
<tr>
<td>1985</td>
<td>First high-speed milling machine</td>
</tr>
<tr>
<td>1988</td>
<td>First multi-drilling machine for wood panels</td>
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</table>

Beginning of Aeronautic market penetration

<table>
<thead>
<tr>
<th>Year</th>
<th>Event</th>
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<tbody>
<tr>
<td>1999</td>
<td>First stack router “bridge cut” machine, for LATÉCOÈRE</td>
</tr>
<tr>
<td>2004</td>
<td>First high-speed drilling machine for the aeronautics industry, for SAFRAN</td>
</tr>
<tr>
<td>2010</td>
<td>First combined ultrasonic and milling machine, for AIRBUS</td>
</tr>
<tr>
<td>2017</td>
<td>First CRENO Siemens NC-controlled robot cell, for HUTCHINSON</td>
</tr>
<tr>
<td>2020</td>
<td>Dual Ace “The most competitive Ultrasonic Cutting machine worldwide”</td>
</tr>
</tbody>
</table>
Jet engines are subjected to very strict standards to gradually reduce noise levels. To achieve these goals, they contain composite panels with hundreds of thousands of small-diameter holes, generally from 0.55 to 1.8mm. These micro-drilled engine panels act as sound traps.

For the past 15 years, and to respond to this very demanding quality and productivity criteria, CRENO has become an expert in “acoustic drilling” with 5-axis machines.

Spearheading industrial innovation, CRENO has developed an acoustic drilling Robot Cell using a Siemens NC-controlled Stäubli robot.

Recognized expertise
- Over 15 drilling machines sold in Europe and North America for Safran, GE-MRAS, UTC Aerospace, and Spirit Aviation
- Process validated by Airbus, Boeing, Bombardier, Comac, and Mitsubishi
- High production performance: Up to 35 holes per second
- Up to 28 spindles on one drilling head
- Drilling cycle below 0.8 seconds

Increased hole quality
- Diameters ranging from 0.55 to 2mm (0.021 to 0.08 inch)
- High precision and less delamination
- Individually controlled drill-hole depth
- No need to add additional finition
- Stability of the process
- Expertise in cutting tools

Continuous monitoring
- Drilling process control
- Drill bit breakage detection
- Drill bit lifecycle management

Highly automatic
- Reduced operator intervention
- Friendly and ergonomic configuration
5-Axis Machine
Micro drilling of acoustic panels dedicated to large parts

- High production level
- Drilling heads with up to 28 spindles
- Up to 35 holes per second (28 holes every 0.8 s)
- High rigidity
- High stability

Robot Cell
Robotic acoustic drilling dedicated to smaller or cylindrical parts

- Saves floor space using standard foundations
- Each spindle is individually assembled on a linear axis used for the drilling motion
- Easy and cost-effective spindle reconfiguration
- Ease of integration in industrial workflows (inline integration)
- Drilling heads with up to 12 spindles
- Up to 12 holes per second
- Siemens NC (ISO code)

Combined Process
- Milling and multi-drilling of composite parts
- Customized size of the machine
- Milling spindle up to 42 KW and 24 000 rpm
- Multi-drilling heads up to 6 independent spindles
- Two processes in one
Honeycomb materials and structures are increasingly used in the aeronautics industry. Machining these materials using traditional methods is often complex, costly, and unsatisfactory in terms of quality and accuracy. CRENO has developed a unique solution for these materials by combining the advantages of the ultrasonic cutting process and traditional milling machines.

The advantages of CRENO solutions

- No dust
- Reduced cutting force
- Unrivalled quality due to the absence of deformed cells and lint
- Significantly reduced cycle time (up to three times faster)
- Increased ultrasonic tool life span
- Possibility to realize complex geometries
CRENO 5-axis cutting machines combine traditional milling and ultrasonic cutting quality in one machine. It is therefore possible to machine composite skins, honeycomb materials, and bonded parts. This solution offers the opportunity to work on a wide range of materials and shapes, in particular when cutting small parts at high-speeds.

### 5-Axis Machine

#### Dual Ace

- Standard machine with working area: 2.5x1.2x0.9m (8.2x4.1x3 ft)
- Siemens 840 D SL Numerical control
- Milling spindle 10 KW / 24 000 rpm / HSK 63
- Up to 4 CRENO ultrasonic heads
- CRENO know how and software solutions for programming
- Best price on the market

#### Customized

- Customized size of the machine up to 20m (66ft) x 9m (30 ft) x 2.5m (8.2ft)
- Milling spindle up to 42 KW and 24 000 rpm
- Up to 5 CRENO Ultrasonic heads
- CRENO know how and software solutions for programming

### Upgrading of your machine with the CRENO ultrasonic cutting function

CRENO can provide a full Ultrasonic kit which included:

- Generator and CRENO ultrasonic heads
- Automatic interface for your spindle
- Tool changer adaptation
- Software and programming training

Available for all Brands of machine

### Robot cell

- Standard robot cell dedicated to honeycomb panels
- Table 3m (9.9 ft) x 2m (6.6 ft)
- Siemens 840 D SL NC
- Milling spindle 3.5 KW - 24 000 rpm
- 4 ultrasonic heads milling tools
- 3 tables for easy loading & unloading
CRENO is known worldwide to have delivered numerous large-sized, customized gantry CNC 3 / 5 axis milling machines dedicated to composite milling. Since 2015, we have extended our range for milling composite parts and materials with robotic machining and robot cell solutions.

**CRENO Solutions**

**Designed for**
- High Accuracy
- Strong Reliability
- More Efficiency
- Robust design and reliability
- Environment Protection
- Various end effector technologies = Counter sink device, orbital drilling, compliance milling
5-Axis Machine

High accuracy and strong reliability, heavy duty, customized, advanced machining solutions.

- A full range of multi-axis machines

Satellite panel machining  
Overhead moving gantry  
Shuttles

- X axis travel up to 20m (66 ft), Y axis up to 9m (30 ft), Z axis up to 2.5m (8.2 ft)
- Spindle power up to 42kW

A full range of high-tech equipment: Countersinking, Orbital drilling, Compliance milling, Machining aggregates, Probes, Laser tool management...

Robot cell

- A full range of robotic machining cell solutions

Multi-placement robot cell for more productivity  
Pendular robot cell for more flexibility

These solutions can be used in all industries likely to use robotic machining of composite materials.

Advantages of machining composite material on robots:
- High productivity, in particular due to the pooling of tools and multiple installation options
- Loading and unloading during machining operations
- Better access to machining areas
Routing of Aluminum Sheets

Creator of the “bridge-cut” process, CRENO aluminum stack routers automate the sheet trimming process with a very high level of productivity and quality.

The aluminum stack router solution

From your 2D CAD files, the machine generates the optimal nesting in order to minimize waste. Metal Trimming and drilling operations are automatically and simultaneously performed on sheet stacks of up to 12mm (0.47in).

The automatic tool changer, the efficient dust extraction system, and the “Bridge-cut” system offer fully automated operations.

This solution offers:

- Complete supervision of the process for each machining sequence
- Multiple aluminum sheets up to 12mm (0.47 inch)
- Single steel sheets up to 2.5mm (0.01 inch)
- Three metal machining operations: trimming, drilling, surfacing
- Part marking system
## Stack Router Machine “Bridge cut”

### Standard Technical Data

#### Axis Strokes

<table>
<thead>
<tr>
<th>Moving Table</th>
<th>Gantry</th>
</tr>
</thead>
<tbody>
<tr>
<td>y: 1500mm (5 ft)</td>
<td>y: 2000mm to 2600mm (6.6 to 8.5 ft)</td>
</tr>
<tr>
<td>z: 300mm (1 ft)</td>
<td>z: 300mm (1 ft)</td>
</tr>
<tr>
<td>x: 3700mm (12 ft)</td>
<td>x: 4000mm to 12000mm (13 to 40 ft)</td>
</tr>
</tbody>
</table>

#### Axis Speed

<table>
<thead>
<tr>
<th>y: 25m/min (1000 inch/min)</th>
<th>z: 20m/min (790 inch/min)</th>
</tr>
</thead>
<tbody>
<tr>
<td>x: 25m/min (1000 inch/min)</td>
<td></td>
</tr>
</tbody>
</table>

#### Spindle

- 20 kW Power
- 24000 rpm Speed
- HSK E50 Taper

#### Tool Changer

- 16 Storage positions up to 60 as an option
- Tool length up to 150 mm (6 inch)
- 50 mm (2 inch) Maximum tool diameter

#### Material

- Aluminum multi sheet up to 12 mm (0.47 inch)
- Steel in single sheet up to 2.5 mm (0.01 inch)
Co-Engineering and Prototyping Services

Local Application Centers in Europe and USA

One Team Working for You
- Engineering Team dedicated for customer studies with strong experience in programming and machining
- Supporting you to take the full advantage of ultrasonic cutting
- Developing and programming with last generation of CAD, CFAO and simulation software
- Operator and Programmer Training: learn how to use the advantages of ultrasonic cutting, how to optimize multi-drilling to fully exploit the potential of CRENO Processes

Highly Performing Machines Park
- Large capacity robot cell with rotative table able to perform several machining processes through end-effectors:
  - Ultrasonic Cutting
  - Multi-Drilling
  - Machining
- Temperature stability metrology room allowing us to warranty the quality of the process and qualification of your parts
- A confidential area to secure your development project and respect your privacy
Qualification of your future products & processes

Assisting you in the very early stages of your project

- Validate the feasibility of your project
- Make your prototype parts
- Build your demonstrator
- Manufacture first parts on production equipment
- Develop the machining strategy for new materials/shapes
- Improve your environmental and safety issue with innovative machining processes

Development of new technologies

Because innovation is your driving force...

You can rely on a dedicated highly skilled CRENO team to work on each of your projects:

- Create new specific machining technologies to improve your performance
- Develop your future innovative equipment in partnership with your team
CRENO services allows you to obtain a quality, efficient and customized support. Our main objective is to enable you to get the best of your CRENO CNC machines and robot cells.

Best-in-class customer services and support

- Hotline and help
- Spare parts
- Preventive maintenance
- Components repairs
- Refurbishing
- Training & process improvement

CRENO Services
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The most prestigious names in the industry rely on us

Every day, our goal is to maintain their trust and earn yours.

AEROCOMPOSIT JSC // AERO VODOCHODY // AVIC INTERNATIONAL BEIJING // AVIC SHENYANG
We would be pleased to welcome you in our head office located in Annecy, in the heart of the French Alps.

We are at your service, whatever your time zone, wherever you are in the world.

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