



The customer portal of Hadocut GmbH



Welcome to the customer portal of Hadocut GmbH.

Customer satisfaction is our top priority. Also, to allow us to offer you more and more service, we have spent the last few years developing our METALLZUSCHNITT (METAL CUTTING) portal.

The aim of our portal is to simplify the entire order process for you and - with the help of our integrated calculation tool in particular - give you more time for essential company matters.

The advantages of the portal for you are obvious:

- **Online calculation**

Once you have loaded your drawing and entered the basic data (material / quantities), your price is output after just a few minutes.

- **Online calculation**

You are given a discount depending on the quantity you order.

- **Express function**

Sometimes things have to be done in a hurry ... which is why we have included an express function allowing us to produce the desired parts for you within **72 hours**.

- **Memo and reorder function**

Orders you make are saved in a history, allowing you to reorder easily whenever you wish.

- **Fairness guarantee**

As we all know, the market has rules of its own, and the prices for materials vary depending on the market situation. We give you a guarantee that we will calculate all parts according to the very latest material prices.

Existing parts are always recalculated when the material price changes.

No matter whether you're ordering or reordering, we always give you the latest daily price.

## Log in and get started - it has never been so easy!

### Why not register now?

After registration, you can carry out ten calculations without your data being stored in our merchandise management system.

(Your email address from the registration process is stored to ensure traceability.)

If you want to make an actual order from the demo access, completely fill in the form which appears after you initiate the order.

You will then receive order confirmation from us.

### So here goes:

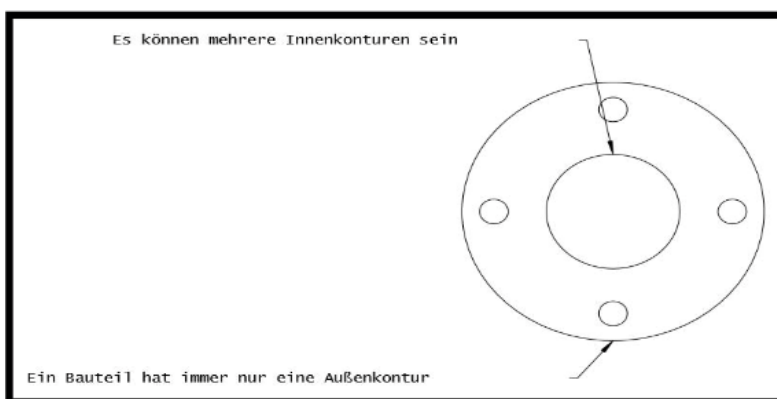
Load your drawings into the system and specify material and quantity.

### Here are a few tips concerning your DXF or DWG drawings:

- We make a distinction between inner and outer contour.
- Inner contours refer to the geometrical shape of a hole surrounded by material etc. There can be many inner contours but only one outer contour.
- Cutting lines can be drawn in any desired colour (usually white/black or green).
- Dimension lines or side views are not permitted.
- Only closed cutting lines are allowed.

If the system recognizes the drawing without issuing an error message, an order can be made without further ado.

Clean part

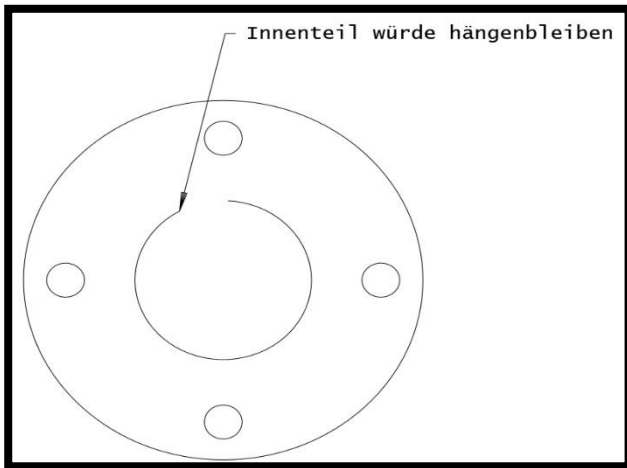


There can be several inner contours

A part always has one outer contour only

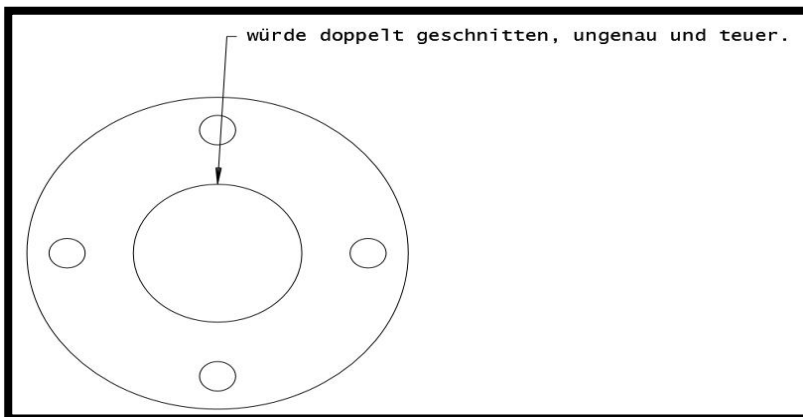
**Possible error messages:**

**50001**      Open contour      One contour is not closed



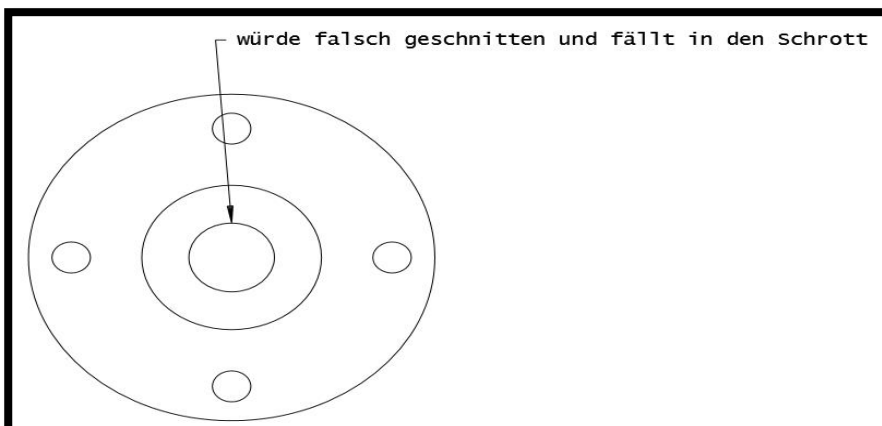
Inner part would snag

**50002**      Double contour      Two contours are superimposed



Would be cut twice, making it imprecise and expensive

**50003**      Part in part      One part is located inside another part



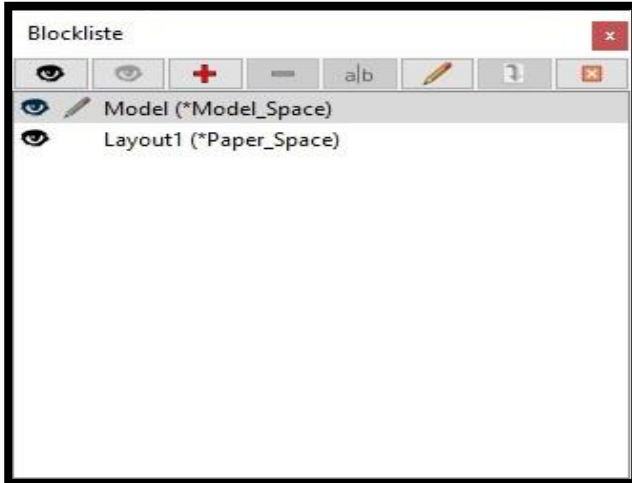
Would be cut incorrectly and land in the scrap

50004

No geometry found

A geometry was not found

The drawing was made not in the model space but in the paper space (ACAD)

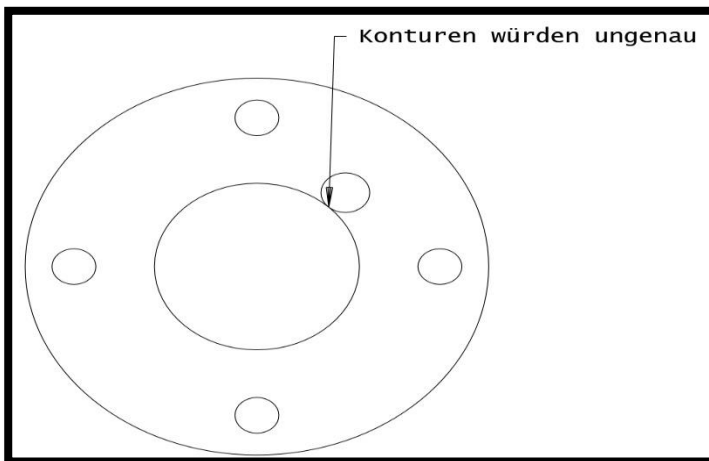


Block list

50005

Overlapping lines

Two or more lines overlap

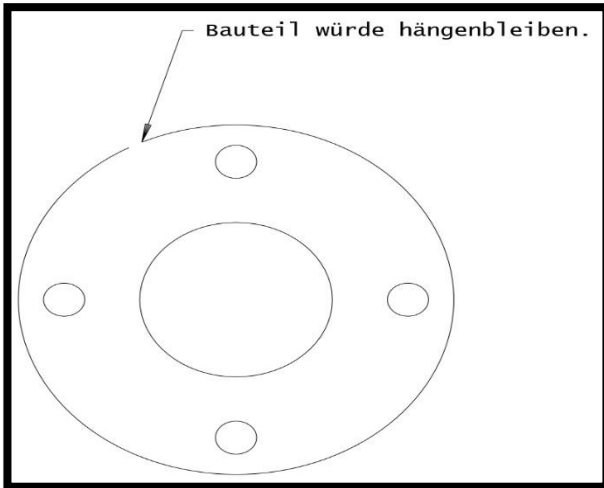


Contours would be imprecise

50006

Open outer contour

Outer contour has several open places

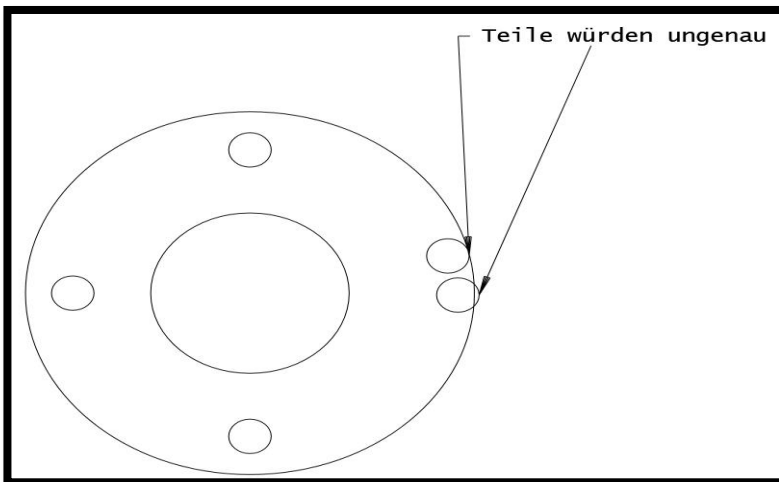


Part would snag

50007

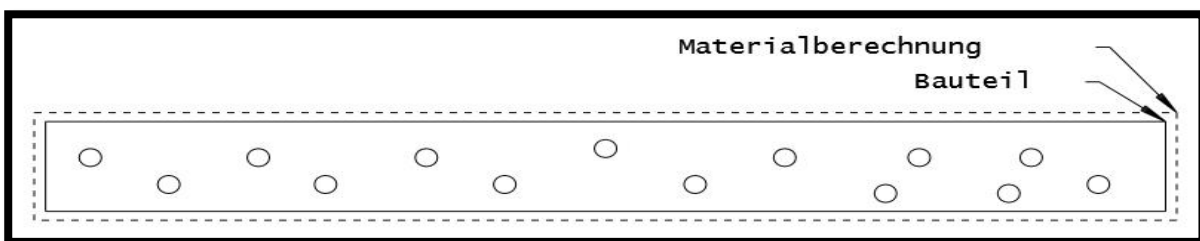
Inner contour collides with outer contour

There is a collision between inner and outer contour

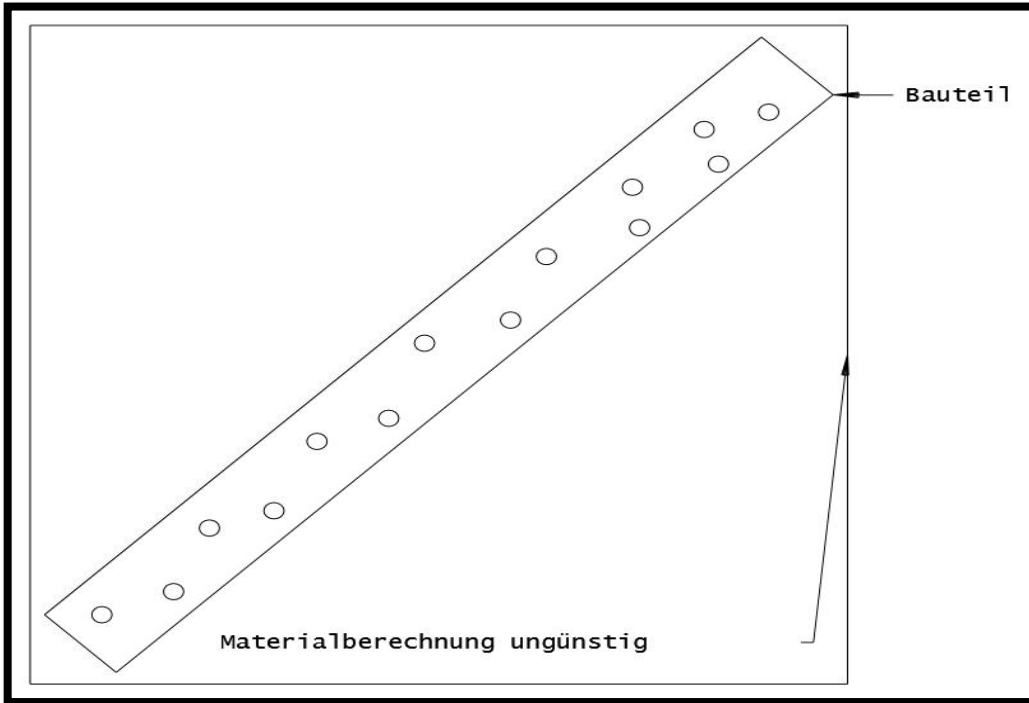


Parts would be imprecise

**Long parts** should always be shown in a horizontal position on the drawing so that the material ratio makes the price as reasonable as possible



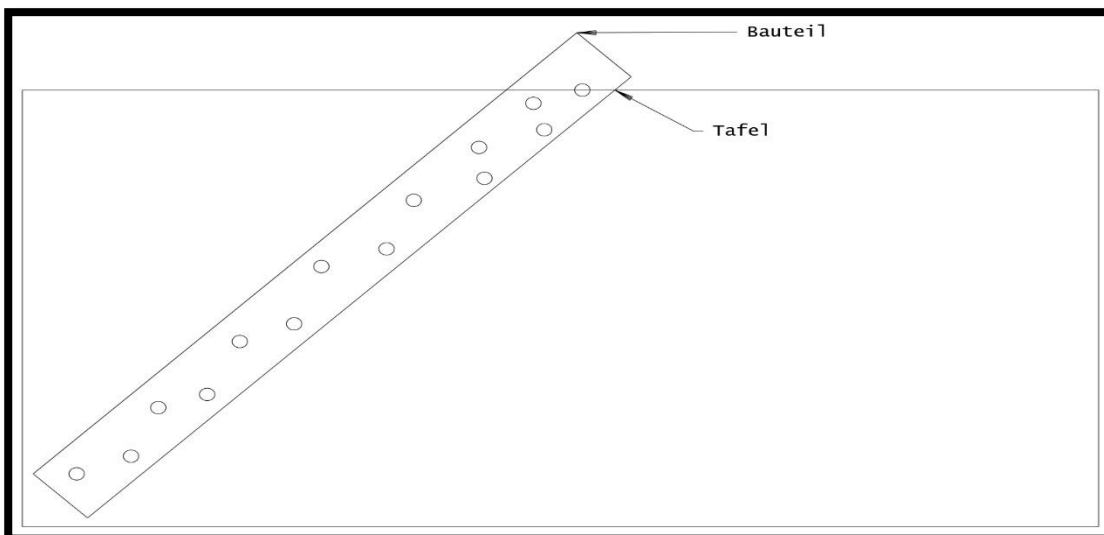
Material calculation Part



Part

Material calculation unfavourable

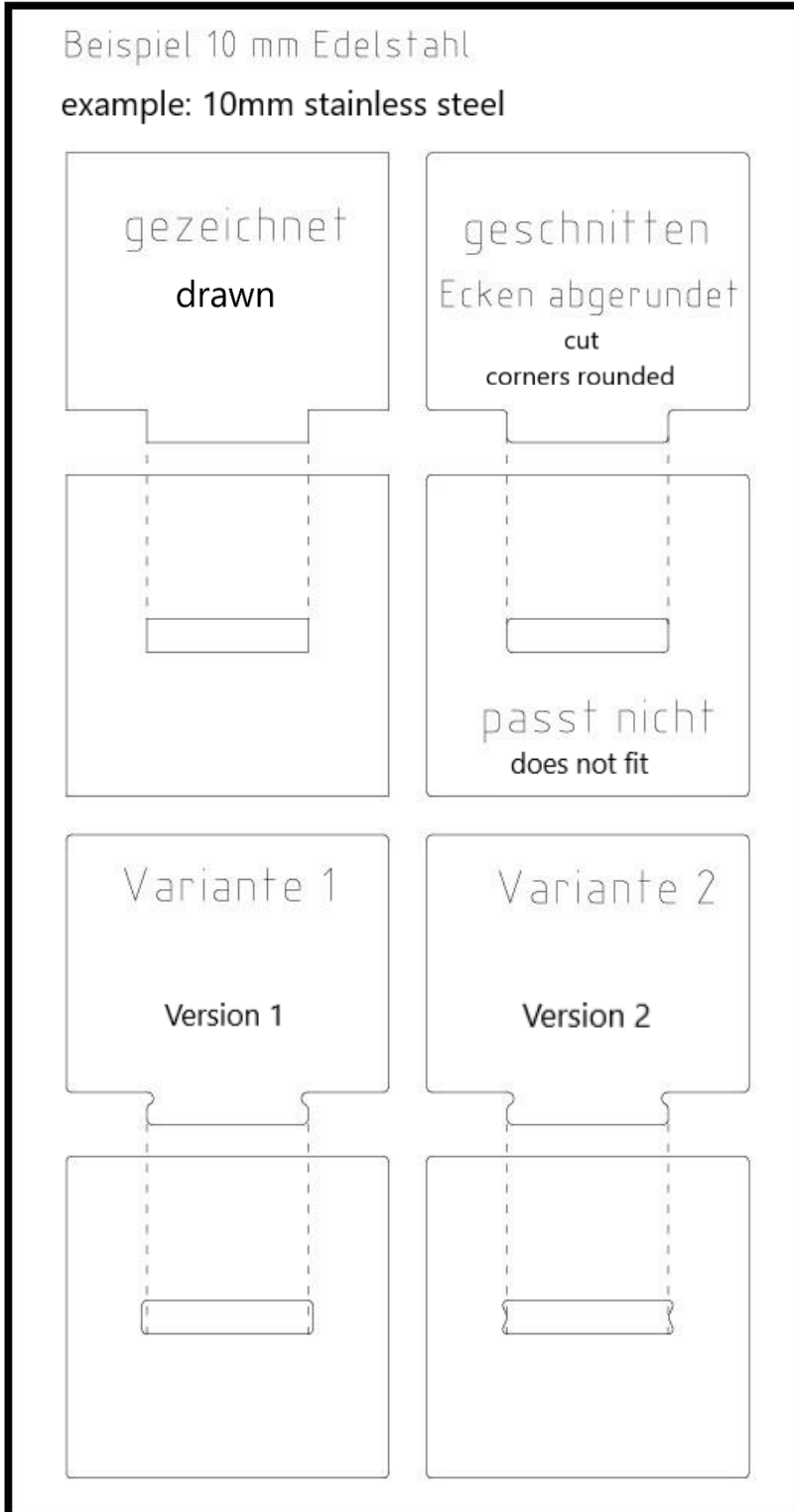
Part does not fit on the table



Part

Table

Please be sure to note the following when using plug-in systems



### Stainless steel

#### Sheet

thickness	Castor corner/radius
0.5 - 2 mm	0.3 mm
2.5 - 6 mm	0.5 mm
8 mm	1.0 mm
10 - 15 mm	1.5 mm

### Steel

#### Sheet

thickness	Castor corner/radius
0.5 - 5 mm	0.5 mm
6 - 20 mm	1.0 mm

### Aluminium

#### Sheet

thickness	Castor corner/radius
0.5 - 2 mm	0.3 mm
2.5 - 3 mm	0.5 mm
4 - 6 mm	1.0 mm
8 mm	1.5 mm

### Plasma (applies for steel)

#### Sheet

thickness	Min.radius	Ampere
15 mm	1.8 mm	130
16 mm	1.9 mm	130
18 mm	2.63 mm	260
20 mm	2.66 mm	260
22 mm	2.93 mm	260
25 mm	3.15 mm	260
30 mm	3.65 mm	400
35 mm	3.9 mm	400
40 mm	4.15 mm	400
45 mm	4.5 mm	400

Please note that, in the standard system, all corners are always rounded during laser or plasma cutting. (See the above tables)