



QUALITY FIRST

LATCHES | HINGES | GASKETS

 **WirtschaftsWoche**

 **WELT
MARKT
FÜHRER**


**Champion
2025**

EMKA Beschlagteile
Verschlüsse, Scharniere und
Dichtungen für Schalt- und
Steuerungsschränke für Elektronik
und Elektrotechnik

Quelle: Weltmarktführerindex
von Dr. Walter Döring
und Prof. Dr. Christoph Müller

WORLD MARKET LEADER SINCE 2018



A portrait of Friedhelm Runge, an older man with white hair and a mustache, wearing a dark suit jacket over a white shirt with a patterned collar. He is standing in a large industrial factory with various machines and equipment in the background. The lighting is bright, and the overall tone is professional.

*"You can negotiate
on prices, but not
on **quality!**"*

† **Friedhelm Runge**
Founder of the EMKA Group

QUALITY FROM THE WORLD MARKET LEADER



92%

In-house production rate



36,000 customers worldwide



Own production at
11 international locations



Represented in 60 countries worldwide



In-house mould making



More than 50 years of production experience



Own technology center



20 million € insurance per product



Identical production possibilities
at different locations



2,100 employees worldwide



Accredited test laboratory



30,000 catalogue and special products



INGENIOUS LOCKING TECHNOLOGY

The EMKA GROUP is the world market leader for locks, latches, hinges and gaskets used in switch and control cabinets. For more than 50 years, the company has been active across all sectors in the fields of industry (switch and control cabinets, HVACR systems, mechanical engineering) and transport (railway and commercial vehicles, caravans, etc.) with conventional and electronic locking solutions.

The total product range comprises 30,000 articles, which are developed, manufactured, finished and assembled at eleven production sites in Germany, France, England, Spain, Bosnia, Serbia, China, Indonesia and India. In one of the two plants in Bosnia, the company produces up to 900 moulds per year for injection moulding and die casting - both for internal use and for external customers.

With 2,100 employees EMKA serves over 36,000 customers in 60 countries.
In 2023, the company achieved turnover of over 350 million euros.

EMKA: Ingenious Locking Technology.



[View EMKA website](#)



[View EMKA corporate video](#)

MOULD + SERIES

PRODUCTION TO CUSTOMER ORDER

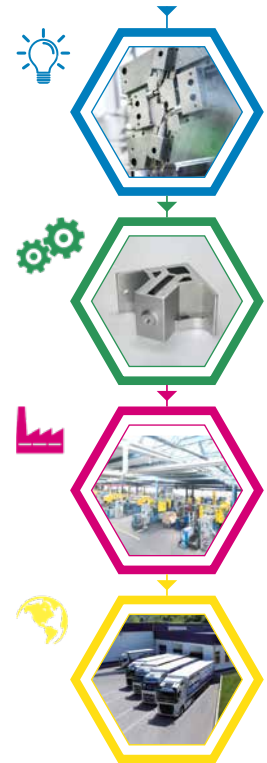


EMKA is one of the three largest mould makers in Europe.

One reason for this is that all of EMKA's 30,000 catalogue and special products are tool-related. In its own production sites, EMKA produces these products from the materials polyamide, zinc, steel, stainless steel and aluminum. EMKA customers can take advantage of this manufacturing excellence that has been developed over decades. With the business model "Mould + Series", EMKA offers a unique service package:

Based on the customer's drawing, the mould is designed. The production of the initial sample with this mould takes place directly at EMKA on site on factory-owned machines from series production. In this way, the mould making and initial sample production stages are directly coupled with each other. Time and quality losses due to transport and coordination loops are eliminated. After tool and initial sample approval, the customer receives the complete test documentation as well as all relevant production parameters. If the customer does not want to manufacture his product himself, but wants to outsource it, EMKA can also take over the series production - if necessary with assembly work and worldwide logistics.

"Mould + Series" is mould making and initial sample production from a single source - with optional series production. In short: Production with a system.



MODULAR PRODUCT PROGRAM

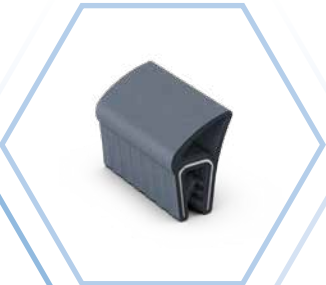
LOCKS AND LATCHES



LOCKING SYSTEMS



HINGES



GASKETS

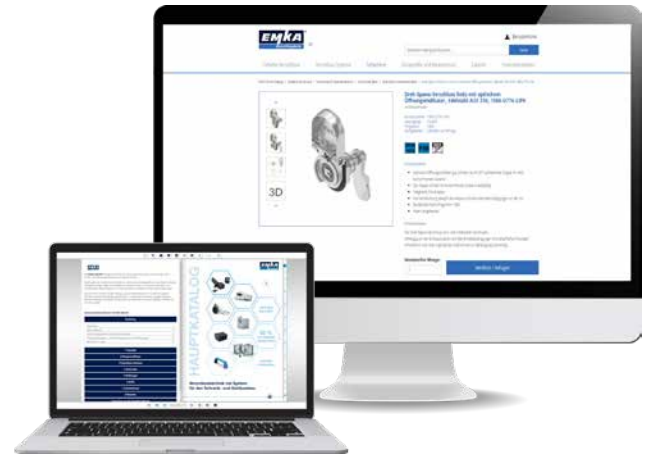


ACCESSORIES

EVERYTHING AT A GLANCE

You will find a large selection of EMKA products in the **interactive EMKA main catalogue** as well as in the **online product database**.

There you also have the possibility to download CAD data in the international exchange formats STEP and IGES as well as detailed product data sheets.

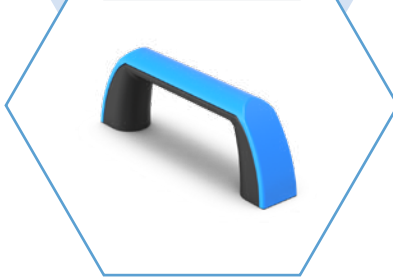


PRODUCTION AT A GLANCE

MOULD MAKING



PLASTIC INJECTION MOULDING



ZINC DIE CASTING



ALUMINIUM DIE CASTING



STAINLESS STEEL PRECISION CASTING



PROFILE EXTRUSION



PRODUCTION WORLDWIDE



Wuppertal, Germany



Goražde (Plant 2), Bosnia-Herzegovina



Henriville, France



Arnedo, Spain



Birmingham, UK



Mionica, Serbia



Tianjin, China



Bhilai, India



Bandung, Indonesia





- Company headquarters
- Production site
- Subsidiary
- Agency

MOULD MAKING

Facts

Production in
Bosnia-Herzegovina

Certified acc. to
ISO 14001:2015, ISO
45001:2018, IATF 16949:2016
and ISO/IEC 27001:2013

150 employees, thereof:

- 46 engineers
- 15 constructors
- 14 developers

55,000 m² area under roof

95 high-quality machines
in mould making

Production of up to
900 moulds per year

Development and engineering

3D-CAD

CAE

Filling simulations for various
materials

Stress-strain analysis by means
of finite element method

Service

Moulds for plastic injection moulding,
zinc and aluminium die-casting

Multi-component moulds (2K)

Moulds for IML foils

Moulds for insert injection moulding

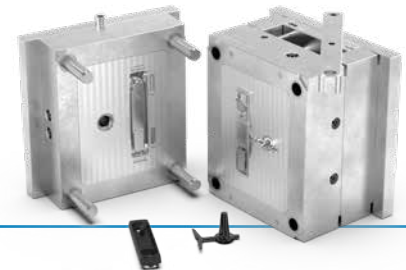
Punch deburring

Pre-series moulds for all materials

Family tools for small quantities

Guaranteed service life

Precision casting tools



MACHINERY IN MOULD MAKING

Equipment in mould making

34 machining centres,
several with 5 axles

7 lathes

5 surface grinding machines

22 die-sinking EDM machines

7 wire EDM machines

8 HSC machines for the production
of graphite electrodes

12 standing drill presses

Manufacturers



DECKEL MAHO



PLASTIC INJECTION MOULDING

Production in Germany,
Bosnia and Herzegovina, India and Indonesia

All production sites are certified
according to ISO 9001:2015

69 machines, thereof 4 2K machines

Manufacturer: Arburg

Clamping forces: 20 - 500 t

Max. tool clamping area: 1,100 x 600 mm

Parts weights: 3 - 3,000 g

Granular types:

Thermoplastic / PA 6 / PA 6 V0 / PA 6 GF
transparent, rubbery to high strength
and chrome platable, others on request

Closed material circuit,
automated material preparation as well as
material feeding and parts removal



ZINC DIE CASTING

Production in Germany,
Bosnia and Herzegovina, France,
India and Indonesia

All production sites are certified
according to ISO 9001:2015

42 machines

Machine manufacturer: Frech

Clamping forces: 20 - 315 t

Max. tool clamping area: 900 x 550 mm

Parts weights: 3 - 3,000 g

Zinc alloys:

- Z410 acc. to DIN1743
- Z430 acc. to DIN1743
- more on request

3 automated special machines for
the thread production



ALUMINIUM DIE CASTING, FORGING AND FRICTION WELDING

Facts	Aluminium die casting	Aluminium forging	Aluminum friction welding
Production in Germany	9 machines for aluminium die casting	1 machine for aluminium forging	Manufacturer: KUKA
Certified according to ISO 9001:2015 and ISO 50001:2011	Clamping forces: 220 - 1,250 t	Pressing force: 800 t	Diameter: up to Ø 90 mm
80 employees	Manufacturers: Frech, Bühler, Italtipresse	Manufacturer: Weingarten	Welding force: up to 20 t
5,000 m ² area under roof	11 machining centres	Part weight: up to 4,000 g	Total length of the parts: up to 1,600 mm
3 Melting furnaces (2 tilting furnaces and 1 shaft furnace)	Max. tool clamping area: 1,500 x 1,500 mm	Forging alloys: AlMgSi0.5 / AlMgSi1 others on request	Suitable for: <ul style="list-style-type: none">• Aluminium• Copper• Steel / various alloys
Fully automatic robot removal with deburring press	Part weight: 50 - 12,500 g		
Own water treatment			



STEEL AND STAINLESS STEEL PRECISION CASTING

Production in Serbia

Certified acc. to ISO 9001:2015

192 employees

10,479 m² area under roof

4,000,000 parts per year

400 t of material per year

Part weight: 5 g - 10 kg

Component lengths: up to 250 mm

Steel and stainless steel
in various qualities and alloys

Heat treatment of steel:

- Hardening / Case hardening
- Tempering

Tolerances according to VDG P690 D2

Surface quality up to N8 (Rz = 16 - 25 µm)
possible without reworking



PROFILE EXTRUSION

Production in Spain and England

Both production sites are certified to ISO 9001:2015, the plant in Spain is also certified to ISO 14001:2015 and IATF 16949:2016

7 lines for EPDM

2 lines for PVC

1 line for TPE

5 injection moulding machines (50 - 100 t) for the production of corners

Manufacturers: Gerlach, Itaigum

Materials:

- EPDM
- NBR
- PVC
- TPE

Sealing profiles with and without metal reinforcement, as mono and bi profiles

Production of rings and frames, as well as ready-made lengths

Profiles with bonded coatings, flock and adhesive tapes



PUNCHING, BENDING AND METAL WORKING

Production in Germany,
Bosnia and Herzegovina

Both production sites are certified
according to ISO 9001:2015

46 machines

Manufacturers: Edelhoff, Kaiser, Leinhaas,
Exner, Burger, Walter, Ruhrmann

Pressing force: 80 - 250 t

Material thicknesses: 1 - 5 mm

Materials:

- Steel
- Stainless Steel
- Aluminium
- Brass



CUTTING

Production in Germany,
Bosnia-Herzegovina and China

All production sites are certified
according to ISO 9001:2015

3 rotary indexing tables

4 cam-controlled single-spindles / automatic
lathes

13 CNC single-spindle automatic lathes

Manufacturer: Pfiffner, Index, Traub, Ergomat

Series production: 100 - 100,000 pieces

Turning part diameter: $\varnothing 2 - \varnothing 65$ mm

Turning part length: 5 - 300 mm from the bar

Materials:

- Plastic
- Zinc
- Aluminium
- Steel
- Stainless Steel
- Non-ferrous metals

4 axis machining

Driven tools

Polygon turning

Simultaneous machining with up to 16 tools

Dimensional accuracy up to H7 (0.02 mm)
without rework

Slugless cutting



POST-PROCESSING / CNC

Production in Germany,
Bosnia and Herzegovina, France and China

All production sites are certified
according to ISO 9001:2015

34 CNC machining centres, 3 - 4 axes

23 lathes

9 grinding machines

14 drilling machines

8 threading machines

6 belt grinders

4 milling machines

2 lathes

Series production: 5 - 10,000 pieces

Materials:

- Steel
- Stainless Steel
- Non-ferrous metals
- Aluminium
- Zinc
- Plastic



ACCREDITED

EMKA TEST LABORATORY



The scope of DIN EN ISO/IEC 17025:2018-03 covers a wide range of simulations and test methods performed by the EMKA test laboratory team in Wuppertal.

This confirms:

The EMKA test laboratory fulfills not only the requirements of the quality management system but also all technical prerequisites. It also has the high level of technical competence to perform independent tests in accordance with the current standard.

Due to the affiliation of the DAKKS to the International Laboratory Accreditation Cooperation (ILAC), the accreditation is also internationally recognized.

Testing options

3D printer for plastic

Climate and humidity test

IP protection class test

Endurance and lifetime test

IK test

Vibration test system

Corrosion test

Tensile-compressive strength test

Torque measurement

Hardness test

Spectral analysis



SALES WORLDWIDE



Kittsee, Austria



Interlaken, Switzerland



Veghel, Netherlands



Bourré, France



Arnedo, Spain



Coventry, UK



Pastrengo, Italy



Myslowice, Poland



Slavonski Brod, Croatia



Sfântu Gheorghe, Romania



Kiev, Ukraine



Täby, Sweden



Çerkesli-Dilovaşı, Turkey



Dubai, UAE



Tianjin, China



Middletown, USA



Santiago de Querétaro, Mexico



Bangalore, India



Bandung, Indonesia



Tullamarine, Australia

A STRONG PARTNER BY YOUR SIDE

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