

1.1. Main features of the machines:

Manufacturer	SCHLOEMANN/SIEMAG, GERMANY ASMAG, AUSTRIA ELPHIAC, BELGIUM
Year of manufacture	1980 ELPHIAC induction heating furnace 1980 SCHLOEMANN press 2004 ASMAG downstream services *This Extrusion Line has been overhauled in 2020.
Extrusion force	- Main ram: 22,06 MN - Advance side cylinders : 3,08 MN - Container shifting: 4,02 MN - Total: 29,16 MN
Piercer	- Force: 3,97 MN - Mandrel stroke: 850 mm.
Bar finished diameter	Up to \varnothing 110 mm.
Length of straight products	26 mt. 3 to 8 mt. after sawing machine
Finished diameter in coil	\varnothing 6 – 40 mm.
Coil diameter	- Internal diam.: \varnothing 700 mm. - External diam. : \varnothing 1'300 mm. - Height 200 mm.
Number of cooling buckets	40
Capacity	4000 ton/year
Dimensions(L*W*H)	60m*25m*5m
Electricity Usage	1000 Kw/h

1.2. Line composition

The following units mainly compose the line:

Billets saw
Billets transfer system
Induction heating furnace (ELPHIAC made)
Extrusion press
Cooling bed for straight lengths (ASMAG made)
Coil basket conveyor system (ASMAG made)
Cut-to length line for bars after the cooling bed
Electric equipment
Hydraulic equipment
Spares and tooling
Drawings and manual