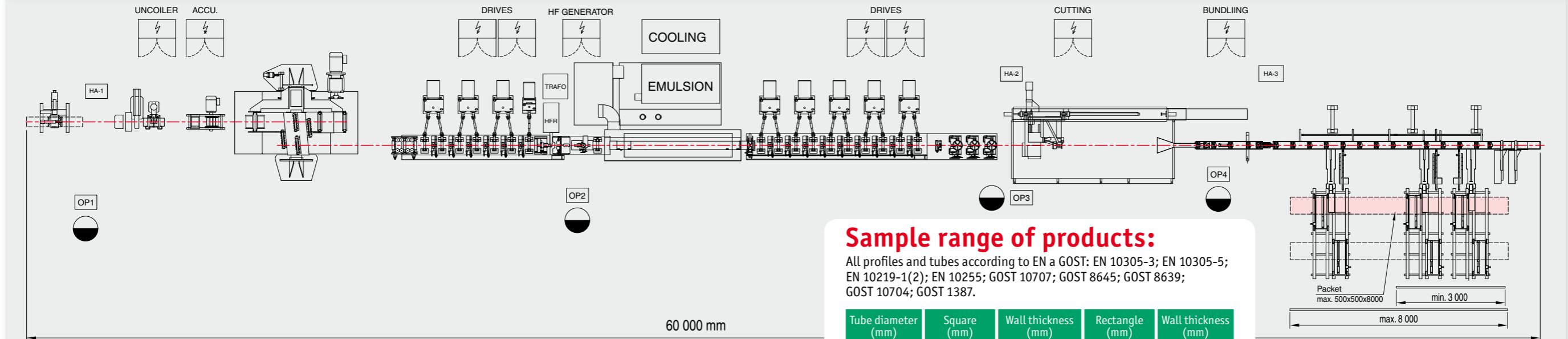
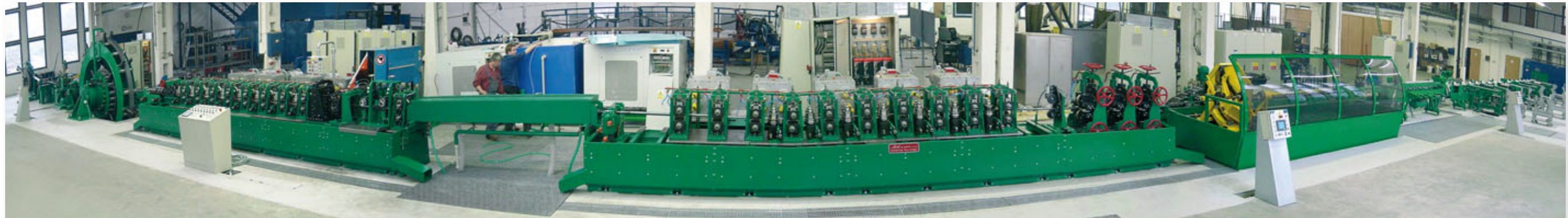


TUBE MILL

Tr ø 76 x 3,2 mm

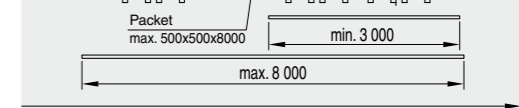
SP 3,2 - 15/250/500/120/9PB



Sample range of products:

All profiles and tubes according to EN a GOST: EN 10305-3; EN 10305-5; EN 10219-1(2); EN 10255; GOST 10707; GOST 8645; GOST 8639; GOST 10704; GOST 1387.

Tube diameter (mm)	Square (mm)	Wall thickness (mm)	Rectangle (mm)	Wall thickness (mm)
18	14 x 14	0,8 ÷ 1,5		
20	15 x 15	0,8 ÷ 1,8	20 x 10	
21	16 x 16		25 x 10	0,8 ÷ 1,8
22	18 x 18	0,8 ÷ 2,0	20 x 15 25 x 10	0,8 ÷ 2,0
24	18 x 18	1,0 ÷ 2,0	25 x 15 30 x 10	1,0 ÷ 2,0
25	20 x 20		25 x 15 30 x 10	1,0 ÷ 2,2
26	20 x 20	1,0 ÷ 2,2		
32	25 x 25	1,0 ÷ 2,4	30 x 20	1,0 ÷ 2,4
33,7				
38	30 x 30	1,0 ÷ 3,0	35 x 25 40 x 20 45 x 15	
42,5	32 x 32		40 x 25 45 x 20 50 x 15	1,0 ÷ 3,0
45 48,3	35 x 35		40 x 30 45 x 25 50 x 20	
50	40 x 40	1,2 ÷ 3,2	50 x 30 45 x 35 60 x 20	
51				
57	45 x 45	1,2 ÷ 3,2	45 x 40 50 x 40 60 x 30	1,2 ÷ 3,2
60,3				
63,5	50 x 50		60 x 40 70 x 30	
76	60 x 60	1,4 ÷ 3,2	70 x 50 80 x 40	1,4 ÷ 3,2



Mill characteristic:

Most common production mill with the outstanding VAK accumulator, HF welding generator, ability to cut the products by interchangeable cold saw or by shearing, packeting final products from 6 to 12 m by using CNC AUT 8000 or CNC AUT 12000. The mill can be advantageously modified by adding the RVS system for quick change of a product type. As standard, the mill is equipped with ET-S longitudinal weld quality control unit, using eddy currents. If using galvanized material, additional galvanizing of the weld can be ordered.

Technical parameters:

Line speed max.	80 ÷ 120	m/min
Service length	1,0 ÷ 2,5	m
Length tolerance at 25 m/min	±0,5	mm
Production lengths	3,0 ÷ 8,0	m
Length tolerance at 60 m/min	±1,5	mm
Power input for strip preparation section	50	kW
Power input for forming section	100 ÷ 140	kW
HF welder power input	150 ÷ 300	kW
Flying cutoff and HA power input	60 ÷ 90	kW
Total installed power input approx.	500	kW
Approximate mill dimensions-length x width x height	60 x 8 x 3	m

Characteristics of entry material:

Material according to EN: S235JRG1, S275JR, S355JR. Stainless steel; aluminum; Galvanized steel - according to the customer requirements.

Strip width	50 ÷ 250	mm
Strip thickness	0,8 ÷ 3,0	mm
Breaking limit Rm max.	560	MPa
Yield point Re max.	430	MPa
Ductility A ₉₀ min.	18	%
Coil specifications:		
Inner diameter min./max.	508 / 610	mm
Outer diameter min./max.	1400 / 1800	mm
Coil weight max./min.	3 000 / 1 800	kg

Possibility to produce other profiles:

