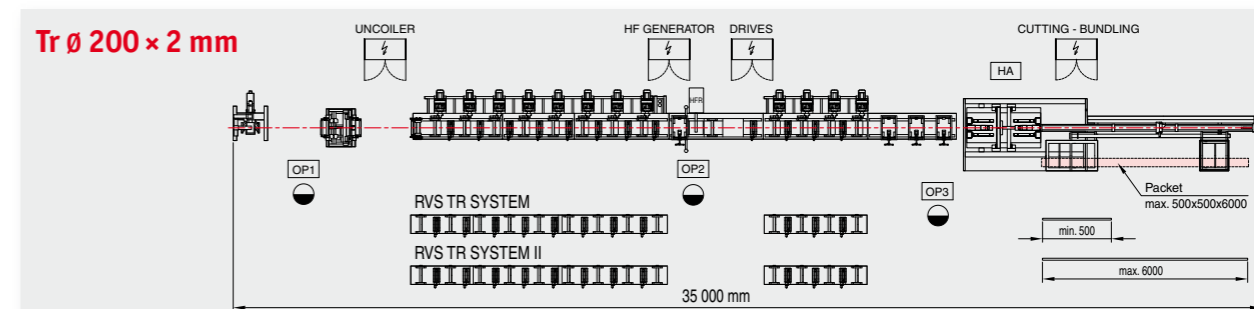
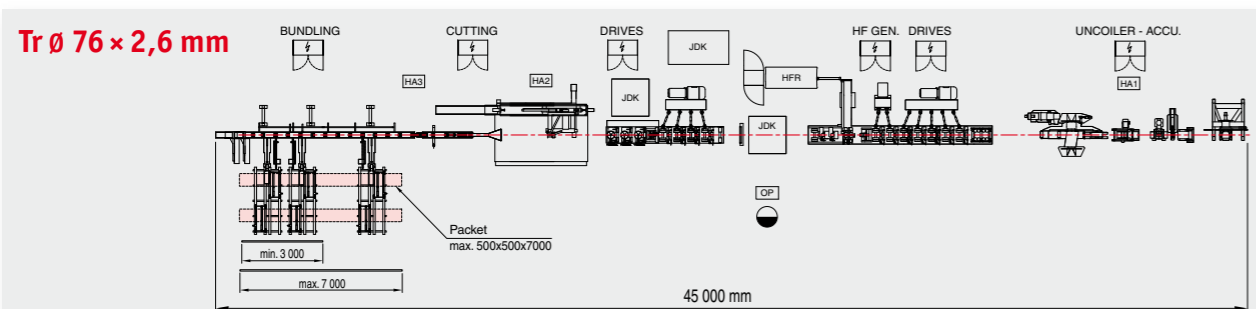
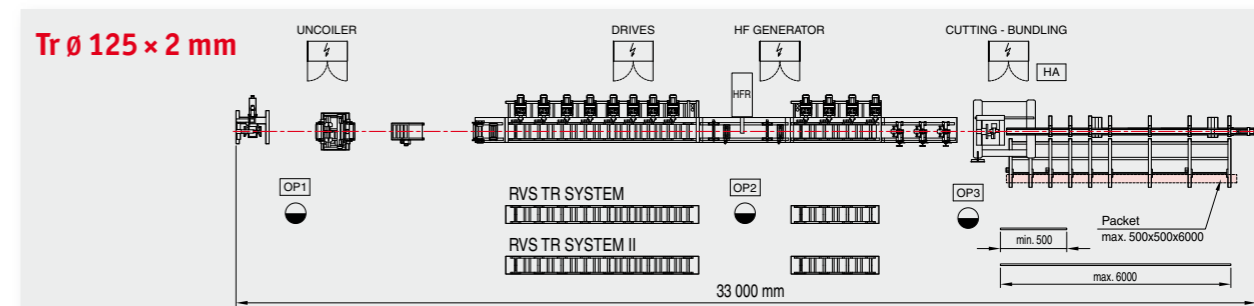
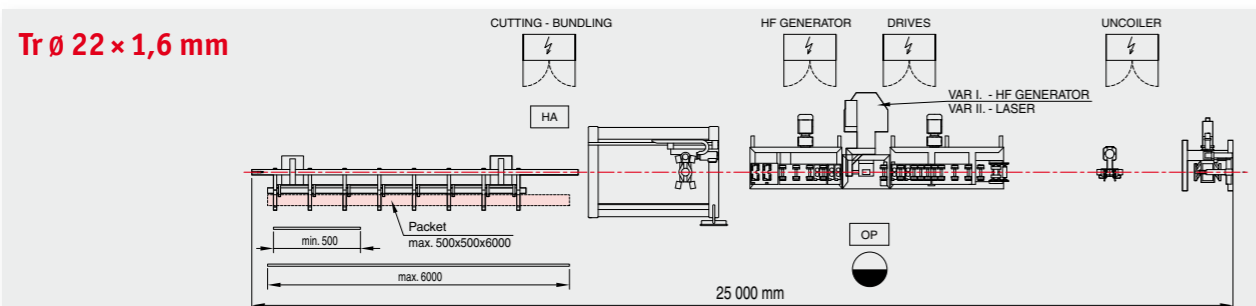


SPS - TUBE MILLS TO MAKE STAINLESS STEEL PROFILES AND TUBES WELDED BY LASER

Tr Ø 22 x 1,6 mm; Tr Ø 125 x 2 mm
Tr Ø 76 x 2,6 mm; Tr Ø 200 x 2 mm

Attl a spol. s.r.o.
Továrna na stroje



Sample range of products:

All profiles and tubes according to EN10217-7, EN10296-2.

Tube diameter (mm)	Square profile (mm)	Wall thickness (mm)	Rectangle (mm)	Wall thickness (mm)
6 ÷ 11		0,15 ÷ 1,0		
12,8	10 x 10	0,15 ÷ 1,2	15 x 5	0,15 ÷ 1,2
13 ÷ 16				
16	12 x 12		15 x 10	
19	15 x 15	0,2 ÷ 1,5	20 x 10	0,2 ÷ 1,5
25	20 x 20		20 x 15 30 x 10	
26	20 x 20	0,2 ÷ 1,6	25 x 15 30 x 10	0,2 ÷ 1,6
32	25 x 25	0,2 ÷ 1,8	30 x 20	0,2 ÷ 1,8
38	30 x 30		35 x 25 40 x 20 45 x 15	
45	35 x 35	0,8 ÷ 2,0	40 x 30 45 x 25 50 x 20	0,8 ÷ 2,8 0,8 ÷ 3,0
50 51	40 x 40		50 x 30 45 x 35 60 x 20	
57	45 x 45		45 x 40 50 x 40 60 x 30	
63,5	50 x 50	0,8 ÷ 2,6	60 x 40 70 x 30 70 x 50 80 x 40	0,8 ÷ 2,6
76	60 x 60			
76 ÷ 114		1,2 ÷ 3,0		
114 ÷ 127				
130 ÷ 159		1,4 ÷ 3,0		
159 ÷ 216				



Characteristic of the mills:

The SPS type of mills use laser welder by Trumpf or Rofin. The mills can include brushing of the weld or of the entire diameter of the tube. Furthermore, the mill can be equipped with rolling out of the inner bead or with the inner bead scarfer and chopper.

Technical parameters:

Line speed max.	20	m/min
Production lengths	0,5 ÷ 6,0	m
Length tolerance at 15 m/min	±0,4	mm
Installed power input for forming section	5 ÷ 100	kW
Welder power input	1 ÷ 15	kW
Total installed power input approx.	50 ÷ 300	kW
Approximate mill dimensions - length	15 ÷ 60	m

Characteristics of entry material:

Material according to EN/AISI:
1.4301/304; 1.4306/304L; 1.4436/316.

Strip width	20 ÷ 640	mm
Strip thickness	0,15 ÷ 2,6	mm
Breaking limit max.	610	MPa
Yield point Re max.	320	MPa
Ductility A80 min.	50	%
Coil specifications:		
Inner diameter min./max.	400 / 500	mm
Outer diameter min./max.	1200 / 1800	mm
Coil weights min./max.	2000 / 4000	kg

Possibility to produce other profiles:

