

# Aluminium Tube Manufacturing Plant

## Full Specifications

### Extrusion Presses

- **SOLD** Kobe CNC 4 column tail rod piercing press; nominal extrusion force 4000t direct; 3500t indirect; nominal piercing force 1000t; mandrel arresting force 1000t; billet size length indirect 400mm-750mm indirect; direct 900mm, container size length 1000mm; container size dia 285mm – 355mm; main ram stroke 2010mm; piercer stroke 1100mm, die shuffle; parallel die in container; Hydraulic media is 46 AWP mineral oil; Symax Sq D PLC electrical control system; cctv monitoring; outside max extrusion dia. 200mm, outside min 30mm; inside dia. max 171mm (180 trialed), inside 20mm; Automatic billet feed system; 2 billet pre heat furnaces with measuring machine; 6 JLS Dye pre heating furnaces; Smith 40m run out table with puller; Smith stretcher, head and tailstop, transfer table, 8 air quenching fans, spray water quenching fans; Bultman cut off saw; Mair 6m packaging system with weighing system, mandrel retainer, 120t autostretching, sprinkler system & pumping station. Full set of drawings & comprehensive inventory of mandrels, dies & spares. Installed 1988/89
- Loewy 5000t 4 column floating mandrel piercing press; container size diameter 16" & 20", container size length 1350mm, billet size length 1000mm, nominal piercing force 740t, main ram stroke 2750mm, piercer 1200mm, run out bolster, taper die in container, hydraulic media is , Symax SQ D PLC electrical control, outside max extrusion dia. 332mm, outside min 50.8 solid, 76.2mm tube, inside dia. max 310mm, inside min 50.8mm; Loewy and Hauhinco throw pumps, 4200psi system pressure, 4 water bottles backed by 3 banks of 4 air bottles; water softening plant, 30m run out table, 30m Tube transfer conveyors, 30m quench bath, Smith Stretcher with head/tail stops, automatic bandsaw, Fielding over line cctv monitoring, auto eject cycle system and die recovery. Full set of drawings, comprehensive inventory of mandrels, dies & spares
- Fielding and Platt 1600t 3 column porthole extrusion press, container size 7.25" dia, container size length 700mm, billet size length 680mm, main ram stroke 1670mm, die slide (c2004), hydraulic media is 100 AWP mineral oil, relay controls, outside max extrusion dia 100mm, hydraulic log feed table, depalletising system with billet pusher, Banyard pre heat billet furnace, forge measurement press load monitoring system, PLC controlled run out table 54m x 6m, with stretcher, head & tailstock, transfer and batching table; 4 station air quench conveyor, Smiths automatic hydraulic cut to length saw with run out table and transfer conveyor. Full set of drawings, comprehensive inventory of mandrels, dies & spares.

### Draw Benches

- Bultman 50 tonne, 10m max length, single bar, 300mm max OD, 75mm min OD, 9m automatic feed and 11m run off tabling, tag or internal grip (1988)
- **SOLD** Bultman GKZ300/2-10 30 tonne, 10m max length, 100mm max OD, 15mm min OD, double bar, 120m per min max, auto tube feed & take off system, in line tagging to 60mm (1988)
- **SOLD** Bultman 40/2-8.5 4 tonne (upgraded to 6 tonne) 8.5m max length, single bar, 20mm max OD, 5mm in OD, 60m per min max (1989)
- **SOLD** Kawazoe NS37-3PPB Automatic, 37 tonne, 10m max length, 150mm max OD, 25mm min OD, Kawazoe restacker, overhead gantry tube handling system (1992)
- Farmer Norton, 150 tonne, 9m max length, single bar, 600mm max OD, 120mm min OD, 35m run off tabling, quench tank

### Tube Straightening

- Bronx 6CR11 6-Roll Reeler in-feed table, in-feed and outlet trough and off take table. , (Refurbished by Bronx 2001)
- Bronx 6CR9 6-Roll Reeler, in-feed table, in-feed and outlet trough straightening roller bench. (1987)
- Bronx 6CR6 6-Roll Reeler, s/n 27470, m/c no. 4240
- **SOLD** Kawazoe NS20-60-10P-R 10-Roller Reeler, feed table, off take batching table, overhead tube handling gantry (1992)
- Bigwood 5-Roll Reeler

### Saws

- **SOLD** Bowmar SL520 automatic horizontal bandsaw with infeed / outfeed conveyor (2005)
- **SOLD** (2) Endoh Kogyo NS1580C1/ NS15128C1 in line/off line saws (1992)
- **SOLD** (2) Wagner KM55 circular saw, (c1978), with (2) weigh stations, feed conveyor 500mm x 10000mm, loading platform, log stamping, sissor lift take off

- Kasto 100mm cold saw, roller out take conveyor
- Kasto 120mm cold saw, bar feed unit, roller out take conveyor, acoustic enclosure
- Kasto 200mm Hydraulic Circular saw, 7m in-feed ,7m off take Conveyors
- Bultmann 300mm hydraulic Circular Saw, in-feed & off take conveyors transfer table (1988)
- Amada H600 band sawing machine
- Mair 4Head Multi Cut Saw (New 1987)
- Qualters & Smith B10 saw master band sawing machine
- Edwards Piccolo circular cross cut saw
- Ucimo Circular Chop Saw, manual roller conveyor, dust extraction
- Maggi Professional Pullover Cross Cut Saw

### **Chamfering, Pointing, Polishing, Finishing**

- **SOLD** Hasegana DH-2 automatic chamfering Machine, Fanuc controls, automatic TIR and length checker (2002)
- **SOLD** Hasegana DH-2 automatic chamfering Machine, DRO, AEG length checker, Fanuc controls, AEG length checker (1997)
- **SOLD** (2) Tamaki FJA-4 Chamfering Machines, Siemens DRO
- **SOLD** Kawazoe NS25-150-100S tube pointing machine (1992)
- **SOLD** SMB HE32040 honing machine, 4m capacity,PLC controller
- (3) Stevens & Bulivant 7CS/11CS/15CS tagging machines
- Robinson 4DIEC5 tagging machine
- Bigwood 100-ton and 5 ton manual stretchers
- **SOLD** Tefkin type 1629 canning scurfing and polishing machine, powered level indexing and roller feed table
- **SOLD** (3) Burrmaster Deburring Machine, Dce Uni-Master UMA454-K11 dust extraction Unit (2000)
- Production Province 4 head horizontal disc polishing machine Serial No: 7-9-1968
- (4) Canning single head polishing machines

### **Heat Treatment**

- Mitsui Kinzoku Metaloclean 1B1R degassing station, 1485x1185, external argon tank (1998) with additional base unit (unused)
- Mitsui Kinzoku Metal O Filter 1101 filtration Unit,1800 x 1865 x 1100 (2005)
- Mecatherm 30 ton homogenizing Furnace, (2) Crane Care hydraulic feed platforms, hydraulic turn table 4.5m dia, log cooler 3m x 3.5m x 2.5m high
- SAS 7-Ton 7" to 22" capacity triple column casting machine,3.5m casting length x 2m x 1.5m platen
- Arnway container pre-heat furnace,1800 x 2000mm Capacity, Rail Mounted, with Loewy Press (1999)
- **SOLD** Mechatherm 7-ton 400c sow drying furnace with rail mounted powered chain, feed tableh Eurotherm Chessell controls
- Northern Furnace 1150 degrees celsius x 17-ton melting holding furnace, extended door, 2:60% gas saving regenerative burners, Eurotherm Chessell 5180V Touch Screen monitoring controls (2006)
- PTF 1150 degrees celsius x 9-Ton gas fired melting holding furnace (1987) PTF Metal cleaning and run-off chutes and Eurotherm Chessell 5180V Touch Screen monitoring controls
- Tardis Dross 1062 EXDP cooling press, 2250PSI Max Working Pressure, 5 Dross pans
- JLS 14m double ended aging furnace, Eurotherm 6180A monitoring controls, 250 degrees c capacity
- **SOLD** JLS Double Ended 550°C x 225kW Annealing Furnace (1987), Chessell 5180 Monitoring PLC Controls
- **SOLD** JLS HE320-40 single ended 300°C electric aging furnace, Eurotherm Chessell 6180A monitoring controls
- **SOLD** JLS double ended furnace, 19m x 2m x 3m high, floor rails,2 – 15m furnace trolleys, winch, cooling station
- **SOLD** Efco end loading batch furnace, 1.85 x 10 x 2.5 high chamber, 1m x 10m in-feed trolley, 1m x 10m stack trolley (1992)
- **SOLD** (2) Efco 8m x ½-ton 540 °C vertical furnaces, Eurotherm Chessell monitoring controls, forestor drives
- (2) Efco ½-Ton x 6m x 540°C vertical furnaces,Eurotherm Chessell 6180 A monitoring controls, vertical quenching facility
- GWB 3-Zone 450°C electrically fired magnesium furnace, rail mounted, twin feed trolley

- Riello RT20 electronica 20kva furnace UPS (1993)
- Wellman Roby high pressure hot water boiler with Nu-Way Burner

### Toolroom

- Degreasing tank, 13.7m x 1.8m with controls and extraction
- **SOLD** Mazak Quick Turn 8 CNC turning centre with Mazatrol controls
- TOS 4m surface sliding and screw cutting gap bed lathe
- Stanko CC horizontal table type boring machine 1.5m x 1m table
- Webster & Bennett 36" vertical milling machine
- Dean Smith & Grace Type 25 x72 gap bed centre lathe
- Rhodes 1000 ton geared hydraulic blanking press
- (2) Bridgeport turret mills
- Bronx 90 tonne x 12ft press brake
- Crawford Swift 26/30D series 60 billet scalping lathe
- Heald No.172 horizontal die grinding machine
- Kayanson high pressure hot water boiler
- (2) Colchester Master 2500 and Student gap bed lathes
- Harrison M400 gap bed lathe
- Archdale 32.12389 1M Radial Arm drilling machine
- Keetona 8ft x 1/8th inch guillotine

### Laboratory and Test Equipment

- ARL 3460 Metal Analyser with associated equipment
- BespokeTent pole 4 head index swaging machine, lightguards, Siemens PLC controls, Flutec hydraulic power pack and cut-off cold saw
- **SOLD** Mair Tube Feed System, Pruftechnik Eddycheck 3 inductive sensor testing machine
- **SOLD** Line Marking Machine, automatic tube feeder, Domino Code Box 3 inkjet coder and off take table
- **SOLD** Browne and Sharpe P1/2 TIR length and straightening checker with PLC controls
- **SOLD** Zwick type 1488 CNC High tensile test machine
- Indentec & Howden hardness test machines
- **SOLD** Marposs Internal diameter gauge with PC
- Haskel Sat Rig High Pressure test rig
- A range of various test 7 laboratory equipment

### Air Compressors

- **SOLD** CompAir CM809 Cyclon 222 5.9 bar packaged (1998) 1000L welded steel air receiver, Ultratroc air and water separation system and Energy Air ex efficiency monitor
- **SOLD** CompAir Broomwade Cyclon 6000N type:6075N07A 7.5 bar packaged (1997)
- **SOLD** Worthington Creyssensac Rollair Type 100 A5 8 bar packaged (1988)

### Emergency Vehicles/Access Platform

- Landrover Redwing Converted Fire Engine, Reg no. 935 FNP
- Ford Ambulance Reg No: POP 463Y
- Nifty HR12NDE bi fuel 2 x 80kg personnel Z boom access platform S/n 12-8348

### Craneage

- 20 various overhead electric travelling cranes
- 20 various jibs & hoists