

ACE Group

Aluminium Extrusion Press

Qty. 1 Second-hand aluminium extrusion press incl. billet furnace

Mfc.: SMS & Junker Force: 3200 MT Billet dia.: 10"

The press had a crack in the cylinder beam – it has been removed and under heat treatment

New welded – in 2007.

Scope of supply: Press Gas heating billet furnace Billet storage & roller table

Billet shear transportation unit to billet loader

Extrusion press Mfc.: SMS Hasenclever Total force: 32.29 MN

Main piston dia.: 1200 mm Force of the main piston: 28.27 MN

Differential cylinder 2 x Ø 320/220 mm Feeding force: 4.02 MN

Retraction force: 2.12 MN Extrusion die stroke: 2 775 mm

Extrusion die speed: at 32.29 MN – 0-30.0 mm/sec. at 28.27 MN - 0-34. mm/sec.

Hydraulic pumps:

Qty. 4 HP-axial flow pumps Mfc. Brüning-Haus

Type: A4VS0500 HM2/10L-PPH13N 00-S0362

Qty. 1 HP-Pressure holding pump Mfc. Rexroth

Type: 1PF 1R4-10/16.00-500 R A01 M01

Qty. 2 LP – pumps Mfc.: Vickers

Type: 4525V60A21-86CC-20L-282

Hydraulic Valves:

Proportional direction control valves for HP-pump regulation Mfc. Hydraulik-

Ring

4/2, 4/3 etc. Directional control valves Mfc.: Rexroth, Excentra

Pilot valves Mfc.: Rexroth, Excentra

LP – Pressure control valves Mfc.: Vickers

Drive motors

Qty. 4 HP-pumps motors Mfc.: Garbe-Lahmeyer 200 kW, 985 RPM, 380/660 V

Cairo Rep. Office: ACE Group

3 Samir Mokhtar St., Ard Al Golf, Cairo – Egypt

Tel: 00202 26903100/200, Fax: 00202 26903500

E-mail: ace1@tedata.net.eg

info@aceindustry.net

website: www.aceindustry.net

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Qty. 2 LP-pump motors Mfc.: Schorch 55 kW, 1475 RPM, 380/660 V
Qty. 1 HP-pressure holding pump motor Mfc.: Schorch 11 kW, 1445 RPM, 380/660 V
Total connection power Press: 1200 kVA Container heating: 100 kVA
Press control Simatic S5 – 135U with CPU 928 (S-processor) & CPU 922 (R-processor)

Incl. computer controlled PICOS system

Container for round billet: 212 – 300 mm for flat billet: 425 x 160 mm
Billet length (warm): 1250 mm Heating system: inductive
Power: 100 kVA Temperature: 475 °C
Differential cylinder: 2 x Ø320/160 mm Container stroke: 1600 mm
Container dia.: 262 mm for round billets only!

Die – cassette pusher Telescope cylinder 1 x Ø 85/115-140/160 mm
Shear force: 0.5 MN Moving stroke: 1720 mm

Cassette changer Differential cylinder 1 x Ø 100/60 mm
Moving stroke: 660 mm

Shear Differential cylinder 1 x Ø 200/190 mm
Shear force: 0.95 MN Retraction force: 0.24 MN
Shear stroke: 1065 mm

Press rest scraper Differential cylinder 1 x Ø 50/35 mm
Moving stroke: 700 mm

Gas heated fast billet furnace with hot billet shear

Mfc.: Junker Type: GBE R 250 LM 74 V 7 F Shear – Type: WS 2000 F
Built: 1990 Connection value: approx. 210 Nm³/h Pressure: 100 mbar
Electrical connection value: 35 kW, 3x380 VAC, 50 Hz Control voltage: 220 V AC, 50 Hz, 24 VDC
Billet dia.: 254 mm Billet square: 370 x 193 mm Length: 4 – 6 m

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Output per hour:

Billet size mm	Length mm	Material	Qty.	Kg	Temp. from 20 °C to:	Consumption Nm ³ /t
Ø 254	1250	Al	35	6000	450	27
370x193	1250	Al	28.5	6000	450	30
Max. heating temp.:		560 °C		Number of control zones:		4
Length of the pre-heating part:		7000 mm		Length of the hearing part:		7000 mm
Outer length of the furnace:		14 750 mm		Noise level:		85 dB(A)
<u>Hot billet shear</u>		Shear force: 2 000 kN		Max. / min.dia.:		279/254mm
Flat billet:	370 x 193 mm		Length:		from 400 – 1250 mm	
Shear stroke: 415 mm		Cutting speed:		50 mm/sec.		
Pressure:	Shear: 265 mm		Auxiliary:		200 bar	
Electrical connection value: 90 kW, 3x380 V, 50 Hz Control volatge: 220 VAC & 24 VDC						

Spare parts

Qty. 2 Containers	Each 1 piston rod for pick-up cylinder, side movement cylinder & shear cylinder
Qty. 1 HP pump	Hydraulic cylinder for billet loader Cassette pusher
Each 1 motor for HP-pump, LP-pump & pressure holding pump	Others