

COMPLETE PLANTS

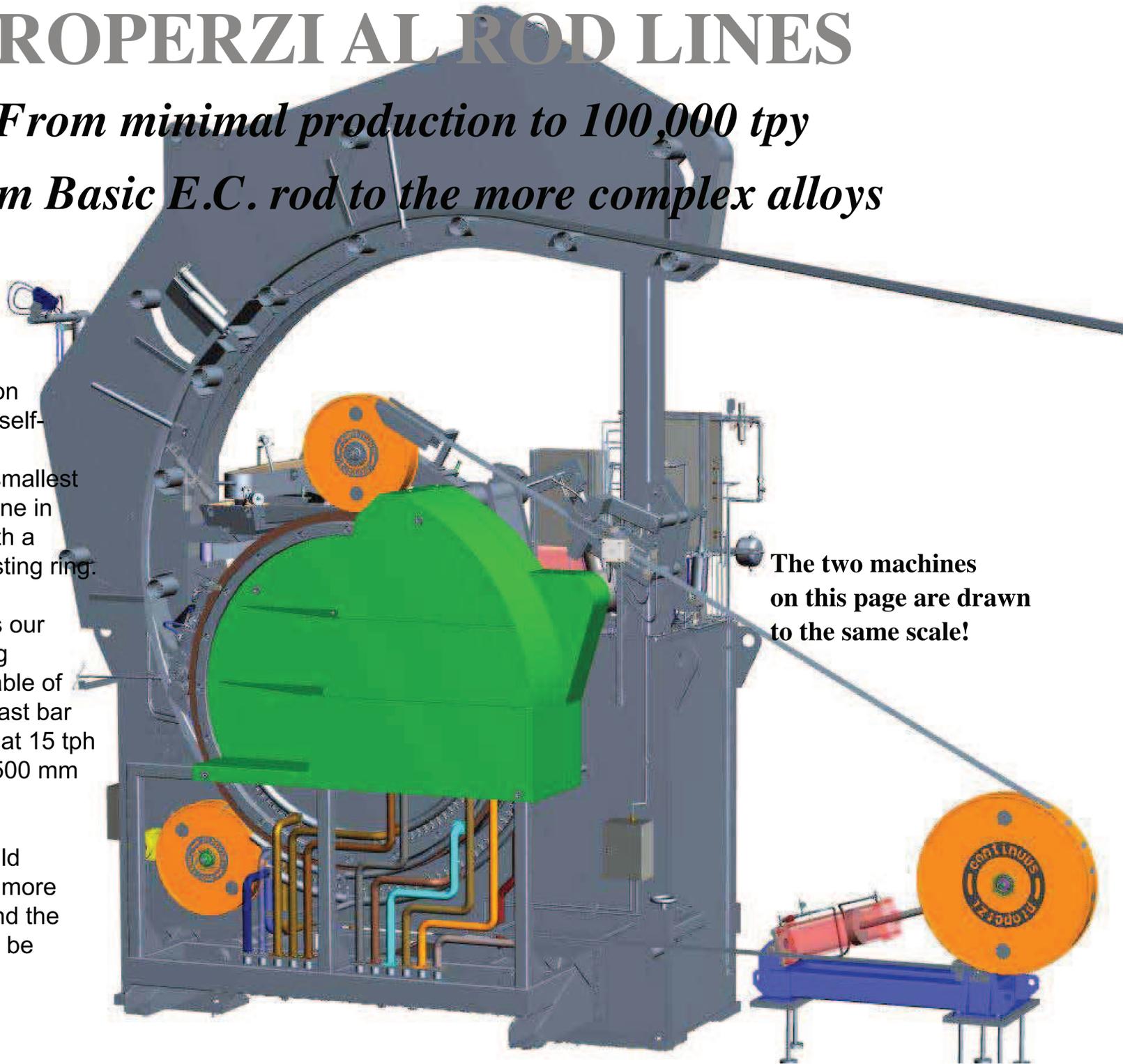
PROPERZI AL ROD LINES

From minimal production to 100,000 tpy
From Basic E.C. rod to the more complex alloys

The pictures on this page are self-explanatory. Below is the smallest casting machine in production with a 1,000 mm casting ring.

On the right is our largest casting machine capable of solidifying a cast bar of 5,500 mm² at 15 tph rate with a 3,500 mm casting ring.

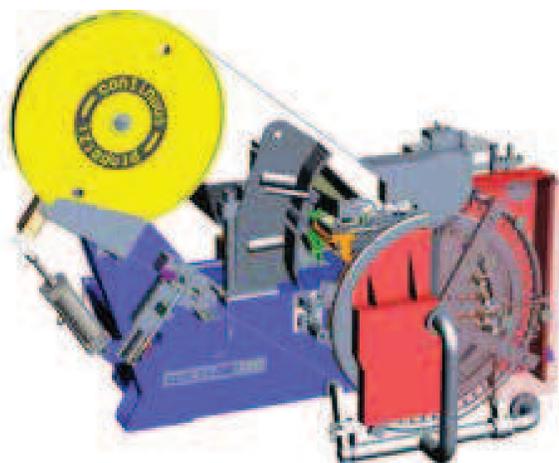
Someone could ask: Which is more advanced? And the answer would be 'both!'



The two machines on this page are drawn to the same scale!

The small one which we call CCW (Continuous Casting Wire) is dedicated to high strength mechanical and welding alloys; products requiring limited tonnages but demanding the maximum control and repeatability of the solidification parameters. Such complex 2,000-5,000-6,000 and 7,000 series alloys are increasingly required by the automotive market.

Because such alloys present some difficulties in cold working, the CCW Line rolls the cast bar down to 6 mm instead of the 9.5 mm standard size.



Three CCW lines of this type will soon be in production focusing on welding wire products.

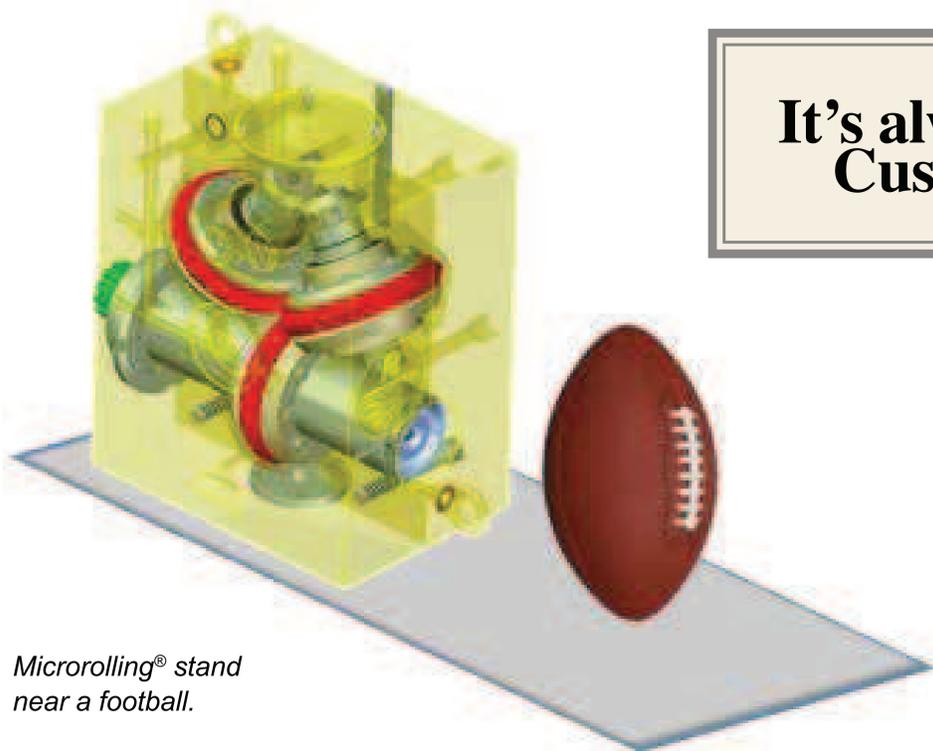
A typical second step after a CCW line of this type is cold reduction by Microrolling® from 6 mm to 2.5 mm.

The range of rolling mills is even larger than that of casting machines.

Here is a summary of our rolling mills. The smallest Microrolling® mill is equipped with 170 mm rolls followed by the mill with 180 mm rolls. These models are monoblocs with 8-12 rolling stands based on the Properzi 3H roll configuration to assure roundness within a few hundredths of a millimeter down to diameters of 1.8-2 mm!

3H stands are also available with 220 mm and 270 mm rolls.

2H stands are used to break down the cast bar and their diameters go from 180 mm to 200, 240, 300, and 400 mm rolls.



It's always possible to satisfy Customer requirements.

Microrolling® stand near a football.

The complete range of CCR Al rod lines

Output rate	Tph	Expected output 5 days/week 48 working weeks per year	Expected output 7 days/week 50 working weeks per year
SMALL	1.5	7,500	Not usual
	2.5	12,500	Not usual
	3.5	17,500	Not usual
MEDIUM	4.5	22,000	30,000
	5.0	24,500	33,000
	6.0	30,000	40,000
LARGE	8.0	Not usual	54,000
	10.0	Not usual	67,000
EXTRA LARGE	12.0	Not usual	80,000
	13.0	Not usual	87,000
	15.0	Not usual	100,000



The expected output of EC grade and OEE 85% for left column and OEE 80% for right column.

A four pass breakdown Mill for a big cast bar.