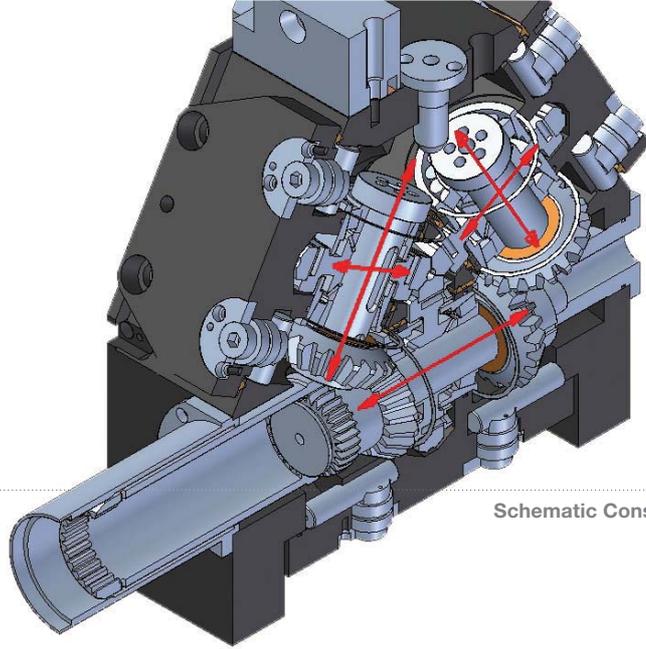


# New Stands Type Model 11

10 *Technology*



Schematic Construction Stand

During the past 20 years many aluminum and copper lines around the world have been equipped with the Model 9 mini stands. The larger parts of these types of stands, such as the body and the housings for the primary and secondary rolls, were obtained starting from a welded structure or a die casting. Both of these were good solutions but had limitations such as voids, inclusions, or weld issues, which required particular attention during the internal quality certification process of each stand.

Recently Continuous-Properti transitioned to new machine tools technology and modernized their Production Department by purchasing some new machining centers. Shortly thereafter, with a complete new 5 axis CNC flexible manufacturing system, we were producing very high quality stands (body and housings for primary and secondary rolls) while reducing the required production time.

The advantage of using these types of machining centers is that they permit us to begin with a monolithic piece of steel that is cut from a rolled bar. Therefore, there are no voids, inclusions or welding deficiencies.

The precision and tolerances we can obtain with this new technology permit us to modify the stand design by simply having a fixed position on the primary roll housing. The primary roll has only one free plane and the centering is

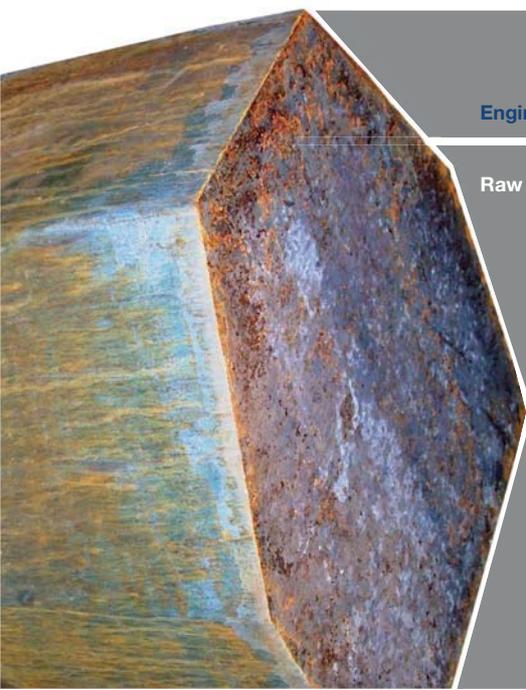
accomplished by two eccentric pins. The secondary rolls maintain the previous configuration where the two free planes are properly positioned with shims while the centering is accomplished by two eccentric pins.

The nickname of this simplified and more advanced stand (less number of pieces compared to its older brother) is "Model 11". Positioning and centering of the rolling rolls is performed by means of a special optical projector. The projector and relevant lamps can be quickly mounted; one lamp on the entry guide and the other on the exit guide.

In the Model 11 stand, the calibration operation using the optical projector has become easier and faster because the primary rolls are already in the correct position.

The new Model 11 stand has a theoretical diameter of the working rolls equal to 220mm and will be a welcome addition to our family of rolling stands. The Model 11 will join the Model 9 and Model 9 Mini (working rolls of 270mm and 180mm respectively) that have already given us and our customers much satisfaction.

The entire Continuous-Properti team wishes you tons and tons of good quality rod production using our new Model 11 stand! *by Michelangelo Nidasio*



Engineering + know how + modern tools

Raw material

Finished stand

