



MET-TECH | Product Data Sheet

EXTRUSION PRESS LINE - 3500 MT - DIA. 343 x 900 MM - 315 BAR

Ref. No.: EXTRUSIONPRL171001

Year: 1960 - 2013

Brand: ALLEN BRADLEY, 3TC, REXROTH ETC.

Subj.: Offer about second-hand extrusion press line ? 3500 MT

Dear Mr,

We have pleasure to provide you with an offer about second-hand extrusion press line

that is immediately for sale.

Qty. 1 Second-hand extrusion press line

Mfc.: 3TC, Allen Bradley, Rexroth, Gautschi, Elhaus, Nederman, Hydrotec, Marx GmbH,

Truninger, Ekatech

Force: 3500 MT Built

Billet dia.: 343 mm x 900 mm (can be modified 14? x 1.0 m)

Modernisation:

2011 Complete exchange of control system on press to Allen Bradley Control Logix including

encoders for Ram, Container and Shear.

Change of pump controls to Bosch Rexroth HS4.

2012 Complete change of hydraulic system (excluding pumps).

New side cylinders and container cylinders.

Safety rebuild of press and with change of PLC to Allen Bradley Control Guard Logix L72S (which is the current CPU).

Change of control system of billet furnace. Complete new electrical system and integration of logic into the press PLC.

Modernisation of gas burners in the furnace.

2013 Change of one of the main pumps to Bosch Rexroth A4VSO355 and new 200 kW,

1500 rpm motor.

The container heating system is also new!

Specification

Billet furnace: Mfc.

Extrusion Press Mfc.: 3TC Built

Weight of the press: 340 T Pressure

Dia. of the main piston: 1200/460 mm

Stroke length of the pressing group: 2120 mm

Operation stroke speed ? automatic: 0.1-10 mm/sec. remote control

Retreat speed: up to 300 mm/sec.

Working pressure: 320 kp/cm²

Vertical shear Pressing force: 157 Mp Piston dia.

Knife speed: 200 mm/sec. Knife stroke

Container length: 1.0 m (can be modified 1.1 m)

3 x Bosch Rexroth A2V500 + 250 kW 1000 rpm motor

1 x Bosch Rexroth A4V355 + 200 kW 1500 rpm ABB motor

PLC system Allen Bradley Control Logix L72S PanelView Plus 1500

Point I/O with Ethernet I/P

Encoders with SSI for Ram, Container and Shear

New container heating system by Marx Iselohn Control: Panel View Plus 1000

Water quenching unit (tank) Mfc.: TBA

Double puller Mfc.: Smith Engineering A/S Built

Stretcher: Mfc.

Force: 200 kp Chain speed

Length of extrusion: 5.7 ? 33 m (1.5 m HS stroke) Stroke of cylinder

Vertical stroke: 20 ? 60 mm

Jaw opening: 0 ? 350 mm Jaw width

Hydraulic power supply Stretching pull: 25 mm/sec. (up to 125 t)

Piston return speed: 160 mm/sec. Max. pressure

Pump mototr: 45 kW, 3 ph., 380 V, 50 Hz, 1450 RPM

Qty. 2 Dies Furnaces Mfc.: Gautschi Built

Cutting chips unit Mfc.: Nederman Built

Scrap system Mfc.: Ekatech System Industrieautomatik

Container pre-heating oven

Container crane

Note: Press had some cracks and it has been welded and made ultrasonic test!