



PRODUCTION PARAMETERS

ALUMINUM SOLUTIONS FOR INDUSTRY

16 EXTRUSION PRESSES

TYPE	1x1000 T	1X1300 T	3x1600 T	4x1800 T	1x2200 T	4x2500 T	1x3500 T	1x4500 T*
Weight								
Minimum weight / m	80 gr/m	80 gr/m	80 gr/m	200 gr/m	500 gr/m	500 gr/m	1500 gr/m	2500 gr/m
Maximum weight / m	600 gr/m	750 gr/m	750 gr/m	1500 gr/m	2500 gr/m	2500 gr/m	4500 gr/m	20000 gr/m
Diameter circumscribed profile								
Tubular profiles	120 mm	140 mm	140 mm	160 mm	210 mm	210 mm	400 mm	530 mm
Flat profiles	140 mm	160 mm	160 mm	185 mm	230 mm	230 mm	420 mm	550 mm
Length of cut								
Minimum	3 m	3 m	3 m	3 m	3 m	3 m	3 m	3 m
Maximum	7,5 m	8 m	8 m	12 m	15 m	15 m	15 m	24 m
Standard	6,5 m	6,5 m	6,5 m	6,5 m	6,5 m	6,5 m	6,5 m	6,5 m
Alloys								
Type	6060, 6063, 6463, 6005 A	6060, 6063, 6463, 6005 A	6060, 6063, 6463, 6005 A	6060, 6063, 6463, 6005 A, 6082, 6106	6060, 6063, 6463, 6005 A, 6082, 6106	6060, 6063, 6463, 6005 A, 6082, 6106	6060, 6063, 6005 A, 6082, 6106	6060, 6063, 6005 A, 6082, 6106
Minimum order								
Quantity	500 - 750 kg	500 - 750 kg	500 - 750 kg	750 - 1000 kg	1000 - 1500 kg	1000 - 1500 kg	2000 - 3000 kg	3000 - 5000 kg

* Available September 2018

TABLE OF MINIMUM THICKNESSES

Minimum circumscribed diameter	EN-AW 6060 EN-AW 6063	EN-AW 6005	EN-AW 6082
Tubular profiles			
≤ 100	1	1,5	1,8
≤ 200	1,8	2	2,2
≤ 300	2,2	2,5	3
≤ 400	2,6	3	3,5
Flat profiles			
≤ 100	1	1,5	3
≤ 200	1,6	2,2	3,5
≤ 300	2,4	2,8	4
≤ 400	3,2	3,5	4,5

* General thickness. Consult other thicknesses.

GENERAL CHARACTERISTICS

Maximum extruded profile length	45 m
Maximum length tempered profile	24 m
Maximum circumscribed diameter	550 mm
Minimum circumscribed diameter	10 mm
Maximum profile weight	20000 g/m
Minimum profile weight	80 g/m
Alloys	6000 (Al+Mg+Si)

ALLOYS TABLE

Alloy	Alloy type	Tempering	Mechanical properties		
			Proff stress (Mpa)	Tensile strength (Mpa)	% Elongation
6005	AlSiMg(A)	T4	90	180	15
		T6	200-225	250-270	8
6060	AlMgSi	T4	60	120	16
		T5	100-120	140-160	8
		T6	140-150	170-190	8
		T64	120	180	12
		T66	150-160	195-215	8
6063	AlMg0.75Si	T4	65	65	14
		T5	110-130	160-175	8
		T6	160-170	195-215	8
		T64	120	180	12
		T66	180-200	245-225	8
6082	AlSiMgMn	T4	110	205	14
		T5	230	270	8
		T6	250-260	290-310	8-10
6106	AlMgSiMn	T6	200	250	8-6
6463	AlMg0.75Si	T4	75	125	14
		T5	110	150	8
		T6	160	195	10

* EN 755-2

PRODUCTIVE CAPACITY **120,000 t/year**

6 ANODIZING PLANTS

Types of plant	100.000 A 80.000 A 60.000 A 2 x 48.000 A 40.000 A
Maximum profile length	8000 mm
Colours	13 colours: Natural, inox, ivory, bronze, gold, champagne, black, bordeaux, cooper, blue, green, acier & grey.
Mechanic treatments	Light emery, hard emery, bright polished, polished, repolished
Classes of anodic protection	Clase 5: 5-9 microns Clase 10: 10-14 microns Clase 15: 15-19 microns Clase 20: 20-24 microns Clase 25: 25-29 microns

2 CHEMICAL BRIGHTENING

Types of plant	5.000 A 4.000 A
Colours	Gold, black, silver
Tratamientos mecánicos	Bright polished, Light emery polished
Class	Class 5 - 10 microns

13 ASSEMBLY OF THERMAL BREAK LINES

Type of assembly	Standard Horizontal and vertical polyamide assembly in the same profile
Polyamide	Own production
Maximum height polyamide	52 mm
Max profile length	10.000 mm
Maximum profile height	490 mm

15 POWDER COATING PLANTS

Types of plant	4 Vertical powder coating plant 4 Horizontal powder coating plant 7 Carousel powder coating plant
Wood effect	4 Lines of imitation wood effect
Maximum length in horizontal line	8000 mm
Maximum length in vertical line	7500 mm
Powder coating type	RAL Chart NCS Chart Antibacterials - Specials Textures - Metallic Wood effect

11 CNC MACHINES UP TO 5 AXES

Useful length	11.000 mm
Useful Width	4100 mm
Axle stroke C	+90° or -90°
Types of machining	Precision cutting Tridimensional cutting Edge removed process Milling: Radial and Peripheral Louvres punched Drilled Threaded Punched
Precision cutting	Precision cuts at any type of angle required Cutting tolerances up to + - 0.2 mm