

18 EXTRUSION PRESSES

TYPE	1 x 1000 T	1 x 1500 T	1 x 1600 T	6 x 1800 T	1 x 2200 T	6 x 2500 T	1 x 3500 T	1 x 4500 T
Weight								
Minimum weight/m	40 gr/m	60 gr/m	60 gr/m	200 gr/m	500 gr/m	500 gr/m	800 gr/m	1200 gr/m
Maximum weight/m	600 gr/m	750 gr/m	750 gr/m	1000 gr/m	2500 gr/m	2500 gr/m	5000 gr/m	29.000 gr/m
Circumscribing circle diameter								
Tubular profiles	100 mm	120 mm	120 mm	140 mm	180 mm	180 mm	400 mm	530 mm
Flat profiles	120 mm	140 mm	140 mm	160 mm	210mm	210 mm	420 mm	550 mm
Cutting lenght								
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	6060, 6063, 6463, 6005	6060, 6063, 6463, 6005	6060, 6063, 6463, 6005, 6082, 6106	6060, 6063, 6463, 6005, 6082, 6106	6060, 6063, 6463, 6005, 6082, 6106	6060, 6063, 6005, 6082, 6106	6060, 6063, 6005, 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

MINIMUM THICKNESS TABLE

MINIMUM CIRCUMSCRIBING CIRCLE DIAMETER	EN-AW 6060 EN-AW 6063	EN-AW 6005	EN-AW 6082
Tubular profiles			
≤ 100	0,9	1,5	1,8
≤ 200	1,8	2	2,2
≤ 300	2,2	2,5	3
≤ 400	2,6	3	3,2
≤ 530	3,0	3,2	3,5
Flat profiles			
≤ 100	0,9	1,5	2,2
≤ 200	1,6	2,2	2,5
≤ 300	2,4	2,8	2,8
≤ 400	3,2	3,5	3,5
≤ 550	3,7	3,7	3,7

*General thickness. For other ones, please consult.

GENERAL CHARACTERISTICS

Maximum lenght extruded profile	45 meters
Maximum lenght tempered profile	24 m
Maximum circumscribing circle profile	550 mm
Minimum circumscribing circle profile	10 mmz
Maximum profile weight	29 kg/m
Minimum profile weight	40 g/m
Alloys	1000 (Al) - 6000 (Al+Mg+Si)

ALLOYS TABLE

Alloy	Alloy type	Tempering	Mechanical properties		
			Proof stress (Mpa)	Tensile strenght (Mpa)	Elongation %
1050	Al		60	23	25
6005	AlSiMg (A)	T4 T6	90 200-215	180 250-255	15 8
6060	AlMgSi	T4 T5 T6 T64 T66	60 100-120 140-150 120 150-160	120 140-160 170-190 180 195-215	16 8 8 12 8
6063	AlMg0.75Si	T4 T5 T6 T64 T66	65 110-130 160-170 120 180-200	130 160-175 195-215 180 245-225	14 7-8 8 12 8
6082	AlSiMgMn	T4 T5 T6	110 230 250-260	205 270 290-310	14 8 8-10
6106	AlMgSiMn	T6	200	250	8
6463	Almg0.75Si	T4 T5 T6	75 110 160	125 150 195	14 8 10

PRODUCTION CAPACITY: 139.000 tonnes

6 ANODISING PLANTS

Types of plants	1 x 100.000 amperes 2 x 80.000 amperes 1 x 60.000 amperes 1 x 48.000 amperes 1x 40.000 amperes
Maximum profile length	8 meters
Colours	13 colours: Silver, Inox, ivory, bronze, gold, champagne, black, bordeaux, cooper, blue, green, acier and grey.
Mechanical treatments	Matt-grain, rough brushed, bright, brushed, polished, re-polished and combinations of any of these finishes.
Anodic protection	Class 5: 5-9 microns Class 10: 10-14 microns Class 15: 15-19 microns Class 20: 20-24 microns Class 25: 25-29 microns

2 CHEMICAL BRIGHTENING PLANTS

Types of plants	2 x 10.000 amperes
Maximum profile length	3,5 meters
Colours	Gold, black, silver.
Mechanical treatments	Bright polished, Light emery polished
Anodic protection	Class 5: 5-10 microns

15 THERMAL BREAK ASSEMBLY LINES

Tipo de ensamblado	Standard Horizontal and vertical polyamide assembly in the same profile
Poliamyde	Own production
Maximum polyamide height	52 mm
Maximum profile length	10 meters
Maximum profile height	490 mm

15 POWDER COATING PLANTS

Types of plants	7 vertical powder coating plants 3 horizontal powder coating plants 5 carousel powder coating plants
Wood effect	4 lines
Maximum profile length in horizontal line	8 meters
Maximum profile length in vertical line	7,5 metros
Finishes	RAL Chart NCS Chart Special Textured Metallic Wood effect Anodising effect Antibacterial
Powder coating qualities	Qualicoat Class 1, Qualicoat Class 2, Qualicoat Class 3
Pre-treatments	Qualicoat Seaside, Anodic pre-treatment

12 CNC MACHINING UP TO 5 AXES

Maximum profile length	12.600 mm
Maximum profile width	780 mm
CNC Machine 5 axes."C" axis stroke	± 220 °
CNC Machine 5 axes."A" axis stroke	± 125 °
CNC Machine 4 axes."C" axis stroke	± 90 °
Machining processes	Precision cutting, tridimensional cutting, edge removed process, milling (radial and peripheral), louvre machining, drilling, tapping, punching... and an endless range of machining options
Precision cutting off	Corte de precisión con tolerancias de hasta +-0.2 mm