

VALUABLE OPPORTUNITY ALL IN

€: 2.800.000,00

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FUNCTIONING & COMPLETE TUBE FACTORY

USED TUBE_MILL Ø 63*0,7-3,5 mm manufacturing year 2014

SLITTING LINE 1550*0,5-3,5 mm manufacturing year 2023

Description	Special Final Sales Price
Tube-Mill Line: Ø 12.7– 63.0mm Th 0.7 – 3.5 mm	
Rolls Rounds : 20, 25, 32, 38, 42 Rolls Square : 16, 20, 25, 30 Rolls Rectangular : 40x20; 40x25	included
Collecting Station (manual packing)	included
Filtrations System	included
High Frequency Welder 200kW	included
Video jet inkjet Printer	included
Slitting line 1550 x 3,5	
Tooling set	included
SERVICES	
Dismanling	included
Loading on container, Transport Fixing Seabag packaging for electrical control Cabinet	
Transfer CFR Containers 40 O.T.	To be Quoted
Re assembling and Installation of both equipment Up to 100Days/man	included
New Mechanical, Hydraulic and Electrical connection	included
Commissioning Up to 86 Days/man	included



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 P.Iva IT02269910135 | C.F. - R.I. 09943340159 | CCIAA Bergamo | REA 380808 | Cap. Soc. € 102.800,00 i.v.



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MILL CAPACITY

<u>Round tube</u>			
Ø	Min	12,70	mm
	Max	63,25	mm
<u>Square profile</u>			
Dimension	Min	10	mm
	Max	50	mm
<u>Rectangular profile</u>			
Dimensions	Min	20 x 10 mm	
	Max	80 x 20 mm	
Thickness	Min	0.7	mm
	Max	3.5	mm
Length	Min	4.0	m
	Max	6.0	m

Production Table

	13		10									
	14,5											
3/8	16,75		12-13									
		19	16	20x10								
3/4	26,75		20		25x15	30x10						
		28,7	22			30x15	35x10					
		30										
		32	25			30x20		40x10				
1"	33,48		25			30x20	35x15					
		35				30x25	35x20	40x15				
		38,7	30				35x25	40x20	50x10			
		40										
1" 1/4	42,25						35x30	40x25	50x10			
		45	35-34					40x30	50x20			
1" 1/2	48,25							40x35	50x25	60x15		
		51	40						50x30	60x20		
		51	45						50x40	60x30	70x20	
2"	60								50x45	60x35	70x25	
		63,25	50						60x40	70x30	80x20	

*To have a 63 Ø Tube mill allows you heat the 50x50 or 60x40 mm tubes market, which is extremely important for construction and scaffolding.

PRODUCTIVITY

Pos	Diameter	Thickness	Weight	Production	Speed	Production	Production	Production
	mm	mm	Kg./m	TON.	m/1'	m	Hr	8 hr - Shift
	O.D	TH	Wh/m	TON.	Speed	Production	Production	Production
1	20	0,80	0,38	1.000	120	2639911	524	65
2	20	1,00	0,47	1.000	120	2134159	423	53
3	20	1,20	0,56	1.000	100	1797386	428	53
5	25	0,80	0,48	1.000	120	2094475	416	52
6	25	1,00	0,59	1.000	120	1689543	335	42
7	25	1,50	0,87	1.000	100	1150327	274	34
8	32	1,20	0,91	1.000	100	1097106	261	33
9	32	2,00	1,48	1.000	80	675817	201	25
10	32	3,00	2,15	1.000	70	466081	159	20
11	38	1,20	1,09	1.000	90	918230	243	30
12	38	2,00	1,78	1.000	75	563181	179	22
13	38	3,00	2,59	1.000	65	386181	141	18
14	42	1,50	1,50	1.000	60	667474	265	33
15	42	2,20	2,16	1.000	55	463100	200	25
16	42	3,00	2,89	1.000	45	346573	183	23
17	51	1,50	1,83	1.000	60	546115	217	27
18	51	2,20	2,65	1.000	50	377692	180	22
19	51	3,00	3,55	1.000	40	281590	168	21
20	63	1,50	2,28	1.000	55	439556	190	24
21	63	2,20	3,30	1.000	45	303148	160	20
22	63	3,00	4,44	1.000	35	225272	153	19
Total				21.000		19.262.917	5.301	663
				Ton		Meter	Hr	Shift
							DAY'S SHIFT	663
				1				331
				2				221
			3					

SCOPE OF SUPPLY

- Item 01 Double Uncoiler ;
- Item 02 Manual Strip Joint bench (welder included);
- Item 03 Horizontal Spiral accumulator ;
- Item 04 Complete profiling line composed by :
 - Forming unit - 7 heads;
 - Impeeder support;
 - Welding head – 3 rolls;
 - Double scarfing Unit;
 - Cooling System;
 - Sizing unit - 4 heads;
 - N° 4 Turks head;
- Item 05 Flying cut-off
- Item 06 Run outlet table
- Item 07 Collecting Stations
- Item 08 Rolls
- Item 09 Electrical equipment
- Item 10 Installation
- Item 11 Filtration System
- Item 12 High Frequency Welder
- Item 13 Slitting Line 1000x4 Second Hand
- Item 14 Slitting Line Commissioning

SLITTING LINE 1550 x 3,5 mt', 16 Ton

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A1) WORKING MATERIAL

- Material: cold rolled, galvanized steel, hot rolled, carbon steel SPHT 1 and 2
- Material tension max: N/mm² 450
- Material thickness: from 0,8 up to 3,5 mm

A2)	ENTRY COIL DIMENSION -External diameter -Inner diameter -Max width -Min width -Max weight	mm mm mm mm ton	1600 508 - 1560 600 16	(610 and 762 in option)
A3)	EXIT COIL DIMENSION -External diameter -Inner diameter -Max width -Max weight	mm mm mm ton	1600 508 1560 16	
A4)	GENERAL FEATURES OF THE UNE: PRODUCED SLIT COILS: -Min width of the strips	mm	30	

CAPACITY SLITTING SHEAR:

-Cuts on 3,5 mm thickness	6
-Cuts on 3 mm thickness	7
-Cuts on 2 mm thickness	10
-Cuts on 1,5 mm thickness	18
-Cuts on 1 mm thickness	36
-Cuts on 0,6 mm thickness	40
-Working speed up to max	m/min 0-150
-Feeding speed	m/min 10
-Blades diameter	mm 200/310

CUTTING TIME at max speed without time of introduction and discharge of coil
For coil width 1250 mm, weight 15 Ton

- Thickness 3 mm 4 min Speed 150 mt/min
- Thickness 2 mm 5 min Speed 150 mt/min
- Thickness 1 mm 10 min Speed 150 mt/mi

SCOPE OF SUPPLY

B1) COIL STORAGE RAMP

- For storage coils longitudinally to the entry coil car.

B2) ENTRY COIL CAR

- Sliding on pit
- "V" saddle
- Translation speed 10 m/min
- Vertical movement: hydraulic
- Horizontal movement: hydraulic



B3) MOTORIZED DECOILER

- Capacity. 16 T
- Shaft width: 1550 mm
- Shaft expansion: hydraulic
- Shaft rotation: forward-backward



SNUBBER ROLL

- Hydraulic snubber pressure arm with:
- Motorized rubber roll



SLIDING BASE

- Hydraulic sliding base +/-100 mm

B4) PEELER TABLE

- Telescopic entry table
- 4 movements
- Hydraulic movements



B5) ENTRY PINCH ROLLS UNIT

- N.2 feeding rolls, upper roll control by means of cylinder with pressure regulation possibility for the introduction of the sheet.

B6) OPTION: CROP SHEAR

- Hydraulic movements
- SCRAP CONTAINER (Scrap Box) for evacuation of scraps



B7) INTRODUCTION GROUP AND SIDE GUIDE

- Lateral guide adjustable

B8) SLITTING SHEAR

- Vertical movement of blade-holding mandrel for the adjustment of the blade penetration by means motor
- Indicator of blade penetration
- Side movement of shoulder for replacing blades pack by hydraulic cylinder
- Shaft hardened and grinded on which are clamping blades pack and spacers.
- Motor power is transmitted to the shear through cardanic shaft and gear box.



B9) SCRAP RECOILER

- Lateral side motorized
- Max. scrap width 15x3 mm
- Max. coil diameter 800 mm
- Control by AC motor

B10) TAILS BLOCK GROUP

- To lock the tails of coil and prevent foil into the pit.

B11) OVERPASSING TABLE

- Loop overpassing table hydraulic movement
- N. 2 ramps basket placed in entry and exit of loop pit

B12) TENSION UNIT (FELT TYPE)

- Separator shafts extractable
- Felt tension pad (pneumatic regulation)
- Pneumatic type tensioning force setting 0-5 Kg/cm
- N.1 deflecting roll
- Table for easy introduction on recoiler



B13) RECOILER

- Capacity 16 Ton
- Useful shaft width 1550 mm
- Internal diameter 508 mm
- A) Motorized recoiler by gear, gear box and motor.
Hydraulic expansion mandrel and clamps to fix the strip heads.
- B) Separator arm for discs which separate each slitted coil
- C) Hydraulic expulsion plate device to eject the slitted coils after recoiling.



B14) EXIT COIL CAR

- Sliding on pit
- "V" saddle
- Translation speed 10 m/min
- Hydraulic movements



COMMISSIONING AND SUPERVISION DURING ERECTION

ACTIVITIES	RESPONSIBILITY		
	BUYER	FIMI	N.A
INSTALLATION			
RESPONSIBLE OF INSTALLATION	X		
SUPERVISORS		X	
SKILLED PERSONNEL	X		
TRAVELLING COSTS AND DAILY ALLOWANCES	X		
ACCOMMODATION	X		

CONSTRUCTION WORK			
FOUNDATIONS	X		
INSTALLATION ACCORDING TO LAYOUT	X		
DRILLING OF ANCHOR BOLT HOLES / POCKETS FOR ANCHOR BOLTS	X		
BASE LINES AND LEVELS	X		
VERIFICATION OF ALIGNMENT AND LEVELS OF EQUIPMENT (if included in the scope of supply)		X	
GROUTING	X		
WIRING WORKS	X		
PIPING WORKS	X		
FLUSHING OF HYDRAULIC OIL PIPING	X		

TOOLS AND ERECTION MATERIALS			
JACKS, WINCHES, LIFTING STRAPS, CRANES	X		
COMMON TOOLS FOR PERSONNE	X		
SPECIAL TOOLS	X		
WELDING TOOLS	X		
WELDING MACHINES	X		
ELECTRODES/WIRES AND WELDING GASES	X		
EXTENSION CABLES	X		
POWER SUPPLIES DISTRIBUTION (BEFORE THE CABINET)	X		
HYDRAULIC FLUID	X		
COMPRESSED AIR	X		
WATER	X		
LUBRICATING FLUIDS	X		
LUBRICATING FLUIDS, INITIAL FILLING	X		
CONSUMING MATERIALS	X		

ON SITE UNLOADING, STORAGE AND ASSEMBLY OF EQUIPMENT ON FOUNDATIONS			
TRUCKS UNLOADING	X		
STORAGE AND PROTECTION (AS APPLICABLE)	X		
REMOVAL OF EQUIPMENT FROM CONTAINERS/ CRATES AND TRANSFER ON FOUNDATIONS	X		
ASSEMBLY OF EQUIPMENT ON FOUNDATIONS	X		
INSTALLATION TOOLS	X		

ERECTION EQUIPMENT			
OVERHEAD CRANES (LIMITED, IF AVAILABLE AT SITE)	X		
MOBILE CRANES (AS NECESSARY)	X		
FORKLIFTS (LIMITED, IF AVAILABLE AT SITE)	X		

GENERAL			
INSTALLATION-SITE CLEANING	X		
SAFETY EQUIPMENT	X	X	
PERSONAL PROTECTION EQUIPMENT		X	
FIRST AID EQUIPMENT	X		
FIRE FIGHTING EQUIPMENT	X		
FIRE SECURITY AT WORKSITE	X		
WORKS SECURITY	X		
MEDICAL HEALTH	X		
WORKSITE LIGHTING	X		
DRESSING ROOM/OFFICE FOR FIMI S.P.A. SUPERVISORS	X		

COMMISSIONING			
FIRST FILLING OF GEAR BOXES AND HYDRAULIC POWER UNITS	X		
COMMISSIONING RESPONSIBILITY		X	
MECHANICAL OPERATORS		X	
ELECTRICAL OPERATORS		X	
PERSONNEL SUPPORT (AS NEEDED)	X		
FIRST PLANT ENERGIZING (CABINETS AND MACHINE)		X	
CHECK OF MAIN ELECTRICAL CONNECTIONS		X	
HYDRAULIC POWER UNITS (HPUs) START-UP / TESTING		X	
PLANT START-UP AND INITIAL PRODUCTION TEST	X	X	
ACCEPTANCE TEST (IF ANY)	X	X	
TRAINING		X	

ON SITE ASSISTANCE FOR START-UP

The supply includes a total amount (excluding travel) of

86	Man / days
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for the verification of alignment and completeness of installation, commissioning and start-up of the tube mill **excluding the ancillaries.**

The intervention will be in two steps:

Verification of alignment (step 1): once the equipment has been assembled, levelled and aligned, one mechanical specialist will arrive to the site to check the correct alignment of the entire equipment and give instructions to the customer for final grouting, wiring and piping works.

Commissioning, start up and acceptance testing (step 2): once wiring and piping works are completed, FIMI S.P.A. will send field engineers (normally one mechanical and one electronic) to start up the machine, train the operators, supervise initial production tests and acceptance tests.

The number of required technicians that take part to each stage of all the activities and the schedule of interventions are mutually agreed, between FIMI S.P.A. and the Buyer, at a later stage.

In case of necessity to extend the permanence of the technicians for a period, exceeding the days foreseen here in this contract for reason due to **FIMI S.P.A.** the additional days will be at FIMI s.p.a. care (not additional charge).

In case of necessity to extend the permanence of the technicians for a period, exceeding the days foreseen here in this contract for reason due to the Buyer, the additional days will be separately invoiced at the cost of:

1500	€/days per person
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Travel costs, board, lodging in a suitable hotel and local transport are included in the scope of supply

Travel costs includes flight ticket, airport from/to transportation and excess baggage penalties (if required for technical instrumentation).

ENGINEERING

Lay-out
Foundation drawing (excluded calculus for reinforced concrete)
Hydraulic maintenance diagrams and drawings.
Pneumatic maintenance diagrams and drawings.
Electric diagrams.
User's operation and maintenance guide.
All documents are in English & Italian

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EXCLUSIONS

All that is not specified in our offer, and mainly:

Foundation, concretes and grouting of any kind.
Installation and start-up
Rolls Toolings excluded series include in scope of supply
Shims for machine leveling, staybolts,
Electrical cabling, pneumatic and hydraulic pipes for the connection between our machines
Cooling Tower or industrial water installation for coolant.
Filtration system and coolant feeding system for production.
Main electric cabinet electric power.
Lighting electric installation.
General earth terminal.
Air compressed distribution system to mill components.
Oil and greases for the first filling.
Materials for machine start-up and tests.
Coolant purifiers.
Exhaust and vacuum systems for steams and fumes.
Every type of transport
Lift-up means
Every energy
Spare parts
Compressors
Gangway and/or protections
Every performance of our technicians
EC certification (excluded from supply)