THREE STAND TANDEM HOT ALUMINUM MILL
CHALCO RUIMIN CO, CHINA
**NEW TANDEM FINISHING MILL**

The new mill has been supplied to Chalco Ruimin Co Ltd, Fujian Province, China

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**PRODUCT DATA**

- **Product**: Hot rolled aluminum and aluminum alloys 1XXX, 3XXX, 5XXX and 8XXX series
- **Max. entry thickness**: 40 mm
- **Min. exit thickness**: 2.5 mm
- **Min./Max. strip width**: 1,050 - 2,250 mm
- **Min./Max. strip width (trimmed)**: 950 - 2,150 mm
- **Max. coil weight**: 23 tons
- **Coil max. outside diameter**: 2,600 mm
- **Coil max. inside diameter**: 610 mm
- **Specific coil density**: 13.1 kg/mm

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**ROLLING MILL DATA**

- **Mill size**: Ø750/1,500 mm x 2,500 mm
- **Max. exit strip**: 460 mpm
- **Stand power (each stand)**: 5,000 kW
- **Max. rolling load per stand**: 4,000 tons

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**SCOPE OF DELIVERY**

**Three 4-high stands including**
- Hydraulic automatic gauge control
- Positive and negative bending
- Work roll chock mounted brushes
- ISV Sprays

**Mill exit equipment including**
- Edge trimmer with separate chopper
- Coiling equipment

**Automation system including**
- Basic automation system incl. technological control
- Sensors and measuring devices
- Process automation system
- Analytical online process models
- Profile, thickness and temperature control
- Flexible production scheduling
- Data logging and reporting system
- Comprehensive diagnostics

**Drive systems**
- Utilizing Sinamics S1100 and S120 converters

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**SOLUTIONS**

The new 3-stand tandem hot finishing mill is an integral part of an aluminum 1+3 hot line, the key process component of the major plant expansion planned by Ruimin.

In addition to the mechanical equipment, Primetals Technologies supplied all automation technology; the drive systems and the sensors. The automation system comprises basic automation, including the technological controllers, as well as operation and visualization equipment. Primetals Technologies also supplied the model based process automation for the complete hot line to ensure the highest standards in product quality. All mechanical and electrical components used are part of our integrated solution for aluminum hot mills. Beside the above, commissioning and customer training is also part of the contract.

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**MAIN BENEFITS**

- Flexible, cost-efficient rolling of a wide range of products
- Most advanced and innovative automation
- Tightest strip thickness and profile tolerances
- High surface quality
- Reliable, consistent performance
- Realising tight tolerances right from the strip head
- Maximum operating efficiency
- Integrated occupational safety concepts

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Primetals Technologies were awarded this contract on the basis of technological competence and the significant number of successful project references for aluminum hot mills.

The tandem hot aluminum mill was supplied to Chalco Ruimin Co Ltd, located in Fuzhou City, Fujian province in south east China and was started up on 1st April 2011. The Primetals Technologies mill has been designed to meet Chalco’s need to expand capacity to over 370,000 metric tones per annum at widths in excess of 2.2 metres, servicing the high quality strip and sheet markets, including printing, packaging and electronics.

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