



STAINLESS STEEL DEPARTMENT



Stainless steel department

Tecnofondi, located in Brescia, is engaged with its activity in the production of **dished heads** since its opening in 1965.

At the beginning of the year 2004 Tecnofondi has built a new production unit separated from the main unit exclusively for the production of stainless steel heads.

Based on this realisation, Tecnofondi is able to guarantee a higher quality standard because of the ability to avoid the promiscuity of stainless steel and carbon steel.

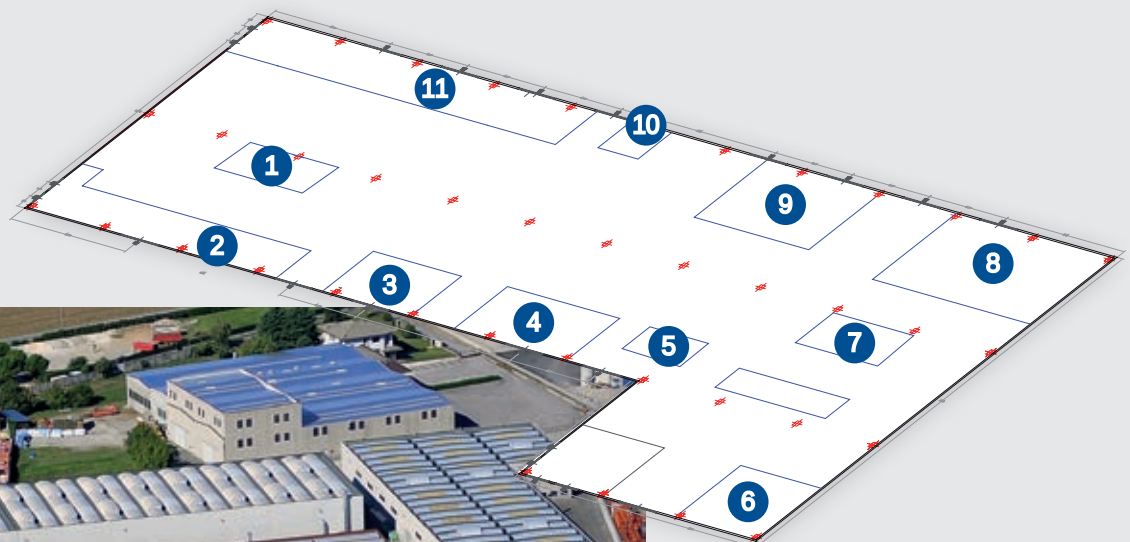
For the realisation of this feature it has been invested in machines and plants developed exclusively for the production of stainless steel heads.

Tecnofondi realizes its production by cold forming both for pressing (pressed heads) and for dishing with the following flanging process (rolled heads).

In this way, it is possible to get the following dimensions (max):

- Diameter: 5000mm
- Thickness: 32mm

In the following page of this brochure are described plants, that are able to produce heads and cones made of stainless steel.





1 - PVC protective wrapping

This machine, purposely equipped to cover with a PVC protective film, is used on steel sheets up to a width of 2000mm and to a length of 13m.



2 - Warehouse for raw material

In this area all metal sheets from the suppliers are stored. 80 tons of sheets in different sizes and thickness are available in stock with the following grades: AISI 304 and AISI 304 L, AISI 316 and AISI 316 L.



3 - Plasma cutting

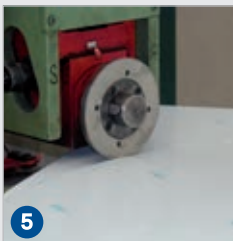
This area is dedicated to the cutting of metal sheets in order to get disks and half disks that have to be welded. The plasma cutting bench is 2 x 12m and is fitted with a plasma torch that has a power of 100 A/HD and that, thanks to a CAD/CAM control, cuts sheets up to 15mm.



4 - Welding and grinding of welding seam

• 2 automatic welding lines with sliding bench, anti-scratching PVC rollers. One with double welding head: TIG for thickness up to 3mm and submerged arc for a thickness ranging from 3 to 8mm and one with plasma welding head for thickness from 2 to 10mm

• 1 welding seam grinding line with a working bench with sliding anti-scratching PVC rolls and a belt grinding arm.



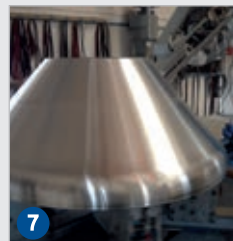
5 - Disc cutting

• 1 Hydraulic circular shearing machine able to cut disks or circular crowns up to a diameter of 3200mm and a thickness of 8mm, either with or without central hole.



6 - Grinding plant

Department for the grinding of dished heads with 1 grinding positioning unit fitted with orthogonal axes and 2 grinding heads with a power of 3 KW, grinding with abrasive belts



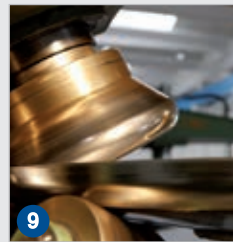
7 - Cones bending

• 1 bending machine with 4 rolls, able to produce conical and cylindrical forms until thickness 6mm, 1500mm of height and a minimum central hole of 105mm



8 - Dished head press-forming

• 2 Hydraulic presses with a power of 600 tons and a maximum 5500mm working area are fitted with a manipulator able to lift discs with \varnothing max 5400mm and a maximum weight of 4,5 tons.

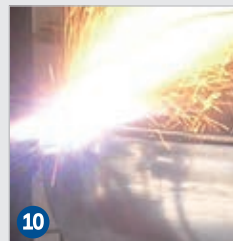


9 - Flanging department

• 1 Cold flanging machine able to flange heads up to a thickness of 12mm, either with or without central hole.

• 1 Cold flanging machine able to flange heads up to a thickness of 24mm.

Both the machines are equipped with rolls in aluminium bronze alloy available up to a 450mm of radius. The physical and mechanical features are purposely programmed for the production of stainless steel dished heads.



10 - Edge turning

Turning by plasma cutting to get either perfectly plan edge or bevelled edge according to the requirements of the client.



11 - Warehouse of dished heads

Department for the storage of the end product, where 70/80 tons of dished heads in stock are available in AISI 304 and 316 with various profiles, diameters and thicknesses.



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