



ROLLED PRODUCTS

impol
Aluminium Industry



ROLLED PRODUCTS

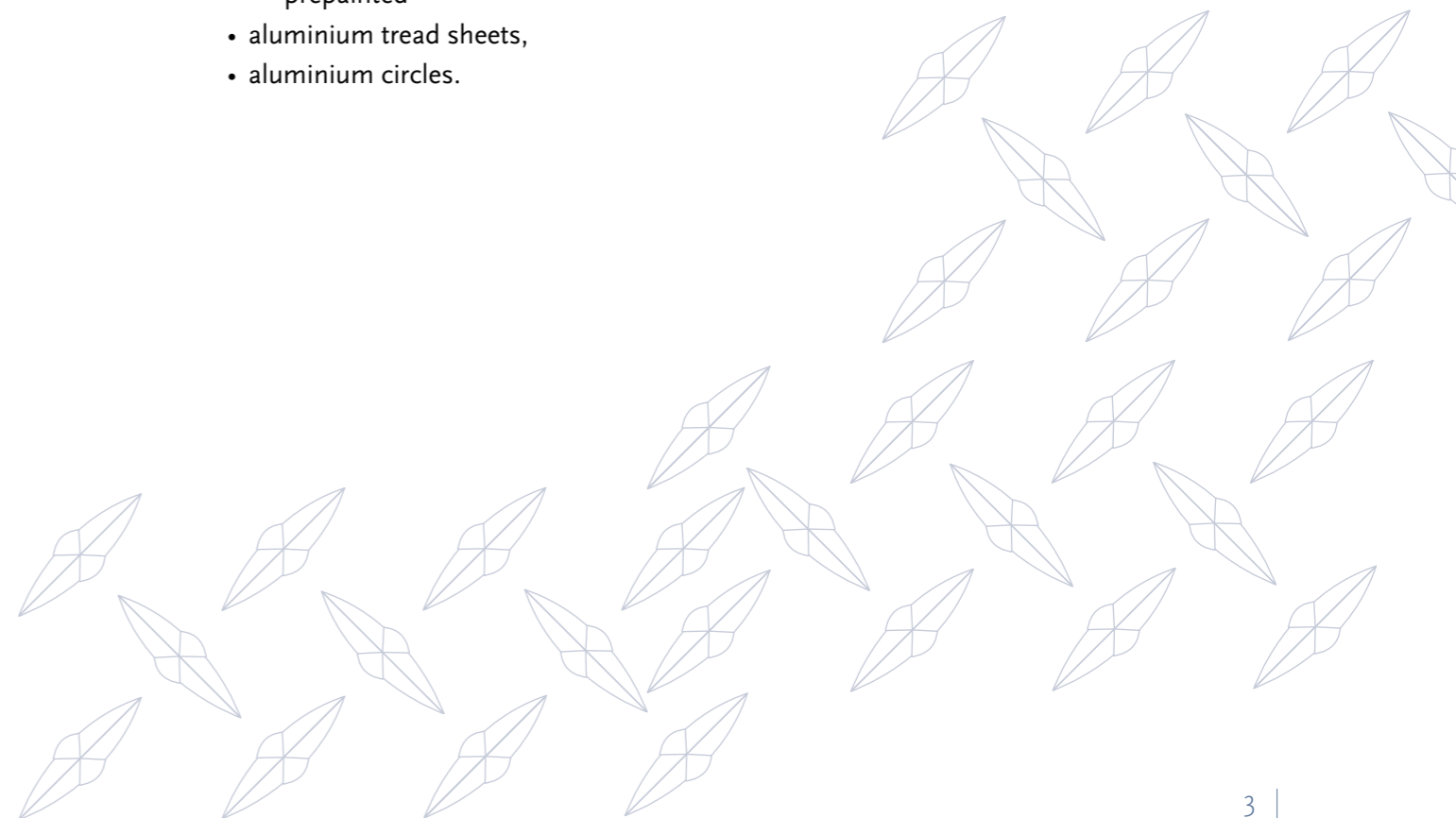
Rolled products with their wide range of use represent the largest segment of aluminium products. We can find their presence in automotive, transport, building and construction, consumer and many other sectors.

Modern technology, appropriate technical equipment together with the knowledge of our employees ensure results that can satisfy the most demanding customer requirements.

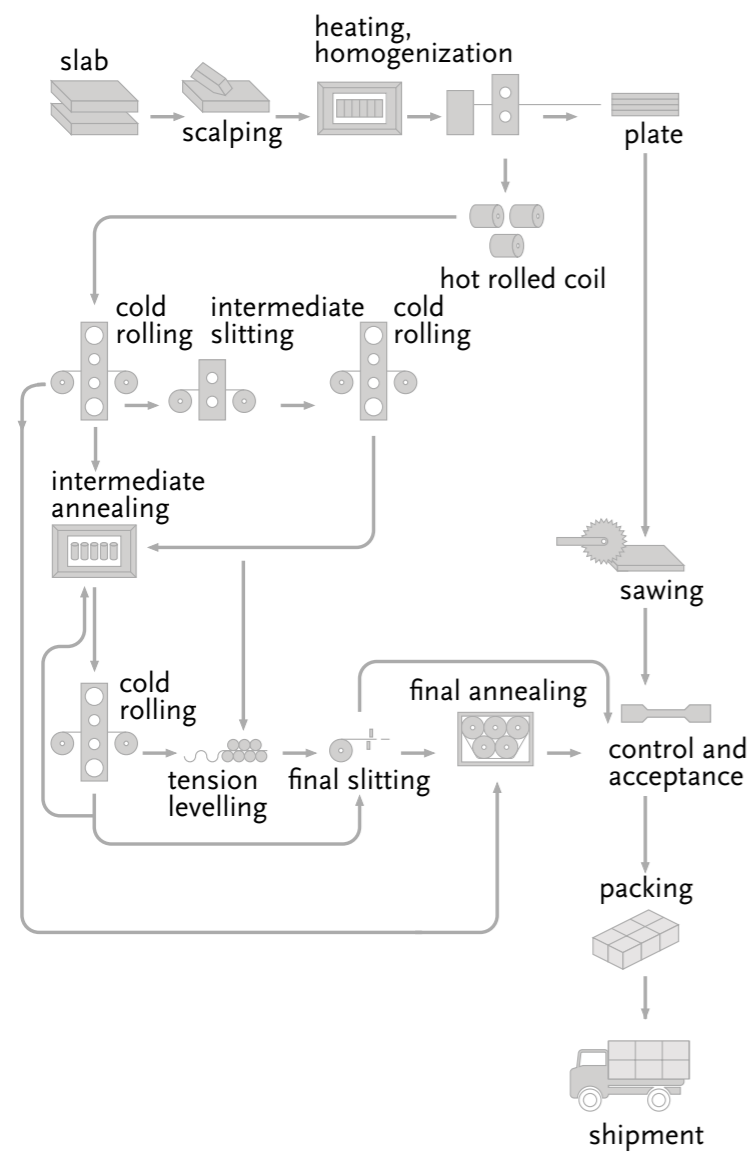
The basic manufacturing procedures are hot and cold rolling of aluminium and its alloys, where hot rolled or cast strips serve as input material for cold rolling. In addition to standard tempers and mechanical properties, entirely specific tempers, properties and quality of rolled products can be achieved through controlled cold working and heat-treatments. The finally rolled coils are slit into various widths with modern rotating shears. Sheet is obtained by cutting strips to lengths on cutting lines with built-in roller straightener.

Main groups of rolled products:

- aluminium plates,
- aluminium cold rolled sheets,
- aluminium cold rolled coils,
 - plain
 - embossed
 - prepainted
- aluminium tread sheets,
- aluminium circles.



PRODUCTION PROCESS



1 Aluminium plates IMPOL SEVAL

Alloys, temper and surface:

Alloy (EN AW-xxxx)	1050, 5754, 6082, 5083, 5086
Temper	O- soft
Surface finish	Hot rolled

Available dimensions:

Thickness	Length	Width	Technical conditions
6-15	to 3000-tension-levelled to 6000-unlevelled	to 1550 depending on alloy and thickness	the standards as for hot-rolled coils apply
16-300	to 6000-unlevelled		

2 Aluminium cold rolled sheets IMPOL SEVAL

Sheet Type	Properties	Width	Thickness	Length
Plain	Cold-rolled, Mill finish, trimmed tension-levelled, suitable for anodization	600-1500	1,5-0,4 tension-levelled 1,5-5,0 unlevelled	600-6000
Prepainted	Cold-rolled, trimmed tension-levelled, RAL Colour Card	600-1000	1,5-1,2	
		600-1250 600-1500	1,2-1,0 1,0-0,55 1,0-0,4	
Embossed	Cold-rolled, trimmed tension-levelled, plain, prepainted, "stucco" pattern D-2010	600-1500 800-1000	1,2-0,4 1,5-1,2 (1050)	

ALL DATA A. M. DATA ON SHEETS THICKNESS AND WIDTH ARE IN THE FUNCTION OF THE ALLOY AND MATERIAL TEMPER AND SHALL BE DEFINED AS PER EACH SPECIFIC CUSTOMER'S REQUIREMENT

3 Aluminium cold rolled coils IMPOL SEVAL

Coil Type	Properties	Thickness	Width	Inner dia.
Plain	Cold-rolled, untrimmed, undegreased, unlevelled	6,0-3,0	900-1600	600
	Cold-rolled, Mill finish, trimmed undegreased, unlevelled	3,0-1,5	300-1500	500, 600
	Cold-rolled, Mill finish, trimmed degreased, tension-levelled to 0,4 mm thickness	2,0-0,35	20-600	400, 500
	Cold-rolled, Mill finish, trimmed degreased, tension-levelled to 0,4 mm thickness	1,5-0,35	300-1500	500, 600
	Cold-rolled, Mill finish, trimmed degreased, tension-levelled to 0,4 mm thickness	0,8-0,35	75-1500	300, 400, 500, 600
Prepainted	Cold-rolled, trimmed, tension-levelled	1,5-1,2	800-1000	500, 600
	Cold-rolled, trimmed, tension-levelled	1,2-1,0	800-1250	500, 600
	Al-Cold-rolled, trimmed, tension-levelled	1,0-0,55	800-1500	500, 600
	Alloys-Cold-rolled, trimmed, tension-levelled	1,0-0,35	800-1500	500, 600
	Cold-rolled, trimmed, tension-levelled	1,2-0,35	20-600	400, 500
	Cold-rolled, trimmed, tension-levelled	1,2-0,55	300-1250	500, 600
	Cold-rolled, trimmed, tension-levelled (alloy)	0,8-0,35	75-1500	300, 400, 500, 600
	Cold-rolled, trimmed, tension-levelled (1050)	0,8-0,55	75-1500	300, 400, 500, 600
Embossed	Cold-rolled, trimmed, tension-levelled, plain, prepainted, "stucco" pattern D-2010	1,2-0,4	300-1500	500, 600
	Cold-rolled, trimmed, tension-levelled, plain, prepainted, "stucco" pattern D-2010	0,8-0,4	75-1500	300, 400, 500, 600
	Alloys with Mg content higher than 3 % are embossed to 1,0 mm thickness			

ALL DATA A. M. DATA ON COIL THICKNESS ARE IN THE FUNCTION OF THE ALLOY, MATERIAL TEMPER, I. D. AND O. D. AND SHALL BE DEFINED AS PER EACH SPECIFIC CUSTOMER'S REQUIREMENT

3 Aluminium cold rolled coils IMPOL FT

Alloy, temper and surface:

Alloy (EN AW-xxxx)	1000 series: 1050 3000 series: 3003, 3103, 3105, 3004, 3005 5000 series: 5005, 5251, 5049, 5754, 5052
Temper	O, H22, H14, H24, H16, H26, H18, H28, H19 (soft, quarter hard, half hard, three quarter hard, hard, extra hard) DDQ is available for selected alloys and tempers
Surface finish	Mill finish, Stucco, pattern D2010 (coarse), Stucco, pattern D2011 (fine) – only up to 1,00 mm

Available dimensions:

Thickness (mm)	0,50 – 2,50
Width (mm)	50 – 1.250 for mill finish surface 500 – 1.000 for stucco surface
Inside Diameter (mm)	508, also available 406 and 304
Core	Without, cardboard core for selected tempers
Outside Diameter (mm)	(see table – coil sizes)
Weight per width	(see table – coil sizes)

Coil sizes:

ID	OD	Weight per mm of width	Alloy group
508	760	0,67 kg / mm	1xxx, 3003, 3103, 3105
508	850	0,90 kg / mm	
508	940	1,40 kg / mm	
508	1.230	2,70 kg / mm	
508	700	0,50 kg / mm	5xxx, 3004, 3005
508	760	0,70 kg / mm	
508	860	1,00 kg / mm	
508	1.100	2,00 kg / mm	

* please ask for coil sizes with ID 406 and/or 304 mm

4 Aluminium tread sheets

Alloy, temper and surface:

	IMPOL FT	IMPOL SEVAL
Alloy (EN AW-xxxx)	5754, 3003, 1050	5754, 3003, 1050
Temper	H114, H224, H244	H114, H224, H244
Surface finish	Two bar (duet) Five bar (quintet) Diamond	Two bar Five bar —

Available dimensions:

	IMPOL FT	IMPOL SEVAL
Thickness (mm)	1,50 – 5,00	1,50 – 5,00
Pattern height (mm)	For thickness 1,50 mm 0,50 or 1,00 mm For thickness 2,00 mm 1,00 or 1,50 mm For thickness over 2,00 mm 1,50 mm	For thickness 1,50 mm 0,50 or 1,00 mm For thickness 2,00 mm 1,00 or 1,50 mm For thickness over 2,00 mm 1,50 mm
Width (mm)	600 – 1250	1000 – 1500
Length	600 – 5000	600 – 6000
Paper interleaves	On request for selected widths	—

5 Aluminium circles IMPOL FT

Alloys, temper and surface:

Alloy (EN AW-xxxx)	1050, 1200, 5454, 5754, 6082, 4006, 8006
Temper	O – soft, H18 – hard DDQ is available on request
Surface finish	Mill finish

Available dimensions:

Thickness (mm)	1,00 – 4,00
Diameter (mm)	See table Shapes are available on request

Available diameters:

80	152	190	245	300	345	558,8	910
90	154	195	248	300	350	568,3	941
96	155	200	250	302	355	571,5	
100	157	205	255	305	360	580	
114	160	210	265	310	370	600	
125	163	215	270	315	380	620	
129	170	220	275	320	390	648	
130	175	225	280	325	400	710	
135	179	230	285	330	420	798	
140	180	232	290	335	430	855	
145	182,5	235	290	340	480	872	
150	185	240	295	340	546	900	

* All sizes are in [mm]
Other sizes and shapes are available on request.

STANDARDS AND CHEMICAL COMPOSITION

Our aluminium products are produced in different alloys according to international standards. The chemical composition, mechanical properties and tolerances are in compliance to EN standards for various products:

- EN 573–3, chemical composition, all aluminium products
- EN 602 chemical composition, aluminium for food contact,
- EN 485–2, mechanical properties, sheets, strips and plates
- EN 683–2, mechanical properties, finstock
- EN 485–4, tolerances, sheets, strips and plates
- EN 683–3, tolerances, finstock
- EN 851, circles and circle stock, specifications
- EN 1386, tread plate specifications

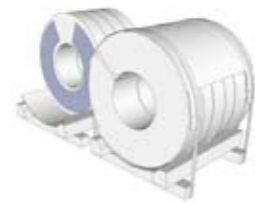
PACKING

Our products are packed according to the customer's wishes and our capabilities. Impol's standard packing methods include packing onto pallets, both axis horizontal or vertical for strips. Special packing is also available on agreement. All packing is returnable. Each shipment is accompanied with a certificate of quality, which also proves suitability of materials.

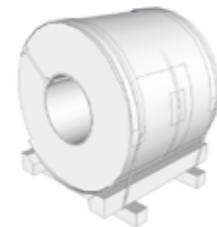
Main packing types used for rolled products:



One coil on a pallet
axis horizontal



Two or more coils on a
pallet, axis horizontal
cardboard interleaves



Coils for painting,
with or without
cardboard core



One coil on a pallet
axis vertical



Two or more coils on a
pallet, axis vertical
cardboard interleaves



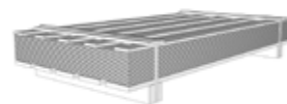
Two or more coils on a
pallet, axis vertical
wooden battens between



Coils for container
shipping



Circles



Cold rolled sheets and
tread sheets, plates

ORDERING

For a quicker response to your inquiry we kindly ask you to provide us the following data:

- Product type
- Alloy and temper
- Dimensions and desired tolerances
- For coils, coil size (desired weight) and/or inside and outside diameter
- Purpose of use or desired mechanical properties
- Quantity





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