



SUMMARY OF ROUND AND SQUARE LUNA PRODUCTS

CCM STARTING BLOOM (mm)	CORNER RADIUS (mm)	SURFACE (mm ²)
200X240	14	47,384

	RANGE (mm)	ARROW (mm)	LENGTHS (mm)	SURFACE		DIMENSIONAL TOLERANCES
				ABS guarantee	Surf. Def. Threshold	
ROUNDS	29 ÷ 105	2 (10 max)	from 5,000 to 12,000 ±50	1 %	0.3 max	½ DIN feasible to date (¼ forecast)
SQUARES	40 ÷ 100	4 (10 max)		1 %	0.3 max	
100% SAND-BLASTED SURFACE, IF REQUIRED						
"CUA" IN-LINE SURFACE AND INTERNAL INSPECTIONS (Circograph-Ultrasuoni-Antimescolanza)						



KOCKS ROLLING

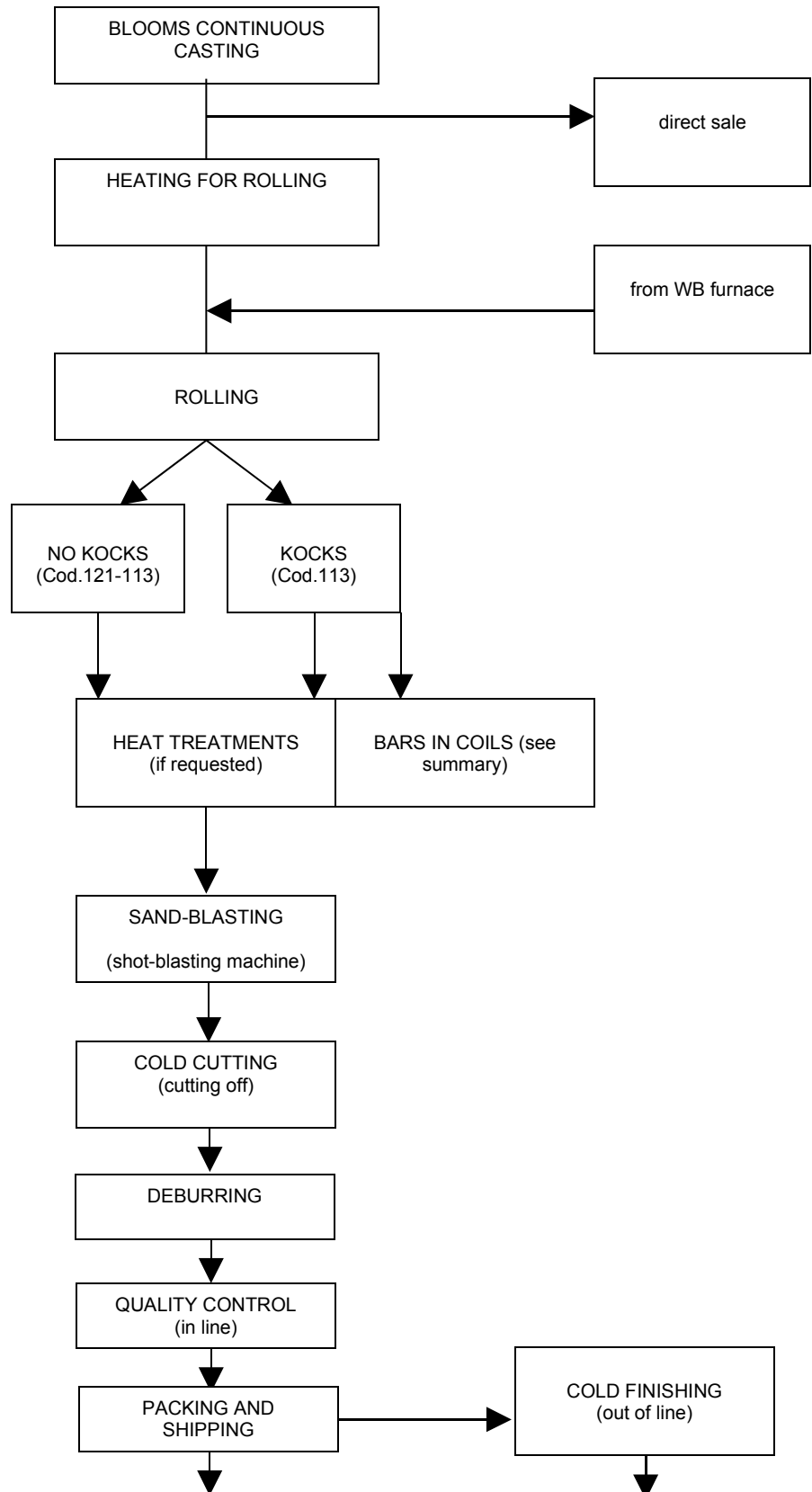
Range 29÷75.5 mm round – with intermediate profiles until 1/10 mm (ex: 29-30 also 29.9)

FEASIBLE SECTIONS AND REDUCTION RATIOS											
Mm	Rounds	Squares	Mm	Rounds	Squares	Mm	Rounds	Squares	Mm	Rounds	Squares
29	71.8	-	48	26.2	20.8	67	13.4	-	105	5.5	-
30	67.1	-	49	25.1	-	68	13.1	-	DIM. TOL. KOCKS RANGE ½ DIN, WITH POSSIBILITY OF ¼ DIN, IF REQUIRED FOR ROUNDS		
31	62.8	-	50	24.1	21.1	69	12.7	-			
32	58.9	-	51	23.2	-	70	12.3	10.7			
33	55.4	-	52	22.3	-	71	12.0	-			
34	52.2	-	53	21.5	-	72	11.6	-			
35	49.3	-	54	20.7	-	73	11.3	-			
36	46.6	-	55	20.0	17.1	74	11.0	-			
37	44.1	-	56	19.2	-	75	10.7	9.2			
38	41.8	-	57	18.6	-	75.5	10.6	-			
39	39.7	-	58	17.9	-	78	9.9	-			
40	37.7	31.9	59	17.3	-	80	9.4	8.3			
41	35.9	-	60	16.8	14.4	83	8.8	-			
42	34.2	-	61	16.2	-	85	8.4	7.3			
43	32.6	-	62	15.7	13.4	88	7.8	-			
44	31.2	-	63	15.2	-	90	7.5	6.5			
45	29.8	26.0	64	14.7	-	93	7.0	-			
46	28.5	-	65	14.3	12.1	95	6.7	5.8			
47	27.3	-	66	13.9	-	100	6.0	5.3			

The range obtainable at KOCKS (only round sections) is highlighted

mm	radii	diag.	mm	radii	diag.	mm	radii	diag.	SQUARE SECTIONS RADII AND DIMENSIONS OBTAINABLE AT LUNA D = √2 x L – 0.828 x R
40	6	51.6	62	10	79.4	90	16	114.0	
45	8	57.0	65	10	83.6	95	16	121.1	
48	9	60.4	70	12	89.1	100	18	126.5	
50	9	63.3	75	12	96.1				
55	9	70.3	80	15	100.7				
60	10	76.6	85	15	107.8				

EXAMPLE OF LUNA PLANT CYCLE





TECHNICAL SUMMARY OF LUNA PRODUCTS

COILS: (type of product: code 126) range 15 ÷ 59.5 mm						
	Round(mm)	Dim. Tol.	Coils Weight (kg)	Max. Height (mm)	Int. Dia. (mm)	Ext. Dia. (mm)
Range	15 ÷ 59.5	EU 17/70	1,500 ÷ 4,300 (fixed for sections. see details)	1,900	1,50	1,400
Surface defects (mm)	1 %					
Internal defects	1 %					
Surface conditions	1 %					
COIL RIGHT-HAND WINDING						
HEAT TREATMENT BY PARTIALLY-CONTROLLED COOLING						
SURFACE AND INTERNAL TESTING BY RANDOM TESTS THROUGH SAMPLING CUTTING						

Coil Dim: Int. Dia. 1,050 (mm) x est. 1,400 (mm)					
Rolled section (mm)	FIXED Weight of coils				
	1,500 Kg	1,750 Kg	3,000 Kg	3,500 Kg	4,300 Kg
from 15 to 18 included	ok	ok	NOT FEASIBLE	NOT FEASIBLE	NOT FEASIBLE
from 19 to 23 included	ok	ok	ok	NOT FEASIBLE	NOT FEASIBLE
from 24 to 29 included	ok (related to the section)	ok	ok	ok	NOT FEASIBLE
from 30 to 59.5 included	ok (related to the section)	ok	ok	ok	ok
REMARK: in case of particular requests, they should be evaluated together with Feasibility Department and Production					



EXAMPLE OF LUNA PLANT CYCLE FOR PRODUCTION OF ROUNDS BARS IN COILS AND WIRE ROD

