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♦ **Type of tool** : **Organic coil Coating line and PVD line**

Company : Arceo Engineering S.A.
 BE 894 304 267
 Belfius 068 8987858 59
 IBAN : BE84 068 8987858 59
 SWIFT : GKCCBEBB

Delivery address :
 ARCEO Engineering
 Rue Sompré, sn
 FLEMALLE (Yvoz-Ramet)

Administrative address (mail and bills delivery) :
 ARCEO Engineering
 21 rue Maréchal Foch
 B-4400 Flémalle

Headquarters :
 ARCEO Engineering
 38, boulevard d'Avroy
 4000 LIEGE (Belgique)
 Tel. : 04/236.96.04 – 04/236.96.52 – 04 /236.96.11
 Fax. : 04/236.95.96


♦ **Access to the company** : Road only

♦ **Loading/unloading** :

For horizontal axis coils:
 Volet (shutter) 9004 (in front of the guard's post)
 Loading and unloading equipment : Crane
 Storage (1bed, 2 beds, racks,...) : 1 to 2 horizontal axis bed
 Roll stop in wood or plastic
 Truck reception schedule: Monday to Friday
 7H00 to 16H00

For vertical axis coils:
 Volet (shutter) 9002 (Between Arceo Engineering and AM's Combiline)
 Loading and unloading equipment : Forklift
 Truck receptions schedule: Monday to Friday
 7H00 to 16H00

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For small packages :
Volet vide 9002 (shutter « vacuum » 9002)

- ♦ **Material identification** : By label
- ♦ **Conditionning** :
 - Entrance : Horizontal axis
Vertical axis
 - Exit : Horizontal axis
Vertical axis
- ♦ **Nature of accepted products** : GI, Electro-galvanized Steel, GA, Stainless Steel (Ferritic/Austenitic), Tin, Laminated Zn, ECCS, non passivated Aluzinc, Aluminium. Other products (Prepatinated Zinc, Copper, Aluzinc with easyfilm (warning ecopassivated not accepted), AluSi with easyfilm on derogation

Substrate \ Pretreatment	None	Oil	Cr3	Cr6	E-passivation	Easyfilm	Organic coating	Other accepted surface conditions
CR Steel	NOK ¹	OK ²	NOK	NOK	NOK	OK	OK	/
HDG Steel	OK	OK ²	NOK	NOK	NOK	OK	OK	/
Electro-Galvanized Steel	OK	OK ²	NOK	NOK	NOK	OK	OK	Phosphated
Aluzinc	OK	OK ²	NOK	NOK	NOK	OK	OK	/
Alusi	OK	OK ²	NOK	NOK	NOK	OK	OK	/
Stainless Steel	OK	OK ²	NOK	NOK	NOK	OK	OK	Any top surface finish (2B, 2R, Scotch-Brite, "corked"...))
Aluminium	OK	OK ²	NOK	NOK	NOK	OK	OK	Anodized
Copper	OK	OK ²	NOK	NOK	NOK	OK	OK	Oxidized
Zinc	OK	OK ²	NOK	NOK	NOK	OK	OK	Phosphated

- ♦ **Substrate width (mm)** :
 - entrance : 700³ minimum
1.500 maximum
 - exit : 700 minimum
1.500 maximum


NB : see width and thickness combination requirement

¹ On derogation if the coil is properly wrapped, without any red rust

² Max. oil quantity = 0.5 gr/m²

³ Smaller on request (derogation)

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◆ Substrate thickness (mm) :

Steel, stainless steel, zinc substrate

Conditions
 If $0,10 < t < 0,17$
 $0,17 < t < 1,2$ mm
 $1,2 < t < 1,50$ mm

If OC only
 On derogation
 OK
 OK

If PVD
 On derogation
 OK
 On derogation

NB : Maximal OC section: 1.950 mm²

That is : 1.3 x 1500
 1.4 x 1390
 1.5 x 1300

NB : Maximal size for PVD :

if width < 1350 mm :
 If width > 1350 mm :

$0,17 \text{ mm} < t < 1,2$ mm
 Limitation to a section of 1050mm² due to the strip guiding in the vacuum
 That is:
 1400 x 0,75
 1500 x 0,70

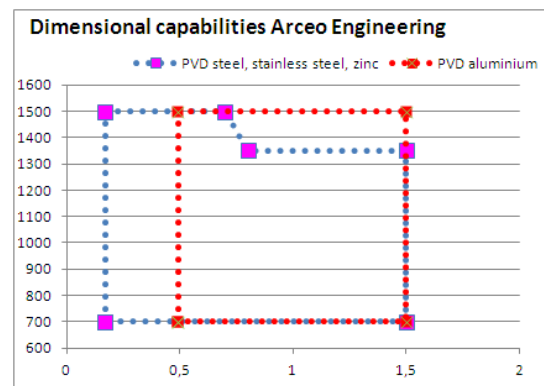
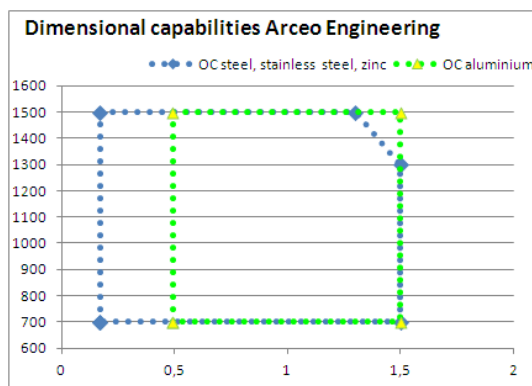
Aluminium substrate:

Conditions
 Si $0,30 < t < 0,49$
 $0,49 < t < 1,2$ mm
 $1,2 < t < 1,50$ mm


If OC only
 On derogation
 OK
 OK

If PVD
 On derogation
 OK
 On derogation

Graphical synthesis:



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- ♦ **External coil diameter (mm)** :

Entrance	:	internal \varnothing + 200 minimum 1.590 maximum 1.640 maximum on derogation
Exit	:	internal \varnothing + 200 minimum 1.450 maximum

- ♦ **Internal coil diameter (mm)** :

Entrance	:	(415 - 0, + 5 on derogation) 508 - 0, + 5 610 - 0, + 5
Exit	:	508 - 0, + 5 610 - 0, + 5

On derogation, oval eye coils are only acceptable if the smallest dimension of the eye is larger than:

488 mm	for 508 mm nominal.
590 mm	for 610 mm nominal.

- ♦ **Weight (kg)** :

Entrance	:	2.000 mini (for Aluminium : 700 kg) 12.500 maxi (for Aluminium : 6.170 kg)
Exit	:	1.000 mini (for Aluminium : 700 kg) 12.500 maxi (for Aluminium : 6.170 kg)

Remark: The automatic weighing of the coiling is done directly at the exit of the line


- ♦ **Minimal coil length (entrance/exit)** :

400 m at the entrance
Derogation at the exit is possible if the minimal length of the client is 400m<...<100m

- ♦ **Oiled substrate not accepted** : See « Nature of accepted products » table

- ♦ **Already painted substrate (repainting)** : Repainting jobs are accepted on derogation provided that :
 - There is no guarantee of durability of the repainted product.
 - No tint guarantee on the backing coat.
 - Description of the previous painting complex is provided (type of paint + thickness of each layer on both sides).
 - Derogation is accepted by the quality department based on the information mentioned above.

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- ♦ **Guarantees of appearance** :
 - Guarantees on one side only is preferred
 - Identical guarantees of the second side: **No**
 - Lesser guarantees on the second side:
 - **Steel, stainless steel, zinc substrate:**
 - Thickness < 0,3 mm : No
 - 0,3 < Thickness < 0,4 : Mat finish: derogation
 - 0,4 < Thickness : Glossy finish: No
 - Derogation
 - **Aluminium substrate :**
 - Thickness < 0,85 mm : No
 - 0,85 < Thickness < 1,1 : Mat finish: derogation
 - 1,1 < Thickness : Glossy finish: derogation
 - Derogation

LINE DESCRIPTION :

- ♦ **Electromechanical speed** : 60 m/min maximum
- ♦ **Uncoilers** :
 - Supply equipement : Crane
 - Type of accepted coiling : Straight
 - Uncoiling direction : Top / Bottom
 - Paper decoiler : On derogation
- ♦ **Regulations** :
 - By accumulator : Yes
 - Traction : By S-block
- ♦ **Marqueuse** : Oui (en axe de la face arrière uniquement)
- ♦ **Welder** : No
- ♦ **Stapler** :
 - Yes
 - Possibility to staple every substrate
 - Staple detection : Yes for the line
 - Non welding possible for recomposition
- ♦ **Shear** :
 - Thickness (mm) : 0,10 à 0,17 on derogation
 - 0,17 minimum
 - 1,50 maximum
 - Localisation : 2 at the entrance, 1 at the exit

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- ♦ Leveler : No
- ♦ Edge cutter : No
- ♦ Oiler : No
- ♦ Filming : Yes
1 side only
Exit of OC line and PVD line
Before coiling
- ♦ Triage - inspection : Yes
1 side (A-side preferred)
2 sides (Less guarantees on the B-side)
Defects spotting : Yes By stickers
Inspection document : Yes
Guaranteed appearance : Every demanded appearance
Standards : AFNOR A36-401
DIN 1623
NBN 770
Inspection station : After exit accumulator
Autre : Coiler
- ♦ Controls : Thickness : Manual
Width : Manual
Flatness : Visual
Organic Coating Thickness : Manual
Colour : Manual
- ♦ Coiler : Evacuation equipment : Crane
Type of coiling : Straight
Strip guiding : Yes
Coiling direction : Top
Bottom
Coiling by : Belt wrapper

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