

# Online Auction Sale

Copper Tube Manufacturing Equipment no longer required by  
KME Germany GmbH & Co KG



**Bidding Ends: Wednesday 17th January at 3pm (UK Time) Viewing by Appointment only**

Offers would be considered for the whole facility prior to auction, please call:

**Martin Cottrill or Simon Halsey on + 44 (0) 121 328 2424**



## Seamless Copper Tube Facility

Capable of producing Tube 54mm to 6mm

Capacity. 30,000 tons per year

Main Items of Plant ;

Ludwig Ofag Continuous Billet Feeding Furnace

Innse Rotary Piercing Mill with Schlak Tube Cutter

SMS/MEER/ Cold Pilger Rolling Mill

4 off MRB Marshall Richards Spinner / Drawing Blocks

Annealing Line with Danieli Straightening Machine &

Schumag K2-P-1B/3 / Drawing Machine

For Full Information & Viewing Appointments please contact our Office:

Cottrill & Co, 401-407 Tyburn Road, Erdington, Birmingham, West Midlands, B24 8HJ, United Kingdom

• Tel: + 44 (0) 121 328 2424 • Fax: + 44 (0) 121 327 9550 • Email: [info@cottandco.com](mailto:info@cottandco.com) • Website: [www.cottandco.com](http://www.cottandco.com) •

Cottrill & Co is a Trade Name of Cottrill & Associates Ltd



## Product

Seamless Copper Tube Facility for the production of domestic heating & plumbing tubes.

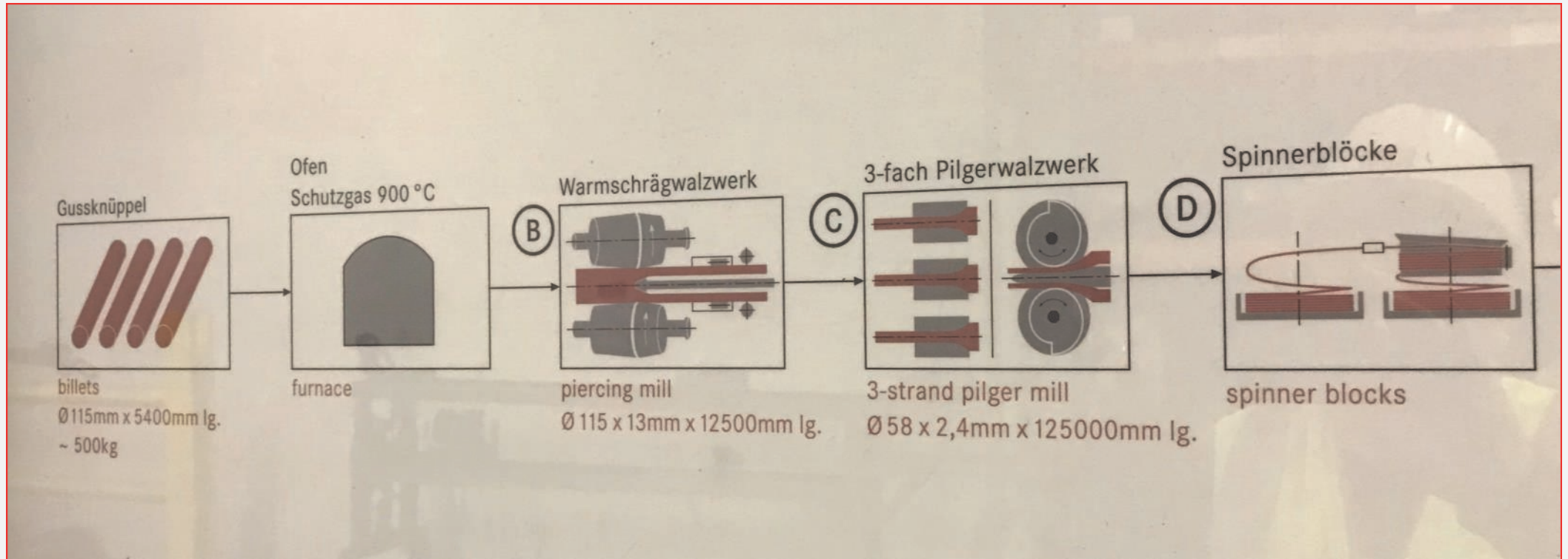
Producing for world renowned Brand  
Previously producing Tube:

54mm dia x 2mm wall thickness  
22mm dia x 1mm wall thickness  
10mm dia x 1mm wall thickness  
6mm dia x 1mm wall thickness



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## Process:

**Billet:**  
5.5m Length x  
115 mm (500kg)



**Ludwig Furnace**



**Piercer produces:**  
125m long x 115mm dia  
X 13mm wall  
thickness shell



**Pilger Mill produces:**  
3 Strand 125m Length x  
58 mm dia x 2.4mm wall  
thickness tube



**MRB Spinners/Draw Blocks  
reduce to:**

54mm dia x 2mm wall thickness,  
22mm dia x 1mm wall thickness,  
10mm dia x 1mm wall thickness  
6mm dia x 1mm wall thickness

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## Schumag Drawing Machine with Annealing Line

Standard Version KZP-1B, Pulling Force 3 Tons, Pulling speed 120 metres per minute, Minimum Exit DIA 6mm, Minimum Tube Length 3m, Maximum Tube Length 6m

Consisting of;

- (2) De-coilers
- (2) **Schlak** Type TZ02 Dancers
- (1) **Schlak** Type HOT 500 Dancer
- **Danieli** Straightening Machine by FMI SPA with Marking Device.
- Dual Induction/Annealing Unit with Cooling Section Extraction - **DCS** System Lauer Control Console
- **Troester** Pulling Unit
- **Schlak** Type LTA 200 Tensioner
- **Friedr Krollman** Type HRA4-65 Crimper/ Pointing Machine with Hydraulics
- **Schumag** Type K2-P-1B/3 / Drawing Machine with Chiller Unit Control and Electrical Cabinets
- **Sea** Type G00 3VPS Flying Cut Off with Siemens Multi Panel Touch Screen Control and Electrical Cabinets
- Product Stacker with Guiding Rolls,
- **Logomatic** 804 Labeller with OP7 Simatic Siemens Control. Swarf Take off
- **LHR** Filter Type DFV2 1-1.012 Dust Extraction System with Siemens Control



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## Innse Rotary Piercing Mill with Ludwig Ofag Indugas Billet Furnace;

- Min / Max Billet 80mm dia x 3000mm length, 120mm dia x 5700mm length
- Continuous Feeding System with Billet Brushing Rotary Crane, Bocker Straightening Machine, Ludwig Ofag Indugas (LOI) / Charging and Discharging Billet Furnace
- Tube Transportation System to Piercing Mill
- Siemens** Main Electric Motor, Gearbox and Transmission **Innse** Billet Pusher, Control Console.
- Re-sawing Unit
- Pressure Rollers 116-145mm dia x 450mm width
- Roller Material No. 12343, Core Material of Pressure Rollers 1.2343.
- Hardness of outer alloy 1.9080
- Incoming Billets 115mm x 5400mm, Weight 508kg, Temperature 930c
- Outgoing Billets 115mm x 13mm x 1250mm
- Mandrel Diameter: 86mm, Mandrel Material 1.2581
- Roller speed 70 – 90rpm,
- Max Performance 28 pieces per hour
- Electric Control with Siemens Multipanel Touch Screen
- Water Cooling and Filtration System
- Tooling for Piercing Mill and Transformers

**Also available; huge quantity of spares for this line**



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## SMS/MEER/ Cold Pilger Rolling Mill 3-Strand

(3) x 115 VMR, number of Billets (3), Continuous Chain, Shell Transportation System with Feeding Table, Strokes 90 maximum – 85 per minute actual, Feed Rate 15.8 / 14.1mm Stroke, Shell Length 14,000mm Max, 8000 Minimum, Shell Dia Outer 115mm Inner 89mm, Shell Weight 500KG, Exit Material: Tube Dia Outer 58mm Inner 53.2mm,

Max Tube Eccentricity: % + - 2,

Main Electric DC Motor 950KW 800 RPM with Controls, Reserve Main Clutch, Kind & Co/ Century Calibrating Roller 610mm dia x 220mm width,

Tools Calibrating Roller Material. No. TQ1/1.2344,

Calibrating Roller Hardness (HRC), Chrome Plate Mandrels – Material 1.2363, Thickness 0.003mm Hardness (HRC) 54-56 Pushing Device.

Push Rods x 4, Noise Protection Hood with Controls,

Chain Shell Transport System, Emulsion System with Controls,

Tube Guiding System – Pilger Tunnel, Turning Device for Pilger Tools,

Mandrel Support, Delimon Central Lubricating System,

Controls and Electrical Cabinets

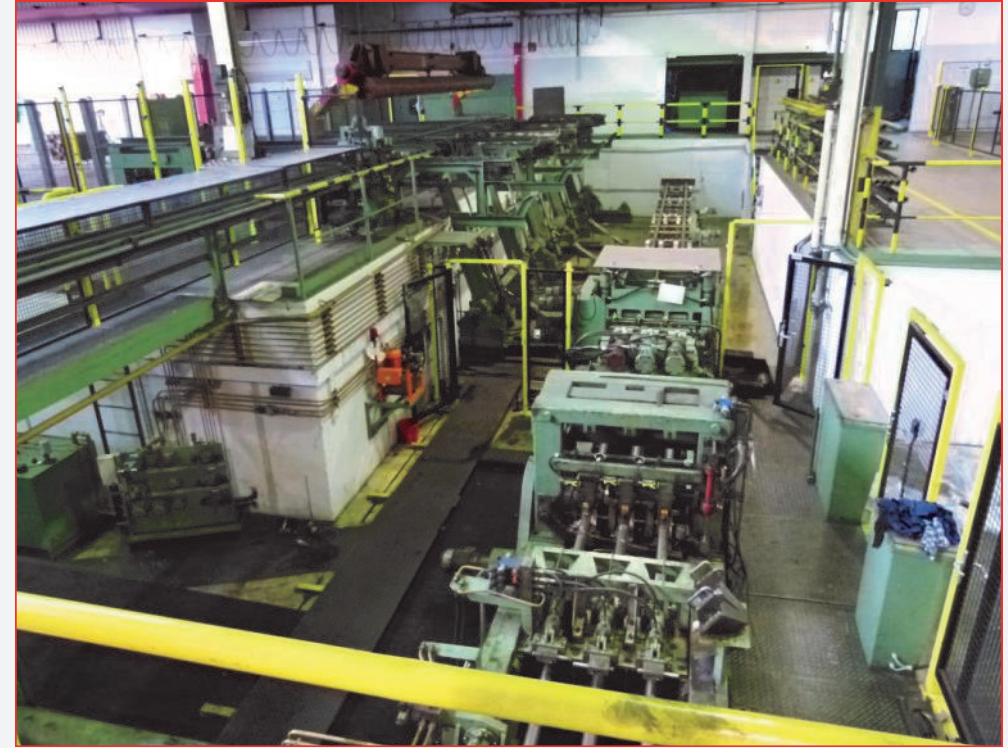
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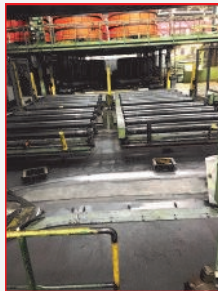
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## Marshall Richard Pre-Draw Spinner Block MR 1

Circular Sawing Unit from Pilger Tubes Transportation and Storage Area, Direction of Rotation - Right Clockwise, Block Dia 2134, Max Tube Inlet Dia: 58mm, Max Wall Thickness: 2.4mm, Min: Tube Outlet Dia 6mm x 1mm Wall Thickness, Max. Carriage Force: 12-Ton, Pulling Speed: 750 m/min, Basket Circulation System with Dual Basket Lifting Devices, (4) Tube Transport Baskets, Dancers, Crimping/Machine Pointing, Pre-Straightner Control, Spinner Block, Discharge Table 1500kg Capacity, Electrical Control, Lubrication System (1978) (Modifications 1998 Controls, 2003 Drum)



## Marshall Richard Pre-Draw Spinner Block MR 2

Direction of Rotation - Right Clockwise, Block Dia 2134, Max. Tube Inlet Dia 58mm, Max. Wall Thickness: 2.4mm, Min. Tube Outlet Dia 6mm x 1mm Wall Thickness, Max. Carriage Force: 10.9-Ton, Pulling Speed: 1000m/min, Basket Circulation System with Basket Lifting Devices, (4) Tube Transport Baskets, Dancers, Crimping/Machine Pointing, Pre-Straightner Control, Spinner Block, Discharge Table: 1500kg Capacity, Electrical Control, Lubrication System (1974/1979) (Modifications 1998)



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## Marshall Richard Pre-Draw Spinner Block MR 3

Direction of Rotation - Right Clockwise, Block Dia 2134, Max. Tube Inlet Dia 29mm, Max. Wall Thickness: 1.45mm, Min. Tube Outlet Dia 6mm x 1mm Wall Thickness, Max. Carriage Force: 7.9-Ton, Pulling Speed: 1120mph min, Basket Circulation System with Basket Lifting Devices, (4) Tube Transport Baskets, Dancers, Crimping/Machine Pointing, Pre-Straightner Control, Spinner Block, Discharge Table 1000kg Capacity, Electrical Control, Lubrication System (1979) (Modifications 1998)



## Marshall Richard Pre-Draw Spinner Block MR 4

Direction of Rotation - Right Clockwise, Block Dia 2134mm, Max. Tube Inlet Dia 45mm, Max. Wall Thickness: 2.1mm, Min. Tube Outlet Dia 6mm x 1mm Wall Thickness, Max. Pulling Carriage Force: 8.1-Ton, Pulling Speed 900 m/min, Basket Circulation System with Basket Lifting Devices, (4) Tube Transport Baskets, Dancers, Crimping/Machine Pointing, Pre-Straightner Control, Spinner Block, Discharge Table 1500kg Capacity, Electrical Control, Lubrication System and (1986) (Modifications 1990)



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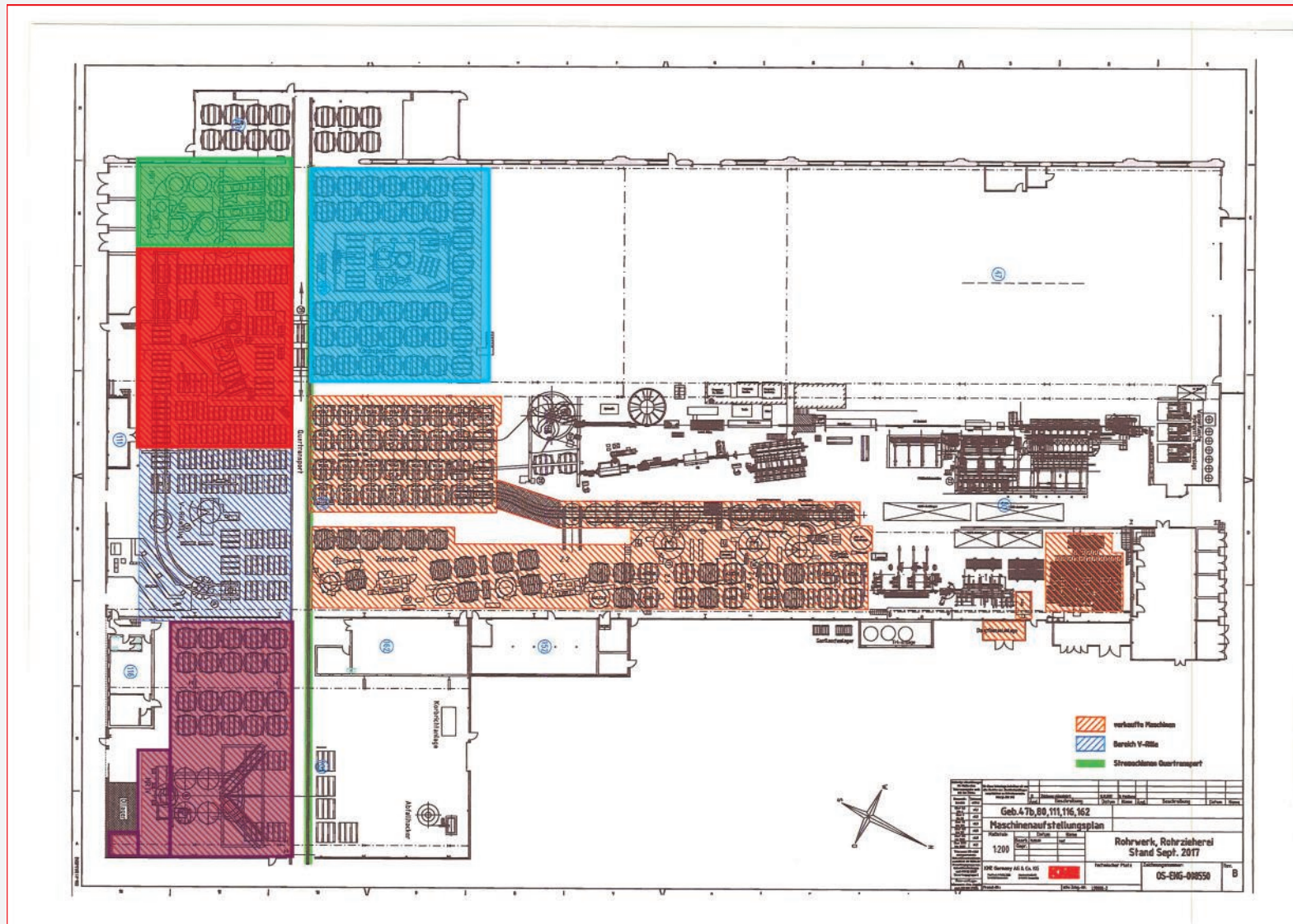
**Firbimatic Degreasing System** – Working Degreasing Chamber, Reserve Heating, Steam Generator and Refrigerating Plant, Max Coil Weight: 2.5t, Max Coil Diameter 750mm, Min Pipe Diameter 12mm, Max Pipe Diameter 54mm, Min Pipe Length 3m, Max Pipe Length 7.5m, Cycle Time approx. 30 min, Operating Voltage 400(V), Connected Load 180kw 185 A, Amount of Solvent 109333 litres, (2005)



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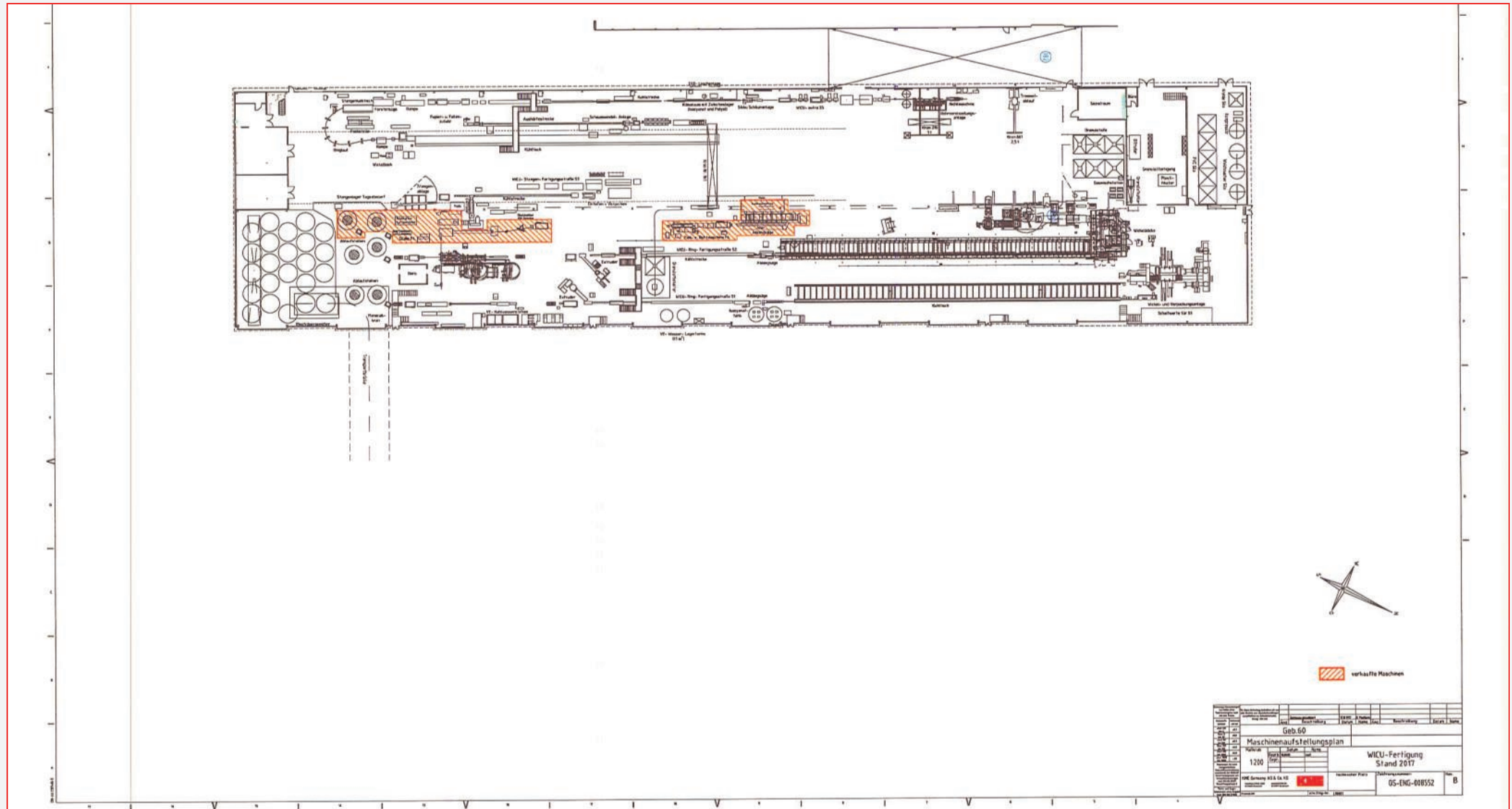


## Key

- = Marshall  
Richard Pre-Draw  
Spinner Block MR 1
- = Marshall  
Richard Pre-Draw  
Spinner Block MR 2
- = Marshall  
Richard Pre-Draw  
Spinner Block MR 3
- = Marshall  
Richard Pre-Draw  
Spinner Block MR 4

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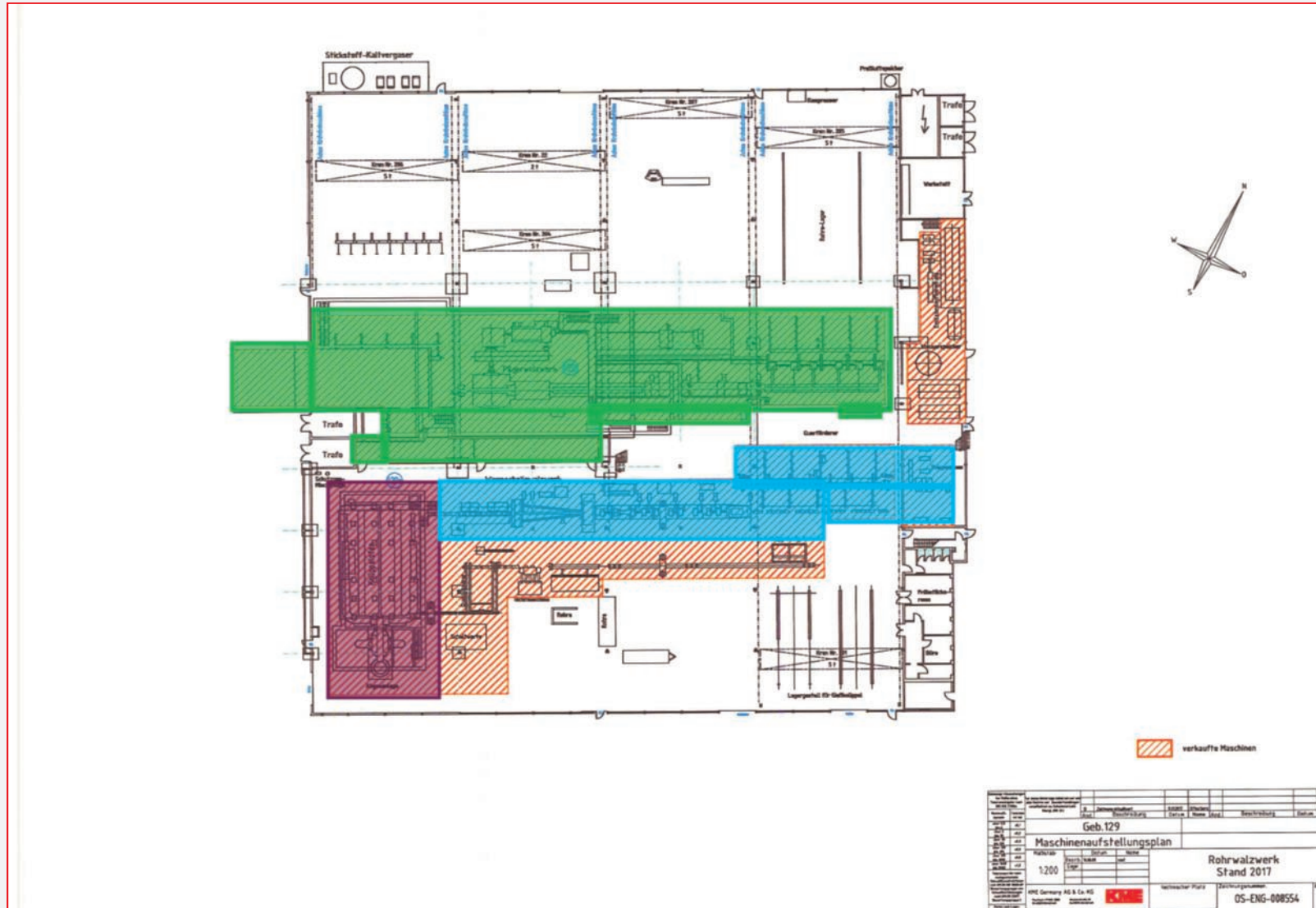
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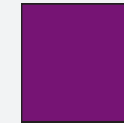
## Key



= SMS/MEER/ Cold  
Pilger Rolling Mill  
3-Strand



= Innse Rotary  
Piercing Mill



= Ludwig Ofag Indugas  
Billet Furnace

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# Large Quantity of Tube Spinning & Transport Baskets for MRB– Marshall Richard Spinner Blocks



- Qty Tube Transport Baskets
- Qty Tube Support Devices
- **Kuka** Type 2H 200-2 / KR 200 / 2 T J Robot
- (2) Tube Transport Basket Turntables with Lifter
- Plus many more ancillary items



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