# **Aluminum Hot Rolled Plate Process**



# **Casting Slab**

Homogenized Surface Treatment **Quality Check** 



### **Furnace Loading**

**Facilities Check** 



## Heating

370°C~520°C 5~10 hours



### Lubricating

**Rolling Oil** Water Additives



### **Hot Rolled**

Rolling Temp.: 400°C~500°C Reversible, 10~30 passes

# **Solution** Heat-treating

#1 Heating: to a suitable temperature #2 Temperature Holding: long enough #3 Cooling: rapidly enough



## Cutting

**Cut Head & Tail** Take 200~300 mm off



### **Edge Rolled**

20~25mm Width Control Prevent Edge Crack



# Cooling

**Cooling Liquid** 





### Cleaning

#1 Pickling

#2 Cold Water

#3 Hot Water



## Straightening

Improve Flatness



Stress Relieved

Permanent Set 1.5%~3%

**Dimension Tolerance** 



T4x: Natural Ageing at room temperature

T6x: Artificial Ageing at elevated temperature

# Packing and Shipping



# **Quality Check**

Appearance & Flatness Quality

Internal Structure

**Mechanical Properties** 

**Dimension Tolerance** 



# **Cutting & Sawing**

**Dimension Confirmation Tolerance Control**