

CORRUGATED ROLLS THAT LAST LOOOOOOONG!






GET READY TO BOOST YOUR PRODUCTION

ATS

Delivering Excellence since 1992

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ATS IS ON A ROLL

A quick glance at ATS

ATS Techno Pvt. Ltd. (ATS) is a one stop destination for all types of single facer rolls. Established in 1992, ATS is considered a legacy in applying tungsten carbide coating and grinding on rolls, which is used mainly in paper, steel, printing and packaging industries. In the manufacturing world, we are now synonymous with precision, quality and durability. We are a respectable and reliable alternate for foreign OEMs.

An ISO 9001:2015 certified company, ATS is the only Indian supplier that has in-house facilities for both roll manufacturing and surface coatings. Spread over a sprawling 32,750 sq.ft., the facilities at ATS include medium frequency induction hardening, advanced welding equipment, heat treatment furnaces, CNC machining centres, heavy-duty lathe machines, imported CNC roll grinding equipment with surface coating facilities such as tungsten carbide coating and advanced hard chrome plating. Our products are renowned for their efficiency, ability to withstand high temperature, pressure, corrosion and wear & tear.

Industries

-  Paper
-  Steel
-  Hydro Power
-  Thermal Power
-  Printing & Packaging

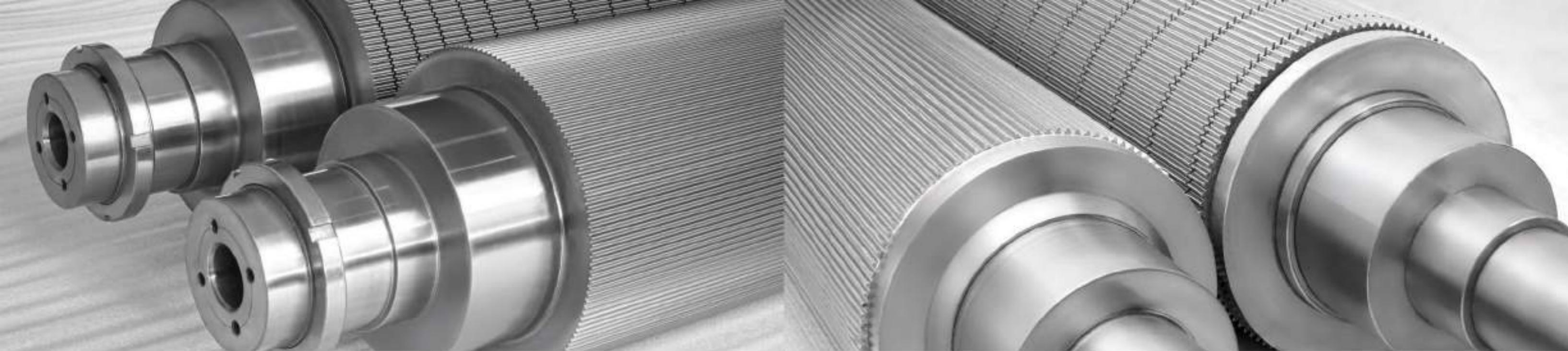
Clients

- Wadpack • Miracle • TGI • Panoply • Relieable • Alok • SMS Group
- GE • BHEL • VOITH • HPCL • NTPC • Indian Oil • Shell • TATA Steel
- JSW Steel • GAIL • Reliance • JK Paper • ITC Paper • Bilt Paper

ROLL OUT THE RED CARPET

Presenting Corrugated Rolls from the leading manufacturer of Rolls

ATS is a leading manufacturer of thermal spray coated rolls that are used in Steel, Paper, Printing and Packaging industries. After an experience that spans 15 years and 1200 rolls, we are proud to launch Corrugated Rolls, which are made from High Alloy Steel Forgings with UV Profile for Automatic & Semi-Automatic Single Facer Machines with Tungsten Carbide Coating and Hard Chrome Plating.



TYPES OF CORRUGATED ROLLS

Tungsten Carbide Coated New and Refluted

Solid Fine Carbon Alloy Steel Forgings
 Roll Surface Hardness : ≥ 55 HRC
 Surface Coating : Tungsten Carbide (72 HRC)
 Circular Runout : ≤ 0.02 mm
 Straightness Accuracy : ≤ 0.02 mm
 Roll Wall Thickness : 50 to 60mm
 Surface Finish : Ra 0.2-0.8 μ m

Flute UV profile	No of flutes/300mm	Height(mm)	TUR
K	26 \pm 2	5.5-6.0	1.50-1.60
A	36 \pm 2	4.5-5.0	1.51-1.55
C	41 \pm 2	3.5-4.0	1.44-1.51
B	53 \pm 3	2.5-3.0	1.36-1.42
E	93 \pm 6	1.1-1.9	1.28-1.38
F	120 \pm 6	0.6-1.0	1.22-1.25
G	185 \pm 10	0.5-0.7	1.19-1.26
N	200 \pm 10	0.4-0.6	1.16-1.22

Advanced Hard Chrome Plated New and Refluted

Solid Fine Carbon Alloy Steel Forgings
 Roll Surface Hardness : ≥ 55 HRC
 Surface Coating : Hard Chrome (60 HRC)
 Circular Runout : ≤ 0.02 mm
 Straightness Accuracy : ≤ 0.02 mm
 Roll Wall Thickness : 50 to 60mm
 Surface Finish : \leq Ra 0.4 μ m

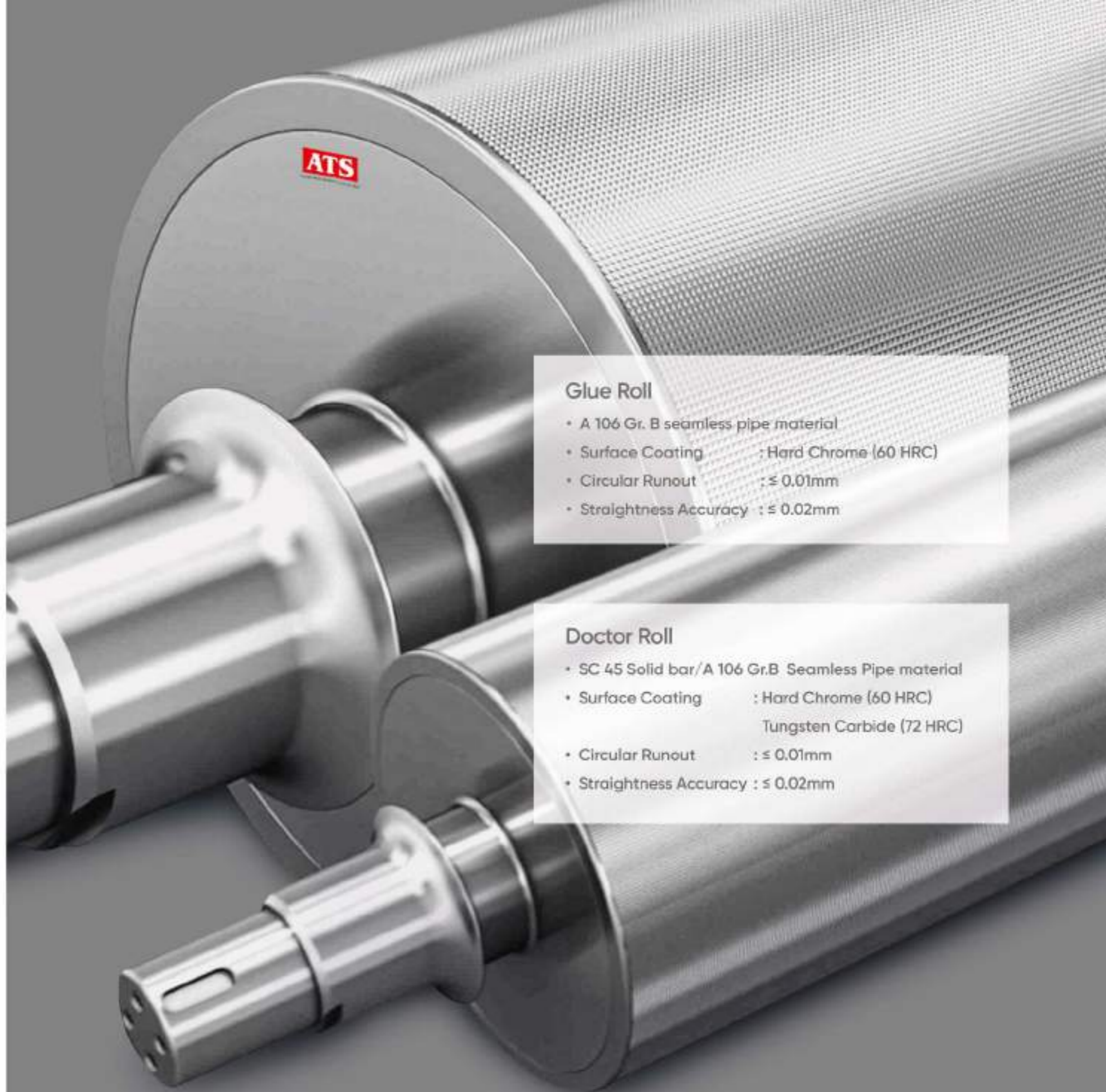
Comparison	Hard Chrome Corrugated Roll	Tungsten Carbide Corrugated Roll
Flute Height	Initial design height is higher than required, due to moderate wear resistance	Initial design height is optimum, due to excellent wear resistance
Cardboard Thickness	Initially high and low with the wear during use	Same thickness of corrugated board throughout roll life
Service Life	8 to 9 million meters	24 to 25 million meters
Roll Usability	2 to 3 times	5 to 6 times
Take-up Factor	High and unstable	Low and stable
Fatigue Strength of Roll	Reduce	Remains the same



PRESSURE ROLL

SC 45 Solid forging Round Bar Material

Roll Hardness	: ≥ 52 HRC
Surface Coating	: Hard Chrome (60 HRC) Tungsten Carbide (72 HRC)
Circular Runout	: ≤ 0.02 mm
Straightness Accuracy	: ≤ 0.02 mm
Shape	: Straight / Crowned
Roll Wall Thickness	: 45 to 55mm
Surface Finish	: $\leq Ra 0.2\mu m$

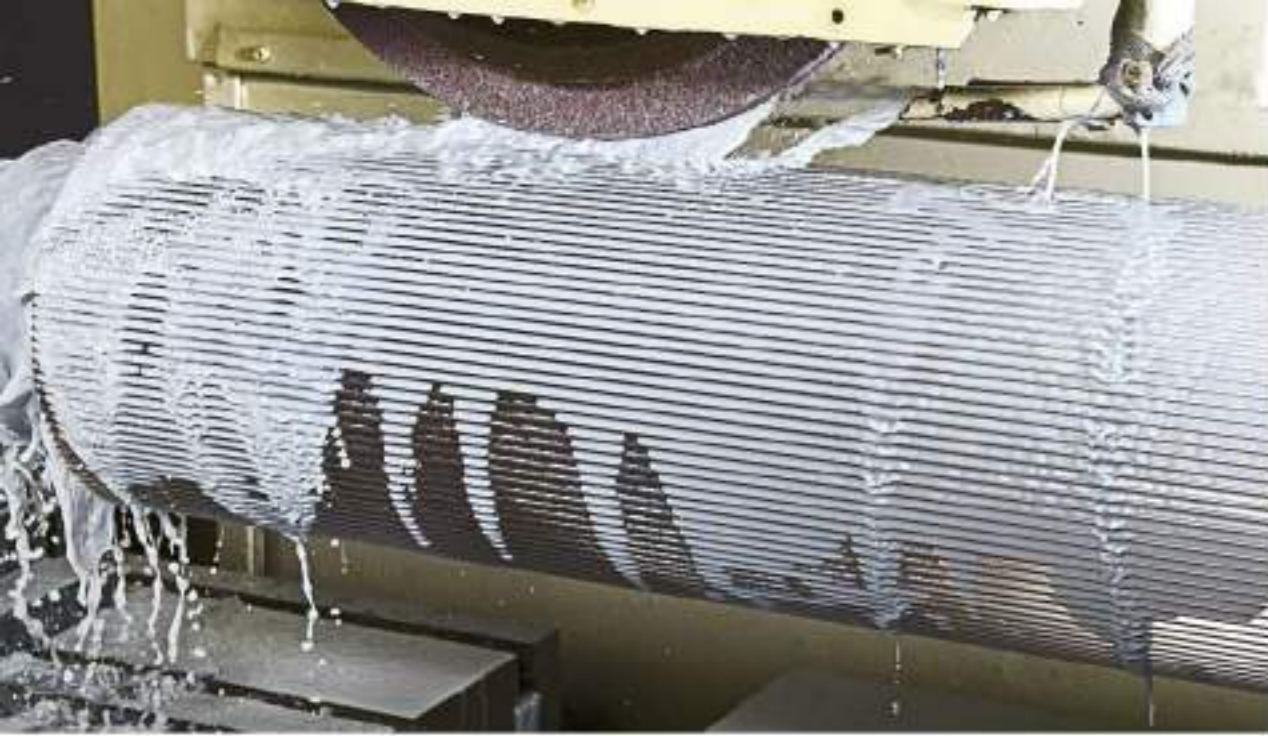


Glue Roll

- A 106 Gr. B seamless pipe material
- Surface Coating : Hard Chrome (60 HRC)
- Circular Runout : ≤ 0.01 mm
- Straightness Accuracy : ≤ 0.02 mm

Doctor Roll

- SC 45 Solid bar / A 106 Gr.B Seamless Pipe material
- Surface Coating : Hard Chrome (60 HRC)
Tungsten Carbide (72 HRC)
- Circular Runout : ≤ 0.01 mm
- Straightness Accuracy : ≤ 0.02 mm



WORLD CLASS FLUTE GRINDING FACILITIES

German made Waldrich Coburg CNC Flute Grinding Machine is globally renowned for producing highest accuracy flute profile. The dimensional and geometrical accuracies of the flute profile is as per international standard for high-speed single facer machines.

The profile diamond tool setup accuracy is within 1 micron.





ADVANCED INDUCTION HARDENING FACILITY

Improves the quality and enhances
the life of the roll

Advanced Medium Frequency Induction Hardening Machine

- EMA, made in Germany
- Carries surface hardening of corrugated rolls to get uniformly thick high-hardness layer

Benefits of EMA Medium Frequency Induction Hardening

- No micro cracks on flute corners
- Good flute toughness
- Thick homogenous hardened layer





CUTTING EDGE CNC ROLL MANUFACTURING FACILITY

The corrugated rolls finishing gets done on high precision CNC turning centers. Next, the barrel length & bearing area size will be ground on CNC imported (WMW, Shibaura & Herkules) grinding machines by maintaining high dimensional & geometrical accuracies as per international standards.

USA MADE WMW CNC Grinding Machine

The dimensional and geometrical accuracies of the corrugated rolls are maintained with high care so that the single facer machine runnability remains smooth.



ROBOTIC COATING ON FLUTE ROLLS

- German-made Kuka robot for high accuracy coating quality
- USA-made Praxair-TAFA for HP/HVOF coating system
- Switzerland-made Gudel for Track Motion
- ATS delivers best-in-the-world coating quality using the above top-class equipment



ADVANCED HARD CHROME COATING FACILITY

- Increases the roll surface hardness to 60 HRC with good surface finish (0.4 μm)
- The imported chemicals, good process knowledge and regular monitoring of the electrolyte & temperature leads to better hard chrome coating characteristics
- Dedicated hard chrome facility is highly suitable for roll coating



QUALITY THAT HELPS YOU ROLL ALONG

- ATS Quality team performs regular quality interventions, from raw materials to finished products so our clients get the best products
- Flute Height, Roll Diameter, Run Out, Surface Hardness, Surface Finish and Surface Soundness of the rolls get checked at appropriate stage with high accuracy measuring instruments.
- Quality checks carried on the roll material
 - Chemical composition test
 - Physical properties test
 - Ultrasonic test
- The steel forgings received from the reputed suppliers is checked for quality as a part of inward inspection to ensure fulfillment of the applicable ASTM specifications.



THAT'S WHERE WE ROLL ALONG

State-of-the-art Manufacturing Facility

ATS has two state-of-the-art manufacturing facilities with a combined space of 32,750 sq. ft. at Ahmedabad, which is the commercial capital of Gujarat and a leading business hub. It is well-connected with roadways, railways and airways, which is highly conducive for transport of raw materials and finished products.

Our plant is equipped with advanced welding machines, grinding machines, acoustic spray booths, static annealing furnace, rotating annealing furnace, automatic blasting chamber, super polishing machines and machine tools with DRO facility.

Short lead time to delivery

ATS keeps sufficient stock of raw materials for a wide range of rolls in-house to reduce the order-to-delivery time gap.

