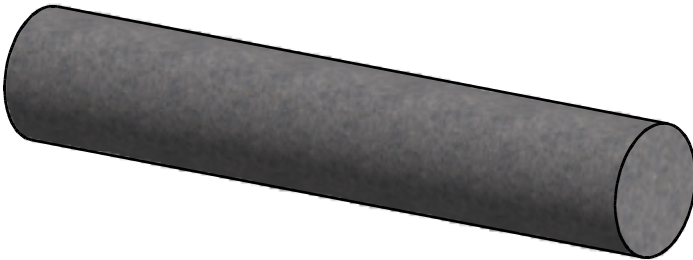


CYLINDER CENTRIFUGATION PROCESS

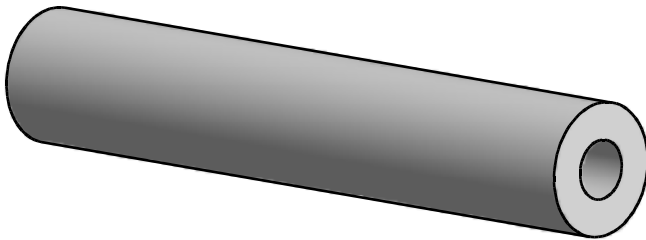
PHASE 1

We start from a solid bar of structural or forged steel



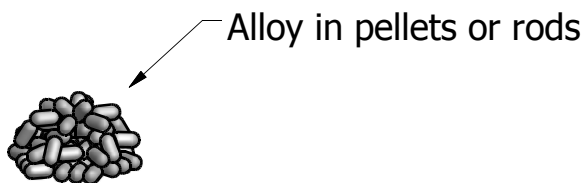
PHASE 2

The exterior will be turned and the interior core perforated in order to convert it in a thick-walled tube



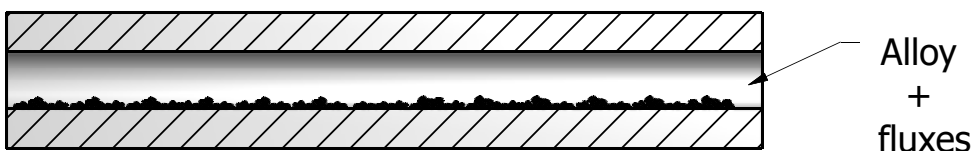
PHASE 3

The chosen alloy will be prepared for "centrifugation"



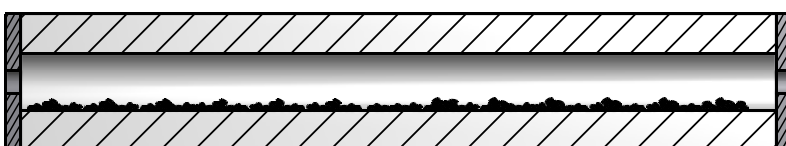
PHASE 4

The alloy is inserted in the interior of the thick-walled tube, together with some fluxes that protect the oxidation (similar to the welding process)



PHASE 5

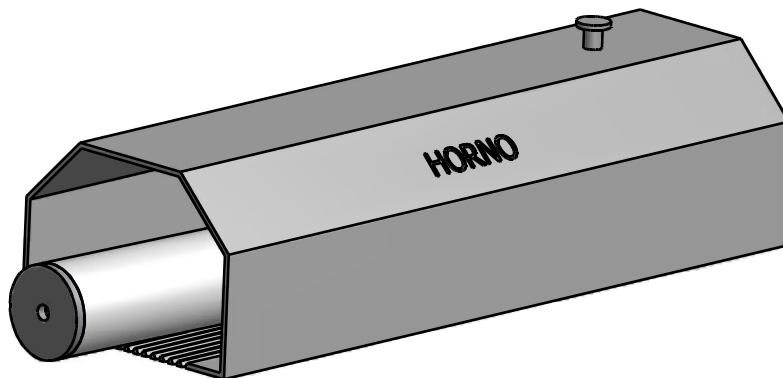
Both sides of the tube are plugged, leaving a small gas outlet



CYLINDER CENTRIFUGATION PROCESS

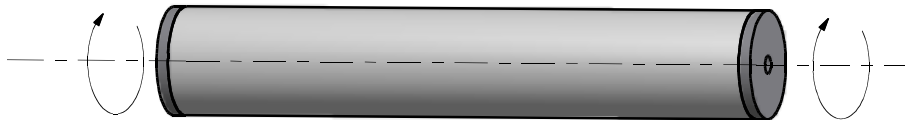
PHASE 6

The tube enters in the furnace to the melting temperature of the alloy (always less than the melting temperature of steel of the thick-walled tube)



PHASE 7

Once the alloy has cast inside the thick-walled tube, it is brought to a "centrifuge", which rotates the tube at high speed



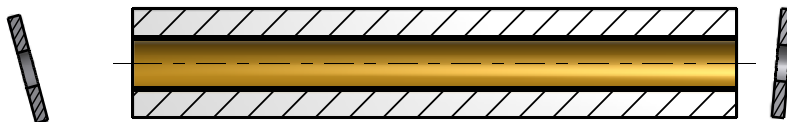
PHASE 8

Temperature descends while the fused alloy is deposited, by centrifugal force, on the inner walls of the tube.

The tube is cooled by air.

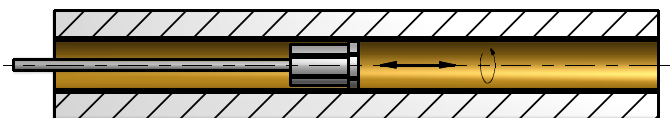
PHASE 9

The plugs of both sides are cut



PHASE 10

The interior of the tube is finished by honing, leaving the interior to the wished diameter.



PHASE 11

The centrifugated tube is finished

