

IN LINE STRIP ASSEMBLY

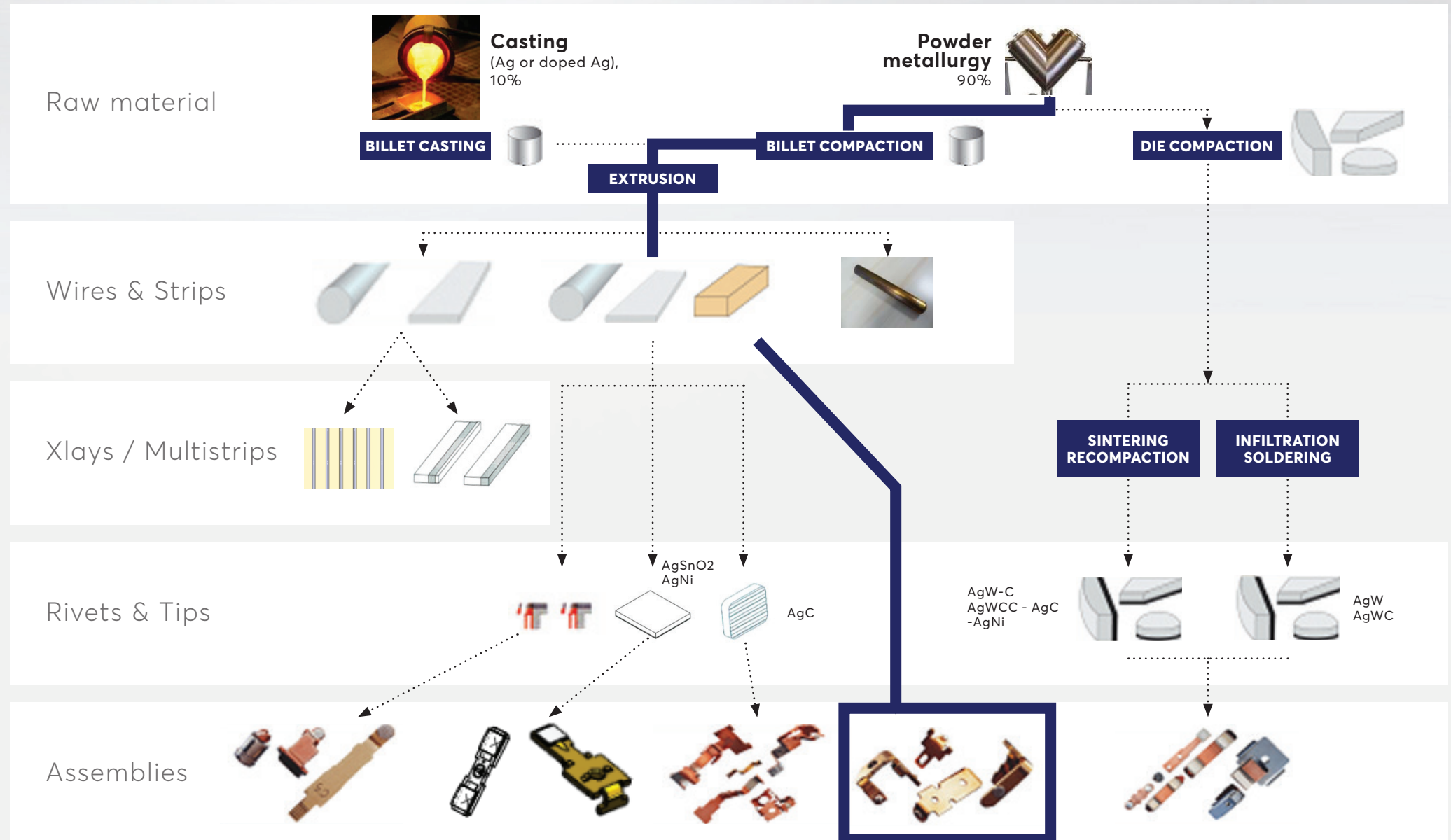
PROCESS DESCRIPTION



PRODUCTION FLOW CHART

METALOR TECHNOLOGIES ELECTROTECHNICS FRANCE

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IN LINE STRIP ASSEMBLY: APPLICATIONS

PRODUCTS	APPLICATIONS	KEY END MARKETS
<p>IN LINE STRIP ASSEMBLY</p> 	<p>MANUAL MOTORSTARTER 32A</p> 	<p>MACHINERY INDUSTRY</p> 
<p>IN LINE STRIP ASSEMBLY</p> 	<p>CONTACTORS 40A</p> 	<p>INDUSTRIAL BUILDING</p> 

IN LINE STRIP ASSEMBLY: PROCESS FLOW

POWDER MIXING



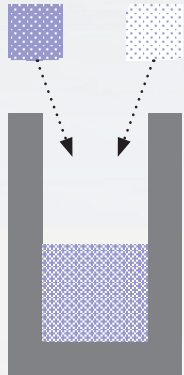
MONO/BI-LAYER BILLET
COMPACTION



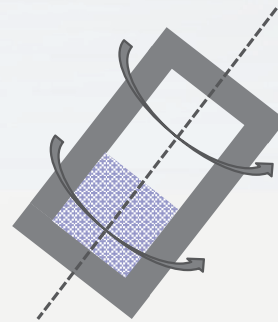
MONO/BI-EXTRUSION



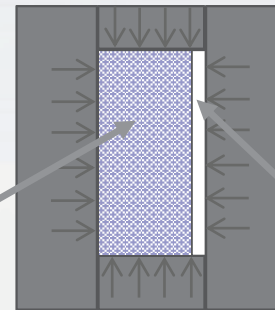
2nd comp.
powder



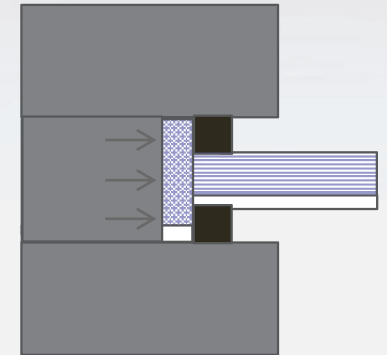
Ag powder



Mixed powder



Ag powder

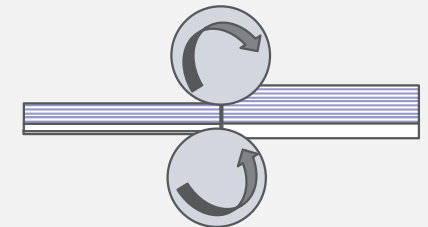
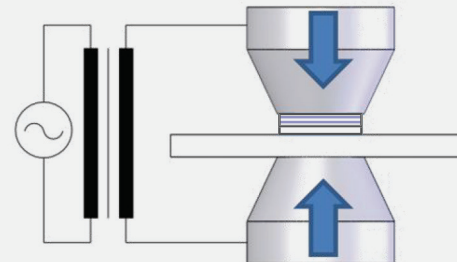


FINAL ASSEMBLY




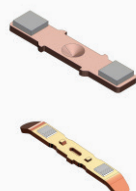
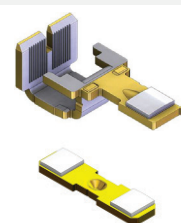

ROLLING

FINAL ASSEMBLY IS ALREADY FULLY
INTEGRATED IN THE METALOR STANDARD
PRODUCTION WORKFLOW



IN LINE STRIP ASSEMBLY:

TYPE OF PRODUCT

TECHNOLOGY	MATERIAL	COMPOSITION(%)	SHAPE		PRODUCT MAX DIMENSIONS (mm)	SILVER UNDERLAYER	SOLDERING
IN LINE STRIP WELDING	AgC	Graphite: 3 and 4%	Square/ rectangle		5.0 x 5.0 x 1.0	✓ AgC calcinated	✓
	AgNi	Ni: 10%	Square/ rectangle		3.3 x 3.3 x 0.75	✓ bi extruded	✓
	AgSnO2	SnO2 8 to 14%	Square/ rectangle		6.1 x 5.9 x 1.1	✓ bi extruded	✓
	AgZnO	ZnO: 8%	Square/ rectangle		3 x 4.5 x 0.6	✓ bi extruded	✓

✓ Standard

✓ Optional

IN LINE STRIP ASSEMBLY:

DESCRIPTION OF THE WELDING LINE

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1ST STAMPING PRESS



1ST WELDING STATION



2ND WELDING STATION



2ND STAMPING PRESS



Max. Speed = 200 strokes/mm

IN LINE STRIP ASSEMBLY:

PROS AND CONS

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PROS	CONS
<ul style="list-style-type: none">- Standard process by METALOR- More than 15 years experience- Fully integrated solution for customer (powder > assemblies)- Competitiveness (2 times faster than tips assemblies)	<ul style="list-style-type: none">- Only parrallel structure can be welded

For more information,
please contact **METALOR**
team on our Web site:
www.metalor.com

