



FEED AND BIOFUEL

ANDRITZ 'DISCUS' DIE RANGE FOR VERTICAL PELLET MILLS

FLAT DIE

ANDRITZ Feed & Biofuel is well known for the worldwide supply of performance parts for pellet mills like dies and roll shells for the feed & biofuel and the waste processing industry. ANDRITZ is a leading manufacturer and global distributor of ring dies for pellet mills. We have extended our portfolio to include flat

dies for vertical pellet mills in order to provide you with the best possible support. Our extensive experience of the entire manufacturing process for over half a century makes us experts in the field of machining, gun drilling, finishing, and hardening of ring dies. We apply this expertise and knowledge to the production of flat dies for

vertical pellet mills as well. Overall, the tendency is to use ring dies for pelletizing on pellet mills due to the capacity benefits. Nevertheless, some companies prefer to stick to the vertical pelleting process for various reasons, like limited capacity, type of commodity, or production process.

ANDRITZ

ENGINEERED SUCCESS

In order to serve you in the way for which ANDRITZ is respected by our customers, we are delighted to offer you this complementary product range.

We are able to supply a wide range of special alloy materials that fit your production process.

MANUFACTURING PROCESS

Every tiny part of the die has, at some stage, been produced with a single machining operation. After drilling and tapping bolt holes, milling keyways, turning up the basic shape of the die blank, cleaning, drying, vacuum hardening, tempering and finally finishing to the fitting sizes, the entire production of the die has gone through nearly 40,000 separate machining, processing, and handling operations.

MATERIALS

ANDRITZ offers a variety of chrome steel alloys. By varying the content of vanadium, chromium, manganese nickel, and carbon, we can select a material that suits every individual requirement for a wide range of operating environments.

PRECISION MACHINING

With our technical support, customers take great care in specifying size, shape, and pattern of the required die holes. We meticulously follow these instructions and manufacture the dies with accuracy and repeatability on the basis of an automated production process.

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GUN DRILLING

A fast and accurate process for producing highly polished extrusion holes. ANDRITZ pioneered this technique in the early 1980s and now produces the finest pelleting dies in the world by optimizing drilling speed and controlling lubricants.

HEAT TREATMENT

Our experienced operators establish heat treatment programs for chrome steel dies going into vacuum hardening ovens. The heat treatment process is of utmost importance as it guarantees the product uniformity. ANDRITZ has invested substantially in the most modern hardening technology to produce a long-life and high-performance die.

VACUUM HARDENING

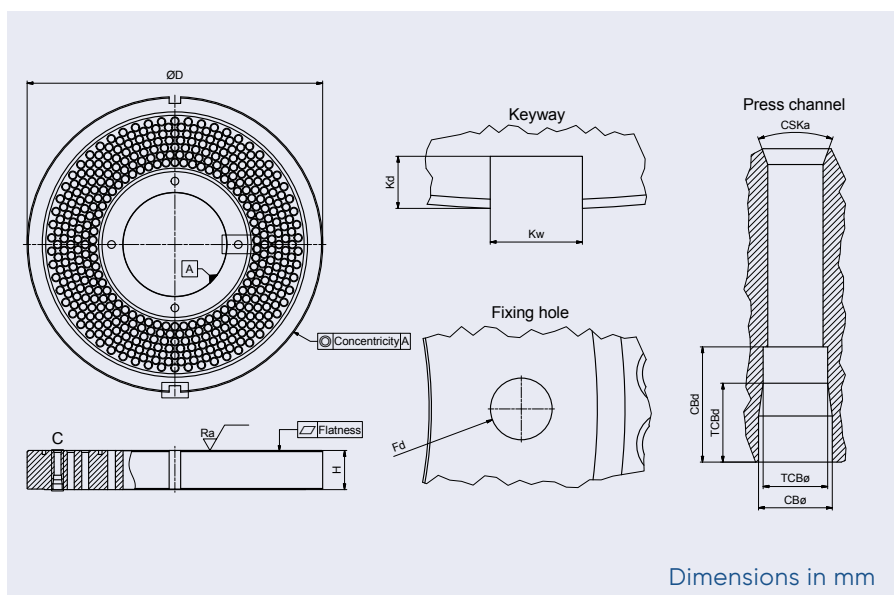
A hard-wearing surface in the holes will maximize the life of the chrome steel dies. Air is removed to create an inert environment. The die is heated in stages controlled by a microprocessor up to a temperature of 1,010°C, and the steel becomes a hard molecular structure as a result of this process.

FINISHING AND FINAL INSPECTION

Quality-assured systems monitor the product throughout the entire manufacturing process. In the final stage, and as the die is machined to fit the pellet mill perfectly, a check is conducted to ensure that the product conforms to the original specifications.

TECHNICAL DATA

Max. Ø outer diameter	1500 mm
Max. thickness	100 mm
Min. Ø drilling	3 mm
Max. Ø drilling	10 mm
Counterdrilling min. Ø	3.5 mm
Counterdrilling max. Ø	10 mm
Min. hole pattern Ø	230 mm
Max. hole pattern Ø	1140 mm



Dimensions in mm

