

LIPOL

ALUMINUM · SEVOJNA · SERBIA

Aluminium, **rolled & extruded.**

Sheets, coils, tread plates, circles, plates, profiles, bars and tubes — cast, rolled, extruded, finished and certified under one accountable supplier.



WHO WE ARE

Our passion. **Precision.**

The processing of aluminium into state-of-the-art semi-finished products is our business and our passion. From Sevojna — a town synonymous with aluminium rolling for more than half a century — Lipol-Seval Valjaonica Aluminijuma a.d. supplies manufacturers across Europe with material held to EN standards and delivered on schedules they can plan around.

We create with and for our customers: developing alloys together, advising on temper and tolerance, and optimising processes so that what arrives at your plant is production-ready — not ready-to-process.

Rolling is our core production group. Technologically perfected rolled semi-finished products — cold-rolled strips, tread plates, circles and shapes, hot and cold rolled sheets — are produced within a three-site European rolling network spanning Slovenia, Croatia and Serbia.

Extrusion completes the programme: an automated cast house feeds presses from 1,000 to 10,500 tonnes, with AMS-grade heat treatment and a metrology laboratory measuring to a quarter of a micron.

INDUSTRIES WE SERVE

Building & construction · transport & automotive · machinery & engineering · electrical & energy · packaging & consumer · marine & defense grades.

KEY FIGURES

6,753_t

aluminium shipped to customers in a single year

10,500_t

press force of our largest extrusion line

54

alloys with complete engineering data sheets

Ø1,060_{mm}

largest as-cast billet diameter (41.7 in)

QUALITY & CERTIFICATIONS

Quality you can **audit.**

An aerospace-grade management system audited per EN 9104-001 — covering the production of cast slabs and billets, extruded bars and profile shapes and mechanical components — on top of three decades of continuously maintained ISO certification.



CERTIFICATE	BODY	SINCE / VALIDITY
EN 9100:2018 — aerospace QMS equivalent to AS9100D & JIS Q 9100:2016	DQS GmbH	valid to 2028
ISO 9001 — quality	BVQI	since 1992
ISO 14001 — environment	BVQI	since 2000
OHSAS 18001 — health & safety	BVQI	since 2000

METROLOGY LABORATORY

Optical emission spectrometry on every heat · universal tensile testing · metallographic microscopy · 2D vision metrology (error to 0.25 µm) · 3D Vision H500 coordinate measurement · SEM, deep-drawing and metallographic research in the extended group laboratory.

DOCUMENTATION

A quality certificate accompanies every shipment. EN 10204 3.1 inspection certificates on request. Heat numbers marked for full traceability through cutting and finishing.

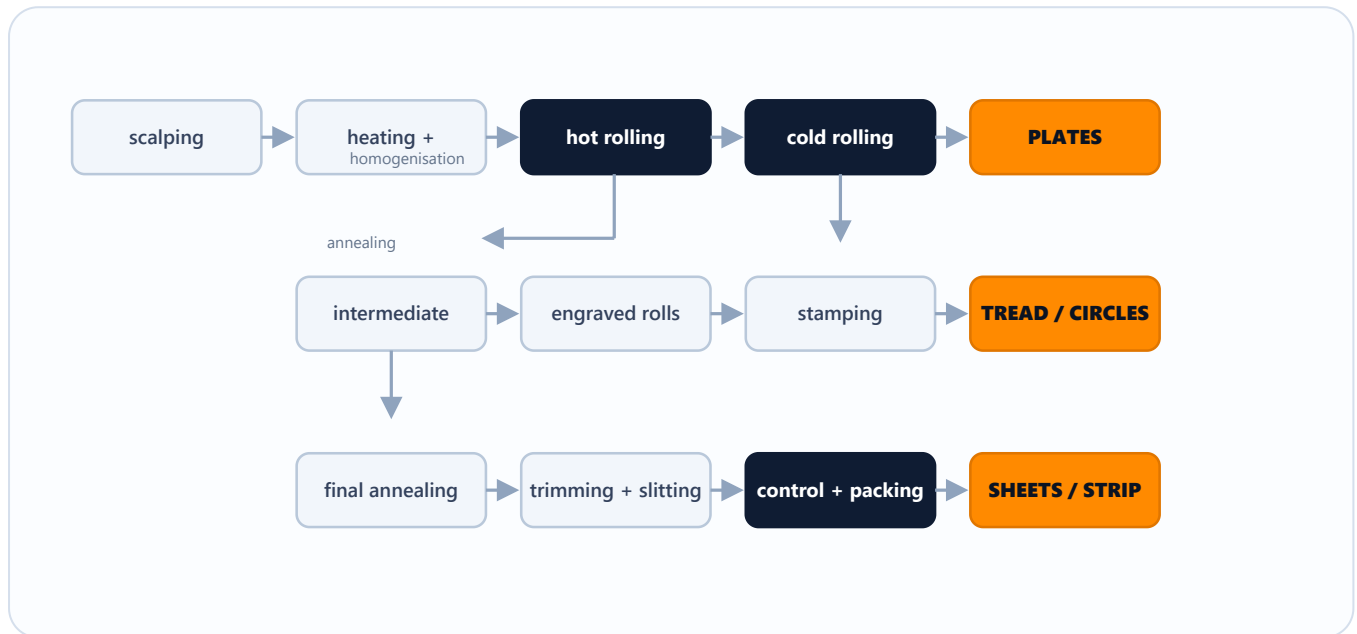
CERTIFICATE REG. NO.
50400207 AS0018D

DQS GmbH (DAkkS-accredited) · certified 2025-01-02 · valid to 2028-01-16

THE ROLLING PROCESS

From slab to shipment.

Hot and cold rolling of aluminium and its alloys, with hot-rolled or cast strip as input for cold rolling. Beyond standard tempers, entirely specific properties are achieved through controlled cold working and heat treatment. Finished coils are slit on modern rotating shears; sheet is cut to length on lines with built-in roller straighteners.



PACKAGING

Packing to customer requirement — with cardboard or wooden interleaves, with or without core, container-ready and seaworthy configurations available. All packaging is returnable.



coil · axis horizontal



coils · axis vertical



coil · cardboard core



sheets & plates · crated



circles · boxed



container shipping

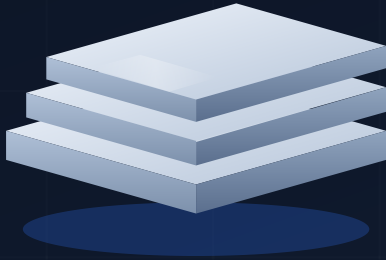


Control & acceptance before every dispatch. Each shipment is accompanied by a certificate of quality proving the suitability of the material — EN 10204 3.1 inspection certificates on request, heat numbers marked for traceability.

ROLLED PRODUCTS

Sheets

Flat-rolled sheet in twelve mill alloys, from bright architectural quality to marine-grade 5083 — mill finish, prepainted, embossed or stucco, cut to length with roller straightening.



PARAMETER	RANGE
Alloys (EN AW-)	1050A · 3003 · 3103 · 3004 · 3005 · 3105 · 5005 · 5049 · 5052 · 5251 · 5754 · 5083
Tempers	O H111 H22 H14 H24 H16 H26 H18 H28 H19 DDQ*
Thickness	0.4 – 5.0 mm
Width × length	600 – 1500 mm × 600 – 6000 mm
Surface finish	mill · prepainted · embossed · stucco D2010
Surface care	tension levelling · PVC foil · paper interleaves (selected sizes)

Tolerances per EN 485-4 · *DDQ deep-drawing quality for selected alloys and tempers.

WHERE OUR SHEET GOES

- **Facades & roofing** — coated and stucco sheet that holds shade and flatness across a building
- **Transport bodies** — 5052 / 5754 panels for trailers, buses and rail
- **HVAC & ducting** — 3003 that folds cleanly and seams tight on automated lines
- **Signage & lighting** — bright 1050A surfaces that take print and anodize evenly
- **Marine components** — 5083 with the certificates surveyors ask for

FULL SHEET SPECIFICATION PROGRAMME — ALL GRADES

1000 1050 · 1060 · 1100 · 1200
2000 2014 · 2024 · 2219
3000 3003
5000 5052 · 5083 · 5086 · 5251 · 5454 · 5456
6000 6061 · 6063
7000 7050 · 7075 · 7076 · 7178 · 7475

Mill programme plus aerospace & industry specification grades, incl. clad variants — complete data sheets at www.lipol-al.eu/alloys.

ROLLED PRODUCTS

Coils

Precision-slit coil that runs at line speed — tension-controlled slitting for straight edges and consistent camber, wound on the core your decoiler needs.

PARAMETER	RANGE
Alloys (EN AW-)	1050A · 3003 · 3103 · 3004 · 3005 · 3105 · 5005 · 5049 · 5052 · 5251 · 5754 · 5083
Tempers	O · H111 · H22 · H14 · H24 · H16 · H26 · H18 · H28 · H19 · DDQ*
Thickness	0.5 – 4.0 mm
Width	50 – 1500 mm
Coil ID	300/304 · 400/406 · 500/508 · 600/608 mm — cardboard core or coreless
Coil OD / weight	750 – 1740 mm at ID 508 · 0.7 – 5.8 kg per mm of width
Surface	mill · prepainted · embossed · stucco D2010 / D2011

Coil sizes vary with alloy, temper and gauge — detailed coil sizing on request against your specific requirement.

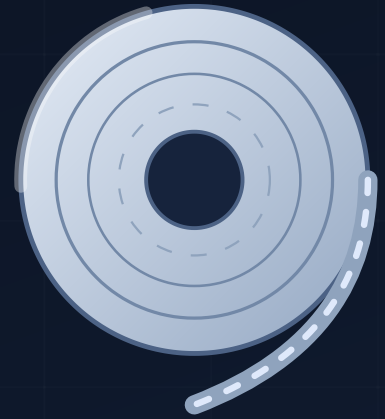
■ WHERE OUR COIL GOES

- **Roll forming** — consistent camber keeps profiles straight out of the last stand
- **Heat exchangers** — 3003 finstock and tube strip with reliable brazing behavior
- **Prepainted products** — batch-consistent shade from the first coil to the thousandth metre
- **Transformers & cable** — 1050A winding strip and smooth armoring wrap
- **Blinds & building** — narrow slit strip in coated finishes

SLIT FROM THE FULL SHEET PROGRAMME

1000 1050 · 1060 · 1100 · 1200 **2000** 2014 · 2024 · 2219 **3000**
 3003 **5000** 5052 · 5083 · 5086 · 5251 · 5454 · 5456 **6000** 6061 ·
 6063 **7000** 7050 · 7075 · 7076 · 7178 · 7475

Any sheet-programme grade can be slit to strip — state slit width, coil weight and core in the inquiry.



ROLLED PRODUCTS

Tread plates & circles.



■ TREAD PLATES — EN 1386

ALLOYS	TEMPERS	RANGE
1050A · 3003 · 5754	H114 H224	two-bar (duet) · five-bar (quintet) · diamond 1.5 – 5.0 mm · pattern height 0.5 / 1.0 / 1.5 mm 600–1500 × 600–6000 mm

Paper interleaves on request for selected widths.

■ vehicle floors & decks

■ anti-slip walkways & ramps

■ stair treads & platforms

■ CIRCLES & SHAPES — EN 851

ALLOYS	TEMPERS	RANGE
1050A · 1200 · 3003 · 4006 · 5454 · 5754 · 6082 · 8006	O H18 DDQ*	diameters 80 – 941 mm (57 standard sizes) thickness 1.0 – 5.0 mm · mill finish other sizes and shapes on request

The cookware, lighting and general deep-drawing programme — stamped or cut from strip.

■ cookware & bakeware

■ lighting reflectors

■ deep-drawn housings & slugs



3

tread patterns — duet, quintet, diamond

57

standard circle diameters, 80 – 941 mm

11

alloys across both programmes

EN

1386 tread plate · 851 circles — certified quality

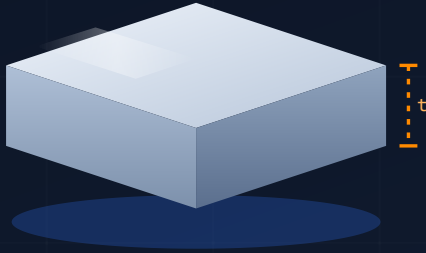
One programme, one purchase order. Tread plates and circles roll from the same mill programme as our sheets and coils — combine them on a single order, a single delivery and a single quality certificate, with packaging matched to each product.

Tempers H114 / H224 / H244 per EN 1386 · circle tolerances per EN 851 · DDQ deep-drawing quality on request for selected alloys · quality certificate with every shipment, EN 10204 3.1 on request.

ROLLED PRODUCTS

Plates

Hot-rolled plate for machining, tooling and marine structures — flat, stable and traceable, sawn to your cut list or milled into precision blanks with parallel faces.



PARAMETER	RANGE
Alloys	1050A · 5754 · 5083 · 5086 · 6082
Temper / surface	☒ F ☐ O hot rolled
Thickness	6 – 300 mm
Width × length	up to 1550 × 6000 mm
Processing	saw cutting ±1 mm · milled blanks to ±0.1 mm
Documentation	EN 10204 3.1 · heat number on every piece

Tension levelling available for selected sizes · heat-treated tempers via the group specification programme on request.

■ WHERE OUR PLATE GOES

- **Molds & tooling** — 5083 blocks for blow molds, foam tooling and checking fixtures
- **Machine building** — 6082 bases and gantry parts that stay flat after heavy pocketing
- **Marine structures** — 5083 / 5086 with low-temperature toughness surveys require
- **Jigs & fixtures** — milled blanks that go straight from dock to CNC

FULL PLATE SPECIFICATION PROGRAMME — ALL GRADES

1000 1050 · 1060 · 1200 **2000** 2007 · 2011 · 2017 · 2024 · 2030 · 2124 · 2219 · 2618A **3000** 3003 **5000** 5005 · 5052 · 5083 · 5086 · 5154 · 5182 · 5454 · 5456 · 5754 **6000** 6013 · 6061 · 6063 · 6066 · 6082 · 6262 · 6351 **7000** 7010 · 7020 · 7021 · 7022 · 7040 · 7049 · 7050 · 7075 · 7150 · 7175 · 7178 · 7449 · 7475

Hot-rolled mill programme plus the aerospace, machinery/mold and general-industry plate grades — complete data sheets at www.lipol-al.eu/alloys.

EXTRUSION TECHNOLOGY

Heavy industry, **precisely instrumented.**

The cast house runs on the proprietary **CASTRIGHT II™** PLC-automated billet and ingot casting system with **LARS™** in-line liquid aluminium refining — metal cleanliness decided before the first press stroke.

4 × 66_t

melting furnaces feeding 2 automated casting lines

2 + 4

continuous homogenising + batch furnaces, 2 coolers

±1.1°C

AMS-dedicated thermocouples, ±2 °C furnace uniformity

0.1°C/1s

full PLC data archive of every heat-treatment cycle

PRESS CLASS	STRETCHER CAPACITY	APPLICATION
1,000 – 2,000 t (1000T/1100UST · 1800 t · 2000T/2100UST)	profiles Ø 90 – 120 mm	architectural & precision profiles
2,500 – 3,600 t four-pillar hydraulic	profiles Ø 127 – 254 mm	structural sections
7,500 – 10,500 t heavy hydraulic presses	profiles Ø 450 – 558 mm	heavy industrial sections
AS-CAST FORMATS	SIZES	
Billets — 12 standard diameters	178 · 254 · 304 · 381 · 446 · 581 · 660 · 762 · 816 · 914 · 995 · 1060 mm	
Slabs	420 / 520 mm thick · 1620 mm wide · length as required	

Solution and ageing treatment for 4–6 m profiles · T77-capable multi-stage ageing with ±10% airflow uniformity and cold-air injection · in-line stretching and straightening adapted to each section · automatic cutting 0–180° (OMRM 125 AL, Ø 450 mm diamond saw) · 26 × 6 m cooling and conveying table.

EXTRUDED PRODUCTS

*Profiles, bars & tubes.*LUI
TO

■ PROFILES

6060 · 6063 · 6005A · 6082
T4 / T5 / T6 / T64 / T66

Standard shapes and custom dies with first-article approval · circumscribing circle to 320 mm · wall from 1.0 mm · length to 7000 mm · EN 755-9 / EN 12020-2 · anodized 5–25 µm or powder-coated (RAL).

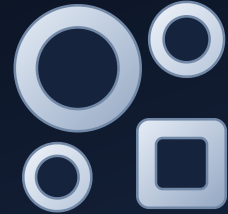


■ BARS & RODS

2011 · 2024 · 5083 · 6061 · 6082 · 7075

+ the full 2000 / 7000 programme

Rounds Ø 8–300 mm (drawn to Ø 60) · flats 10×3–200×40 · squares 8–120 · hex AF 10–75 mm · cut 50–6000 mm at ±0.5 mm · EN 754-2 / EN 755-2.



■ PIPES & TUBES

3003 · 5083 · 6060 · 6061 · 6082
extruded and cold-drawn

Round OD 8–250 mm, wall 1–10 mm · square 20–150 · rectangular 30×20–200×100 mm · precision-drawn bores · EN 755-8 / EN 754-8 · cut ±0.5 mm.

EXTRUSION & DRAWING PROGRAMME — ALL GRADES BY SERIES

1000 1050 · 1060 · 1100 · 1200 **2000** 2007 · 2011 · 2014 · 2014A · 2017 · 2017A · 2024 · 2030 · 2033 · 2124 · 2219 · 2618A **3000** 3003 **5000** 5052 · 5083 · 5086 · 5251 · 5454 · 5456 **6000** 6005A · 6012 · 6013 · 6026 · 6060 · 6061 · 6063 · 6066 · 6082 · 6262 · 6351 **7000** 7010 · 7012 · 7020 · 7049 · 7050 · 7068 · 7075 · 7079 · 7149 · 7150 · 7175 · 7178

Extruded bar/flat and tube/profile plus the cold-drawn bar and tube programmes (EN 754 / EN 755) — complete data sheets at www.lipol-al.eu/alloys.

■ COLD-DRAWN PROGRAMME

Cold drawing adds what extrusion alone cannot: tighter diameter tolerance, better straightness and bore quality for machining and pneumatic applications — available across the 2000-series machining grades, 5052/5083 and the 6000/7000 structural grades listed above.

■ FINISHING UNDER ONE ROOF

Precision cutting · CNC machining to ±0.1 mm · anodizing · painting & powder coating · continuous coil coloring · export packaging and pan-European delivery.

PLANT & MACHINERY

The machine list.

Capability claims are easy; equipment lists are checkable. This is the plant behind every promise in this brochure.

■ CAST HOUSE

EQUIPMENT	COUNT / SPEC
Melting furnaces	4 × 66 metric tonnes
Casting lines	2, fully automated — CASTRIGHT II™ PLC control
In-line refining	LARS™ liquid aluminium refining system
Homogenising furnaces	2 continuous
Batch furnaces / coolers	4 / 2
Billets	12 standard diameters, Ø 178 – 1060 mm
Slabs	420 / 520 mm thick × 1620 mm wide

■ EXTRUSION LINES

PRESS	TYPE
1000 T / 1100 UST	aluminium extrusion press
1,800 MT	four-pillar hydraulic system
2000 T / 2100 UST	aluminium extrusion press
3,600 MT	four-pillar hydraulic system
7,500 MT	hydraulic profile extrusion press
8,500 MT	hydraulic profile extrusion press
10,500 MT	hydraulic profile extrusion press

■ STRETCHING & STRAIGHTENING

PRESS CLASS	STRETCHER CAPACITY
650 – 2,000 t	billets / profiles Ø 90 – 120 mm
2,500 – 3,600 t	profiles Ø 127 – 254 mm
8,500 – 10,500 t	profiles Ø 450 – 558 mm

■ HEAT TREATMENT — SOLUTION & AGEING, 4 – 6 M PROFILES

PARAMETER	SPECIFICATION
Furnace class	Class 1 — ±2 °C temperature uniformity · horizontal or vertical airflow by load configuration
Thermocouples	Class 1 (±1.5 °C) · AMS-dedicated (±1.1 °C) · certified modules
Recording	Siemens / Allen-Bradley PLC — full data and trend archive from 0.1 °C at 1 s intervals
Ageing	T77-capable multi-stage, multi-ramp · ±10% airflow uniformity · cold-air injection for low-temperature steps

■ CUTTING & HANDLING

EQUIPMENT	SPECIFICATION
OMRM 125 AL automatic single-head cutting	0° – 180° and intermediate angles · Ø 450 mm diamond saw
Cooling & conveying table	26 × 6 m automatic — straightening and cutting via tractor + straightener, rolls adapted per profile

QUALITY ASSURANCE

Measured to a quarter of a micron.

Every value on a certificate is backed by an instrument on this list — from the spectrometer that verifies each heat to coordinate measurement of complex profile geometry.

MEASURING INSTRUMENTS FOR QUALITY ASSURANCE

INSTRUMENT	WHAT IT VERIFIES
Optical emission spectrometer (M10)	chemical composition of every heat
Universal mechanical testing machines	tensile and yield strength, elongation, hardness
Metallographic microscope	micro- and macro-structure evaluation
Digital calipers — 0.01 mm resolution	tight-tolerance dimensional checks
Dial & vernier calipers — 0.02 mm	conventional dimensional measurement
Height gauges	diameters of rods and tubes
Plug gauges	flatness, straightness, linearity, perpendicularity
Ring & pin gauges	bore verification on larger holes
2D vision measuring system	non-contact geometry — fields of view 0.8 × 0.6 mm to 225 × 190 mm, length error to 0.25 µm
3D Vision H500 coordinate system	geometric & positional tolerances (cylindricity, flatness, profile, coaxiality), twist and bend testing, complex surfaces — computer-processed against 3D drawings

EXTENDED GROUP LABORATORY

Scanning electron microscopy (SEM) · deep-drawing testing · sample preparation and metallographic research — the full chain from chemical composition to tensile test for rolled products.

every heat

spectrometer-verified chemistry

every shipment

accompanied by a quality certificate

every piece

heat-number marked for traceability

audits

customer audits welcome in Sevojna

Operating under an aerospace-grade management system. The laboratory works within our EN 9100:2018 / AS9100D certified QMS (DQS GmbH, reg. 50400207 AS0018D — see page 03), with ISO 9001 quality management maintained continuously since 1992.

ALLOY PROGRAMME

54 alloys. 258 specifications.

Across six product forms and four industry programmes — aerospace & defense, machinery / automotive / mold, general industry and cold drawing. Every alloy carries a complete data sheet: composition, physical and mechanical properties, tempers and cross-referenced designations (UNS · AMS · ASTM · EN · WNr) — available at www.lipol-al.eu/alloys.

SERIES	ALLOYING ELEMENT	CHARACTER	PROGRAMME EXAMPLES (EN AW-)
1000	≥ 99% Al	conductivity, corrosion resistance, formability	1050A · 1060 · 1100 · 1200
2000	copper	very high strength — the aerospace family	2011 · 2014 · 2017A · 2024 · 2124 · 2219 · 2618A
3000	manganese	forming and brazing workhorse	3003 · 3004 · 3005 · 3103 · 3105
5000	magnesium	marine-grade, weldable	5052 · 5083 · 5086 · 5454 · 5456 · 5754
6000	Mg + Si	heat-treatable structural all-rounders	6005A · 6013 · 6060 · 6061 · 6063 · 6082
7000	zinc	maximum strength	7010 · 7020 · 7049 · 7050 · 7075 · 7150 · 7475

STANDARDS OUR PRODUCTS ARE MADE AND TESTED TO

STANDARD	SCOPE	STANDARD	SCOPE
EN 573-3	chemical composition	EN 851	circles and circle stock
EN 485-2 / -4	properties / tolerances — sheet, strip, plate	EN 1386	tread plates
EN 683-2 / -3	finstock	EN 15088	structural products (CE)
EN 602	aluminium in contact with food	EN 1396	coil-coated sheet and strip
EN 754 / 755	drawn / extruded products	EN 10204	3.1 inspection certificates

FOUR INDUSTRY PROGRAMMES

175

specifications
Aerospace & Defense

12

specifications
Machinery, Automotive
& Mold

31

specifications
General Industry

40

specifications
Cold Drawing

LIPOL

ALUMINUM · SEVOJNA · SERBIA

Tell us your specification.
We'll handle the rest.

■ **FOR THE FASTEST QUOTATION, STATE:**

product type · alloy and temper · dimensions and desired tolerances · for coils: coil weight and/or inside–outside diameter · purpose of use or required mechanical properties · quantity.

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CERTIFIED

EN 9100:2018 / AS9100D — DQS

ISO 9001 since 1992

ISO 14001 · OHSAS 18001 since 2000

