



SINCE 1966 · BOLOGNA, ITALY

Mechanical expertise for steelworks, rolling mills and industrial machinery.

Precision, experience and production continuity for six decades. Custom high-precision steel rolls for customers on 6 continents.

COMPANY PRESENTATION

A company built on quality.

COMESA S.r.l., founded in 1966 in Bologna, manufactures a wide range of custom high-precision steel rolls and related products for the metalworking industry. Build-to-print manufacturing and in-depth technical knowledge of turning, heat treatment, machining and advanced coatings, with a production cycle controlled at every stage – from raw material to delivery.

1966 Year founded	6 Decades of experience	+20 Skilled operators	ISO 9001 Certified quality system
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Custom precision

Finished parts built to drawing, with micron-level tolerances, for the world's leading special-machine builders.

Ongoing support

Prompt, continuous support from the technical sales team.

Certified quality

UNI EN ISO 9001:2015 quality management system, with a control cycle for every machining stage.

International presence

Customers on 6 continents; now part of an international group that extends its reach.

Sixty years of specialisation in precision engineering.

A path of progressive specialisation: from general engineering to wear components, leading to an established position as a reference in the sector.

A success story, built over time, in the steel market.



1966

The founding

CO.ME.SA. — Costruzioni Meccaniche Saliceto is established in Bologna as a general metal engineering workshop.



1980s

Specialisation

The business focuses on steel wear parts: work rolls and back-up rolls for straighteners and levellers.



2000+

Quality and markets

Quality system certification and growing exports to steelworks and rolling mills on 6 continents.



Today

Part of a group

Comesa operates within an industrial holding, keeping design, machining and testing in-house.

OUR PEOPLE

Organisation and in-house expertise.

Our staff includes specialists who oversee the entire life cycle of each component, from drawing analysis to final testing.



Emanuele Porzionato

CHIEF EXECUTIVE OFFICER



The Comesa team

SPECIALISTS ACROSS THE WHOLE CYCLE

Engineering office

Drawings, steel selection, machining cycle.

Machining

Lathes, grinders and CNC machines.

Testing and quality

Dimensional, destructive and non-destructive testing.

Technical sales

Support before, during and after commissioning.



ITALIAN INDUSTRIAL MANUFACTURING

Italian manufacturing: build quality and operational reliability.

Italian manufacturing rests on verifiable elements: established expertise in steel machining, a machine fleet kept at full efficiency, an in-house production cycle and complete documentary traceability. Comesa makes every component to the customer's drawing, controls every stage and delivers it ready for use in production.

TOLERANCES

to the micron

ROUGHNESS

$Ra \leq 0.05 \mu m$

TRACEABILITY

Of all processes and materials

Integrated production cycle.

Sourcing from certified EU suppliers, standardised steels only.

Machining up to Ø 1,000 mm and 12,000 mm in length.

01 Raw material

Solid round bars Ø 10–1,000 mm from certified suppliers, with a stock of over 1,000 tonnes of steel.

02 Cutting

Dedicated area with high-speed semi-automatic band saws and cut-off machines.

03 Turning

Engine lathes and CNC lathes, up to Ø 1,000 mm and 12,000 mm.

04 Heat treatment

Induction or through hardening, carburising and nitriding with long-standing partners.

05 Grinding

A range of grinders up to Ø 1,000 mm and 8,000 mm: micron-level tolerances. This is the core strength of the cycle.





PRODUCTION · 06-10

Finishing, inspection and delivery.

06 Chrome plating / Polishing

Chrome plating and optional polishing, with surface finish down to $Ra \leq 0.05 \mu m$.

07 Marking

Stamped or acid-etched with logo, year and order number.

08 Packaging

Custom wooden crates; special packaging for long-term storage or transport on request.

09 Quality

A production cycle that certifies every stage; dimensional, destructive and non-destructive testing.

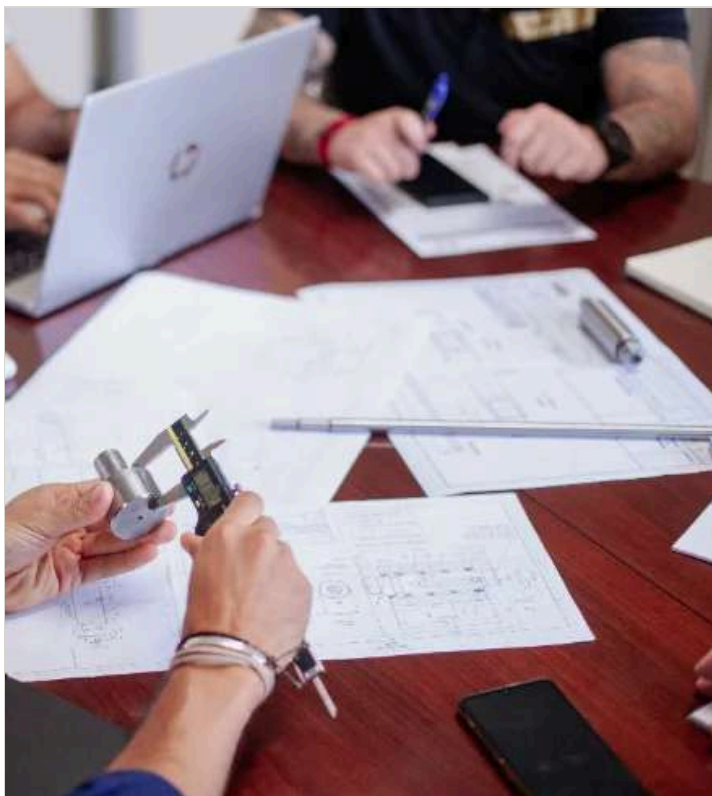
10 Ongoing support

Prompt, continuous support from the technical sales team.

Build-to-print production and reverse engineering.

Finished parts made to Comesa drawings are used by the world's leading special-machine builders. When the original drawing is no longer available or the component is out of production, Comesa surveys the geometry and technical characteristics of the existing part and reproduces it with full interchangeability with the original.

- Geometric survey and reconstruction of the technical drawing
- Certified components, 100% interchangeable with the originals
- Advanced treatments and coatings



PRODUCTS

Product range: high-precision steel rolls, back-up rolls and shafts.

Each product is finished according to its end application: alloy steels, quenched and tempered, hardened, and coated when required – chrome plating, sandblasting, tungsten carbide coatings.

01 – HOT STRAIGHTENERS Work rolls and back-up rolls for hot straighteners of heavy plate Made from forged steels suited to high operating temperatures, to withstand severe thermal shock.	02 – COLD STRAIGHTENERS Work rolls and back-up rolls for cold straighteners of heavy plate Made from high-hardness steels for high wear resistance.
03 – LEVELLERS AND TENSION LEVELLERS Rolls and intermediate rolls for levellers and tension levellers Made from alloy steels, quenched and tempered and hardened, coated where appropriate (chrome plating, sandblasting, etc.) according to the final application.	04 – STRAIGHTENERS AND LEVELLERS Work rolls, intermediate rolls, back-up rolls Made from alloy steels, quenched and tempered and hardened, coated where appropriate (chrome plating, sandblasting, etc.) according to the final application.
05 – PINCH ROLLS Pinch rolls for guiding the strip Rolls to control strip tension, speed and feed.	06 – CASSETTES Cassette services Worn and damaged cassettes are refurbished and returned to customers ready for installation.
07 – BARS AND SECTIONS Rolls for bar and section straighteners Rolls for round and flat section straighteners, made from tool steels, high-speed steels or powder-metallurgy steels, induction or through hardened according to the final application and customer specifications.	08 – CALENDERS AND BENDING MACHINES Rolls for calenders and bending machines Made from alloy steels, quenched and tempered and hardened, finished according to the final application.
09 – KNIFE SHAFTS Knife shafts and roll-forming shafts Made from alloy steels, quenched and tempered and hardened to the required depth in the areas specified on the drawing.	10 – SENDZIMIR ROLLS Rolls for cold rolling Key mechanical components used to reduce thickness, shape or apply adhesive films to materials (metals or paper/prints) below the recrystallisation temperature or at room temperature.
REVERSE ENGINEERING & UPGRADE We rebuild your component, even without the original drawing.	

STEELS USED

50CrMo4	50CrV4	51CrMoV4	S6-5-2 / M2	100Cr6	100CrMo7	88CrMoV7	42CrMo4	X155CrVMo12.1
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MAINTENANCE AND REFURBISHMENT

Maintenance and revamping services for rolls and cassettes.

Established expertise and high-precision alignment and calibration equipment enable a complete maintenance and revamping service, reducing the need for full component replacement.

01 – ROLLS

Refurbishment of leveller and straightener rolls

Straightening, stress relieving and grinding of worn rolls, restoring the surface to its original quality.

02 – CASSETTES

Cassette services

- Bench disassembly, cleaning and reassembly
- Roll geometry restoration
- Work roll grinding/replacement and inspection
- Bench calibration

ROLL REFURBISHMENT

Refurbishment work: before and after.



UNI EN ISO 9001:2015 certified quality system.

Comesa operates a quality management system certified to **UNI EN ISO 9001:2015**. For every part produced, a production cycle is drawn up that certifies each machining stage.

Process inspections are carried out at every production stage, continuously and methodically, using advanced instruments, in line with customer specifications and the strictest international standards.

The testing department performs the required dimensional, destructive or non-destructive tests. Its experience keeps Comesa at the forefront in equipment, facilities and the selection of high-tech raw materials.



Continuous inspection

Checks at every production stage, not only at the end of the cycle.

Dimensional testing

Destructive and non-destructive testing to customer specification.

Documentation

ISO certificate, steel handbook, technical data sheets and application overview.

Headquarters and contacts.

For quotations, send us the component drawing or request a technical site visit. Our technical sales office will assess feasibility, materials and delivery times.

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