

1250

500, 600, 700, 800, 1000, 1070



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## Automatic High-Precision Slitting/Cut-To-length Line

### Technical Specifications

0.4mm-6.5mm×1250mm

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#### 1 Basic Technical Parameters of Coils

- Material of coils: HR/CR carbon steel, galvanized plate, colored steel plate etc.G350-500Mpa
- Strip thickness: 0.4-6.5mm
- Strip width: 500-1250 mm *Coil width 500 to 1250 mm*
- Inner diameter of coils:  $\Phi$  460-760 mm three steps form:508mm,610mm,760mm
- Outer diameter of coils:  $\Phi$  2,100 mm
- Min. Outer diameter of coils:  $\Phi$ 1,500mm *Min. Outer diameter 900 only*
- Max. coil weight: 25,000 Kg

#### 2 Working Process for 0.4-4 slitting

Coil-loading - Double mandrel uncoiling - Coil-head-feeding, press & shoveling - Double-roller pinch feeding, five-roller leveler (2+5 rolls) - End-cutting - Hole Accumulator (1) - Strip-aligning - Disc slitting - Scrap reeling - Hole Accumulator(2) - Pre-separator / Tensioner / Length-measuring roller/plate shearing machine - Recoiling / Coils press & separator - Coils-discharging - Hydraulic control - Electric control

#### Working Process for 4-6.5mm Cut-to-length line

Coil-loading - Double mandrel uncoiling - Coil-head-feeding, press & shoveling - Double-roller pinch feeding, five-roller leveler (2+5 rolls) -center aligner-slitting-waste scrap reeler--center aligner--15

rollsieving--hydraulic shearing machine--- Hydraulic control - Electric control

### 3 Main Technical Specification of Equipment

#### 3.1 Coil Loading Car

- Structure: four wheels, car body made by welding
- Driving motor: 3 kW cycloid pin-wheel motor
- Up-down movement driving: hydraulic cylinder  $\Phi 200 \times 700$  mm
- Walking speed and distance: 8.5 m/min, 4,000 mm
- Max loading weight: 25,000 Kg



#### 3.2 Double-mandrel Uncoiler

- Structure and working style: mandrel radially expands through slider driven by hydraulic cylinder ( $\Phi 140 \times 75$  mm, two sets); to make sure coil on centerline of the slitting line, the double mandrels bi-directionally move toward or faraway each other, or one of the mandrel bi-directionally move toward or faraway to the other, by hydraulic cylinder ( $\Phi 125 \times 1100$  mm, two sets)
- The decoiler base can adjustable to perpendicular the center of the coil, hydraulic control
- Braking style: hydraulic clutch and hydraulic brake YWZ315
- Mandrel expansion scope:  $\Phi 450 - 760$  mm, three step: 508mm, 610mm, 760mm
- Applicable coil width: 500- 1250 mm