

N1 SLITTING LINE mod. SI 19.30.1500

MAIN FEATURES :

A/ Material to be processed :

• **Material specifications :**

. material	type	:	steel coils
. resistance tension	N/mm ²	:	430
. elastical limit	N/mm ²	:	250 ÷ 360
. thickness mini ÷ maxi (R = 42 Kg /mm ²)	mm	:	0,5 ÷ 3

• **Coils specifications :**

. maximum weight	Kg	:	12 000
. mini ÷ maxi width	mm	:	700 ÷ 1 500
. external diameter	mm	:	1 600
. core diameter	mm	:	500 (710 with spacers)

• **Cuts :**

. nb maxi of cuts into 3 mm thick.	N	:	10
. nb maxi of cuts into 2 mm thick.	N	:	15
. minimum strip width	mm	:	50

• **General technical specifications :**

. resistance tension	N/mm ²	:	430
. elastical limit	N/mm ²	:	250 ÷ 360
. max. production speed	m/1'	:	20
. useful width (transversale)	mm	:	1 550
. reference axis		:	Centerline

• **Maximum band tension :**

. decoiler	N/mm ²	:	5
. recoiler	N/mm ²	:	10
. scrap rewinders	N/mm ²	:	15 ÷ 40

• **Slitter specifications :**

. coil maximum thickness	mm	:	3
. speed	m/1'	:	20
. coil maximum width	mm	:	1 500
. resistance tension	N/mm ²	:	430
. nb maxi of cuts into 3 mm thick.	N	:	10
. nb maxi of cuts into 2 mm thick.	N	:	15

B/ Supply

Electrical energy :

. line tension (motors d.c.)	V	:	400 ± 10%
. PLC control tension (d.c.)	V	:	220
. solenoïds volts tension (d.c.)	V	:	24
. line frequency	Hz	:	50
. total working power (approx.)	Kw	:	85

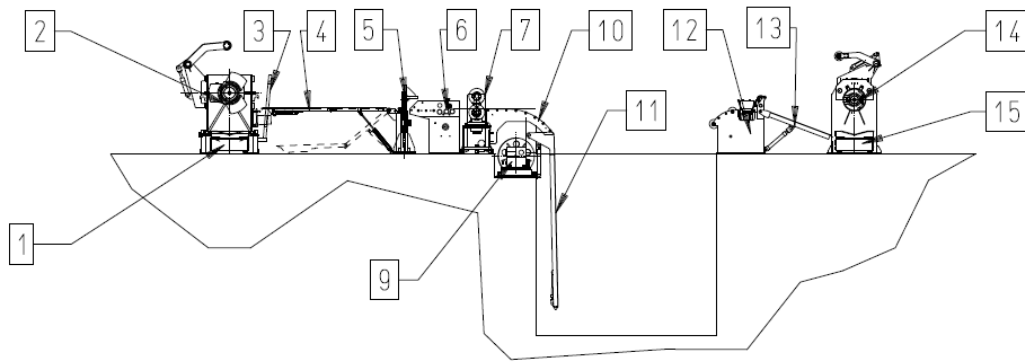
Compressed air :

. minimum pressure	bar	:	5
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Hydraulic plant :

. working pressure	bar	:	120
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DESCRIPTION



① CANTILEVERED HYDRAULIC DECOILER mod. DOH 1500/12

. max. width	mm	:	1 550
. max. weight	Kg	:	12 000
. centering Ø	mm	:	470-520

- **hydraulic roll** pressing arm
- independent hydraulic **centering**
- **motorization** of the mandrel back and forth with electronic **control**
- electronic **control** of the **loop**

② CENTERING GROUP

. translation stroke	mm	:	100
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- adjustable **side gauges + deflection**
- **roll of band control**
- reflection **photocell** for the **electronic centering** of the coil

③ CIRCULAR SHEAR

. maximum cutting width	mm	:	1 550
. shaft Ø	mm	:	190
. blades Ø	mm	:	350

- one piece all steel frame, stabilized and fully machined on CNC milling boring
- chrome-plated and rectified shafts
- **n2** chrome-plated and rectified **introduction rolls**
- **n2** tempered & adjustable **side guides**
- **positioning** of the side-guides **powered**
- **stations** motorized **opening** for a quick **blades change & adjustment**
- motorized adjustment of the blades crossing (upper mandrel)
- **powering back / forth** with **electronic** control of the speed
- millimetrical scale bar fixed upper the blades

④ SCRAP REWINDERS

. Ø maxi	mm	:	600
. max. width	mm	:	250
. motors	Kw	:	1,5

- n1 rewriter fixed on reference side
- n1 rewriter mobile on a slot according to coil width
- a.c. motors with inverter

⑤ LOOP SADDLES

- n2 beds with rolls and guides for the loop
- hardened and ground bands **separators** in exit

⑥ PIT BYPASS TABLE

. Width	mm	:	1550
- Hydraulic drive			

⑦ FELT PRESS

. maxi width	mm	:	1 500
. adjustable working pressure	Kg/cm ²	:	0/7

- air cylinder + servo-valve
- open lifting for introduction
- guiding with adjustable spacers form rectificated steel

⑧ CANTILEVERED HYDRAULIC RECOILER mod. EOH 1500/12

. capacity	Kg	:	12 000
. useful width	mm	:	1 550
. centering	mm	:	460-520

- **hydraulic mandrel centering**
- **hydraulic discharging of the coils**
- **hydraulic arm** with spacing **discs**
- **motorization** back and forth with **electronic control**
- hydraulic gripping of the head-bands

⑨ ELECTRICAL EQUIPMENT & CONTROL DESK

. supply voltage	V	:	400
. supply frequency	Hz	:	50
. a.c. ancillary motors, tropicalised	V	:	400
. ancillary voltage	V	:	24
	Hz	:	50

- motor protection by quick fuses
- general cabinet including equipments for the protection and the control of the motors.
- connection from the main control panel to the various line components by protected ground cables (as per our instructions) or by air channels.
- Siemens material with PLC control
- the choice of the type of connection must be checked signing contract.

OPTIONAL :

① Straightener pinch roll (between decoiler and circular shear)

- **n2 driving – in rolls** hardened and ground
- **n3 straightening rolls** hardened and ground
- **motorization** back and forth with electronic control

② Primary cut shear

. capacity	mm	:	1 500 x 3
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- hydraulic guillotine shear between the decoiler and the circular shear

③ Coils loading trolley 12T

. max weight	Kg	:	12 000
. lifting stroke	mm	:	200
. translation speed	m/1'	:	5

- **lifting and translation** hydraulically powered on floor
- **independent control desk**
- **translation rails mm 4000**

④ Coils unloading trolley 12T

. max weight	Kg	:	12 000
. lifting stroke	mm	:	200
. translation speed	m/1'	:	5

- **lifting and translation** hydraulically powered on floor
- **independent control desk**
- **translation rails mm 4000**

⑤ *Extra price for speed 40 m/1' (powering, driving, control)*

⑥ *Blades quick change carousel*

. capacity mm : 2 x 1550

- all steel frame, with rotative turret on x large bearings
- n2 shafts with manual **rotation**
- **translation** on railways

