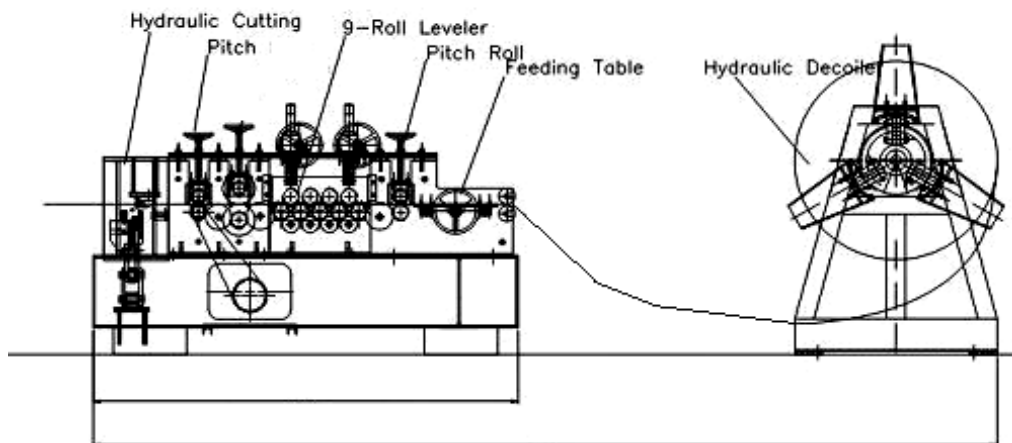




CUT TO LENGTH PRODUCTION LINE FOR 0.4 to 3.0x1300mm with 7 Ton Decoiler



MACHINE DESCRIPTION:

Cut To Length Production line Machines is used for uncoiling, straightening, gauging, cross-cutting to length and stacking work. It performs a variety of operational functions including cut sheet leveling, edge trim (if required), **cut to length** and stack sheets and plates.



WORKING PRINCIPLE:

Cut to length line uses a pair of feed rolls, driven by an AC servo motor/AC drive, to feed the sheet precisely according to the set **length**. They ensure fast positioning with higher accuracy. The rolls are adjusted by pneumatic cylinders. In case of tight line, the **length** measurement is done by encoder assembly.

TECHNICAL PARAMETER:

Supported width	: 500-1300mm
Supported material thickness	: 0.4-3.0mm (Q235 and SS 316)
Supported Max weight	: 7 Ton
Coil inner diameter	: 450-650mm
Outside diameter	: ≤1800mm
Working speed	: 10m/min
Cutting frequency	: 12-20 pieces per minutes (standard 1000×3000mm)
Length range	: 500-4000mm
Length tolerance	: ±0.5/mm
Diagonal accuracy	: ±0.5/mm
Total power	: ≈20kw
Decoiler direction	: From the right to left facing the control PLC Siemens
Size	: ≈5m×1.5m
Power Supply	: 380v/50hz/3 Phrase or customize

HYDRAULIC SINGLE ARM DECOILER WITH LOADING CAR

S/N	ITEM	PARAMETERS
1	Main shaft	This is the core part of the decoiler. It has four fan parts, By adjusting the fan expansion or not, we can finish loading coil to big or small part.
2	Position roller at back	This shaft or roll is used for positioning the coil and make it steady when it works. Meanwhile it also fixes coil in case of loosing.
3	Transmission	Transmission part in external frame, the motor, reducer through the chain driven reel spindle rotation, and also achieve positive and negative uncoiling and coiling.
4	ID	∅ 450-650-mm
5	Max loading weight	7 T
6	Structure	This machine is a single cantilever hydraulic expansion type uncoiled, the spindle part, transmission part, support the composition
7	Loading car	The car can move levelly and vertically, which is convenient for putting the steel coils into the de-coiler. It is

driven vertically by hydraulic cylinder with four guide pillars. The level movement is driven by cycloid motor. The capacity of it can reach to 7 Tons (MAX) It is used to lift up and down, move forward and back to make it easy to load the coils on decoiler. Hydraulic controls lifting, motor drives moving. The car is controlled on the auxiliary control panel. Its moving speed is 6-7m/min. When the coils on decoiler, the car will return back to the start position. It can also carry back the unfinished coils from decoiler.

9 ROLLERS LEVELING SYSTEM

S/N	ITEM	PARAMETERS
1	Leveling roller number	9
2	Leveling roller diameter	110mm
3	Roller material	Cr15Roll treatment by HRC58-62 (straightening quenching, grinding.)
4	Main power	7.5 kw main motor and gearbox
5	Bearing	Takes rolling bearing mode:22209
6	Power system	Motor drive, driven by the speed reducer and then give power to gear
7	Reducer	155 type worm gear reducer
8	Structure	The leveling roller container 9 rollers, 4 upper 5 down leveling roller.

MAIN CUT TO LENGTH PART

Mainly elements of this part: left and right bracket, connecting rod, upper and lower turret, working table, drive motor and others.

S/N	ITEM	PARAMETERS
1	Max cutting thickness	3mm
2	Cutting width	1300mm
3	Main material	Luo Si
4	Main power	5.5KW
5	Conveyor belt	Belt length 7500mm, width 1450mm, motor 2.2kw.
6	Hydraulic station	Composed by electromagnetic valve and an oil pump motor

DV53 Cuter blade material HRV 65= Shearing system (high speed cutting machine)