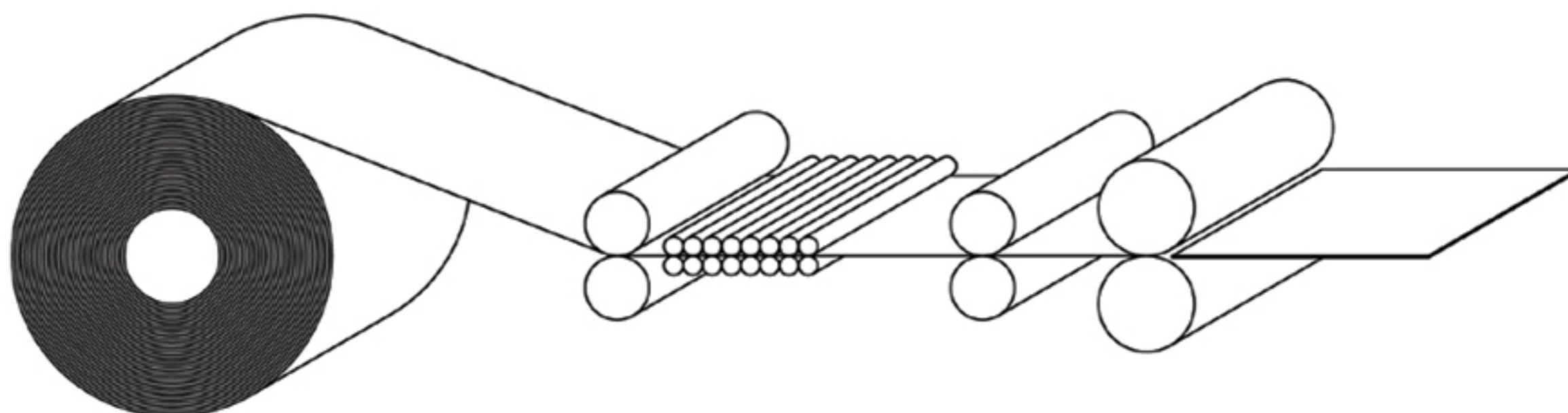




CUT TO LENGTH LINES

Mid Capacity Line

MAX 1500 CL



CUT TO LENGTH LINES Mid Capacity MAX 1500 CL Type

Technical information:

This is an optimised **Cut to Length Line** with a modular basic design on which can add and fit options for **increasing production capacity and performance characteristics of the Line**, according customer's specifications and requirements.

This modular design is applied so for mechanical components as for electronics because an integrated **"in house"** construction, made inside **INDECO's** plant.

All **control systems** are manufactured with elec. standard components, available in the market permitting an easy replacement for maintenance services anywhere at anytime.

The main advantage of this type of modular design for the customer is a **present low investment**, for a **High Quality and Performance Line** and a future step by step development according production requirements.

Production Parameters of Cut to Length Line MAX 1500 CL type

TYPE OF MATERIAL TO BE PROCESSED

- » Carbon steel, Stainless Steel, Aluminium, Non ferrous metals and alloys.
- » Cold and hot rolled, pickled, dry or oiled, galvanized and coatings.
- » Mechanical characteristics:

Material strength	N/mm ²	Máx.	900
Yield point	N/mm ²	Máx.	600

COIL CHARACTERISTICS (Representative case)

		Min.	Máx.
Strip width	mm.	500	1500
Strip thickness	mm.	2	8
Coil O.D.	mm.	800	2000
Coil I.D.	mm.	508/610	
Coil weight	Tn..	-	25

- » METAL COIL SLITTING and CUT to LENGTH LINES
- » LÍNEAS de CORTE LONGITUDINAL y TRANSVERSAL
- » LIGNES de REFENDAGE et COUPE à LONGUEUR



CUT TO LENGTH LINES Mid Capacity MAX 1500 CL Type

Technical information:

CUT TO LENGTH LINE GENERAL SPECIFICATIONS

PROCESSING SPEEDS

Strip Threading speed	mts/min.	15
Max. speed for leveller and cutting	mts/min.	0-42

TENSION UNIT (Unwind)

Strip width máx.mm	Line speed Mts/min	Tension in Kg.-Max.
		Unwind
1500 x 5	42	3500
1500 x 8	21	7000

LINE DESIGN

Feeding System	Precision feeder rolls system
Shear type	Flying shear

BOARD OF PRODUCTION

Formats length mm.	Speed nº 1 = 21 m/min		Speed nº2 = 42 m/min	
	Nº formats	Speed	Nº formats	Speed
500	38	19	38	19
1000	21	21	32	32
2000	10,5	21	21	42
3000	7	21	14	42
4000	5,25	21	10,5	42
5000	4,2	21	8,4	42
6000	3,5	21	7	42

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Technical information:

PROCESSING MATERIAL SPECIFICATIONS

Formats

		Min.	Máx.
Formats Length	mm.	500	6000
Formats Width	mm.	400	1500

Stacks of Formats

Stack Weight	kg/m.	750
Stack Weight	kg.	6000
Stack Height including pallet	mm.	600
Pallet Height	mm.	150

Tolerance average (For formats length of 2000 mm.)

- › Length +/- 0, 2 mm.
- › Diagonal +/- 0, 5 mm.

Indicated tolerances and productions are in function and related with following factors:

- Strip Tension stability and fluctuations
- Strip quality and surface smoothness
- External factors such electromagnetism and mechanical vibrations
- Machine operator skill

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Technical information:

ELECTRIC PARAMETERS

	10%	5%
Main Elec. current	380 V.	50 Hz.
Auxiliary Elec. current	110 V.	50 Hz.
Solenoid valves Elec. current	110 V.	50 Hz.

COMPRESSED AIR

Air Pressure	5 bars.
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HYDRAULIC POWER PACK

Nominal Pressure	100 bars.
Max. Pressure	110 bars.
- Cooling system by	aire.

CLIMATIC CONDITION

	Min.	Máx.
Outdoor temperature	- 6°C	+ 44°C
Indoor temperature	+ 5°C	+ 40°C

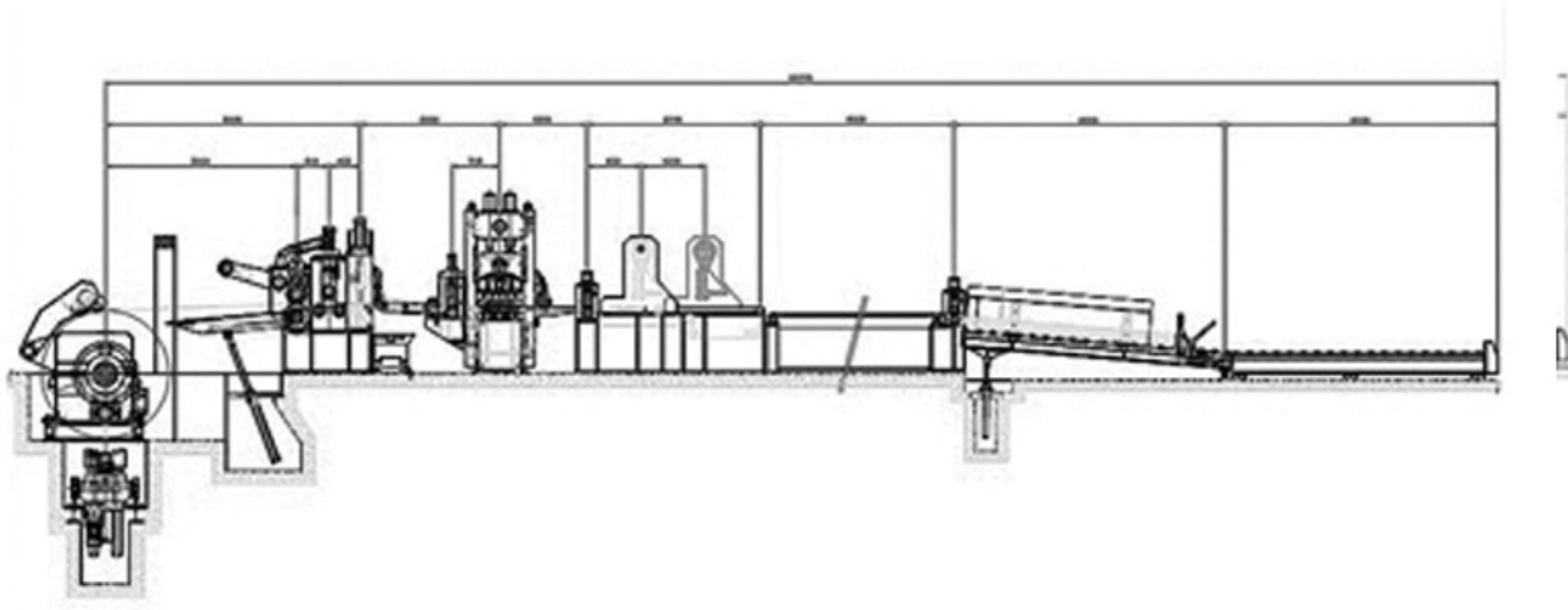
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CUT TO LENGTH LINES

Mid Capacity MAX 1500 CL Type

MACHINES



1.- Mid Capacity, cut to length, MAX 1500 CL



2.- Feeder Rolls for a Cut to Length Line of 0,5 mm. to 2 mm. x 1250 mm.

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CUT TO LENGTH LINES

Mid Capacity MAX 1500 CL Type

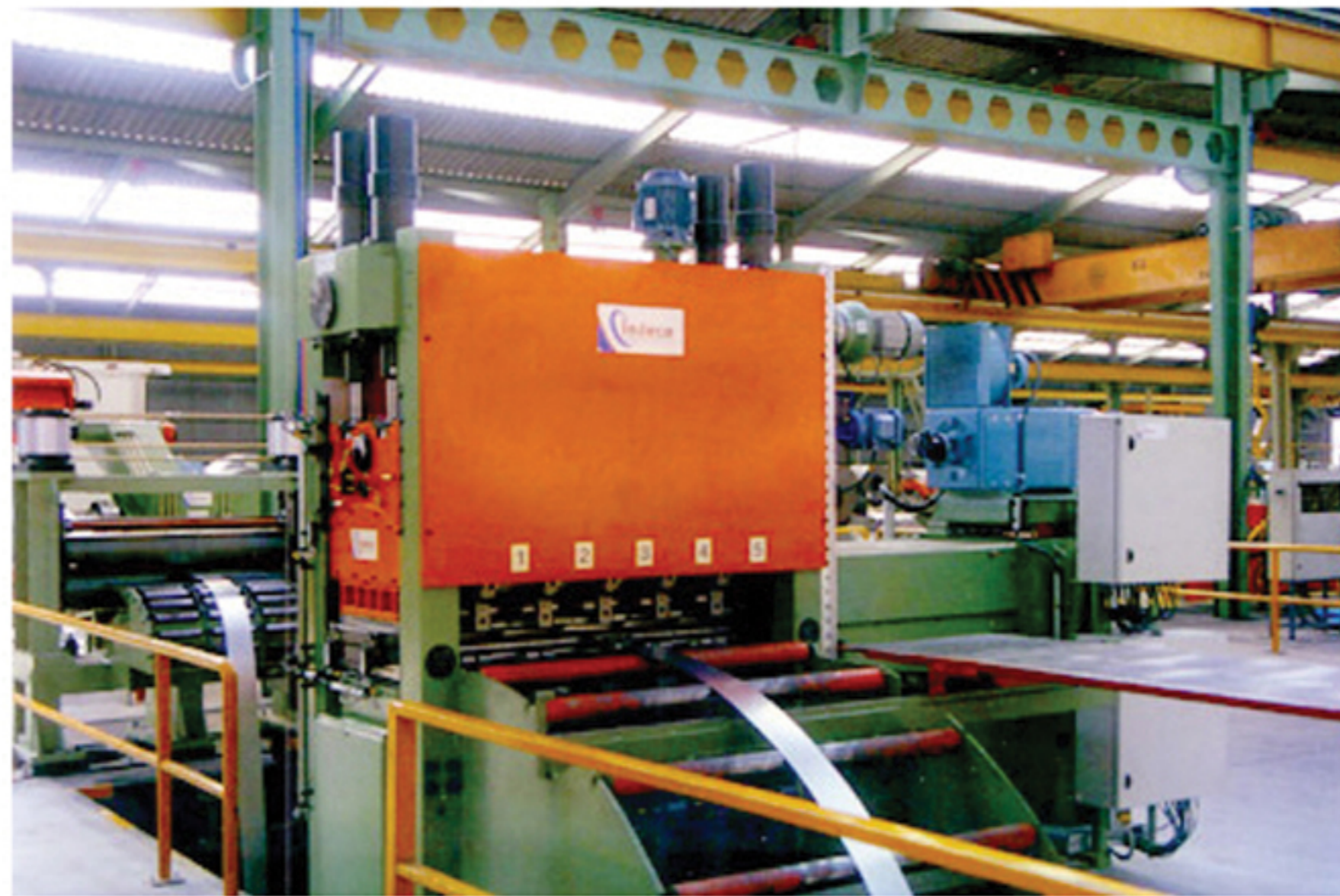
MACHINES



3.- Decoiler with Brake Generator for coils of 1250 mm. width and 15 t. weight.



4.- Feeder Rolls with vertical strip guides for strip of 3 mm. x 600 mm width.



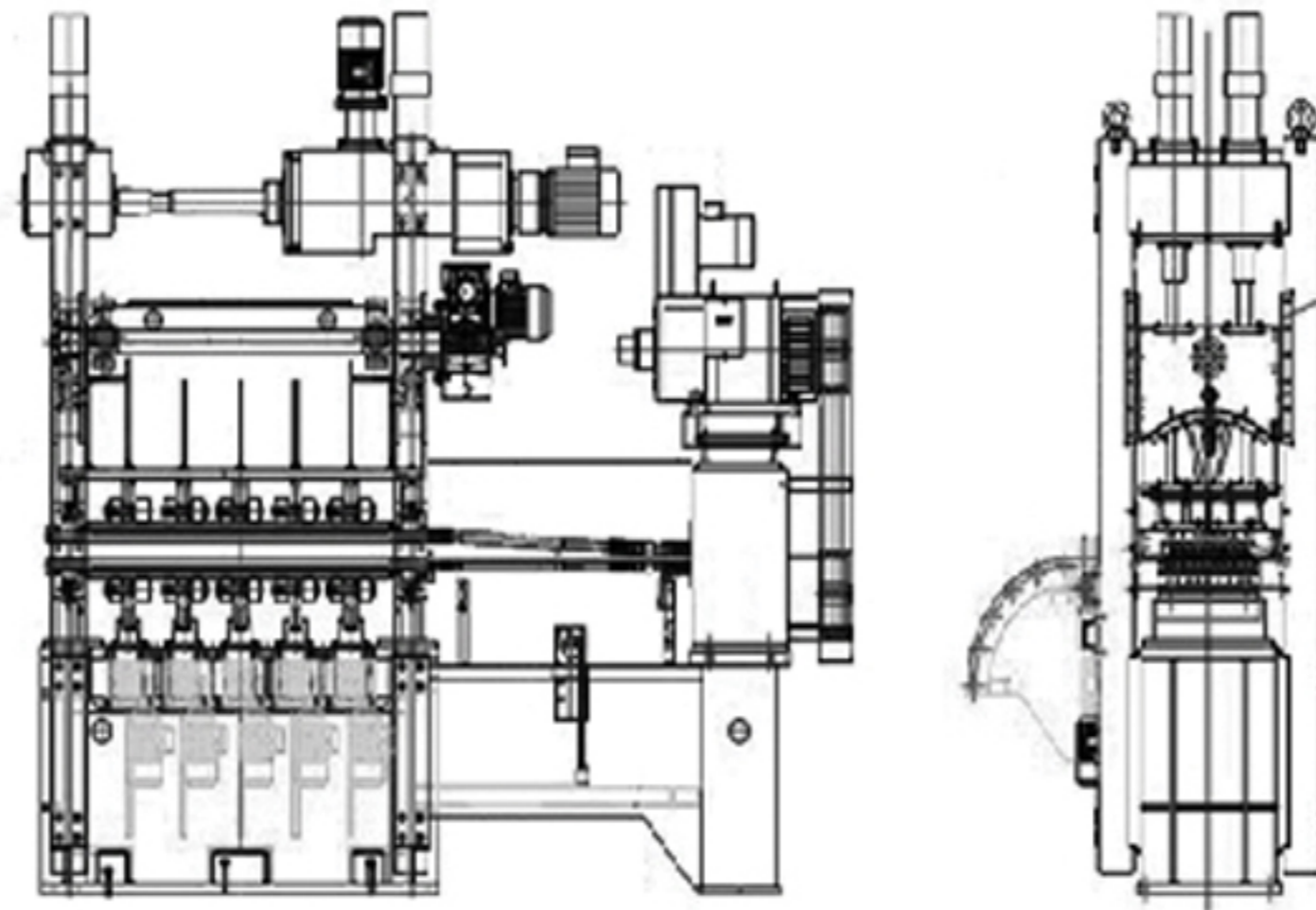
5.- Precision Leveler of 3 + 3 Highs for strip of 2 mm thickness x 1250 mm. width.

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CUT TO LENGTH LINES Mid Capacity MAX 1500 CL Type

MACHINES



6.- Precision Leveler of 3 + 3 Highs for strip of 4 mm. thickness x 1000 mm. width.



7.- Support for cantilever mandrel for coils up to 20 t. weight

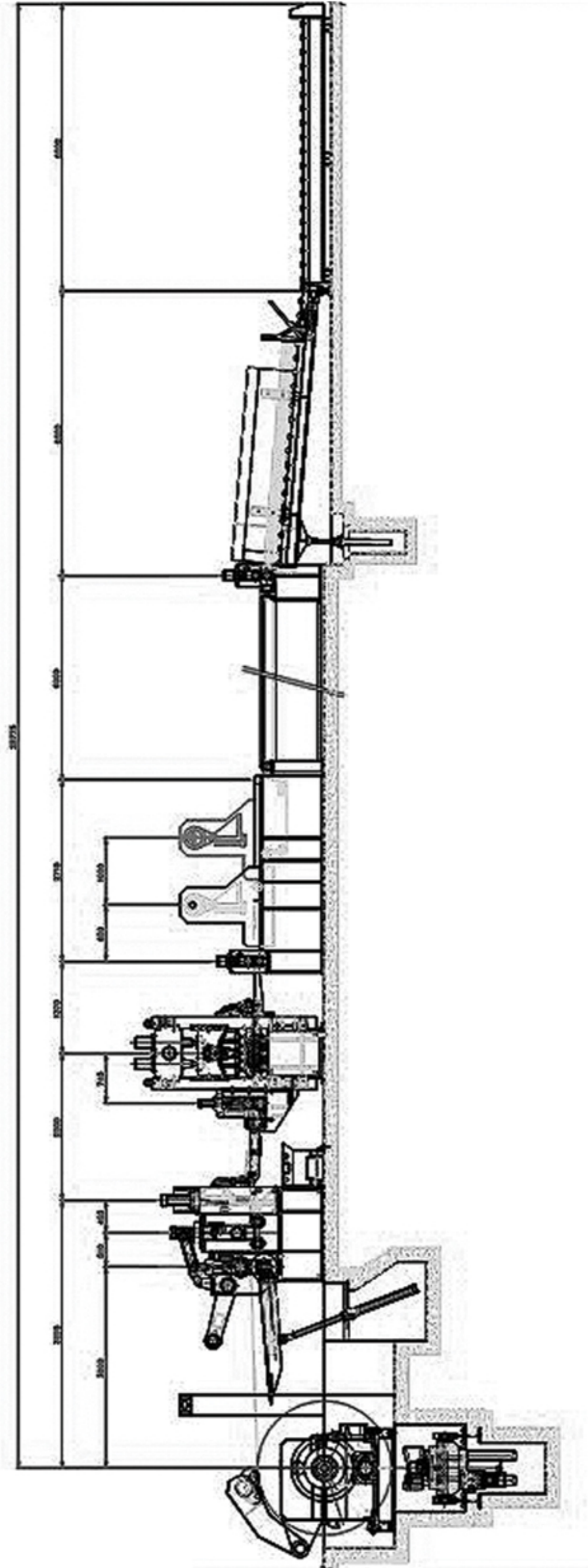
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CUT TO LENGTH LINES

Mid Capacity MAX 1500 CL Type

MACHINES



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