

슬리터 사양서

NO	사양서	
1. material data & basic specification		
1-1	raw material	Ni 200 series INVAR, KORVAR, MONEL
1-2	width	50mm ~250mm
1-3	THICKNESS	0.05mm ~ 0.6mm
	incoming/recoiling doil spec.	
1-4	coil ID	Ø200, Ø300, Ø400
	coil OD	Max. Ø1,000
	coil weight	1000kg
1-5	line speed	Max. 120MPM
1-6	slitting capacity	
	No. of cut	13out at 0.6mm(12strip) 21out at 0.2mm (20strip)
	min. width of cut	2.5mm (knife thickness 1.0mm)
1-7	slitting accuracy	+/- 0.02mm
1-8	slitting method	drive & pull cutting // ring type
1-9	line direction	from left to right
1-10	electrical source	
	main power	
	control power	
1-11	pneumatic source	max.pressure 7kg /cm2 normal pressure 5kg /cm2
2. Constitution of the line		
2-1	pay off reel	1set
2-2	slitter	1set
2-3	scrap winder	1set
2-4	tension reel(bobbin slip type)	2set
2-5	pneumatic system	1set
2-6	electric control system	1set
3. Technical specification		
3-1	pay off reel	
	type	overhung over unwing system
	mandrel size	Ø200, Ø300, Ø400
	mandrel expand	by manual
	centering stroke	+/- 37.5mm either side of center line
	centering method	air cylinder by operator
	tension control	by motor with ac vector drive(3.7kw) (automatically reduced thru od
	pay off reel in //out	by air cylinder
3-2	slitter	
	type	drive & pull cut //ring type
	arbor size	Ø80 x 300L mm
	material	suj2
	surface condition	hard cr plating after heat treat
	knife	tool list (discuss after fix)
	spacer	tool list (discuss after fix)
	lap adjustment	manual screw jack
	lap display	by digital meter (1/100mm read out)
	pass line adj	by screw handle
	knife clamping	by lock nut
	main drive motor	15kw ac vector motor //powder brake
	strip guide	by steel ring
	base line of slitting	can be adjusted within the arbor
	op side stand moving	slide & hinge open type(by manual)

3-3	scrap winder	
	type	dual mandrel type
	scrap size	Ø250 x Ø450 x Ø 168mm width x 2
	drive	driven with main motor
	traverser	by pneumatic cylinder
3-4	tension reel	
3-4-1	No1. tension reel	
	type	loopless winding with slip disc
	coil size	
	inner dia	Ø50.8mm(Ø76.2mm adapter)
	outer dia	Ø 600
	winding shaft dia	Ø50.8mm (1set)
	slip disc size	Ø50.8/ Ø120mm
	spacer, strip core	
	winding tension control	by fine air pressure control
	drive motor	driven with No.1 tension reel motor
3-4-2	No2. tension reel	
	type	loopless winding with slip disc
	coil size	
	inner dia	Ø50.8mm(Ø76.2mm adapter)
	outer dia	Ø 600
	winding shaft dia	Ø50.8mm (1set)
	slip disc size	Ø50.8/ Ø120mm
	spacer, strip core	
	winding tension control	by fine air pressure control
	drive motor	driven with No.1 tension reel motor
3-4-3	separator (2set)	
	type	hinged overhung arm type
	separator disc	tool steel , hard Cr plating
	spacer	tool steel
3-5	pneumatic system	
	pressure controller	
	winding tension control	
	separator pressure control	
	FRL unit	
3-6	electric system	
	main power source	AC 380, 60Hz, 3 phase
	control source	AC 220V, 60Hz, Single phase
	control panel	speed control
		strip tension control
		winding tension control
		scrap winder control
	plc system	plc hardware and soft ware
	main OP desk& local op stand	
	main OP desk	box type(assembled at machine)
	monitoring	by touch screen
	local op panel	pendant type