

Specifications

Shear Line(Cut-to-Length Line)

1.6~ 4.5(6.0)t ×1,600w×30ton×3.1mL

1. Specification

1] Basic specification

Raw material	Hot rolled, PO steel strip	
T.S	50kg/mm ²	
Thickness	1,6 - 4,5[6,0]mm	
Width	600 -1600mm	
Coil weight	Max 30tons	
Coil I,D	508Ø,610Ø,762Ø mm	
Coil O,D	Max 2300Ømm	
Cut to Length	1000 - 3100mm	
Cutting tolerance	± 0,5mm Below	
Line speed	1,6 - 3,2mm	70m/min Max
	3,3 - 4,5mm	45m/min Max
	4,6 - 6,0mm	46m/min Max
No of cut	50cuts /min	
Power source	AC440volts & 220volts x 60Hz	

Control power	220volts x 60Hz
Solenoid power	220volts x 60Hz
Line direction	Right to Left

2. Brand & Year, Upgrade

1992	Installed by Token,Japan
1993	Installed by Yaskawa Electric, Japan
2005	Upgrade for Rough leveller by Token, Japan
2005	Renewal for Scrap chopper by Token , Japan
2005	Renewal for Flying hear by Token, Japan
2009	Renewal for Control of Flying shear by Yaskawa Simens
2014	Renewal for Battery by Reliance Electric, Japan

3. Line Description

Coil skid	3 coil used
Coil car	
Uncoiler	3 step cone type
CPC system	
Snubber roller & Coil opener	
Pinch roll Leveller	250Ømm x 1750mm x 5 roll

Side guide & s- type roller

Side trimmer 450Ø mm/ 245Ø mm x 20mm

Scrap chopper Rotary type

Finish Leveller 4 high type , 90Ø mm x 1750mm x 17roll

Double Pinch roller

Flying up cut shear included Measuring & Feeder roller

Shot sheet treatment unit

Inspection table with Tilter table Belt conveyor 4M Long

Reject Piler

Run out table with auto centering unit Belt conveyor 6M Long

**Auto Piler Auto centering
2ton x 300mmH x 1000-3100mm Length**

Pneumatic controller

Hydraulic control unit

Electric controller

Photo for 1600w Flying Shear Line



Full View (Entry Side)



Full View (Exit Side)



Coil Skid , Coil Car



Entry Sensor & Frame

Photo for 1600w Flying Shear Line



Uncoiler



Uncoiler (WS)



Uncoiler (DS)



Coil Protector , Coil Opener

Photo for 1600w Flying Shear Line



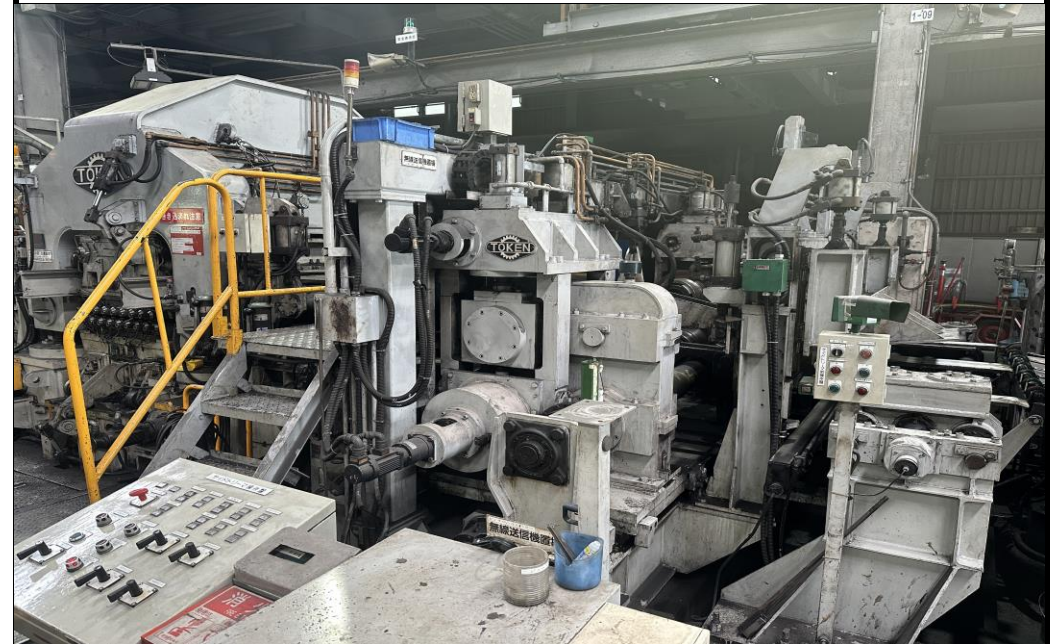
Snubber Roll



Rough Leveler



Side Guide



Trimmer

Photo for 1600w Flying Shear Line



Scrap Chopper



Scrap Conveyor



Finish Leveler



Roll Exchanger

Photo for 1600w Flying Shear Line



Double Pinch Roll



Table



Flying Shear



Flying Shear

Photo for 1600w Flying Shear Line



Scrap Car-1



Inspection Conveyor



Inspection Conveyor



Run-out Conveyor

Photo for 1600w Flying Shear Line



Scrap Car-2



Work Deck



Piler



Piler (Top)

Photo for 1600w Flying Shear Line



Hydraulic Unit (Entry Side)



Hydraulic Unit for Piler



Rubber Sleeve



Pinch Roll

Photo for 1600w Flying Shear Line



Leveler Roll (Steel Box)



Roll



Chuck (Steel Box), Reducer Gear (Steel Box)



Knives for Chopper

Photo for 1600w Flying Shear Line



Entry OP



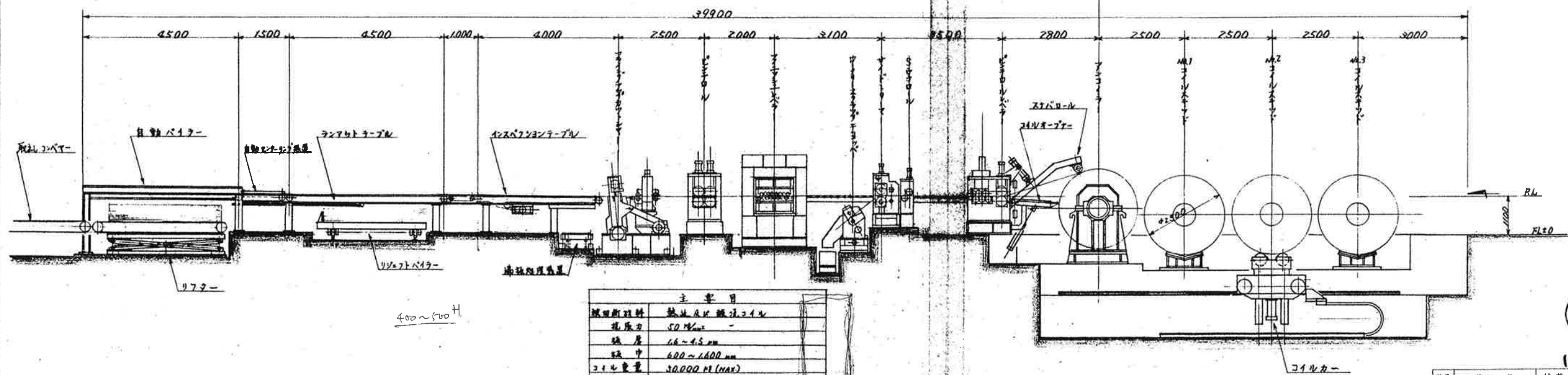
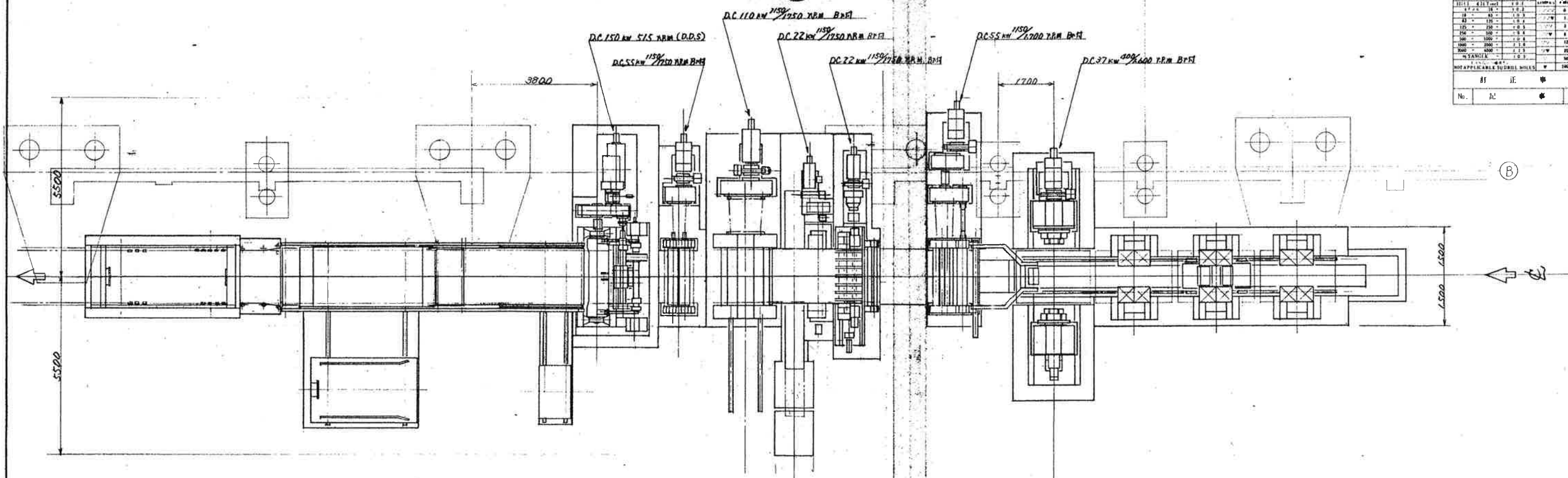
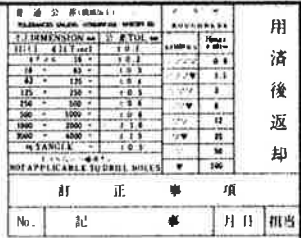
Entry ACGC Panel



CP



Reactor



主 要 目	
煤油断丝料	熟油及煤油 24 号
抗压力	50 吨/m ² -
厚度	1.6 ~ 4.5 mm
硬 度	600 ~ 1600 mm
3 号重量	30,000 H (MAX)
• 内径	50P. 610. 262 mm
24 号外径	2,300 mm (MAX)
内 部 空 子	1000 ~ 3,100 mm
切 断 销 座	2.05 mm 以下
94 号速度	1.6 ~ 27 mm 90 %in (MAX)
	3.21 ~ 45 mm 50 %in (MAX)
最大 2 号小	50 吨/m ²
电动机电压	A.C 440V 60 Hz 220V 60 Hz
操作电压	A.C 220V 60 Hz
电源电压	A.C 220V 60 Hz



1991. 1. 16

品番	品名	材質	数量	摘要	重量
名	16.95 ⁴ x 1600 ^W				
号	7ラインシャワーライン				
	是種用全体配置圖				
承認	檢閱	設計	製図	計算	尺貫
			校本	2.10.29	1/60
株式会社 東研機械製作所		図番	BXS0301		

KW

Motor List for 1600w Flying shear

(モーターリスト一覧表)

2023年6月7日

	用途 (use)	AC DC	台 数	容量 (kw)	メーカー (Maf.)	回転数 (R.P.M)	極数 (Poles)	年式 (year)	周波数 (Hz)	電圧 (V)
1	Uncoiler	DC	1	37.00 kw	Yaskawa	400/ 1600		1991		400
2	Uncoiler	AC	1	1.50 kw			4p		50/60	400
3	3-Roll	DC	1	22.00 kw	Yaskawa	1750			50/60	200/220
4	3-Roll	AC	1	0.75 kw	Yaskawa	1440/ 1730	4p		50/60	400
5	Trimmer	DC	1	22.00 kw	Yaskawa	1750		1991		440
6	Scrap Chopper	DC	1	22.00 kw	Yaskawa	1900/ 1150		1991		440
7	Leveler	DC	1	110.00 kw	Yaskawa	2100/ 1150		1991		440
8	Lever	AC	1	0.75 kw						
9	Shear	DC	1	150.00 kw	Reliance	515	6p			
10	Belt Conveyor	AC	1	7.50 kw	Yaskawa	1730	4p		60	
11	Hydraulic Unit	AC	2	11.00 kw	Yaskawa	1160/ 1170	4p		50/60	200/220
12	Hydraulic Unit	AC	2	15.00 kw	Yaskawa	1460/ 1760	4p		50/60	200/220
合 計 (Total)			14	399.50 kw						
内 訳 (Details)		AC		36.50 kw						
		DC	6	363.00 kw						

※目視及び資料で確認できる範囲の主要部モーターリストです。