MET-TECH | Product Data Sheet
CUT-TO-LENGTH - SHEAR LINE - 300-1600 MM, 0.3-2.3 MM - STEEL - 300-3500 M

Ref. No.: CUTTOLENGTH171201
Year: 1991
Brand: YONEMORI IRON WORKS CO.
Qty. 1 Second-hand cut-to-length line including 6-Hi leveler ? Shear line
Mfc.: Yonemori Ironworks Co. Built
Material: Cold rolled mild steel & surface treated steel strip Voltage
Width: 300 ? 1600 mm Thickness
Coil OD: 1600 mm ID
Cut length: 300 ? 3500 mm Line speed
Cut accuracy: +/- 0.3 mm Line direction
Scope of supply Coil skid Entry coil car Uncoiler Opener
Deflecting roll Hydraulic shear Heavy line leveller Loop unit
Side guide Light 6-Hi line leveller Feeder unit DDS-R shear unit
Inspection conveyor Reject conveyor with a reject truck
No. 1 prime piler with a taking out conveyor Over pass conveyor
No. 2 prime piler with a taking out conveyor Hydraulic device
Pneumatic device Electric control device

Specification
Coil skid Loading capacity: Coil OD
No. of coils: 1 Weight
Skid surface: applied with MC nylon plate
Entry coil car Type: 4 wheel car type Max. loading weight
Lifting receiving table: by mean of hydraulic cylinder
Receiving table surface: applied with MC nylon plate
Travelling speed: 6 m/min. Travelling distance
Travelling drive: AC 3.7 kW, GMB Lubrication
Guide rod: dust seal cover
Uncoiler Type: Expanding cantilever drum type Frame
Drum expansion: dia. 470 ? 520 mm Drum operation

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Drum surface: plated with hard chrome Winding length of drum
Loading capacity: 15.0 T Spindle brake
Drum drive: 2.2 kW, AC motor Clutch operation
Holding down roll size: dia. 200 mm x 500 mm L
Holding down roll surface: lined with hard urethane rubber
Lifting holding down roll: Hydraulic cylinder
Holding down roll drive: 1.5 kW, AC with torque limiter
Centering stroke: +/- 50 mm Lubrication
Automatic control: automatic reduction brake pressure control
Reducing drum expansion pressure control
Automatic reduction gear (speed) acting at coil tail end
Detector: Function detecting coil center position
Coil opener (Piller) Type: Sliding table type Frame
Table drive: Hydraulic cylinder Lifting table
Table surface: applied with brass plate Lubrication
Deflecting roll Type: directly acting pressure pinch roll type
Roll size: dia. 250 mm x 1700 mm L ? qty. 2 pieces
Roll surface: lined with hard urethane rubber
Lifting roll: pneumatic cylinder Roll drive
Hydraulic shear Type: Hydraulic down cut type
Lifting upper blade: Hydraulic cylinder
Blade size & material: 30 mm thickness x 100 mm width x 1950 mm L
equal to SKD11 JIS
Alloy tool steel SKD11
Lubrication: Grease gun Frame
Heavy line leveller Type: qty. 15 pieces rolls with double
Pinch roll Roll size: dia. 195 mm x 1700 mm L
Lifting roll: pneumatic cylinder
Work roll Roll size: dia. 65 mm x 1800 mm L upper side 7 pieces
Dia. 65 mm x 1800 mm L lower side 8 pieces
Pressing down roll: 1.5 kW, AC geared motor controlled by inverter
with 200 mm adjustment amount displayed by a mechanical counter
Back-up roll Roll size: dia. 85 mm x 51 mm L upper side 8 pieces 7 rank
Lower side 9 pieces 7 rank ? total 119 pieces
Pressing down roll: Upper side by manual handling
Lower side by semi-fixed
Adjustment display: Scales
Drive 75 kW, DC motor with pneumatic disk brake
Threading speed 15 ? 87 m/min.

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Lubrication Grease pump
Kammwalz lubrication Pump 0.75 kW, AC motor
Back-up roll washing machine One set
Loop unit Type: Elevator type Catenary dadius
Roll size: dia. 85 mm x 1700 mm L lined with hard urethane rubber
Lifting loop table: 1.5 kW, AC motor
Apron side guide: disk type with quenched surface
Width adjustment: 300 ? 1600 mm manual handling
Total shift: +/- 50 mm Frame
Lubrication: Grease gun
Side guide Type: Twin head roll type
Roll size: dia. 90 mm x 150 mm L qty. 3 pieces x 2=6 Pi
Width adjustment: dia. 300 mm x 1600 mm L manual adjusted ? displayed on the scale
Total shift: +/- 50 mm Frame
Lubrication: Grease gun
Light 6-Hi line leveller Type: Both upper & lower 3-High rolls such as work rolls,
Intermediate rolls & back-up rolls ? total 6-Hi ? 19 pieces rolls with double pinch rolly type
Pinch roll ? 2 sets Roll size: dia. 200 mm x 1800 mm L ? 2 rolls per one set
Upper & lower rolls with chrome plated surface
Lifting roll Pneumatic cylinder Roll drive: Kammwalz
Work roll Roll size: dia. 50 mm x 1956 mm L upper side 9 pieces
Lower side 10 pieces
Pressing down roll: 1.5 kW, AC geared motor with 200 mm adjustment
Amount displayed by a mechanical counter & controlled by inverter
Intermediate roll: dia. 45 mm x 1956 mm L upper side 10 pieces
lower side 11 pieces
Back-up roll Roll size: dia. 70 mm x 51 mm L - upper side 11 pieces 7 rank
Lower side 12 pieces 7 rank ? total 161 pieces
Pressing down roll: upper side manual handling & lower side semi-fixed
Adjustment display: Scale
Drive 75 kW, DC motor
Threading speed: 15 ? 80 m/min.
Brake roll Type: Pinch roll type Brake adjustment
Lifting roll: Pneumatic cylinder
Lubrication: Grease gun

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Kammwalz lubrication: Pump driven by 0.75 kW AC motor
Back-up rolls washing machine: One set
Feeder unit Type: Directly acting pressure measuring roll type
Feeding roll: dia. 180 mm x 300 mm L ? 2 pieces
Measuring roll: dia. 180 mm x 300 mm L ? 2 pieces
Pulse generator for length measurement: RP-6 qty. 2 pieces
Lifting roll: Pneumatic cylinder Frame
Drive: 0.2 kW, AC motor with powder clutch
Lubrication: Grease gun
DDS ? Rotary shear unit Type: Electrical crank up cut shear
Material coil Material: Cold rolled steel strip & surface treated steel strip with
Tensile strength max. 40 kg/cm²
Thickness: 0.3 ? 2.3 mm
Max. width: 1700 mm
Blade Size: 25 mm x 100 mm x 1700 mm L Upper side 1 piece & lower side 1 piece
Rake: Double rake
Material: SKD-11 or equal to it
Shear opening: 199 mm Blade stroke
Number of cut: Refer to SPM table Cut length
Cut accuracy: +/- 0.3 mm at equal speed & +/- 0.5 mm at accelerated/decelerated
Speed but excluding one sheet cut first & last respectively
Control: DDS-R11 control made by Japan Reliance
Drive: 75 kW, DC motor Lubrication
Inspection Conveyor Type: Belt conveyor type Conveyor length
Conveyor belt: Transilon belt made by Japan Sigling
Pulley size: dia. 160 mm x 1650 mm L Conveyor speed
Frame: welded steel plate construction
Reject conveyor Type: belt conveyor type Conveyor length
Conveyor belt: Transilon belt made by Japan Sigling
Pulley size: dia. 160 mm x 1650 mm L Tilting gate operation
Conveyor speed: max. 100 m/min. Drive
Frame: welded steel plate structure Reject truck
Truck travelling drive: 1.5 kW, AC geared motor
Loading capacity: 1600 mm in width x 3500 mm in length ? 3000 kg in weight
Lubrication: Grease gun Air blower drive
No. 1 Prime piller Type: Dropping sheet cushioned by air blower & piling

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the sheet longer
Than one prime piler capacity together with no. 2 prime piler type
Loading capacity: Size 300 ? 1600 mm in width x 400 ? 3500 mm in length
4000 kg in weight & max. 700 mm in piled height including a skid
Shifting end stopper: 0.2 kW, AC GMB
Shifting side guide: 1.5 kW, AC GMB used in common with No. 2 piler?s
Stamping side guide: Pneumatic cylinder with 100 mm in diameter & 30 mm in stroke
Air blower drive: 7.5 kW, AC with 2 poles controlled by inverter
Lifting: A pantograph type hydraulic cylinder moved by a pump driven by 3.7 kW,
AC motor
Taking out conveyor: with roll 114.3 mm in dia. & 3500 mm in length
Taking out conveyor drive: 1.5 kW AC motors
Reserved space Lubrication: Grease gun
Over pass conveyor Type: Belt conveyor type Conveyor length
Lifting & tilting table: Pneumatic cylinder Conveyor belt
Pulley: dia. 160 mm x 1650 mm L Conveyor speed
Drive: 3.7 kW, AC GM controlled by inverter
Frame: welded steel plate structure
No. 2 Prime piler Type: Dropping sheet cushioned by air blower & piling the sheet longer
Than one prime piler capacity together with No. 1 prime piler type
Loading capacity: Size 300 ? 1600 mm in width x 400-3500 mm in length,
4000 kg weight & max. 700 mm in piled height including a skid
Shifting end stopper: 0.2 kW, AC GMB
Shifting side guide: 1.5 kW, AC GMB used in common with No. 1 piler?s
Stamping side guide: Pneumatic cylinder with 100 mm in diameter & 30 mm in stroke
Air blower drive: 7.5 kW, AC with 2 poles controlled by inverter
Lifting: A pantograph type hydraulic cylinder moved by a pump driven by 3.7 kW,
AC motor
Taking out conveyor: with roll 114.3 mm in dia. & 3500 mm in length
Taking out conveyor drive: 1.5 kW AC motors Lubrication
Hydraulic device Hydraulic unit: one set Discharging pump
Max. pressure: 70 kg/cm² Working pressure
Drive: 18.5 kW, AC 6 poles motor Oil reservoir cap.
Accessories: Valves & rubber hoses
A set of the primary and secondary piping materials, parts & piping

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Reference Valve maker Daikin Kogyou Hydraulic cylinder Taiyou Iron Works
Pneumatic pressure device Max. pressure: 7.0 kg/cm² Working pressure
Electric control system Voltage: 220 V AC, 60 Hz

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