MET-TECH | Product Data Sheet
COATING STRIP LINE - 600-1250 MM - 0.2-1.4 MM - 10 Âµ

Ref. No.: COATINGSTRIPL200601
Year:
Brand: POSCO
Qty. 1 Second-hand color coating strip production line
Mfc.: POSEC Built
Strip width: 600 ? 1250 mm Thickness
Coil ID 508 & 610 mm OD 2000 mm Weight: max. 22 Ton
Speed max. Entry section: 120 m/min Process
Steel grade: GI, EGI, CR, GL, Coils
Final product PCM Coil Width: 600 ? 1250 mm Thickness
Coil weight: max. 10 T ID 508 & 610 mm OD 1500 mm
Coating material Polyester Si-Polyester PVDF
Prime coater - Thickness Top max. 10 µ Bottom max. 10 µ
Finish coater ? Thickness Top max. 30 µ Bottom max. 30 µ for oven
Chemical coater ? wet base ? thickness Top 3 g/m² Bottom 3 g/m²

Specification
Ovens 1040 mm x 0.45 mm ? W x T Speed: 80 m/min Polyester coating
Peak metal temp.: Prime oven 30 ? 220 °C Finish oven 30 ? 250 °C
Prime oven 3 Zones Length: 34 m
Finish oven 4 Zones Length: 44 m
Baking time Prime oven 25 sec. at 80 m/min Finish oven 33 sec. at 80 m/min.
Hot air temperature max.: 400 °C
Strip Joiner Type: Double row die-press Cycle time
Capacity: 1250 x 1.4 mm x 2 strips to join Splice detection
Strip centering: Manual type side guide Push-pull type
Edge flattener Type: One set ? pneumatic type
Roll dimensions: Two sets ? dia. 200 mm x 1500 mm face x 2
Roll material: Chrome coated Cylinder

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Degreasing No. 1 Treatment time: approx. 5 sec. Solution
Temp.: approx. 60-80 °C Tank material
Spraying booth: One set Spray by nozzle through header
Wringler roll: Two sets Dia. 250 x 1500 mm Non-drive
Wringler rolls covering: Hypalone, 20 mm
Wringler rolls actuator: Two sets, Pneumatic cylinder
Circulation tank: SUS 304 ? Approx. 8000 L Heating
Circulation pump: Two sets ? 1 operation & 1 stand by
Approx. 2.9 m³/min x 3.0 kg/cm² Power: approx. 30 kW
Alkali mixing tank Material: SUS 304 Heating by steam coil
Agitator Power: 2.2 kW
Pump Two sets 1 operation & 1 stand by
Approx. 0.85 m³/min x 2.0 kg/cm² Power: 5.5 kW
Waste water sump pump Two sets 1 operation & 1 stand by
Approx. 2.0 m³/min x 3.7 kg/cm² Power: 22 kW
Brush Scrubber Treatment time: approx. 2.5 sec. Demi water or Alkali water
Temp.: Ambient or approx. 60 ? 80 °C Tank material
Tank length: 4500 mm Qty. 4 Brush rolls Dia. 350 x 1500 mm
Brush type: Nylon with Silicon Carbide tip Drive motor
Actuator: Pneumatic cylinder & screw jack
Qty. 4 Counter roll Dia. 250 x 1500 mm Hard chromium plated carbon steel
Roll drive: by VVVF motor Power
Qty. 2 Sets Wringler roll Dia. 250 x 1500 mm Roll covering: Hyplone - 20 mm
Actuator: Two sets Pneumatic cylinder
Circulation tank Material: SUS 304 7000 L
Heating by steam coil
Circulation pump Two sets ? 1 operation & 1 stand by
Approx. 1.1 m³/min x 3.0 kg/cm² Power: 11 kW
Degreasing No. 2 Treatment time: approx. 5 sec. Solution
Temp.: approx. 60-80 °C Tank material
Spraying booth: One set Spray by nozzle through header
Wringler roll: Two sets Dia. 250 x 1500 mm Non-drive
Wringler rolls for upper: Non-driven
Wringler rolls drive for bottom: by VVVF motor Power
Wringler rolls covering: Hyplone, 20 mm
Wringler rolls actuator: Two sets, Pneumatic cylinder
Circulation tank: SUS 304 ? Approx. 8000 L Heating

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Circulation pump: Two sets ? 1 operation & 1 stand by
Approx. 2.9 m³/min x 3.0 kg/cm² Power: approx. 30 kW
Hot Water Rinse No. 1 Treatment time: 2.5 sec. Demi water Temp.
Tank material: SUS 304 Tank length
Spraying booth by nozzle through header
Wringler Dia. 250 x 1500 mm Roll covering: Hyplone, 20 mm
Actuator: Pneumatic cylinder Non driven
Circulation tank Material: SUS 304 6000 L Heating by steam coil
Circulation pump Two sets 1 operation & 1 stand by
Approx. 2.0 m³/min x 3.0 kg/cm² Power: 18.5 kW
Hot Water Rinse No. 2 Treatment time: 2.5 sec. Demi water Temp.
Tank material: SUS 304 Tank length
Spraying booth by nozzle through header
Wringler Two sets Dia. 250 x 1500 mm Roll covering: Hyplone, 20 mm
Actuator: Two sets - Pneumatic cylinder Non driven
Circulation tank Material: SUS 304 6000 L Heating by steam coil
Circulation pump Two sets 1 operation & 1 stand by
Approx. 2.0 m³/min x 3.0 kg/cm² Power: 18.5 kW
Hot air dryer Type: Hot air circulation type through slit on tube header by steam heat exchanger
Temp.: 60 ? 80 °C Frame table
Blow unit: Centrifugal blower arrange for direct connection to AC motor.
Capacity: 250 m³/min 300 mmAq Power
Heating: Fin tube type by steam
Support roll: Dia. 89 x 1500 mm Hard Chrome plate
Fume exhaust system for pre-treatment
Duct & Damper: Welded mild steel Exhaust fan
Fan capacity: 120 m³/min 140 mmAq Power
Chemical coater
Number of heads: Two ? 1 Top side 1 Bottom side
Roll type Top 3 Rolls Bottom 2 Rolls
Applicator roll Qty. 2 Dia. 260 x 1500 mm AC vector motor 11.0 kW
Polyurethane covered
Pick-up roll Qty. 2 Dia. 260 x 1500 mm AC vector motor 5.5 kW
Hard chrome coating
Intermediate roll Dia. 260 x 1500 mm AC vector motor 5.5 kW
Polyurethane covered
Lift roll Dia. 350 x 1500 mm By handle stroke adjustement (screw jack)
Quick releasing system By hydraulic cylinder

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Coater pan Qty. 2 sets Material: SUS 316
Nip pressure indicating for top coating
Between applicator roll and intermediate roll
Between intermediate roll and pick-up roll
Nip pressure indicating for bottom coating
Between applicator roll and pick-up roll
Chemical Dryer
Design 0.45 x 1040 mm ? T x W Speed: 80 m/min.
Type Hot air recirculation type Heating: Direct gas firing by burner
Strip P.M.T.: 65 °C +/- 5 °C - max. 70 °C Hot air temp.
Circulation fan: 600 m³/min 120 mmAq Power
Burner capacity: 500 000 kcal/h Dimensions
Fume exhaust fan: 5.5 kW Combustion air blower
Cooling roll unit
Type: Water cooling roll type (2 rolls)
Roll Qty. 2 Dia. 706 x 1500 mm - Hard chrome coating
Reference metal temp.: in 70 °C ? out 50 °C
Appurtenances: Rotary joint, Flexible hose, Valve etc.
Cooling water temp. (inlet): max. 32 °C
Prime Coater
Qty. 2 Number of heads - top side & bottom side
Roll type: top ? 2 rolls bottom ? 2 rolls
Qty. 2 Applicator rolls Dia. 260 x 1500 mm AC vector motor 11.0 kW
Speed 0-200 % Polyurethane covered
Qty. 2 Pick-up rolls Dia. 260 x 1500 mm AC vector motor 5.5 kW
Speed 0-150% Hard chrome coating
Back-up roll Dia. 760 x 1500 mm Hard chrome coating
Lift roll Dia. 350 x 1500 mm Hard chrome coating
Actuated by hydr. cylinder
Deflector roll Dia. 760 x 1500 mm Hard chrome coating
Doctor blade One set
Quick releasing system by pneumatic or hydraulic cylinder
Qty. 2 Sets Coater pans SUS 304
NIP pressure indicating for top coating
Between back-up and applicator rolls Between applicator and pick-up rolls
NIP pressure indicating for bottom coating
Between applicator and pick-up rolls
Water Quench Unit No. 1
Standard design Strip width: 1040 mm Thickness

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Speed: 80 m/min. Temp.
Tank material: Stainless steel Type
Support roll Dia. 300 x 1500 mm Hypalon covered ? 20 mm
Qty. 2 Wiper rolls Dia. 250 x 1500 mm Hypalon covered ? 20 mm
Manual position adjustment (top roll: screw jack)
Qty. 2 Water spray pumps one operation & one stand by Power 15 kW
1.7 m³/min. 2.8 kg/cm²
Cooler One set Plate type
Air curtain fan One set 70 m³/min 150 mmAq 3.7 kW
Hot Air Dryer No. 2
Type: Hot air circulation type through slit on tube header by steam heat exchanger
Temp.: 60 ? 80 °C Frame table
Blow unit: Centrifugal blower arrange for direct connection to AC motor.
Circulated air temperature
Capacity: 250 m³/min. 300 mmAq 22.0 kW
Heater type: Fin tube type by steam
Finish Coater No. 1
Number of heads: One ? top side Roll type
Applicator roll Dia. 260 x 1500 mm AC vector motor 11.0 kW
Speed 50 ? 200 % Polyurethane covered
Pick-up roll Dia. 260 x 1500 mm AC vector motor 5.5 kW
Speed 25 ? 150 % Hard chrome coating
Metering roll Dia. 200 x 1500 mm AC vector motor 3.7 kW
Speed 10 ? 50 % Hard chrome coating
Back-up roll Dia. 760 x 1500 mm Hard chrome coating
Doctor blade One set by pneumatic cylinder
Quick release system by pneumatic or hydraulic cylinder
Coater pan One set SUS 304
Nip pressure indicating for top coating
Between back-up & applicator rolls Between applicator & pick-up rolls
Between pick-up & metering rolls
Finish Coater No. 2
Number of heads: Two ? top & bottom side
Roll type: Top ? 3 rolls Bottom ? 2 rolls
Qty. 2 Applicator rolls Dia. 260 x 1500 mm AC vector motor 11.0 kW
Speed 50 ? 200 % Polyurethane covered
Qty. 2 Pick-up rolls Dia. 260 x 1500 mm AC vector motor 5.5 kW
Speed 25 ? 150 % Hard chrome coating

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Metering roll Dia. 200 x 1500 mm AC vector motor 3.7 kW
Speed 10 ? 50 % Hard chrome coating
Back-up roll Dia. 760 x 1500 mm Hard chrome coating
Lift roll Dia. 350 x 1500 mm Hard chrome coating
Doctor blade One set by pneumatic cylinder
Quick release system by pneumatic or hydraulic cylinder
Coater pans Two sets SUS 304
Nip pressure indicating for top coating
Between back-up & applicator rolls Between applicator & pick-up rolls
Between pick-up & metering rolls
Nip pressure indicating for bottom coating Between applicator & pick-up rolls
Finish Oven
Type: Direct heat hot air recirculation type Catenary pass
Design Width: 1040 mm Thickness
Curing time: 33 sec. Number of zone
Fuel for burner: LPG LHV of LPG
Temp.: max. 400 °C Qty. 4 RC fan sets 37 kW
Qty. 4 Combustion air blower sets 1.2 kW Qty. 4 Burnere sets 500 000 kcal
Cooling method for RC fan bearing: by individual air cooling fan
Panel material: Al coated Gl steel
Regenerative Thermal Oxidiser (RTO)
Type: 2 bed Exhaust temp.
Fuel kind: LPG Destruction efficiency
Thermal energy recovery of RTO: max. 85% Burner
Ceramic: Ceramic saddle or equivalent
Combustion air blower: 20 m³/min. Hydraulic unit
Secondary heat exchanger Type: Plate type Fluid
Mixing box Type: Vertical type Material
Ceramic module insulation
Exhaust fan: AC VVVF motor ID fan
Air supply fan: AC general motor
Water Quench Unit No. 2
Designed Width: 1040 mm Thickness
Temp.: 220 ? 50 °C Tank material
Support roll: Dia. 300 x 1500 mm Hypalon covered 20 mm
Qty. 2 Wiper rolls Dia. 250 x 1500 mm Hypalon covered 20 mm
Manual position adjustment (top roll: screw jack)
Circulation tank: Volume

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Qty. 2 Water spray pumps 1 operation & 1 stand by 1.7 m³/min.
2.8 kg/cm² 15 kW
Cooler Plate type
Air curtain fan 70 m³/min 150 mmAq 3.7 kW
Fume exhaust fan 80 m³/min. 80 mmAq 3.7 kW
Qty. 2 Waste water sump pumps 1 operation & 1 stand by
0.5 m³/min. 2.0 kg/cm² 3.7 kW
Hot Air Dryer No. 3
Type: Hot air circulation type through slit on tube header by steam heat exchanger
Temp.: 60 ? 80 °C Frame table
Blow unit: Centrifugal blower arrange for direct connection to AC motor.
Capacity: 250 m³/min. 300 mmAq 22 kW
Heater type: Fin tube type by steam

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