

Used 4-hi 1450 cold rolling and leveling mill

- * rolling mill size : E450/E1050X1450mm
- * max incoming coil thickness : 6.00mm
- * min finished coil thickness : 0.3mm (rolling) , when leveling : 0.15mm ;
- * max finished coil width : 1300mm
- * min finished coil width : 700mm
- * max coil OD : 2200mm
- * material coil ID : Φ 508-610mm, finished coil ID : Φ 610mm
- * max coil weight : 25T
- * max rolling force : 18000KN
- * max rolling torque : 121.5KN&m
- * max rolling speed : 600m/min
- * working roll diameter : E450mm new rolls
E410mm old rolls
- * back up roll diameter : E1050mm new rolls
E980mm old rolls
- * tension roll diameter : E610mm
- * anti-wrinkle roll diameter : E255mm
- * roll length : 1450mm (working roll)
1400mm (back up roll)
1450mm (tension roll)
1450mm (anti-wrinkle roll)
- * max open mouth : 40mm (when max roll diameter)
- * coiler cone diameter : E610mm/E595mm jaw
- * coiler max tension : 300kN
- * max tension at exit when leveling : 180KN
- * transmission : driven by working rolls
- * max coiling speed : 600m/min
- * uncoiler cone diameter:(expanding): E610mm-E560mm (E508mm-E460mm)
- * uncoiler cone shaft direction fluctuation : \pm 75 mm
- * uncoiler max tension : 100kN
- * max tension at entrance when leveling : 144KN
- * house : whole body forge , section area: 580X500mm²
- * rolling line standard height : +1000 mm
- * rolling line standard height adjusting travel distance : 75mm
- * craft lubrication flow : 5000l/min
- * hydraulic system working pressure :
- * balance、roll bending : system working pressure :
system working pressure : 21MPa system flow : 40 L/min
- * CPC uncoiler auto center hydraulic control system :
system working pressure : 16MPa system flow : 40 L/min
- * common hydraulic transmission system pressure:
system flow: Q=120 L/min ; system working pressure: 12MPa ;
- * AGC press system pressure:
design max pressure 32Mpa , working pressure 25Mpa , system flow 187L/min
- * GC servo hydraulic cylinder : when single cylinder force 9000KN , oil pressure 18.5Mpa
- * rolls balance : hydraulic multi-cylinder balance
- * main motors power:
rolling mill main motor : DC 1500KW , 750V , 350/1000r/min , 2 units
right tension roll motor : DC 280KW , 400V , 1000/1600r/min, 2 units
left tension roll motor : DC 355KW , 400V , 1000/1600r/min, 2 units
uncoiler motor : DC 540KW , 660V , 350/1000r/min , 1 unit
left and right coilers motors : DC 1700KW , 780V , 300/1000r/min, 4 units

* roll changing device : hydraulic changing for back up rolls , car changing for working rolls.

More Information

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- 1/ year of manufacturer: 2008
 - 2/ stop at mill floor but dismantled
 - 3/ name of manufacturer of mechanical equipment: hebei
 - 4/ name of manufacturer of electronic equipment: tianchuan
 - 5/ spare parts include rollers, bearings, bearing houses, transformers and so on,
but complete list can only be provided after seller checking work shop,
 - 6/ all spare parts can be supplied for future production,
 - 7/ line weight: approximately 600 tons, not include spare parts(can confirm after getting list)
 - 8/ buyer can send people to dismantle the mill but in case of any accident, during dismantling,
buyer have to face all legal problems
 - 9/ location is in or near shanghai
 - 10/ this line is cold rolling machine which has skin pass function.