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## 4Hi Cold Rolling Mills - Origin China

made in 2009, stop in 2015

\* rolling mill size : E450/E1050X1450mm

\* max incoming coil thickness : 6.00mm

\* min finished coil thickness : 0.4mm ( rolling ) , when leveling : 0.15mm ;

\* max finished coil width : 1300mm

\* min finished coil width : 700mm

\* max coil OD : 2200mm

\* material coil ID :  $\Phi$ 508-610mm, finished coil ID :  $\Phi$ 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 )

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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: 580X500mm<sup>2</sup>

\* 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:

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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.