

2MM ROTARY SHEAR

Equipment Capacity

Material:

Cold Rolled Carbon Steels
Critical Surface Finish
Electro-galvanised
Prepainted and HSLA Steels
Cold Rolled Stainless Steel
300 and 400 Series
Bright Annealed and 2B Finish

Product Quality:

Surface condition and coating:

Strip Material Strength

	Minimum	Maximum	
Yield Strength	150MPa	450MPa	
Yield Limit	N/A	N/A	
Shear Strenght	250MPa	600MPa	
Elongation	N/A	N/A	
Strip Width	600mm	1850mm	(including mill edge)
Strip Thickness	0.3mm	2.0mm	
Steel Flatness	If strip flatness does not exceed 40 I units, 90% of the exit products will be flat to within 10 I units		

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Coil Dimensions

	Minimum	Maximum
Coil Weight	N/A	25000kg
Coil Outer Diameter	1000mm	2300mm
Coil Inner Diameter	508mm	610mm with filler segments

Decoiling strip tension

Strip Thickness

Minimum	Maximum	Material	Yield Stress	Shear Stress
N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A

Slitting Capacity

	Minimum	Maximum
Edge Trim Width	5mm per side	50mm per side

Edge Trim Tolerance	Minimum	Maximum	Tolerance
	600mm	1000mm	$S_x = \pm 0.125\text{mm}$
	1000mm	1850mm	$S_x = \pm 0.250\text{mm}$

Sheet and Stacking Capacity

	Minimum	Maximum
Sheet Length Stacker 1	500mm	4000mm
Sheet Length Stacker 2	500mm	4000mm
Scrap Length	N/A	N/A
Stacking Capacity	2 x 4000mm long x 1850mm wide packs	
Stacking	5000kg maximum uniformly distributed	
Pack Height	750mm including pallet	

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Line Speeds

	Minimum	Maximum	
Coil Carraige	N/A	N/A	
Infeed	N/A	15m/min	
Leveller	N/A	100m/min	
	N/A	N/A	
Roll Feed	N/A	100m/min	
Shear Rate	N/A	100Cuts/min	
Exit Conveyor/Stacker	0m/min	150m/min	Leveller Speed (m/min)
Stacker rollways	N/A	N/A	N/A
Line Speed	0m/min	100m/min	N/A
	N/A	N/A	N/A
	N/A	N/A	N/A

Shear Capabilities

	Minimum	Maximum	
Cutting length	500mm	4000mm	
Cutting Speeds	Cut Length	Cuts/min	Leveller Speed (m/min)
	500	100	50
	750	100	75
	1000	76	76
	1500	66	99
	2000	50	100
	2500	40	100
	3000	33	99
	3500	28	98
	4000	25	100
Inspection Mode	N/A	N/A	30
Classification Mode	N/A	27	30

Lenght Tolerance

	Minimum	Maximum	Tolerance
	500mm	1000mm	$S_x = \pm 0.2\text{mm}$
	1000mm	2000mm	$S_x = \pm 0.4\text{mm}$
	2000mm	4000mm	$S_x = \pm 0.8\text{mm}$
	N/A	N/A	N/A
	N/A	N/A	N/A
	N/A	N/A	N/A
Squareness	Minimum	Maximum	Tolerance
	500mm	1000mm	$S_x = \pm 0.25\text{mm}$
	1000mm	2000mm	$S_x = \pm 0.50\text{mm}$
	2000mm	4000mm	$S_x = \pm 1.00\text{mm}$