

Sendzimir 20 High Cold Rolling Mill

Manufactured by DMS (under license of Sendzimir Inc.)



General Specifications

MANUFACTURER:

DMS (France)

COMMISSIONING DATE:

1992

MODEL:

ZR22BBS52

PRODUCTION CAPACITY:

250,000t

INPUT MAX:

0.0250" x 52"

OUTPUT MAX:

0.009" x 52"

ENTRY MATERIAL:

High / Low Carbon Steel / Stainless Steel

ENTRY COIL:

52" Wide (1320mm)

0.25" (6.3mm) Thickness

35.8" to 72" O.D. (910mm to 1830mm)

24" I.D. (610mm)

EXIT COIL:

23.6" to 52" Wide (600mm to 1321mm)

0.009" Thickness (0.22mm)

35.8" to 72" O.D. (910mm to 1830mm)

24" I.D. (610mm)

COIL WEIGHT:

20,000Kgs

LINE SPEED:

2500fpm (762mpm)

TENSION:

40,000Kg Max.

DIRECTION OF TRAVEL:

Right to left seen from Operator's side.

BACKUP BEARINGS:

11.750" / 11.810" (298mm / 300mm)

SECOND INTERMEDIATE ROLLS:

6.875" / 7.200" (175mm / 183mm)

FIRST INTERMEDIATE ROLLS:

3.900" / 4.200" (99mm / 107mm)

WORK ROLLS:

2.900" / 3.400" (74mm / 86mm)

ROLL OPENING:

0.345" MAX (8.76mm)

HOUSING TYPE:

CLOSED TOP

MAIN DRIVE MOTOR:

4000HP DC (3000Kw)

(2 x 2000HP) (2 x 1500Kw)

395 / 1000RPM – 730v

PAYOFF REEL:

24" DIA MANDREL (610mm)

160HP MOTOR DC (120Kw)

770 / 2300RPM – 400v

ENTRY REEL:

24" DIA MANDREL (610mm)

4000HP MOTOR DC (2 x 2000HP)

(2 x 1500Kw)

395 / 1000RPM – 730v

EXIT REEL:

24" DIA MANDREL (610mm)

4000HP MOTOR DC (2 x 2000HP)

(2 x 1500Kw)

395 / 1000RPM – 730v

INCLUDED:

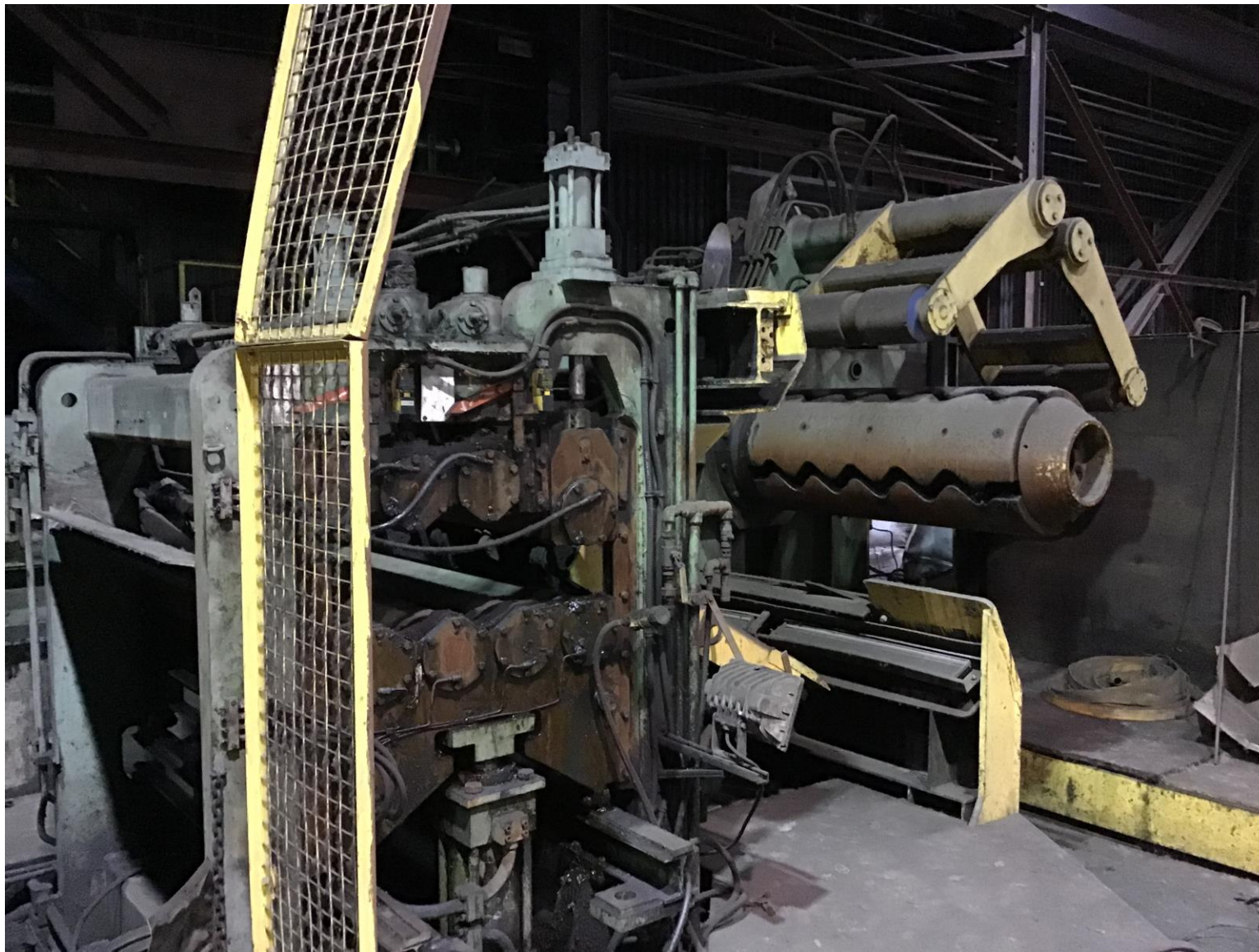
Electrical Drives, 2 Gamma Gauges, 2 Rotary Shears, Automatic Gauge Control, Hydraulic side guides, Lubrication systems, Full Drawings, Operating Spares.

MAIN MECHANICAL COMPONENTS:

Payoff, 20 high cage, 2 mandrels, 2 gamma gages, 2 rotary shears, Automatic gage control, Hydraulic side guides, Includes gear box, hydraulics and lubrication systems

TDI REFERENCE NUMBER

4416



PAYOFF REEL:
24" DIA MANDREL (610mm)
160HP MOTOR DC (120Kw)
770 / 2300RPM – 400v



MATERIAL FLATTENER



CARRYOVER TABLE
(VERTICAL POSITION)



TENSION REEL #1 W/ OUTBOARD BEARING SUPPORT
24" DIA MANDREL (610mm)
4000HP MOTOR DC (2 x 2000HP)
(2 x 1500Kw)
395 / 1000RPM – 730v



CLOSE UP OF OUTBOARD BEARING SUPPORT



ENTRY GAMMA GAUGE, ROTARY SHEAR,
AUTOMATIC GAUGE CONTROL, HYDRAULIC SIDE GUIDES



20 HIGH CLUSTER MILL HOUSING



DELIVERY GAMMA GAUGE, ROTARY SHEAR,
AUTOMATIC GAUGE CONTROL, HYDRAULIC SIDE GUIDES



TENSION REEL #2 W/ OUTBOARD BEARING SUPPORT

24" DIA MANDREL (610mm)
4000HP MOTOR DC (2 x 2000HP)
(2 x 1500Kw)
395 / 1000RPM – 730v



VIEW FROM END OF MILL



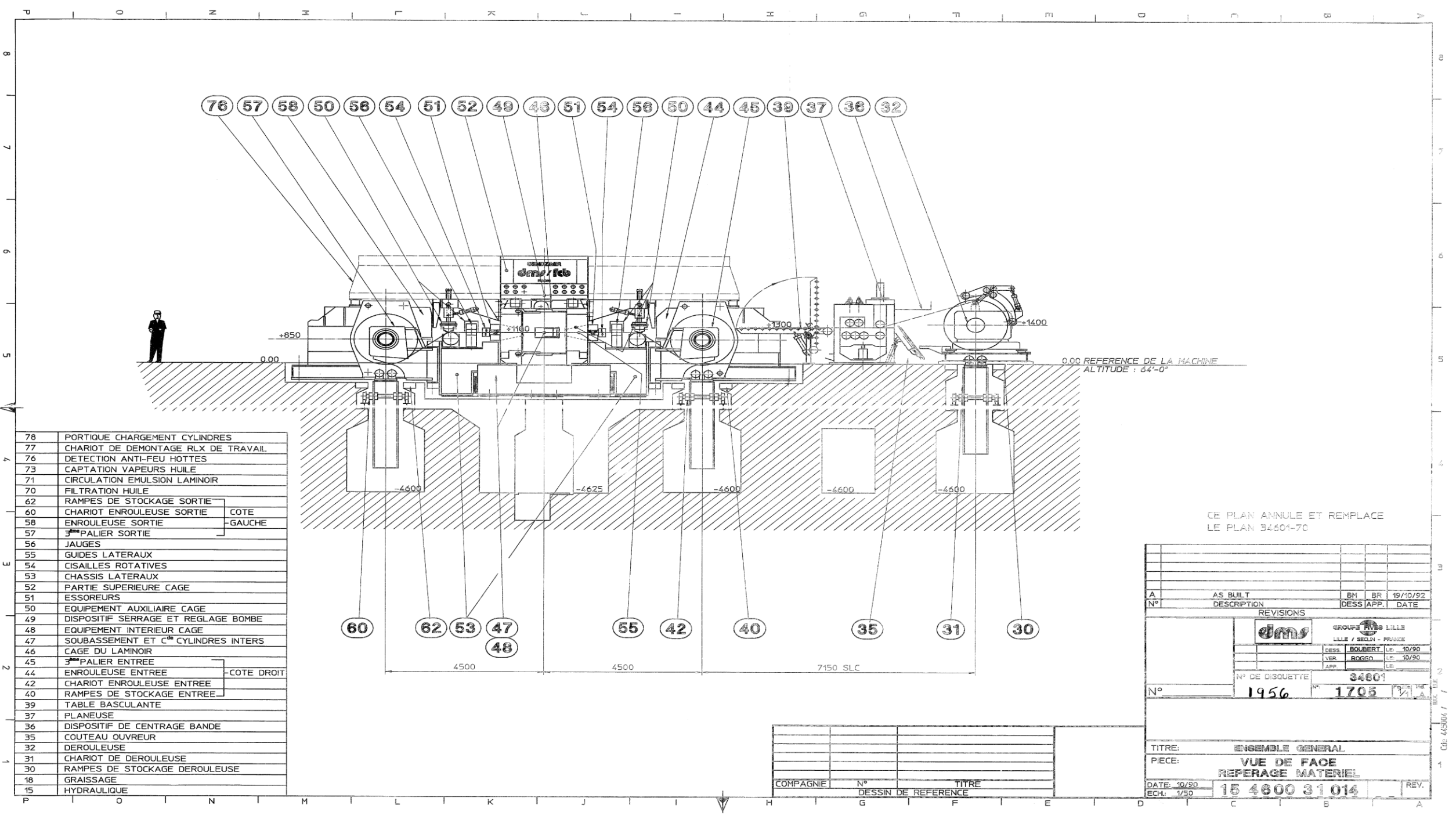
EXHAUST SYSTEMS AND DUCT WORK



MILL MOTOR ROOM




PANORAMIC VIEW OF MILL




78	PORTIQUE CHARGEMENT CYLINDRES
77	CHARIOT DE DEMONTAGE RLX DE TRAVAIL
76	DETECTION ANTI-FEU HOTTES
73	CAPTATION VAPEURS HUILE
71	CIRCULATION EMULSION LAMINOIR
70	FILTRATION HUILE
62	RAMPES DE STOCKAGE SORTIE
60	CHARIOT ENROULEUSE SORTIE
58	ENROULEUSE SORTIE
57	3 ^{ème} PALIER SORTIE
56	JAUGES
55	GUIDES LATERAUX
54	CISAILLES ROTATIVES
53	CHASSIS LATERAUX
52	PARTIE SUPERIEURE CAGE
51	ESSOREURS
50	EQUIPEMENT AUXILIAIRE CAGE
49	DISPOSITIF SERRAGE ET REGLAGE BOMBE
48	EQUIPEMENT INTERIEUR CAGE
47	SOUBASSEMENT ET C ^{de} CYLINDRES INTERS
46	CAGE DU LAMINOIR
45	3 ^{ème} PALIER ENTREE
44	ENROULEUSE ENTREE
42	CHARIOT ENROULEUSE ENTREE
40	RAMPES DE STOCKAGE ENTREE
39	TABLE BASCULANTE
37	PLANEUSE
36	DISPOSITIF DE CENTRAGE BANDE
35	COUPEAU OUVEREUR
32	DEROULEUSE
31	CHARIOT DE DEROULEUSE
30	RAMPES DE STOCKAGE DEROULEUSE
18	GRAISSAGE
15	HYDRAULIQUE

CE PLAN ANNULE ET REMPLACE
LE PLAN 34601-70

AS BUILT		BM	BR	19/10/92
N°	DESCRIPTION	DESS	APP.	DATE
REVISIONS				
 GRUPE FMS LILLE LILLE / SECLIN - FRANCE				
DESS	BOUBERT	LE	10/90	
VER	ROGO	LE	10/90	
APP.		LE		
N° DE DISQUETTE		34601		
N°	1956	N°	1705	
TITRE: ENSEMBLE GENERAL PIECE: VUE DE FACE REPERAGE MATERIEL				
DATE: 10/90	15 4600 31 014			REV.
ECH: 1/50				

COMPAGNIE	N°	TITRE
		DESSIN DE REFERENCE



B	AS BUILT	BH	BR	28/10/92					
A	Mise à jour position crâniotomique de serrage 606,690 posée à 605,8 à position initiale des différents cylindres	JB		06.12.90					
N°	DESCRIPTION	DESS APP.	DATE						
REVISIONS									
		GRUPPO FIVES LILLE LILLE / SECLIN - FRANCE							
		DESS	MODIFICATION	L/E 10/90					
		VER	APPROBATION	L/E 30/90					
		APP	RONDO	L/E 30/90					
N° DE DISQUETTE		34601							
NZ-	/	N°	0 0 9	(révisé) fol. 1/2 B					
TITRE: ENSEMBLE CYLINDRES									
PIECE: POSITION AVEO SERRAGE OUVERT MAXIMUM									
DATE:	10/90								
ECH:	2/5	15 807 31 001							
				REV.					