

**ZAPPA SLITTING LINE
FULLY REFURBISHED
Euro 750,000.00**

1. ZAPPA slitting line:



**2. Technical specifications:
ZAPPA SLITTING LINE**

MAX. COIL WEIGHT.....	28 TON
MAX. COIL WIDTH.....	1500mm
MIN. COIL WIDTH.....	600mm
COIL I.D.....	400mm to 850mm
COIL O.D.....	2200mm
MAX. SLIT WIDTH.....	540mm
MIN. SLIT WIDTH.....	68mm
MAX. THICKNESS.....	8.0mm
MIN. THICKNESS.....	1.5mm
CUTTING KNIVES DIAMETER.....	450mm
CUTTING KNIVES I.D.....	260mm
LINE DIRECTION.....	LEFT TO RIGHT
LINE SPEED.....	0 to 30 M/MIN 7 CUTS OF 8mm 0 to 45 M/MIN 14 CUTS OF 6mm 0 to 60 M/MIN 17 CUTS OF 4mm 0-100 M/MIN 29 CUTS OF 2mm 0-50 M/MIN FROM 4 to 8mm MAX 0-100 M/MIN FROM 1.5 to 4mm MAX

3.ZAPPA SLITTING LINE COMPLETING MACHINES:

3.1. DOUBLE CONE UNCOILER.....



HYDRAULIC OPERATION

Function

AUTOMATIC ALIGNMENT – every unit moves horizontally (left/right) by independent cylinder in the process of coils loading. During the process of coil rewinding, the decoiler machine supports the coil with same both cylinders.



AIR BRAKE

Function

It controls tension of coil according to speed of working line.

COIL CAR



Function

Coil car allows coil loading at the line entry of the decoiler

Composition

Car: Moving on wheels and driven by a hydraulic cylinder.

Cradle: Coil supporting structure provided with vertical motion by a hydraulic cylinder up to conical mandrels height.

3.2. INTRODUCTION UNIT



SNUBBER ARM

Function

It presses the coil during packing strips breaking process; it allows introduction into the line during the first turn of the coil.

Composition

Two rubber rolls - motorized by a hydraulic motor gear.

Arm is supporting the rubber roll and is moving up/down by two hydraulic cylinders



INTRODUCTION TABLE

Function

To carry the strip from the decoiler to the introduction pinch-roll.

Composition and technical data

Introduction table: motion and extension obtained by hydraulic cylinders;

Strip-breaking wedge, built by hardened material, installed at the beginning of the table.

Introduction pressing roll

Function

It ensures strip pressing during feeding up the coil strip to the slitting head.

It moves up/down by two hydraulic cylinders.

3.3. STRAIGHTENER WITH CROP SHEAR



STRIP CENTERING UNIT

Function

To centre the strip longitudinally, to introduce the material into the unit.

Centering of the strip is controlled by photo-optical system.



STRIP STRAIGHTENING MACHINE

Function

To straighten the beginning of the strip.

Composition and technical data

Introduction pinch and straightening rolls, moved by the 32kW DC motor – reducer.

ENTRY CROP SHEAR GUILLOTINE

Function

To cut the beginning of the strip.

Composition

Hydraulic motion.

Manual correction of blades' gap.

Hardened blades made by special steel.

3.4. SLITTER'S HEAD CENTERING UNIT



Function

To centre the strip longitudinally, to introduce the material into the SLITTER'S HEAD.

Composition

Entry and exit hardened shafts for strip fixing and supporting. Fixing power is changed by the hydro cylinders and an el. motor-reducer.

8 hardened rolls (4 for each side) moved by hydro-cylinders.

3.5. SLITTER HEAD.....



Diameter of shafts - 260 [mm]
Max blades diameter – 450 [mm]

Function

To cut longitudinally the raw coil strip in strips with different width.

Composition and technical data

Cutting head: To cut the material.

The slitter's head consists of 2 pairs of shafts. Each pair is positioned to working (nonworking) place by a manual rotating around the main axis.

Blades penetration obtained by upper shaft supporting unit (one independent for each pair), which is moving vertically by an el. motor-reducer.

Pair of mechanical nuts for axial locking of cutting equipment (blades) for each shaft.

The non working pair of shafts is supported by an additional head. Every position is controlled by a hydraulic cylinder.

DRIVE:

The working pair is rotating by a movable head and 105 kW DC Motor.

3.6. TRANSLATING TABLE.....



Function

To separate the lateral scrap strips from main strips and to lead them to a special underground pit.

3.7. LATERAL SRCAP REWINDER



Function

To rewind the scrap produced by slitting into bundles.

Composition and technical data

Base fixed to the foundation at a suitable height.

Coiling group composed by:

A. Coiling cone controlled by A.C. motor.

B. Structure moving by a hydraulic cylinder forward/backward.

Hardened pressure roller to obtain a more compact coiling of bundles.

Bundle ejection roll controlled by a hydraulic cylinder.

Max dimensions of bundles \varnothing 800x800 [mm].



3.8. RECOIL



3.8.1. Strips translating table

Function

To translate trips to the recoiler.

Composition

Table driven by pneumatic cylinders is moving left/right on wheels, and toward/backward.



3.8.2.Recoiler

Function

To rewind strips keeping a constant pull, in order to obtain compact coils.

Composition and technical data

Base: Welded plate structure, fixed to the floor, suitable to carry the following groups.

Mandrel

Expanded mandrel with strips locking: for strips locking (by hydraulic control) and rewinding them in coils.

Clamp control and expansion obtained by a hydraulic cylinder.

The mandrel has a third support unit. The supporting arm of this unit is moving up/down by a hydro-cylinder and toward/backward the mandrel by a hydro-motor.

Motorization:

Rotation obtained by 95kW DC motor.

Gear train inside to the machine structure.

Pneumatic stationary brake.

Separators:

Allow strips positioning during introduction phase.

Separators-holder arm movable by a hydraulic cylinder. It keeps the strips separated during rewinding.

The Separators-holder arm has an additional supporting part positioned on the third support unit..

Ejector: To eject coils from the clamp.

Ejection plate driven by a hydraulic cylinder.



3.9. UNLOADING STRIPS CAR



Function

To unload rewind coils from the recoiler mandrel.

Composition and technical data

Car: Moving on wheels and driven by a hydraulic cylinder.

Cradle: Coil supporting structure provided with vertical motion up to mandrel height by a hydraulic cylinder.

Levers for side containment coils with manual insertion.

3.10. TWO ARMS TURNSTILE



Technical data

Max capacity on each arm - 28.000[kg]

Arm length About – 1.500[mm]

Function

It receives coils coming out from the recoiler mandrel.

Composition

Base fixed on the floor

Arms rotate by a hydraulic gear motor and they stop and fix at 180°.