

Rolling mill equipment and rolling mill rolls. Coiling devices



Peculiarities and advantages:

- reliable grip of the strip with carryover pinch rolls, forming rolls and drum at the speeds up to 12,5 m/s.
- reliable contact of the strip with the drum, pretightening time is reduced by 70%.
- coiling of the coils with minimal telescoping (not more than 20 mm).
- coiling of the coils with minimal gaps between the coil laps (coiling degree not less than 0,98).
- coiling of the coils with minimal damages of the strip surface.
- efficient cooling of the coils and coiler assemblies.
- accurate and stable positioning of mechanisms, keeping adjusted gaps, speed and energy-and-force parameters.
- minimal dynamic loads
- reliability and long service life of basic coiler assemblies.
- user-friendly maintenance and repair.

Specification

Parameter	Rolling mill	
	2000-mm mill	2500-mm mill
Strip thickness, mm	1,2...20	1,2...25
Strip width, mm	700...1850	1000...2350
Coil outer diameter, mm	up to 2300	up to 2100
Coil inner diameter, mm	850	
Coil weight, t	up to 45	up to 40
Strip tightening, kN	up to 25	up to 60
Strip coiling speed, m/s	up to 23	up to 17
Strip feed speed, m/s	0,5...12,5	
Coiled strip temperature, °C	500...850	
Strip yield point at 500 °C, MPa	up to 500	

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COILER WITH WRAPPING MACHINE



Specification

Parameter		Rolling mill
		KUMZ 2840-mm aluminium hot rolling mill
Strip thickness, mm	Soft alloys, mm	2,5...18
	Hard alloys, mm	2,5...14
Strip width, mm		800...2600
Coil outer diameter, mm		1000... 1900
Coil inner diameter, mm		615
Coil weight, t		up to 12
Strip tightening, kN		19...190
Strip coiling speed, m/s		up to 5,5
Strip feed speed, m/s		up to 1,5
Coiled strip temperature, °C		320...420

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COIL-BOX

“Coil-box” system is an intermediate hot-rolled strip recoiling device providing coiling of strip sheets 45-mm thick, coming from roughing stands, into intermediate coils and further feed of strip sheets into finishing mill train simultaneously with uncoiling of intermediate coil.



Specification

Parameter	Rolling mill
	Magnitogorsk SP, 2500-mm hot rolling mill
Grades of processed material:	Low- and high alloyed steels, high-strength low-alloyed steels, pipe steel X70, X80
Thickness of strip sheets, mm	22...45
Width of transferred strip, mm	1000... 2350
Temperature of transferred strip, °C	850-1150
Max. coil weight, t	45
Max. coil outer diameter at coil-box, mm	2000
Coil-box feed speed, m/s	2,0-4,0
Regular coiling speed, m/s	2,5-4,0
Uncoiling speed, m/s	0,28...2,5