

## Rolling mill equipment and rolls. Sheet-cutting shears

### TWING TRIMMERS

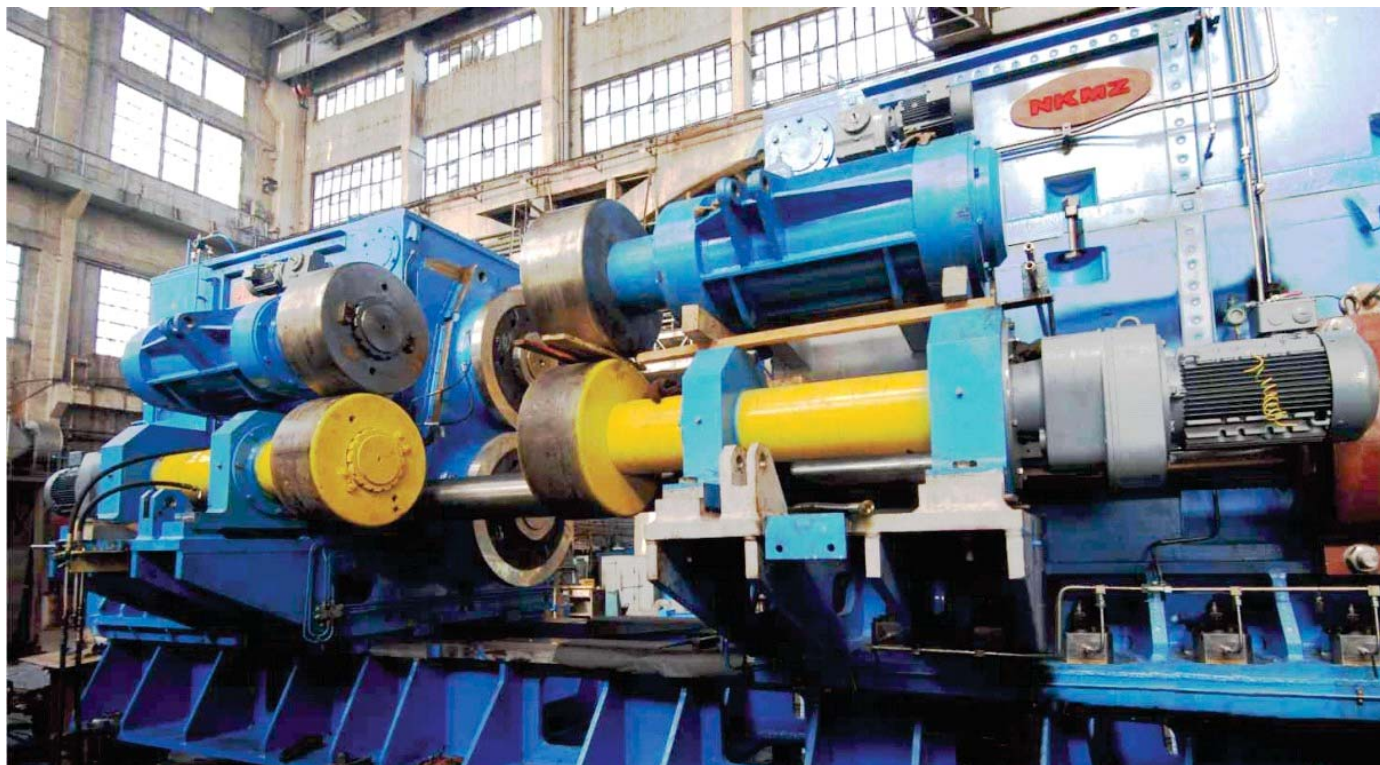


#### Specification

Company	“Severstal”, TJIC 5000 plate mill	“AMZ”, Asha, TJIC 2800 plate mill
Application	Rolled sheet trimming	
Type	Stationary	
Drive	Electromechanical	
Plate width after cutting, mm	1500...4600	1400..2600
Cut plate specification: - plate thickness, mm - plate length, m - plate width prior to cutting, mm - max. length of plate, kg	10...50 8...30 up to 1600...4800 35000	5...50 6..28 up to 2800 12500
Tensile strength: - width up to 40 mm, MPa - width up to 50 mm, MPa	1200	1000
No. of cuts per minute, cut/min	16...24	
Cutting force, MN	7,3	6,1

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ROTARY TRIMMERS



Specification

Company	MZ “Staleva Volia”, TJC 2300 plate mill	KUMZ, 2840-mm hot rolling mill
Application	Sheet trimming	
Type	Rotary	
Drive	Electromechanical	
Trimmed plate specification: - material	Steel	Aluminum
Plate thickness, mm: - in cold condition - in hot condition	8...25 26...40 (t=700...750 °C)	- 2,5...12 (t=350...420 °C)
Sheet width, mm: - prior to cutting - after cutting	800...2150 700..2000	900...2600 800...2500
Trimmed edge width (max.), mm	150	20...50
Trimming speed (feed), m/s	0,2	5,5 (1,5)
Rotary blades diameter, mm	1000...920	595...650
Cutting force, MN	0,865	0,21

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ROTARY TRIMMERS WITH CHOPPERS



Specification

Company	“MMK” Magnitogorsk, AIP 5...25x2350
Application	Sheet (strip) trimming with edge chopping
Type	Rotary
Drive	Electromechanical
Trimmed strip specification: - strip thickness, mm - strip width after trimming, mm - strip material tensile strength, MPa - min. width of trimmed edge, mm	5...25 1000...2350 1000 1-2 of thickness
Edge trimming mechanism: - blade diameter, mm - trimming speed, m/sec - trimming force, MN	1000...920 0,2...0,6 1,3
Chopper: - Cutting force, MN - No. of blades on one drum, шт. - max. length of scrap after chopping, mm	0,9 4 544

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### MULTIBLADE SHEARS



#### Specification

Company	“ETZ”, Engelsk, АИП №3
Application	slitting strip to candy
Type	Multiblade
Drive	Electromechanical
Strip material: - tensile strength, MPa - yield point, MPa - elongation, %	Carbon and low-alloyed steel 280...500 180...400 30...10
Strip thickness, mm	1...4
Initial width of strip, mm	700...1550
Rotary blade diameter, mm	350...320
Cutting force (on the drive), MN	0,2
Max. no. of cuts at the initial width, mm: - at the thickness of 1...1,5 mm, pcs. - at the thickness 2 mm, pcs. - at the thickness 2,5 mm, pcs. - at the thickness 2,8 mm, pcs. - at the thickness 3 mm, pcs. - at the thickness 3,2 mm, pcs. - at the thickness 3,5 mm, pcs. - at the thickness 4 mm, pcs.	1550 30 26 22 20 18 16 12 8
Strip slitting speed, m/sec	0,5 (constant)
Slitting program change	by changing cutting units

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MULTIBLADE SHEARS



Specification

Company	“ArcelorMittal Temirtau”, Temirtau, AIIpP No.5
Application	slitting strip to candy
Type	Multiblade
Drive	Electromechanical
Strip material: - tensile strength, MPa - elongation, %	Carbon and low-alloyed steel 500 10...25
Strip thickness, mm	1,5...6
Initial width of strip, mm	700...1550
Rotary blade diameter, mm	360...406
Cutting force, MN	0,2
Max. no. of strips: - at the thickness up to 2mm, pcs. - at the thickness up to 3 mm, pcs. - at the thickness up to 5 mm, pcs. - at the thickness up to 6 mm, pcs.	10 9 6 4
Slitting speed (feed), m/s	0,2 (2,5)
Slitting program change	by changing cutting units