

## Braner/Loopco Completes RSDC Project

Schiller Park, IL. – January 26, 1999 – Braner/Loopco is pleased to announce the completion of a large coil slitting and slit coil packaging project at “Regional Steel Distribution Center of Michigan, LLC” (RSDC), in Holt, MI. RSDC is a gigantic 625,000 square foot greenfield coil processing center, a joint venture between Itochu International Trading Co., NY, NY, and Kasle Steel Corp., Detroit, constructed just outside of Detroit, MI. RSDC will supply six General Motors stamping plants with 1.2 million tons of processed steel sheet annually. It is reported that the RSDC “megacenter” is the largest automotive sheet processing plant ever built in North America.



90,000# x 84" wide x .135"/.010" x 1200 FPM Double Loop "Turret Head" Slitting Line

RSDC processes its coils on two (2) Slitting Lines; a 90,000# x 77" x .135"/.010" x 1,200 FPM Double Loop "Turret Head" Slitting Line, and a 90,000# x 84" x .135"/.010" X 1,200 FPM Double Loop "Turret Head" Slitting Line. Both lines are capable of processing light gauge bare cold rolled steel, pre-painted, and deep draw surface critical hot dipped class 1 exposed automotive sheet coils. An Automatic Slit Coil Packaging Line capable of separat-

ing, downlaying, strapping, and palletizing 20,000# x 24" wide x 84" O.D. slit coils handles the output from the two (2) Turret Slitting Lines. Braner/Loopco designed, manufactured, and installed the two Slitting Lines and the Packaging Line at RSDC on a "turn-key" basis.



90,000# x 77" wide x .135"/.010" x 1200 FPM Double Loop "Turret Head" Slitting Line

Both the 77" and the 84" Turret Slitting Lines are specifically designed to process the fragile deep draw automotive coils without strip surface damage. Braner/Loopco's patented non-marking "Duplex" Roll Tension Stands with DC drag generator brakes and 800 line horsepower provide the tension to recoil slippery pre-lubricated slit material into straight sided 84" O.D. coils. An Inspection Station with special lighting allows RSDC to monitor and inspect the surface of the coils during slitting, assuring RSDC's customers that the coils produced from the two lines are free of surface defects. Understanding that even the best prime coils may have certain shape defects such as "center buckle" and "wavy edge", both Slitting Lines are equipped with Braner/Loopco's patented microprocessor



controlled "Cluster Levelers". The Cluster Levelers are capable of correcting strip shape defects, removing cross bow, and de-burring slit strips at line speeds to 1,200 FPM. Because of the concern for surface condition, both Cluster Levelers are equipped with 6-high intermediate back-ups, and chrome plated work rolls. The concern for the coil surface condition was so great that both lines are completely covered by special transparent overhead canopies so that any debris from the overhead cranes cannot fall onto the strip. An unusual request that was successfully accommodated by Braner/Loopco.

Because of the huge light gauge tonnage required by RSDC's customers, slitter running efficiency is of paramount importance. Both lines are equipped with features designed for fast coil loading, fast threading, fast Slitter head changes, fast Tension Roll changes, fast Tensioner strip separator changes, fast Overarm Separator tooling changes, and fast Recoiler drum diameter changes. Running time is enhanced with Braner/Loopco's patented quick-change "Turret Head" Slitters. Both the 77" and 84" lines are equipped with three (3) head Turret Slitters capable of effecting slitter head changes in 2 minutes. Lubricated and dry coils require different Tension Rolls, and exchanging Tension Rolls for each product can be a time consuming process. Patented "Duplex" Roll Tension Units with "crane-free" 60 second roll exchange time are included in both lines. Tension Stand and Overarm Separator strip separators must be changed for each order, another time consuming task. Separator tooling change is accomplished in 2 minutes via Braner/Loopco's unique speed load tooling sleeve and set-up fixture design.

RSDC's customers require both 20" and 24" I.D. slit coils. Changing Recoiler drum "filler plates" is a huge waste of running time, often taking 15-20 minutes to install, and 15-20 minutes to remove. The 77" and 84" Recoilers are equipped with Braner/Loopco's new "Magnetic Speed Load Filler Sleeves"

that change from 20" to 24" I.D., and vice-versa, in 60 seconds. No bolts, no crane. Scrap threading and disposal also wastes valuable running time, so both lines are equipped with Braner/Loopco "Helical Cutter" Rotary Scrap Choppers and scrap conveyors. In order to cut coil threading time, both the 77" and the 84" Slitting Lines were designed and built as "high pass line" lines. As opposed to "low pass line" slitting lines, high pass line slitting lines allow much faster threading because the coil is never "reverse bent" during threading from the Uncoiler to the Entry Unit, or from the Exit Unit to the Recoiler. The high pass line also reduces the chance of inducing "coil breaks" during unwinding and rewinding.



*20,000# x 24" wide x 84" O.D. Automatic Slit Coil Packaging Line*

Three (3) Four Arm Horns provide coil storage for a dozen coils after the two slitting lines. An "operatorless" Programmable Downender automatically retrieves slit coils from the Transfer Horn, and downlays the coils onto the Packaging Line conveyor. A Semi-Automatic Coiltech Strapping Machine applies radial bands to the slit coils, and an Automatic ID/OD Coil Stacker automatically stacks the coils onto shipping pallets. An eight station color coded Turntable allows for coil sorting by size and customer.



**Engineering Excellence**

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