

# NEWS RELEASE

## Randall Metals Installs Ultra-Precision Light-Gauge Slitter

Salisbury, NC – Randall Metals Corporation, a multi-facility flat rolled metal service center specializing in the processing and distribution of precise-tolerance cold rolled, pre-painted, galvanized, tinsplate, and long terne sheet and coil, has installed an Ultra-Precision High-Speed Single-Loop Turret Head™ Slitting Line in its expanded Salisbury, NC facility.

The new slitting line manufactured by Braner/Loopco, Schiller Park, IL, is designed to process 45,000# x 62" wide coils in gauges from .006" through .075" at slitting speeds to 1,200 FPM. The slitting line handles 16" and 20" ID x 72" OD master coils and produces slit coils with 16" and 20" IDs with coil ODs to 72".



*Ultra-Precision Single-Loop Turret Head™ Slitting Line*

**High Pass Line:** The new Randall Metals slitting line employs the high pass line slitting line arrangement, a technological advancement over the older floor level slitting lines. In comparison with floor level slitting lines, high pass line slitters offer faster coil threading, improved coil tracking, and improved slit coil side-wall registration while occupying significantly less floor space. The Uncoiler and Recoiler are installed at floor level while all equipment between is elevated to match the largest coil OD. This concept eliminates reverse bending of the strip against the natural coil-set as the coil is processed, and because the strip is never reverse bent strip threading is quick and coil-breaks generated

from reverse strip bending is eliminated. Product quality is improved with the elimination of deflector/pass line roll induced strip surface scuffing and scratching because all deflector rolls are positioned below the strip, not above, therefore deflector/pass line rolls never contact the top of the strip.

**Ultra-Precision Turret Head™ Slitter:** The Braner/Loopco exclusive Turret Head™ Slitter is equipped with three (3) quick-change *ultra-precision* slitter heads that allows Randall Metals to consistently produce close-tolerance light-gauge slit coil. The unique Turret Head™ design features unobstructed access to the slitter arbors, which makes tooling loading and unloading easier and faster. Re-tooled slitter heads can be exchanged in less than 2-minutes. The Turret Slitter is powered by a 125 HP-DC drive that allows full loop slitting of all gauges from .006" through .075".



*Ultra-Precision Triple Turret Head™ Slitter*

**Pushbutton Tooling Lock-Up:** The Randall Metals slitter is equipped with a feature that locks the tooling onto the slitter arbors with pushbutton activated hydraulic locking bars rather than threaded lock nuts. The Pushbutton Tooling Lock-Up feature reduces re-tooling time by eliminating the time-consuming task of loading and threading lock nuts onto the arbors. In addition, thread maintenance, broken grease fittings, and sloppy grease guns are completely eliminated.



*Pushbutton Hydraulic Tooling Lock Bars*

**Exit Unit:** In order to produce tightly wound straight side wall coils, the Randall Metals slitting line is equipped with two tensioning devices: a Pneumatic Pad Tensioner, and a non-marking Roll Tensioner. The Pad Tensioner is utilized for processing non-critical surface coil, while the Roll Tensioner is employed for processing surface critical materials such as pre-painted and coated coil. The strip tensioning devices can be engaged separately or in tandem, depending upon the materials being processed. A Traversing Loop-Doubler that forms two free loops in the looping pit reduces the chances of light gauge strips dragging on the bottom of the pit. The Loop Doubler also acts as an efficient threading device by transporting slit strips across the looping pit from the slitter to the tensioning devices. A guillotine shear is mounted after the tensioning devices to speed the task of breaking coil ODs, and the Overarm Separator that guides the slit strips onto the Recoiler is mounted onto the Exit Unit for rigidity.



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*Slitting Line Exit End*

**Recoiler:** A 200 HP Recoiler rewinds the slit coils onto a hardened hydraulic rewind drum. The base drum is sized to produce 16" ID coils. 20" ID coils can be produced when a patented "Speed-Load" Sleeve is loaded onto the base drum. The quick mounting and dismounting ability of the Speed-Load Sleeve allows Randall Metals to change coil IDs from 16" to 20" and vice-versa in a matter of a few minutes.

**Coil Unloading:** Finished slit coils are unloaded from the Recoiler by a floor level Coil Car. A unique feature of the Coil Car is its power rotating "V" saddle, which gives Randall Metals the ability to package slit coils in both clockwise or counter-clockwise winding directions without additional coil handling.



*Rotating "V" Saddle Exit Car*



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