

NEWS RELEASE

Mi-Tech Steel Installs 72” Surface Inspection/Slitting Line

Madison, MS – Mi-Tech Steel has installed a state-of-the-art “Double-Loop” surface inspection/slitting line in its Madison, MS coil processing facility near Jackson, MS. The line is designed to process 60,000# x 74” wide exposed automotive quality cold rolled and coated coil in gauges from .015” through .125” at processing speeds to 1,000 FPM. Coils can be unwound from top or bottom in either pull-off or “loop” modes, surface inspected top side and bottom side, side trimmed or slit, and rewound either from the top or bottom with a Top/Bottom Belt Wrapper attaching the strip to the Recoiler mandrel.



Double-Loop Inspection/Slitting Line

Coil Staging & Loading: Master coils are staged ahead of the line on non-marking Storage Saddles. A unique Coil Car retrieves, transports, and loads the coils onto the Uncoiler. Driven “blocker rolls” on the Car rotate the coil for convenient OD band removal prior to loading while an electronic scale records the coil weight. Imperfect inside coil wraps are cropped off the coil and rewound back onto the Uncoiler. The Coil Car quickly removes the ID pup coils from the Uncoiler drum and unloads the scrapped material onto a storage ramp while traveling to retrieve the next master coil.



Entry Car Unloading Pup Coil ID Wraps

Uncoiling: The Mi-Tech Uncoiler operates in a “pull-off” tight strip mode and a “free-loop” mode, and is capable of top unwinding and bottom unwinding depending upon the coil processing job. A 250 HP-DC motor provides the forward “loop-control” power for the free-loop operation, and provides enormous back tension during a tight-line pull-off operation. A floor mounted Outboard Support eliminates shaft deflection and vibration in all operating modes.



250 HP-DC Loop-Control/Drag Generator Uncoiler

Pushbutton Tooling Lock-Up Turret Head Slitter™: Side trimming and precision multi-cut slitting is accomplished by a quick-change 150 HP x 9.000” Turret Head™ Slitter with 3-heads. Slitter re-tooling time is reduced with a pushbutton hydraulic tooling lock-up system that locks shimless slitter tooling onto the arbors without threaded lock nuts or grease guns. The slitter can be operated in a driven loop mode for multi-cut slitting or drive-assist mode for side-trimming.



3 Head Turret Head™ Slitter w/Pushbutton Tooling Lock-Up

Surface Inspection: A unique Surface Inspection Tower provides the means for Mi-Tech to visually inspect the top side and the bottom side of the strip as the coil is processed. High-intensity fluorescent lamps and electronic strobe lamps provide the lighting for top and bot-

tom surface inspection. Large diameter non-marking bridle rolls installed in a hydraulic elevating tower raises the strip pass line so that the top and bottom of the strip can be inspected while the strip is moving vertically. The tower rolls are lowered during strip threading and slitting, and elevated while performing surface inspection.



Top & Bottom Surface Inspection Tower

Strip Tensioning: Multi-cut rewind tension is generated from a Pneumatic Pad Tension Stand and a Non-Marking Roll Tension Stand. Either or both strip tensioning means can be employed depending upon the job being performed. The strip tensioning equipment is capable of processing both dry and oiled-lubricated strip.

Recoiling: The Mi-Tech Recoiler is capable of over rewinding and under rewinding at 1,000 FPM. A 300 HP-DC drive provides rewind tension. In order to assure perfect side-wall registration while rewinding full width coils, the Recoiler is equipped with a hydraulic shifting base and an automatic edge tracking system. A floor mounted Outboard Support eliminates shaft deflection



Automatic Tracking Recoiler with Over and Under Rewind Capability

and vibration in all operating modes. The collapsible Recoiler drum is equipped with 2" thick forged clamshell segments heat-treated to Rc58 for wear resistance. A 3" diameter hydraulic gripper bar secures slit strips in the drum. Slit coils are guided onto the Recoiler drum via a quick-change Overarm Separator with a side-adjust feature.

Automatic Belt Wrapper: Coils can be attached to the Recoiler drum via the hydraulic gripper bar or the Automatic Belt Wrapper. The Belt Wrapper surrounds the Recoiler drum with a non-marking belt that tightly wraps the strip around the drum while the Recoiler is winding the coil. The Belt Wrapper withdraws as soon as the strip is secured to the drum. The Belt Wrapper is capable of wrapping the strip for over winding or under winding.



Automatic Belt Wrapper

Coil Unloading: Finished coils are unloaded from the Recoiler via Coil Car. The Car is equipped with a power pivot "V" saddle that unloads pup coils and winding sleeves onto a collection ramp. Finished coil weights are recorded by an integral electronic scale.



Unloading Exposed Automotive Quality Coil After Surface Inspection



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