

NEWS RELEASE

Ratner Steel Installs 1/4" x 72" Turret Head™ Slitting & Slit Coil Packaging Line

Roseville, MN – Ratner Steel Supply Company, a carbon steel coil and sheet distributor and coil processor has installed a Braner/Loopco Single-Loop Turret Head™ Coil Slitting and Slit Coil Packaging Line in Roseville, MN, a suburb just north of Minneapolis-St. Paul. The new Slitting Line is capable of processing 60,000# x 72" wide hot rolled black, pickled, cold rolled, and galvanized coils in gauges from .024" through 1/4" at line speeds to 1,000 FPM. The Slitting Line is equipped with Entry and Exit 4-Arms, Entry and Exit Crop Shears, a 150 HP Turret Head™ Slitter with two quick-change 9" heads, a unique "Loop-Control" Tension Stand that reduces looping pit depth requirements, and a 250 HP x two-ratio Recoiler. The Packaging Line is capable of quickly and efficiently strapping and packaging 1" to 24" wide slit coils weighing up to 10,000#.



60,000# x 72" x 1/4" Single Loop Turret Head™ Slitting Line

Compact Design: Although the Ratner Steel Slitting Line is well equipped and is designed to process 60,000# x 1/4" x 72" coils, the line is less than 45' long. The compact design reduces floor space requirements, allows for extremely fast coil threading, improves personnel safety and productivity by positioning all line components from entry end to exit end within the operator's sight lines, and makes delicate cameras and hard to view TV screens unnecessary. The compact Slitting Line employs the modern "hi-pass line" equipment arrangement wherein the strip processing equipment is elevated above the coil OD to eliminate "reverse-bending" as the strip is processed. Compact hi-pass line benefits include faster coil threading, elimination of equipment-induced coil-breaks, elimination of entry and exit pass line roll damage to the strip surface, straighter sidewall coils, and productivity unmatched by any other slitting line arrangement.



Strip runs over the Pass Line Roll to prevent surface marking. Lightweight "Red" Fillers handle 28"-32" ID master coils

Turret Head Slitter™ A 9" arbor x 150 HP two (2) head quick-change Turret Head™ Slitter produces precise width tolerance slit strips with minimum burr throughout the entire gauge range. The Slitter arbors are supported in precision machine tool bearings mounted in massive one-piece stress-relieved and precision ground solid steel block arbor bearing housings that weigh nearly a ton apiece. The rotatable Turret housing is supported on a 300,000# capacity anti-friction bearing, and the hydraulic cylinder positioned outboard arbor bearing housing is supported on zero-maintenance precision anti-friction machine tool slides. Huge aluminum-bronze slides contain the vertically adjustable upper arbor bearing boxes and allow "zero" axial arbor movement. The upper arbor bearing boxes are positioned by motorized anti-backlash screw jacks equipped with electronic encoder digital position readouts for quick and precise positioning. The unique Turret Head™ Slitter allows re-tooling and head changes to be accomplished faster than with any other slitter design.



Completely exposed and accessible arbors minimize tooling time. Heads are exchanged in less than 2 minutes.

Loop Control Tensioner: Slit coil tensioning is accomplished by a unique Loop Control Tensioner that allows the line operator to adjust the depth that individual slit strips hang into the looping pit. The Loop Control Tensioner allows lighter gauge large OD coils to be processed with a shallower looping pit than usual. The Loop Control Tensioner is capable of generating appropriate strip tension for processing light to heavy gauge slit coil.

Exit End Equipment: The Overarm Separator is firmly attached to the Exit Unit to eliminate Overarm deflection and resulting misalignment that can cause coil side-wall scuffing and oscillation. A unique side-adjust is incorporated to compensate for Overarm tooling set-up errors. A Hydraulic Feed Table acts in concert with an Overarm mounted deflector plate to form a threading "funnel" that guides slit strips directly from the Exit Pass Line Roll into the Recoiler gripper bar. A unique Recoiler drum is constructed from special hollow forged 2" thick segments heat-treated to Rc 58. A 3" diameter solid steel gripper bar grips the slit strips against a heat-treated serrated steel anvil. The



1/4" x 72" Hi-Pass Line Exit End Equipment



Overarm Separator with "swing-out" quick change tooling arbor. The heat-treated tooling sleeve is quickly removed and exchanged with a pre-tooled Overarm sleeve.



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Recoiler includes a massive single-unit parallel shaft helical gear reducer with a huge 14" diameter main shaft.

Slit Coil Packaging: 1" wide to 24" wide x 10,000# slit coils are quickly and efficiently sorted and packaged for shipment by a Semi-Automatic Slit Coil Packaging Line. Individual slit coils are removed from the 4-Arm Exit Horn by a "Programmable Operatorless Downender" that automatically travels to a coil group, lifts one-coil off the arm, returns to the Conveyor line, and deposits the coil onto the Conveyor. The Downender control can be programmed with up to 40-individual slit coil quantities and widths. Radial coil strapping is quickly accomplished by a Coiltech semi-automatic Strapping Machine equipped with an electronic load cell scale for individual coil weights.



Fully automatic operatorless Programmable Slit Coil Downender.



Coiltech Semi-Automatic Strapping Machine and automatically controlled Power Conveyor feed the stacking equipment.

Heavy mill-duty construction, bullet-proof reliability, experience from building more than 560-lines, and superb technical support made Ratner Steel's selection of a Braner/Loopco Slitting and Slit Coil Packaging Line a "no-brainer".



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