

NEWS RELEASE

Fortacero Installs 1/4" Cassette Leveler/Servo Feed CTL Line

Monterrey, MX – Fortacero SA de CV, a large flat rolled steel distributor and coil processor has installed a Braner/Loopco Cassette Leveler Servo-Feed Cut-to-Length Line in its Monterrey Mexico flagship facility. The new CTL line is capable of processing 75" wide x 80,000 PSI yield strength hot rolled black & pickled and cold rolled carbon steel coil in gauges from .024" through 1/4". The line processes from 20" to 75" wide weighing up to 25-tons and produces panel flat sheets in lengths to 20'. The new Cassette Leveler CTL line is Fortacero's second Braner/Loopco CTL line, joining a 75" x .024" to 3/8" Cassette Leveler-Servo Feed line operating in Fortacero's Mexico City facility.



1/4" x 75" Hi-Strength Cassette Leveler-Servo Feed CTL Line

Entry Station: A telescoping blade Peeler, hydraulic Pinch Rolls, and pushbutton positioned Side Guides thread the coil into the Entry Shear where the coil lead-end is cropped and squared-off. A Scrap cart collects the sheared head end scrap. A laser aids master coil positioning on the Uncoiler while a hydraulic servo non-contact Edge Control automatically maintains coil edge alignment while running.



Entry Station Aligns, Threads, and Crops the Lead End of the Coil

Cassette Leveler: A massive 4-post "Cassette" type corrective Leveler equipped with two (2) interchangeable Cassettes delivers panel-flat sheets throughout the entire .024" - .250" gauge range. A 1.625" x 4-Hi Cassette processes gauges from .024" through .100". A 3.500" x 4-Hi Cassette is employed to process hi-strength gauges from .075" through .250". Cassettes are exchanged via pushbutton in about 2-minutes. Benefits of the Cassette Leveler include a wide gauge and product range, simplified work roll, back-up, and universal shaft maintenance, and improved "up-time" because Cassette cleaning & maintenance is accomplished while the Leveler operates with another Cassette.



Massive 4-Post Cassette Leveler Running w/ 1.625" Cassette

Hydraulic Leveler Roll Positioning: The Fortacero Leveler employs hydraulic cylinders rather than mechanical screws and sliding wedges associated with older technology Levelers to position its work rolls. Hydraulic cylinders mounted in the 4-post Leveler frame mate with the entry and exit ends of each Cassette back-up flight. All hydraulic cylinders employ precision electronic linear transducers to sense the position of the cylinder rod. Work rolls are tilted front-to-back to eliminate coil-set by adjusting the entry and exit cylinder elevations. Adjusting cylinder elevations across the width of the Leveler accomplishes "work roll bending" for center-buckle and wavy-edge shape correction. Independent back-up flight adjustments front-to-back as well as side-to-side allows the hydraulic leveler to perform more precise shape correction vis-à-vis older mechanical leveler technology.

Automatic Leveler Control: The hydraulic Cassette Leveler employs an industrial duty PLC for automatic entry & exit roll gap and roll bend calculations and adjustments. The hydraulic back-up cylinders are automatically positioned to establish entry and exit roll gaps based upon gauge and yield strength data input. Edge wave and/or center-buckle shape correction is accomplished by menu or operator command. Leveler settings can be committed to the PLC memory for future recall, a valuable time and material saving feature when processing partial coil orders. An "automatic calibrate" feature allows the Cassette Leveler to be quickly calibrated in a few minutes without having to dismantle the Leveler.



Cassette Leveler w/ Small Cassette Produces Panel-Flat Product

Cassette Injector/Maintenance Opener: Cassettes are installed and removed from the 4-post Leveler frame by a 2-Cassette Power Cassette Injector in about 2-minutes. The Injector indexes from side-to-side to align the 3.500" or the 1.625" Cassette with the Leveler frame. A hydraulic Cassette "Opener" opens the Cassettes like a book for access to the working parts. Cleaning & servicing rolls, back-ups, and universals outside the Leveler frame saves time and energy. All back-up adjusting cylinders are easily accessible when the Cassette is removed from the frame.



Cassette Injector/Maintenance Opener w/ 3.500" Cassette

Hi-Production Precision Electronic Servo Feed: Fortacero's CTL line is equipped with a precision AC Servo Feed that produces precise cut lengths at cyclic rates significantly higher than a reciprocating mechanical feeder. High traction non-marking feed rolls driven by an AC servomotor feeds the strip forward while a precision electronic encoder continuously reads the feed roll position. The servo controller uses the electronic encoder signal for accelerate, decelerate, stop, and cut commands. When the feed roll comes to a full stop, the controller sends a signal for the shear to cut. When the shear cuts through the material, the feed rolls are commanded to "back-off" a few thousandths away from the upper blade as it moves up. The back-off feature eliminates upper shear blade "scuffing" the lead edge of the strip. A Servo Feed's cyclic rate capability is much higher than a reciprocating mechanical feeder because reciprocating feeders slide forward and backward, making the overall cycle time twice the feed forward time. Servo Roll Feeds lose no time traveling backwards and are therefore more productive. In addition to



High Cyclic Rate Precision Servo Feed



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high production and accuracy, Servo Roll Feeds offer quick keypad length and batch count set-up, adjustable acceleration, low maintenance cost (few moving parts), and low operating cost.

Hi-Speed Hydraulic Shear: The Hi-Speed Shear capable of 60-strokes/minute is ideal for producing pattern length sheets. The PLC controlled Shear employs hydraulic cylinders to power the upper guillotine ram through its cycle. 4-edge blades are mounted on the guillotine ram and the lower blade holder. Blade clearance is adjustable for processing the entire .024" to .250" gauge range. Benefits of the Hydraulic Shear include low maintenance costs and a virtually silent shearing cycle.



Low Maintenance & Silent Operation Hi-Speed Hydraulic Shear

Automatic Sheet Stacker: Fortacero's Stacker is a "Flipper" type drop stacker capable of generating "solid-block" sheet packs from 20" to 75" wide up to 20' long. Sheet packs can be built up 24" high and weighing up to 50,000#, the master coil capacity. A hydraulic Stack Table raises the sheet pack to an elevation just below the lower shear blade to minimize sheet drop after shearing. Non-marking rollers support the sheet to a position above the sheet pack. Pneumatic "Flippers" release the sheet onto the sheet pack. Power positioned side skirts contain the sheet pack sides while a pushbutton end stop squares the package ends. An end discharge power roller conveyor conveys finished sheet packs from the stacker onto a runout/storage conveyor.



Panel Flat Solid Block Sheet Packs Discharged from the Stacker



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