

NEWS RELEASE

Wheatland Tube Installs 80,000# x 72" x 3/8" Hi-Strength Slitter

Warren, OH – Wheatland Tube Company, a leading manufacturer of welded steel pipe and tubular products, has installed an enormous Braner/Loopco Single-Loop Turret Head™ Coil Slitting Line in its Warren, OH manufacturing facility. The new Slitting Line is capable of processing 80,000# x 72" wide x 100,000 PSI yield strength hot rolled, pickled, galvanized, and stainless steel coils in gauges from .065" through 3/8" at line speeds to 600 FPM. The Slitting Line is equipped with Entry and Exit coil storage equipment, Twin Expanding Stub Uncoiler, Entry Coil Straightener & Shear, a Turret Head™ Slitter with two quick-change 12" slitter heads, Scrap Choppers, heavy-gauge strip tensioning equipment, a 2-ratio Recoiler, and 1,000 HP for processing heavy-gauge hi-strength coils.



80,000# x 72" x 3/8" Single-Loop Turret Head™ Slitting Line. Notice Crop Shear & Chopper conveyors deliver scrap to outdoor scrap boxes.

Unique Entry Coil Staging & Loading: Four 80,000# x 72" wide x 84" OD coils are staged ahead of the Slitting Line on a 4-Coil Turntable that supports the coils from the coil OD. The Turntable allows quick and easy coil loading and coil selection. A Rotary Deck Coil Car retrieves coils from the Turntable, rotates coils 90-degrees, and loads coils onto the Twin Expanding Stub Uncoiler. The equipment is arranged to permit coils to be crane loaded onto or unloaded from the Coil Car.



Coil Storage Turntable w/ Rotary Deck Coil Car services the Twin Stub Uncoiler

Entry End: The Wheatland Uncoiler handles .065" to 3/8" gauge coils from 20" wide through 72" wide with coil IDs from 24" through 34" on a pair of opposed expanding Uncoiler drums. Both Uncoiler drums are equipped with drag brakes and reversing jog drives. A huge free-standing Hold-Down assists threading hi-strength coil. A quick-open powered Straightener removes head end coil-set and the tail end coil "hook" for fast threading and safe tail-out. A Laser Edge Guide combined with hydraulic cylinder positioned Roller Side Guides assure coil alignment with the Slitter. A hydraulic Guillotine Shear crops-off hot band coil heads and tails. A power Tail Feed Roll ejects sheared head and tail scrap into a powered Scrap Cart that travels away from the Slitting Line and dumps the scrap into a container outside the building.



View of Uncoiler, Hold-Down, Straightener, Guides, & Shear ahead of the Turret Slitter

Turret Head Slitter™: A 12" arbor x 350 HP two (2) head quick-change Turret Head™ Slitter produces precise width tolerance slit strips with minimum burr throughout the entire range of gauges and mechanical properties. The Slitter arbors are mounted in precision machine tool bearings installed in massive one-piece stress-relieved and precision ground solid steel block arbor bearing housings that weigh 2-1/2 tons each. The rotatable inboard Turret housing is supported on a huge anti-friction bearing, and the hydraulic cylinder positioned outboard bearing housing is mounted on zero-maintenance anti-friction precision machine tool slides. Huge aluminum-bronze gibs contain the vertically adjustable upper arbor bearing boxes and allow for "zero" axial arbor movement. The upper arbor bearing boxes



Open and accessible arbors cuts re-tooling time. There are no housings or bases that interfere with re-tooling



12" x 72" Turret Head™ Slitter can exchange heads in less than 2-minutes. Scrap guides are pre-set with the Slitter set-up.

are positioned by motorized anti-backlash screw jacks equipped with electronic encoder digital position readouts for fast and precise positioning. The Turret Head™ Slitter design allows re-tooling and head changes to be accomplished faster than with any other slitter design.

Strip Tensioning: A looping pit and Tensioner guarantee straight-wall tight coils throughout the entire .065" though 3/8" gauge range. An End Lift Pit Table carries the slit strips across the looping pit from the Slitter to the Tensioner. A Hydraulic Tensioner with quick-change pads and separators arbors is utilized to generate coil winding tension in both tight-line and single-loop slitting modes. Quick-change Tensioner pads that slide in and out of the Tensioner like a drawer are cleaned and re-covered off-line. The Tensioner strip separators are positioned for running or off-line set-up in 1-minute without manhandling or crane lifting.



Heavy-Gauge Hydraulic Tensioner with Quick-Change Separator

Exit End Equipment: The Overarm Separator is mounted on a heavy Exit Unit frame for rigidity. Supported from both ends, Overarm deflection and resulting misalignment that causes coil side-wall scuffing and coil oscillation is eliminated. Overarm mounted coil tail hold-downs prevent hi-strength coil tail clock-springing during tail-out and coil OD banding. A Hydraulic Feed Table operates in concert with an Overarm mounted deflector plate to form a threading "funnel" that directs slit strips from the Exit Pass Line Roll into the Recoiler gripper bar. The Recoiler drum is manufactured from 2" thick forged steel segments heat-

treated to Rc 58 for wear resistance. A 3" diameter solid steel gripper bar grips the strips against a heat-treated serrated steel anvil. The Recoiler includes a massive single-unit parallel shaft helical gear reducer with a 14" diameter main shaft with an Outboard Support to eliminate drum deflection.



Strip Tensioner, Overarm, and Recoiler

Finished slit coils are unloaded from the Recoiler and transported to a 4-Arm Storage Horn by floor level Coil Car. The Coil Car is equipped with a powered Overarm coil stabilizer to support narrow slit coils during unloading, and a wireless radio pushbutton control that permits an operator to maintain a safe distance from the Car and coil while operating.



Coil Unloading Car with Power Overarm Stabilizer and Wireless Controls



80,000# x 72" x 3/8" Slitting Line Exit End View

Heavy mill-duty construction, know-how derived from 560+ Slitting Lines, *bullet-proof* reliability, and outstanding technical support make Braner/Loopco Slitting Lines a "no-brainer" choice.



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