

# NEWS RELEASE

## Independence Tube Installs 98,000# x 5/8" Hi-Strength Slitter

Decatur, AL - Independence Tube Corporation, a leading manufacturer of square and rectangular structural steel tubular products with manufacturing plants in Chicago, IL, and Marseilles, IL, has installed a huge Braner/Loopco Turret Head™ Coil Slitting Line in its new 300,000+ square feet structural tube manufacturing facility on the banks of the Tennessee River in Decatur, AL. The new Slitting Line processes 98,000# x 72" wide hi-strength hot rolled black and pickled & oiled steel coils in gauges from .112" through 5/8". The new Braner/Loopco Slitting Line is designed to generate enormous slit coil tonnage to feed Independence Tube's structural tube mills. The new Decatur, AL 5/8" Slitting Line is Independence Tube's second hi-tonnage heavy-gauge Braner/Loopco Slitting Line.



98,000# x 72" x 5/8" Hi-Tonnage Turret Head™ Slitting Line.

**Coil Loading & Payoff:** A wireless control Floor-Level Coil Car receives master coils weighing up to 98,000# and transports and loads the coil onto a Twin Housing Cone Uncoiler. The Uncoiler handles .112" through 5/8" gauge coils from 29" wide through 72" wide. Coil IDs can range from 24" through 34". The coil is supported on a pair of opposed heat-treated cones that support the coil from both ends. The Cone Uncoiler is ideal for efficiently handling large hot rolled steel coils as it can



DC Motor Cone Uncoiler and Free-Standing Coil Hold-Down

handle 24"-34" coil ID range with no adjustments or ID "filler" plates. The Twin Housing Uncoiler shifts laterally for quick alignment with the Slitter centerline. Each Uncoiler housing is equipped with 100 HP DC motor tension braking and reversing jog drive. A huge free-standing Coil Hold-Down straddles the Coil Loading Car and assists threading hi-strength coil. The Coil Hold-Down Roll shifts laterally with the Uncoiler to allow coil alignment while the roll presses on the coil OD.

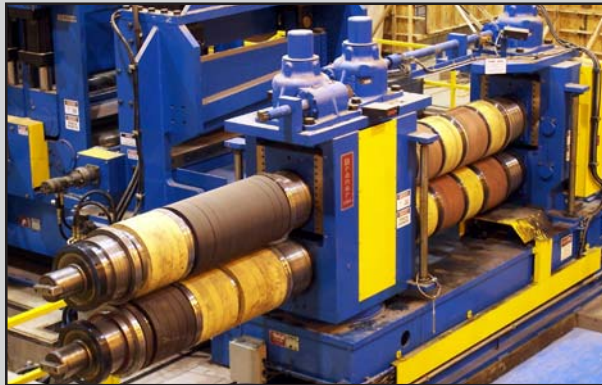
**Entry Section:** Threading hi-strength heavy-gauge coil requires enormous power, synchronization, and agility. The Cone Uncoiler and Hold-Down combine to drive the coil head end to a Telescoping Blade Peeler that strips the outer wrap from the coil. The Peeler directs the head end into hydraulic Pinch Rolls and through a set of Roller Side Guides that aligns the strip along the Slitter centerline. The heavy-gauge Side Guides are equipped with quick-removal heat-treated tool steel guide rolls powered by hydraulic cylinders for strip alignment. A quick-open powered 5-roll Straightener removes head end coil-set and feeds the strip into the Crop Shear. The Straightener is also employed to remove the tail hook on the coil tail end to prevent equipment damage during coil tail-out. An infrared Edge Guide combined with second set of hydraulic cylinder powered Roller Side Guides assures precise coil alignment and guiding. A hydraulic Guillotine Shear crops off and squares coil heads and tails. Sheared coil tails are ejected into a powered Scrap Cart that travels away from the Slitting Line and dumps the scrap into a scrap container.



Slitting Line Entry Section

**Turret Head Slitter™:** A massive 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 nearly 3-tons each. The rotatable inboard Turret housing is supported on a huge anti-fric-

tion bearing that provides rigidity and precise slitter head alignment. The solid one-piece outboard arbor bearing housing is mounted on zero-maintenance precision anti-friction machine tool slides and is opened and closed by hydraulic cylinder. Huge aluminum-bronze slides guide the vertically adjustable upper arbor bearing boxes and provide for "zero" axial arbor movement. The upper arbor bearing boxes are vertically positioned by motorized anti-backlash screw jacks equipped with electronic encoder digital position readouts for fast and precise set-up. The unique unobstructed Turret Head™ Slitter head design permits heavy slitter tooling set-ups to be made quicker and easier than with any other Slitter head design. Re-tooled slitter head changeover can be accomplished in less than 2-minutes.



Massive Turret Head™ Slitter Sets-Up and Changes Heads Quickly

**Scrap Handling:** Like Independence Tube's Marseilles, IL Braner/Loopco Slitting Line, the new Decatur line employs a pair of Hydraulic Scrap Winders rather than Scrap Choppers to handle and dispose of edge trim scrap. The Scrap Winders are arranged to make heavy-gauge edge trim threading fast and easy. Edge trim is guided into the Winders through wide-open hydraulic oscillators, and the scrap is wound onto tapered cones. Variable winding tension is controlled from the main opera-



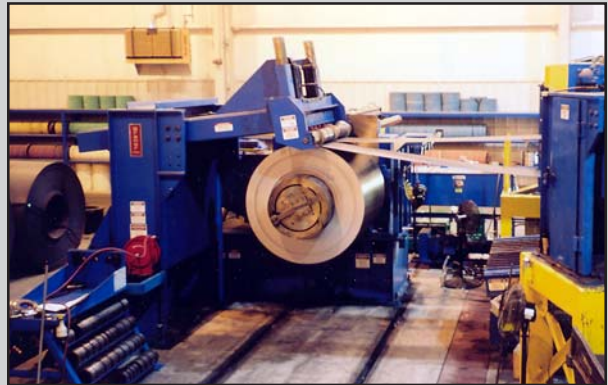
Heavy-Duty Scrap Winders Provide Excellent Performance and Exceptional Reliability



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tor console. Finished scrap bundles are pushbutton unloaded into a scrap container. Compared with a Scrap Chopper, a Scrap Winder has no special cutter tooling, no synchronized DC motors and controls, no scrap chutes, and no scrap conveyor. The absence of maintenance intensive components results in *bullet-proof reliability* and minimal down-time. Properly designed scrap winding systems are exceptionally reliable, are easy to maintain, and offer excellent operating efficiency.

**Exit End:** 98,000# x 5/8" coils are rewound to a 30" ID x 84" OD on a massive 2-ratio parallel shaft helical gear operational and safety feature. Slit strips are directed into the Recoiler gripper by a Telescoping Hydraulic Feed Table.



Recoiler w/ Overarm and Tail Hold-Down

A Floor Level Coil Car efficiently unloads and transports slit coils away from the Recoiler. A wireless radio pushbutton control allows the operator to maintain a safe distance from the Car and coil while operating.



Coil Unloading Car with Wireless Controls

*Proven performance, excellent technical support, and bullet-proof reliability* made Independence Tube's selection of a Braner/Loopco slitter for their new Decatur plant a "no-brainer".



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