

NEWS RELEASE

Hascall Steel Installs 60,000# x 72" x 1/4" Slitter with Shape Correction Leveler

Grandville, MI – Hascall Steel Company, a multi-facility full service flat rolled steel service center headquartered in Grandville, MI has installed a new high-production Single-Loop *Turret Head™* Slitting & Packaging Line with a shape correction *Cluster Leveler™* in its 150,000 square foot flagship Grandville, MI facility. The new Slitting/Shape Correction Slitting Line is Hascall Steel's third Braner/Loopco *Turret Head™* Slitting Line. The new line has the capacity to slit and shape correct 60,000# x 72" wide hot rolled black, pickled, cold rolled and galvanized carbon steel coils in gauges from .015" through 1/4" at processing speeds to 1,000 FPM.



60,000# x 72" x 1/4" Single-Loop *Turret Head™* Slitting Line with a *Shape Correction Cluster Leveler™* that corrects edge-wave, center-buckle, and cross-bow strip shape defects.

Compact High Pass Line: Hascall Steel's Slitting Line is a high-performance compact high pass line arrangement that locates the Uncoiler and Recoiler at floor level with the processing section elevated to match the largest coil OD. The design allows the strip to be processed through the line without reverse bending against the natural coil set. High pass line benefits include quick and easy coil threading, elimination of reverse-bend coil-breaks, and elimination of strip surface damage from deflector roll scuffing. The high pass line allows the Uncoiler and Recoiler to be tucked-in close to the Entry and Exit Units, which shortens the overall length of the line. The shorter compact line conserves floor space, speeds coil threading, and provides excellent coil tracking, which results in perfect straight side-wall coils.



The *Compact High Pass Line* design processes coils without bending the strip against the natural coil-set. The Uncoiler is installed tight against the Entry Unit, which minimizes coil threading time and conserves floor space.

Turret Head Slitter™: A 9,000" arbor x 150 HP 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 supported in precision machine tool quality bearings mounted in huge one-piece stress-relieved and precision machined solid steel housings. The rotatable Turret is mounted on a precision anti-friction ring bearing, which assures precise arbor alignment and makes head change effortless. The outboard arbor housing is supported on precision anti-friction machine tool slides and is engaged and disengaged by hydraulic cylinder. Large aluminum-bronze blocks secure the adjustable upper arbor bearing boxes in the arbor housings. Axial arbor movement is "zero". The upper arbor bearing boxes are vertically positioned by motorized anti-backlash screw jacks fitted with electronic encoder digital position read-outs for quick and precise vertical knife clearance adjustment. Compared with "slide-out" injector head slitters, *Turret Head™* Slitters can be set up faster and change heads quicker, and because the multiple heads in a *Turret Head™* Slitter are a non-removable and integral part of the one-piece turret, *Turret Head™* Slitters are more rigid and more precise than "slide-out" injector head slitters.



Turret Head™ Slitters are precise and rugged, and offer bullet-proof reliability. Head change time is less than two-minutes.



Instead of separate "slide-out" slitter heads pushed in and out from a table, *Turret Head™* Slitters have multiple slitter heads built into a one-piece precision "turret" housing, which makes it absolutely precise. Notice the slitter head at the tooling set-up station is open and accessible with no frames, bases, or other obstructions that can delay slitter set-ups. Re-tooling and changing a *Turret Head™* Slitter is easier and faster than with any other slitter design.

Exit End: The Hascall Steel line is equipped with a Pad Tensioner that generates strip tension necessary to produce tight straight-wall slit coils. Tension is adjustable and regulated from the main operator console. Entry strip separator tooling is secured on lightweight aluminum alloy arbors that exchange with pre-tooled

arbors in 60-seconds. Tension Pads are also exchanged in 60-seconds. An Exit Shear squares coil tails and splits coil ODs. The Overarm Separator is firmly attached from both inboard and outboard sides to the Exit Unit frame, which eliminates Overarm frame deflection and resulting misalignment that can cause coil side-wall scuffing and coil oscillation. The Overarm has a "side-adjust" feature that allows the operator to make Overarm alignment adjustments without having to make a new set-up.



The Exit End equipment generates strip tension, crops coil tails, and rigidly supports the Overarm Separator

Cluster Leveler™: A 72" x 4-Hi x 7-flight Precision Cluster Leveler™ allows Hascall Steel to supply its customers with coil free of wavy-edge and center-buckle strip shape defects. The patented Leveler design has multiple roll "clusters" with work roll sizes ranging from 1.500" to 3.000", which allows it to correct strip shape defects throughout the Slitting Line's .015" to .250" gauge range. Seven (7) adjustable back-up flights support the work rolls and provide roll bend ability. Automatic Leveler set-up is accomplished by a PLC controller after the operator enters gauge, yield strength, and defect data into the terminal.



The Cluster Leveler™ is installed between the Tensioner and the Exit Shear. With its seven (7) adjustable back-up flights and work roll bend capability, the Cluster Leveler™ does not depend on tension for shape correction, and therefore will not "neck" the strip and reduce slit width dimensions.

Pushbutton Overarm Tooling Lock-Up: The Overarm Separator swings open to align with a tooling set-up cart where Overarm tooling set-ups are made off-line while the Slitter is running. Tooling is transferred from the Overarm arbor onto the Gatling Gun type set-up cart, and the tooling for the next order is quickly transferred onto the Overarm arbor. Once loaded, the Overarm tooling is locked onto the arbor by pushbutton.



Braner USA, Inc., 9301 W. Bernice St., Schiller Park, IL 60176
Phone (847) 671-6210 Fax: (847) 671-0537
www.braner.com



The Cluster Leveler™ employs its large work roll cluster to shape correct .150" gauge x 50,000 PSI pickled & oiled coil. The Cluster Leveler™ is a unique patented roller leveler designed specifically for coil-to-coil shape correction applications where the range of coil gauge and yield strength parameters far exceed CTL line gauge and strength capacities. Joy stick controls allow the operator to override the PLC automatic set-up and make roll bend adjustments while running.



Specifically designed for coil-to-coil applications, the Cluster Leveler™ employs non-driven work rolls. The hydraulic cylinder "quick-open" feature allows coil threading to be quickly accomplished.



Swing-Open Pushbutton Tooling Lock-Up Overarm Separator and Gatling set-up cart.

Quality, Productivity, Bullet-Proof Reliability, know-how from building nearly 600 Slitting Lines, plus outstanding technical support made Hascall Steel's selection of its third Braner/Loopco Turret Head™ Slitting Line a "no-brainer".



4165 Spartan Industrial Drive
Grandville, MI 49418
Phone: (616) 531-8600
Fax: (616) 531-7555
www.hascallsteel.com