

NEWS RELEASE

California Steel & Tube Installs Turret Head™ Slitting Line

City of Industry, CA – California Steel & Tube, a manufacturer of high-quality welded mechanical tubing for automotive, metal furniture and construction applications, and roll formed sections for metal building components, cabinets, and medical equipment, among others, has installed a high-performance Single-Loop Turret Head™ Slitting Line to generate slit coils for its welded tube mills and roll formers in its City of Industry manufacturing facility. The new slitting line assures California Steel & Tube's ability to deliver high-quality slit coil to its production equipment.

The new California Steel & Tube Slitting Line has the ability to process 40,000# x 60" wide carbon steel coils in gauges ranging from .024" through .135". The line is equipped with Entry & Exit Coil Storage Turnstiles, Entry & Exit Coil Cars, Crop Shear, a quick-change precision Turret Head™ Slitter, quick-change Strip Tensioner, and a Recoiler capable of generating strip tension necessary to produce tight straight-walled coils.



40,000# x 60" x .135"/.024" Single-Loop Turret Head™ Slitting Line at California Steel & Tube

Compact Hi Pass Line Arrangement: The California Steel & Tube Slitting Line is an example of Braner/Loopco's high-performance compact high pass line system that positions the Uncoiler and Recoiler at floor level with the strip processing equipment elevated above the largest coil OD. That arrangement eliminates reverse-bending of the strip against the natural coil-set as the coil is threaded and processed, which results in faster strip threading and the elimination of coil-breaks induced by reverse strip bending. The high pass line arrangement causes the strip to run over all line deflector rolls rather than under, therefore common strip surface scuffing and scratch damage is eliminated. With a compact Uncoiler to Recoiler centerline dimension of 37-feet, California Steel & Tube's slitting line offers quick and efficient coil threading and superb coil tracking and coil side-wall build-up while occupying minimal floor space.



The Compact Hi Pass Line arrangement allows quick threading, elimination of induced coil-breaks, provides superb strip tracking, and reduces the line length to 37-feet.

Entry Coil Prep Station: The Coil Peeler, Pinch Rolls, Automatic Edge Guide, Side Guides, and Crop Shear are installed close to the Uncoiler on a compact common base immediately ahead of the Turret Head™ Slitter. The unique Entry Station design makes heavy and thin gauge coil threading quick and easy while providing excellent coil tracking at high processing speeds. A laser beam master coil alignment and electronic Side Guide position readouts reduce coil set-up and threading time.



Entry Station combines entry coil threading and guiding equipment into a single compact machine that speeds coil threading and improves strip tracking.

Turret Head™ Slitter: A 2-head quick-change Turret Head™ Slitter produces precise tolerance slit strips with minimum burr throughout the entire range of gauges and mechanical properties. Turret Slitter arbors are supported in precision machine tool quality tapered roller bearings installed in massive stress-relieved and precision ground solid steel housings. The rotatable Turret housing is mounted on a high-capacity ring bearing, and the hydraulic cylinder positioned outboard arbor housing travels on zero-maintenance precision machine tool bearing slides. Large aluminum-bronze blocks secure the vertically adjustable

upper arbor bearing boxes and allow “zero” axial arbor movement. Huge upper arbor bearing boxes are vertically positioned by motorized anti-backlash screw jacks with electronic encoder digital position readouts that allow fast and precise vertical knife clearance adjustment. Because the exchangeable Slitter heads are never detached, shuttled, or disassembled, the Turret Head™ design is more rigid and precise than any other multi-head Slitter. In addition, access to the set-up arbors is free and clear with no obstructions so re-tooling for the next order can be accomplished faster than with any other slitter. The Turret Head™ Slitter exchanges heads in less than 2-minutes.



Turret Head™ Slitters are more precise, set up faster, change heads quicker, and occupy less floor space than any other Slitter.

Strip Tensioning: California Steel & Tube’s Slitting Line is equipped with a Tension Stand that generates high strip tension necessary to rewind tight straight-wall slit coils regardless of widths. Strip tension is variable and regulated from the main operator console. Entry strip separator tooling is installed on a lightweight aluminum alloy arbor that can be exchanged with a pre-tooled arbor in 60-seconds to process a new order. Tension Pads are also exchanged in 60-seconds.



Multiple strips are precisely guided from the free-loop into a Tension Stand that generates high strip tension for producing tightly wound straight-wall slit coils.



Overarm frame deflection and misalignment that results in coil side-wall scuffing and coil oscillation is eliminated by rigidly mounting the Overarm onto the Exit Unit housing. A quick-change “swing-out” Overarm arbor allows pre-tooled arbors to be exchanged in 2-minutes when changing to the next order. A Hydraulic Threading Funnel directs slit strips from the Exit Pass Line Roll into the Recoiler gripper bar during threading.



A high-torque 2-ratio Recoiler is equipped with a massive Recoiler drum manufactured from custom forged 2” thick segments hardened to Rc 58. A 3” diameter solid steel gripper bar grips slit strips against a heat-treated serrated steel anvil. The Recoiler drum is installed on the 14” diameter output shaft of a 1.2 service factor parallel shaft helical gear reducer. The result is the production of superb quality slit coils.

Quality. Performance. Bullet-Proof Reliability. know-how from building 600+ Slitting Lines, plus outstanding technical support made California Steel & Tube’s decision to install a Braner/Loopco Turret Head™ Slitting Line over any other a “no-brainer”.



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



16049 Stephens Street., City of Industry, CA 91745
 Phone: (626) 968-5511 Fax: (626) 961-0421
www.californiasteelandtube.com