SOMENOR 76mm (3") HF TUBE MILL

C O M P L E T E L Y R E - M A N U F A C T U R E D

TOOLED

WITH NEW ELECTRICS / TURKSHEADS *****

1) DECOILER

Three-sector mandrel with 'manual' expansion. Air disk-brake for material tensioning and emergency braking.

2) LINE ENTRY EQUIPMENT

--'Manual' cutoff shear

--Twin welding clamps

--MIG welding machine, NOT INCLUDED

The above placed on a single baseframe (to allow removing it during operation).

3) HORIZONTAL STRIP ACCUMULATOR 3600

Strip width: 35mm ÷ 250mm

Material thickness: .8mm ÷ 3mm

Material tensile strength (N./mm2): 500

Air pressure (bar): 6 ÷ 8

Total installed power (kW): 40

Process material: not-alloyed carbon steel

Pinch roll rotation adjustment: pneumatic

4) STRIP ENTRY GUIDE

Four-roll, with coupled rolls two by two. Two saddles for lateral strip guide.

5) FORMING UNITS

6 steel heads; up/downmotion of upper rolls by screw jack and torsion bar. Shaft diameter: 60 mm

3 lateral guides with rotating shafts and “C” supports

6) EDGE GUIDES

With 3 movements: vertical, horizontal, and rotating in resp. to tube axis. Two rolls: the lower roll, fixed; the upper roll adjustable, with guiding-knife regulation (up/down)

7) WELDING CLAMPS

With three horizontal-axis idle rolls to forge the material in the welding area, with all required adjustment possibility

8) OUTSIDE WELD BEAD SCARFING UNIT, WITH 2 TOOLS

Fine adjustment of tools and quick-lifting (simultaneous for both tools) in case of line-stopping. Each tool with vertical and horizontal movement axes perpendicular to tube.
The contrast-base of tools is with two rolls.
At unit entry a "V"-shaped roll with vertical movement is placed, for the guiding of tube

09) COOLING SYSTEM

Cooling (water-tight tank) tunnel, with vertical adjustment for different diameters.

10) SIZING & STRAIGHTENING UNIT

3 heads; upper rolls with up/downmotion by screw jack and torsion bar. Shaft diameter: 60 mm

3 lateral guides with rotating shafts and “C” supports

11) TURKSHEADS NEW

3 turksheads for straightening tube

- complete with spider

With 3 movements: vertical, horizontal, and rotating in resp. to tube axis

12) FLYING CUTOFF SAW

CUTTING HEAD

Motorized disc saw - AC motor, 9 kW with inverter; gearbox

Disc diameter: 350mm

Feed: by adjustable-stroke hydraulic cylinder

SLIDING CAR

Car advance and return motion by servomotor

Pneumatic clamps

The car runs on hardened and ground steel guides; the 4 wheels are adjustable by eccentrics

FIXED MOTORIZED BASEMENT

Servomotor driven

HYDRAULIC UNIT

Cut type: ' slow '

Dia. of cutting disc (mm): 350

Disc thickness (mm): 3

Material tensile strenght max (N/mm2): 500

Tube dia. (mm): 12 to 76

Max tube length (mm): 12000

Max operating speed (m/min): 120

Accuracy at 6000 mm: ±1,5

Max speed of cutting discs, ∅ 350 mm: 280m /min

Motor: AC 9 kW

Head advance: hydraulic

Sliding car drive: by servomotor

Sliding car length (mm.): ca. 3500

Cutting disc cooling: by emulsible fluid

Lubrication: by oil mist

Electric power: (V) 400 / 50 Hz

Air pressure: (bar) 6

13) OFF-LOADER

Mainframe total length ca. 15m (useful: 14m. 14 hardened steel motorized rolls

Tube deceleration system

Discharging to both sides, at choice

14) HF WELDING UNIT [REVAMPED]

150 kW

– option: 200 kW / NEW

15) ELECTRICS NEW

16) <u>TOOLING</u>

ROLL TOOLING FOR:

Ø : 20-21mm / 42-44mm / 60,3mm /
32-35-37mm / 28-30mm / 48-51mm
&
8 ROLL SETS FOR TURKSHEADS
to obtain SQUARE & RECTANGULAR tubes