USED COLD ROLLING MILL (4Hi MILL) FOR SALE
Located in South India

SPECIFICATIONS
Type of Mill 4hi Rev. Cold Rolling Mill
Manufacturer M/S Flat Products Equipments (I) Ltd., Mumbai
Material to be rolled Low Carbon Steel (0.05% to 0.15% Carbon)
Year of Installation Year 1995

Incoming Coil Data
Width 500 mm max. / 250 mm min.
Type Tight Square Wound
Thickness 6 mm up to 400 mm
5 mm up to 450 mm
4 mm for 500 mm
Coil ID 508 mm
Coil OD 1600 mm
Coil Weight 7.0 tons

Out going Coil Data
Thickness 0.6 mm to 3.0 mm
Coil ID 508 mm
Coil OD 1600 mm
Coil Weight 7.0 tons
Other Specifications

Work Rolls  φ215 * φ 202 * 600 mm barrel
Backup Rolls φ 550 * φ 520 * 600 mm barrel
Mill Hand Left to Right
Mill Speed 0 - 130 - 300 mpm
Pay off reel shift ± 75 mm
Roll Loading system Hydraulic from top with moog controle
Roll separating force 360 tons
Roll Force Cylinder Dia. 420 mm φ × 45 mm stroke

Tensions

Pay Off Reel 180 kgs. Max. up to 250 mpm
1500 kgs. Max up to 300 mpm
180 kgs. Min. up to 300 mpm
Tension Reel 7500 kgs. Max. up to 250 mpm
6100 kgs. Max up to 300 mpm
750 kgs. Min. up to 300 mpm

Electricals

D.C. MOTORS

Main Mill Drive 650 kw, 0 - 500 - 1250 rpm 430V
Recoiler Drive 320 kw, 0 - 500 - 1600 rpm 430V (for each coiler)
Pay Off Reel Drive 75 kw, 0 - 500 - 1600 rpm 430V

A.C. MOTORS

<table>
<thead>
<tr>
<th>Item Description</th>
<th>KW</th>
<th>QTY. (NOS)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 Pinch roll cum flattener</td>
<td>11.0</td>
<td>1</td>
</tr>
<tr>
<td>2 L.P. Hydraulic System</td>
<td>22.0</td>
<td>1+1</td>
</tr>
<tr>
<td>3 L.P. Auxiliary Circulating</td>
<td>2.2</td>
<td>1</td>
</tr>
<tr>
<td>4 H.P. Hydraulic Bending/</td>
<td>7.5</td>
<td>1</td>
</tr>
<tr>
<td>Balancing</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5 H.P. Hydraulic Roll Loading</td>
<td>30.0</td>
<td>1+1</td>
</tr>
<tr>
<td>6 H.P. Hydraulic Circulating</td>
<td>2.2</td>
<td>1</td>
</tr>
<tr>
<td>7 Drive Lubricating System</td>
<td>5.5</td>
<td>1+1</td>
</tr>
<tr>
<td>8 Fume Exhaust Blower</td>
<td>15.0</td>
<td>1</td>
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</tbody>
</table>
**Roll Coolent System - With out Tank**

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
<th>Unit</th>
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</thead>
<tbody>
<tr>
<td>Coolant supply pump</td>
<td>30.0</td>
<td>1+1</td>
</tr>
<tr>
<td>Magnetic seperator</td>
<td>0.37</td>
<td>1</td>
</tr>
<tr>
<td>Skimmer Device</td>
<td>0.37</td>
<td>1</td>
</tr>
<tr>
<td>Paper Band Filter</td>
<td>0.37</td>
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</tbody>
</table>

**DC Motors Cooling Fans**

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
<th>Unit</th>
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</thead>
<tbody>
<tr>
<td>ETR</td>
<td>7.5</td>
<td>1</td>
</tr>
<tr>
<td>MILL</td>
<td>11.0</td>
<td>1</td>
</tr>
<tr>
<td>DTR</td>
<td>7.5</td>
<td>1</td>
</tr>
<tr>
<td>POR</td>
<td>3.7</td>
<td>1</td>
</tr>
</tbody>
</table>

**LIST OF EQUIPMENTS**

1. Coil storage saddle & Coil Car at pay off reel
2. Pay off reel with Snubber roll
3. Peeler Unit
4. Pinch roll cum Flattener Unit
5. Carry over table
6. Deflector Roll (Entry & Exit)
7. Crop Shear (Entry & Exit)
8. Thickness measuring gauges (Entry & Exit)
9. Strip Wiper (Entry & Exit)
10. 4Hi reversing Mill stand with rolls, drive roll changing, strip coolant sprays, spindles, Hydraulic roll force cylinders, Pressure board, Side guide etc..
11. Threading Table (Entry & Exit)
12. Tension reel with coil stripper (Entry & Exit)
13. Coil storage saddle & Coil Car (Entry & Exit)

**Auxiliary Systems**

1. Roll Coolant System with out tank
2. Drive Lubrication System
3. Hydraulic System (High & Low pressure system)
4. Fume exhaust system

**Electricals**

1. Electrical Equipment & Control:
   a) DC Motors
   b) DC & AC Drive Controls & Automation
2. Automatic gauge control system
3. Mill Management system with PC AT & 80 Column Dot Matrix Printer.
OTHER INFORMATION

Back up rolls stock 6 Nos (3 pairs)
Back up rolls Bearings 12 Nos (8 Nos brand new)
Back up Bearing Timken HM 259049 DTQO
Work roll Bearing Timken M 224749 DTQO
Work roll stock 20 Nos
Work roll Bearings stock 16 Nos (12 Nos brand new)
Work roll chocks stock 3 sets
Back up roll chocks stock 2 sets
Moog valves 4 Nos (brand new)
Thickness gage make Loral
AGC Available
Mill management Available
ASD Available