

# SHANTHI INTERNATIONAL

19/20, Center Point, Indira Gandhi Road, Jamnagar 361008 (India)  
Phone: +91-288-2556671/2556672/2555867 Fax: +91-288-2554254/2751388  
Email: servoday@sify.com – www.servoday.com  
Subject to Jamnagar Jurisdiction

## OFFER BY E-MAIL

TO:	DEAR CUSTOMER,	FROM:	KIRIT MASURIA [DIRECTOR]
SENDER'S REFERENCE NUMBER:	SI/2437.	DATE:	OCTOBER 25, 2007.
RE:	CTL.	TOTAL NO. OF PAGES INCLUDING COVER:	21 (TWENTY ONE)

## CUT TO LENGTH LINE

Located in Korea with VERY GOOD condition.
Present Condition: Installed.
PRICE: US ON REQUEST (SUBJECT TO AVAILABILITY)
1.0mm ~ 6.4mm t x 1550mm W x 20 Ton x 30 Cuts/ Minute
Made in 2001 and FDS modified in 2006

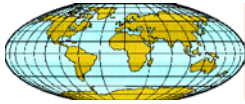
### 1. GENERAL SPECIFICATION

#### 1) MOTHER COIL

- 1 MATERIAL	HOT ROLLED COILS
- 2 TENSILE STRENGTH	45Kg/mm <sup>2</sup>
- 3 SHEARING STRESS	36Kg/mm <sup>2</sup>
- 4 COIL THICKNESS	1.0mm - 6.4mm
- 5 COIL WIDTH	500 - 1550mm
- 6 COIL WEIGHT	20,000Kg
- 7 COIL INSIDE DIA.	Φ508mm, Φ610mm, Φ762mm
- 8 COIL OUTSIDE DIA.	MAX.Φ2, 000mm Min. Φ1, 000mm
- 9 MOTHER COIL TEMPERATURE	NORMAL TEMPERATURE
-10 LINE SPEED	1.0 - 3.2mmT=30m/min 3.3 - 6.4mmT=20m/min

#### 2) PRODUCT SPECIFICATION

- 1 SHEET THICKNESS	1.0mmT - 6.4mmT
- 2 SHEET WIDTH	500mmW - 1,550mmW
- 3 SHEET LENGTH	NO.1PILER = 1,000mm - 6,100mmL
- 4 PILING WEIGHT	NO.1PINER = 7,500Kg
- 5 CUTTING SYSTEM	STOP CUT
- 6 CONTROL SYSTEM	D.D.S CONTROL
- 7 NUMBER OF CUT	Max. 30CUT/Min
- 8 LINE THREADING DIRECTION	FROM LEFT TO RIGHT (VIEW OF OPERATION SIDE)
- 9 PASS LINE HEIGHT	THE FRONT OF SHEAR = FL + 1,100mm THE REAR OF SHEAR = FL + 1,000mm



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- 10 ACCURACY LENGTH	±0.5mm/m (AT UNIFORM VELOCITY) ±0.75mm/m (AT INCREASE & DECREASE VELOCITY)
- 11 DIAGONAL	±0.75mm/m
- 12 HYDRAULIC PRESSURE	MAX. = 140Kg/cm <sup>2</sup> NORMAL = 100Kg/cm <sup>2</sup>
- 13 PNEUMATIC PRESSURE	MAX. = 7Kg/cm <sup>2</sup> Normal 5Kg/cm <sup>2</sup>

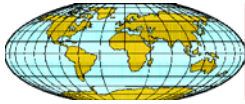
## 2. DETAIL OF LINE ARRANGEMENT

- ENTRY COIL CAR WITH SKID ----	1SET
- UNCOILER -----	1SET
- COIL PEELER-----	1SET
- COIL OPENER -----	1SET
- ROUGH LEVELLER -----	1SET
- CROP SHEAR -----	1SET
- THREADING TABLE WITH SCRAP BOX -----	1SET(OPTION)
- LOOP TABLE -----	1SET
- SIDE GUIDE -----	1SET
- PINCH ROLL -----	1SET
- SIDE TRIMMER -----	1SET
- THREADING TABLE -----	1SET
- SCRAP WINDER -----	2SET
- FINISH LEVELLER WITH PINCH ROLL-----	1SET
- LOOP TABLE -----	1SET
- FEED ROLL UNIT -----	1SET
- FLYING SHEAR -----	1SET
- RUN OUT CONVEYOR -----	1SET
- NO.1 PILER -----	1SET
- NO.1 SHEET CAR -----	2SET
- NO.1 TABLE LIFT -----	2SET
- HYDRAULIC EQUIPMENT -----	1SET
- PNEUMATIC EQUIPMENT -----	1SET
- ELECTRICAL EQUIPMENT -----	1SET

## 3. DETAIL OF TECHNICAL SPECIFICATION

### - ENTRY COIL CAR WITH COIL SKID

TYPE	4-WHEEL LIFT TYPE
CAPACITY	20,000Kg(Max.)
LIFTING	BY HYDRAULIC CYLINDER (Φ200mm × 1000mmST ×1PCE)
LIFTING SPEED	ABOUT 2 m/min
CAR RUNNING	BY AC GEARED MOTOR WITH BRAKE



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RUNNING SPEED	(AC3.7KW-4P) ABOUT 6m/min
LUBRICATION	MANUAL GREASE GUN
MAIN BODY	WELDED STEEL PLATE
ELECTRIC AND HYDRAULIC SUPPLY	CABLEVEYOR TYPE
COIL SKID	1SET

## - UNCOILER

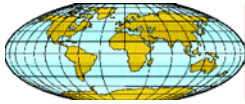
TYPE	MANDREL TYPE
LOADING CAPACITY	20,000Kg(Max.)
DRUM DIA	Φ508mm, Φ610mm, Φ762mm (겸용DRUM)
SURFACE OF DRUM	HARD CHROMITM PLATING FINISH
DRUM EXPANSION	BY HYDRAULIC CYLINDER Φ200mm × 150mmST)
DRUM DRIVE	AC3.7KW 1750rpm MOTOR with brake
MAIN BODY CENTERING	BY HYDRAULIC CYLINDER (Φ140mm × 200mmST × 1PCE)
CENTERING DISTANCE	±100mm
BACK TENSION	HYDRAULIC DISC BRAKE BY AIR CONTROL
MAIN BODY	WELDED STEEL PLATE
MAIN SHAFT	CARBON STEEL FOR MACHINE STRUCTURAL USE
LUBRICATION	MANUAL GREASE GUN

## - COIL PEELER

PEELER ROLL	Φ270mm × 350mmL × 1PCE (HARD URETHANE COATING)
PEELER ROLL UP AND DOWN	HYDRAULIC CYLINDER (Φ120mm × 750mmST × 2PCE)
PEELER ROLL DRIVE	BY GEARED MOTOR OR HYDRAULIC MOTOR (AC 2.2KW × 4P × 1SET)

## - COIL OPENER

TYPE	SWIVEL ARM TYPE
TABLE SWING	BY HYDRAULIC CYLINDER (Φ120mm × 750mmST × 1PCE)
SLIDING	BY HYDRAULIC CYLINDER (Φ80mm × 550mmST × 1PCE)
MAIN BODY	WELDED STEEL PLATE AND SHAPED STEEL
SURFACE OF TABLE	HARD CHROMIUM PLATING FINISH
LUBRICATION	MANUAL GREASE GUN



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## - ROUGH LEVELLER WITH PINCH ROLL

TYPE	5 ROLL LEVELLER
ENTRY PINCH ROLL	Φ200mm × 1,700mmL × 2PCS
	SPECIAL STEEL MATERIAL
WORK ROLL	Φ200mm × 1,700mmL × 2PCS/3PCS
	SPECIAL STEEL MATERIAL
	HEAT TREATED & GROUND
	ROLL TYPE: NON-CASSET TYPE
ROLL DRIVEN	DC MOTOR WITH BRAKE
LEVELLING SPEED	MAX 30M/MIN
<u>WORK ROLL UP/DOWN</u>	
MOTOR	AC 1.5Kw G/M WITH Brake, 2SET
STROKE	100mm (FL-15mm, FL+85mm)
UP/DOWN SPEED	ABOUT 2m/min
INDICATOR OF WORK ROLL	DISC GAUGE
PINCH ROLL UP/DOWN	HYDRAULIC CYLINDER
REDUCER	CAMWALTZ TYPE
LUBRICATION	AC 0.4Kw G/P FOR GEAR BOX
GREASING	MANUAL GREASE PUMP & GREASE GUN

## - CROP SHEAR

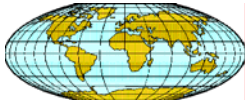
TYPE	DOWN CUT TYPE BY HYDRAULIC CYLINDER
BLADE	20mmT × 1700mmL × 100mmH × 2PCS
	(USED 4EDGE)
UP AND DOWN OF TOP BLADE	BY HYDRAULIC CYLINDER
	(Φ125mm × 280mmST)
MAIN BODY	WELDED STEEL PLATE
LUBRICATION	MANUAL GREASE GUN

## - LOOP TABLE

TYPE	DOUBLE ROLLER TABLE SWING TYPE
SURFACE OF TABLE	HARD CHROMIUM PLATING
SURFACE OF ROLL	HARD URETHANE PLATING
LOOP LENGTH	6,400mmL
TABLE UP AND DOWN	BY HYDRAULIC CYLINDER
	(Φ125mm × 750mmL × 2PCE)

## - SIDE GUIDE

TYPE	VERTICAL ROLL GUIDE TYPE
WIDTH ADJUSTMENT	SCREW BY AC GEARED MOTOR
CENTERING	SCREW BY AC GEARED MOTOR
GUIDE ROLL	Φ150mm × 220mmL × 4PCS



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GUIDE OF WIDTH  
SURFACE OF ROLL  
MAIN BODY

MATERIAL = SUJ-2  
500mm(Min.) - 1,700mm(Max.)  
HARD CHROMIUM PLATING  
WELDED STEEL PLATE

## - PINCH ROLL

TYPE  
ROLL  
SURFACE OF ROLL  
ROLL UP AND DOWN  
  
UP AND DOWN EQUALIZER  
DRIVE  
MAIN BODY  
LUBRICATION

2 ROLL TYPE  
Φ200mm × 2PCS  
HARD URETHANE COATED  
BY PNEUMATIC CYLINDER  
(Φ140mm × 80mmST × 2PCS)  
BY RACK AND PINION GEAR  
BY SIDE TRIMMER  
WELDED STEEL PLATE  
MANUAL GREASE GUN

## - SIDE TRIMMER

TYPE  
MAIN SHAFT  
  
KNIFE  
  
SPACER SIZE  
RUBBER RING SIZE  
LAP ADJUSTMENT  
MAIN DRIVE MOTOR  
WIDTH ADJUSTMENT  
MAIN BODY  
LUBRICATION

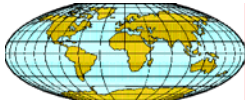
DIRECT PRESSURE TYPE  
Φ220mmDIA × 2PCS  
(SPECIAL STEEL, HEAT TREATED AND GROUND)  
Φ220mm × Φ340mm-Φ300mm × 20mmT  
SKD-11 OR EQUIVALENT  
HEAT TREATED AND GROUND  
Φ220mm × Φ280mm × VAR.Tmm  
Φ280mm × Φ340mm × VAR.Tmm  
SCREW JACK BY GEARED MOTOR  
DC MOTOR  
BY AC GEARED MOTOR  
WELDED STEEL PLATE  
MANUAL GREASE GUN

## - THREADING TABLE

TYPE  
ENTRY TABLE SWING  
  
TABLE LENGTH  
MAIN BODY  
SURFACE OF TABLE  
LUBRICATION

ROLLER TABLE TYPE  
BY PNEUMATIC CYLINDER  
(Φ100mm × 500mmST × 1PCE)  
1,500mmL  
WELDED STEEL PLATE AND SHAPED STEEL  
HARD CHROMIUM PLATING FINISH  
MANUAL GREASE GUN

## - SCRAP WINDER



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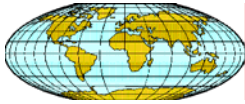
TYPE	TWO DRUM WINDER TYPE
WINDING CAPACITY	1,000Kg (Max.) × 2 SETS
DRIVE MOTOR	VS MOTOR (VS 7.5KW × 4P × 2PCS)
DRUM EXPENSION	HYDRAULIC CYLINDER
MAIN BODY	WELDED STEEL PLATE

## - FINISH LEVELLER WITH PINCH ROLL

TYPE	11 ROLL 4HI LEVELLER
ENTRY PINCH ROLL	Φ200mm × 1,800mmL × 2PCS SPECIAL STEEL MATERIAL
WORK ROLL	Φ90mm × 1,800mmL × 5PCS/6PCS SPECIAL STEEL MATERIAL HEAT TREATED & GROUND ROLL TYPE: NON-CASSET TYPE
BACK UP ROLL	Φ150mm × 3 ARRANGEMENT SPECIAL STEEL MATERIAL HEAT TREATED & GROUND ROLL TYPE: FIXED TYPE
ROLL DRIVEN	DC MOTOR WITH BRAKE
LEVELLING SPEED	MAX 30M/MIN
WORK ROLL UP/DOWN	
MOTOR	AC 3.7Kw G/M WITH Brake, 2SET
STROKE	300mm (FL-15mm, FL+285mm)
UP/DOWN SPEED	ABOUT 2m/min
INDICATOR OF WORK ROLL	DISC GAUGE
PINCH ROLL UP/DOWN	PNEUMATIC CYLINDER
ROLL WIPER	AUTOMATIC TRAVEL TYPE
REDUCER	CAMWALTZ TYPE
LUBRICATION	AC 0.4Kw G/P FOR GEAR BOX WITH OIL FLOW SWITCH
GREASING	MANUAL GREASE PUMP & GREASE GUN

## - LOOP TABLE

TYPE	DOUBLE ROLLER TABLE SWING TYPE
SURFACE OF TABLE	HARD CHROMIUM PLATING
SURFACE OF ROLL	HARD URETHANE PLATING
LOOP LENGTH	6,400mmL
TABLE UP AND DOWN	BY HYDRAULIC CYLINDER (Φ125mm × 750mmL × 2PCE)



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## - FEED ROLL UNIT

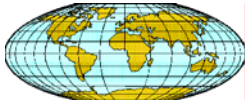
MEASURING ROLL	Φ90mm × 250mmL × 1Pcs(RIGID CHROME COATING)
PRESSURE ROLL	Φ90mm × 250mmL × 1Pcs(RIGID CHROME COATING)
UP AND DOWN	Φ100mm × 50mmST × 2Pcs AIR CYLINDER
LENGTH MEASURING PG	5,000PPR
FEED ROLL	Φ200mm × 1800mmL × 2Pcs
FEED ROLL	PNEUMATIC CYLINDER Φ200mm × 50ST × 2Pcs
FEED ROLL DRIVE	AC SERVO MOTOR

## - FLYING SHEAR

TYPE	DOWN CUT TYPE BY CRANK WITH 4-POST
RAKE	DOUBLE RAKE
RAKE ANGLE	1.5°
KNIFE SIZE	25mmT x 100mmH x 1800mmL x 2PCS
KNIFE MATERIAL	SKD11 (HARDENED & GROUND)
CLEARANCE ADJUSTMENT	SCREW BY MANUAL
KNIFE CHANGE METHOD	MANUAL METHOD
CAPACITY	6.4mmT x 1700mmW
RAW MATERIAL	HOT ROLLED STEEL (T.S 45KG/mm2 AND UNDER)
CRANK RADIUS	50mm
CRANK MATERIAL	SCM440 (HARDENED & GROUND)
OPEN HEIGHT	50mm
CLUTCH/BRAKE	AIR TYPE
DRIVE	75KW
NUMBER OF CUT	30 CUT/MIN
CRANK INDICATOR	ROTARY ENCODER
DIE SET STROKE	550mm
LUBRICATION	GREASE PUMP

## - TRAVELLING SYSTEM

TYPE	RACK & PINION TYPE
LINE SPEED	30 m/min (MAX)
TRAVELLING STROKE	550mm
RACK & PINION UNIT	2 UNIT
RACK MATERIAL	S45C (HARDENED & GROUND)
RACK GUIDE	CAM FLOWER BEARING
GEAR TYPE	HELICAL GEAR
GEAR MATERIAL	SCM440 (HARDENED & GROUND)
REDUCER	PRECISION WORM REDUCER FOR SERVO MOTOR



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REDUCER CAPACITY	75 KW
SERVO MOTOR CAPACITY	22KW (1000 RPM)
COUPLING TYPE	MECHANICAL JOINT
	PRECISION FLEX COUPLING
LUBRICATION	GREASE GUN
MAIN FRAME	STEEL PLATE WELDED

## - RUN OUT CONVEYOR

TYPE	BELT CONVEYOR TYPE
CONVEYOR SIZE	1,600mm × 7,500mmL
DRIVE MOTOR	VS MOTOR (WITH REDUCER)
TILTING CONVEYOR	BY PNEUMATIC CYLINDER
SCRAP CAR	1,600W x 1000L
CAR TRAVELLING	MANUAL TYPE
MAIN BODY	STEEL PLATES WELDED

## - NO.1 PILER

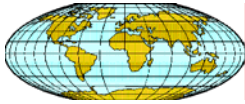
TYPE	FREE DROP TYPE WITH BLOWER
WEIGHT	7,500kg(max.)
HEIGHT OF SHEET	500mm(INCLUDE OF SKID)
WIDTH OF SHEET	450 - 1,600mm
LENGTH OF PILING	NO.1: 1,000 - 6,100mm
ACCURACY OF PILLING	±2.0mm
STANDARD OF PILLING	FRONT PILLING
SIDE GUIDE ADJUSTMENT	AC MOTOR × 2 SETS GEARED MOTOR
INDICATOR OF SIDE GUIDE	SCALE INDICATOR
SIDE STAMPING	PNEUMATIC CYLINDER (φ80mm×15mmST)
END STOPPER ADJUSTMENT	AC 0.75KW GEARED MOTOR WITH BRAKE
INDICATOR OF END STOPPER	SCALE INDICATOR
END CUTION	PNEUMATIC CYLINDER
FRAME	STEEL PLATES WELDED

## - NO.1PILER SHEET CAR

CAR SIZE OF NO1 PILER	1,600mmW ×6000mmL, 1SET
CAR DRIVE	AC0.75KW

## - NO.1, 2PILER TABLE LIFT

LIFTING TYPE	CHAIN LIFT TYPE
LIFTING POWER	7,500KG
TABLE LIFT SIZE	1,600mmW ×2500mmL, 1SET
LIFTING HEIGHT	600mm
LIFTING SPEED	10mm/sec



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## - ELECTRICAL EQUIPMENT

DDS CONTROL PANEL  
DC CONTROL  
AC CONTROL  
MAIN OPERATION  
SUB OPERATION PANEL  
WIRING & PIPING

## - HYDRAULIC EQUIPMENT

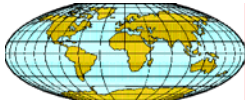
HYDRAULIC UNIT	1 UNIT
DRIVE MOTOR	AC 11kw - 4p
TANK CAPACITY	300L
PUMP	VANE PUMP
MAX PRESSURE	140Kg/cm <sup>2</sup>
HYDRAULIC VALVE	
HYDRAULIC VALVE STAND	
HYDRAULIC PIPING	
HYDRAULIC CONNECTOR & HOSE	

## - PNEUMATIC EQUIPMENT

NORMAL PRESSURE	6Kg/cm <sup>2</sup>
MAX. PRESSURE	7Kg/cm <sup>2</sup>
PNEUMATIC VALVE	
PNEUMATIC CYLINDER	
PNEUMATIC PIPING, CONNECTOR, HOSE	

## 4. MOTOR LIST

UNCOILER	AC3.7KW
ROUGH LEVELLER	DC55KW
SIDE TRIMMER	DC 22KW
SCRAP WINDER	AC 7.5KW×2SET
FINISH LEVELLER	DC 75KW
LEVELLER UP/DOWN	AC 3.7KW ×2SET
FEEDER ROLL UNIT	ACS 15KW
SHEAR DRIVE	AC75KW
SHEAR TRAVELLING	ACS22KW
RUN OUT CONVEYOR	VS5.5KW
PILER SIDE GUIDE (D/S)	AC1.5KW
PILER SIDE GUIDE (O/S)	AC1.5KW
PILER END STOPPER	AC0.75KW ×1SET
PILER CAR	AC0.75KW x 1SET
HYDRAULIC UNIT	AC11KW



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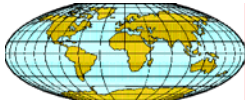
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**TOTAL: ABOUT 350KW**

All technical data are based on supplier's information and therefore without obligation for us. The machines are subject to prior sale; this offer is subject to our General Terms and Conditions.

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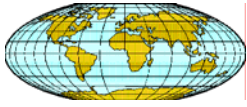




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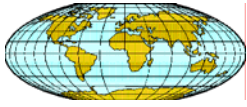




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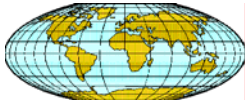




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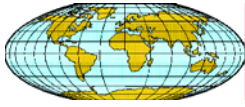




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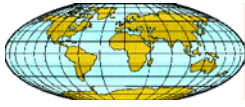




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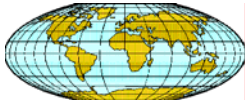




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19/20, Center Point, Indira Gandhi Road, Jamnagar 361008 (India)  
Phone: +91-288-2556671/2556672/2555867 Fax: +91-288-2554254/2751388  
Email: [servoday@sify.com](mailto:servoday@sify.com) - [www.servoday.com](http://www.servoday.com)  
Subject to Jamnagar Jurisdiction

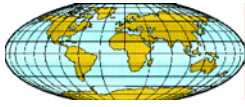




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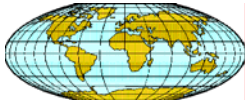




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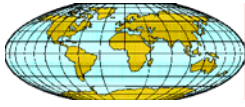




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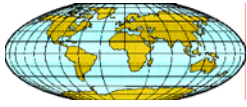




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