

## SHANTHI INTERNATIONAL

19/20, CENTER POINT, INDIRA GANDHI ROAD, JAMNAGAR 361 008 (GUJARAT) INDIA  
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EMAIL: [SERVODAY@SIFY.COM](mailto:SERVODAY@SIFY.COM) WEB: [WWW.SERVODAY.COM](http://WWW.SERVODAY.COM)

### OFFER BY E-MAIL

TO:

**DEAR CUSTOMER,**

FROM:

**KIRIT MASURIA [DIRECTOR]**

SENDER'S REFERENCE NUMBER:

**SI/1504/2636.**

TOTAL NO. OF PAGES INCLUDING COVER:

**13(THIRTEEN)**

## HF WELDED TUBE MILL – DMC KOREAN MAKE

**POWER ON AND VERY GOOD condition.**

**PRICE: PLEASE ASK "AS IS-WHERE IS" (SUBJECT TO AVAILABILITY)**

**DMC KOREAN MAKE H.F. TUBE MILL LINE TUBE DIA 139.8 MM MAX X 1.4-4.5MM THICKNESS.**

This mill is on foundation and power on condition, can be inspected in **SOUTH KOREA**, on prior appointment.

#### Terms:

Payment: 100% by transfer.

Delivery: Immediately.

Dismantling: Dismantling, Loading, Inland Freight, Port charges, Sea Freight, Insurance extra as applicable.

All technical data are based on suppliers information and therefore without obligation for us.

The machines are subject to prior sale; this offer is subject to our General Terms and Conditions.

#### TECHNICAL SPECIFICATIONS:

Pipe O.D : Max.  $\Phi$ 139.8  
Pipe Thickness: Min. 1.4 mm, Max. 4.5 mm  
Pipe Length: Min. 4,400 mm, Max. 8,000 mm  
Tube Mill Line Speed: Max. 15 m/min  
Welder : HF Welder (BSF - 300)  
Pass Line : FL + 850 mm  
Air Pressure : 4 ~ 6 bar  
Electric : 380/220  $\pm$  5 %, 3, 60  $\pm$  2 %

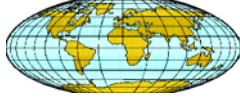
#### COMPOSITION

Single drum uncoiler ----- 1 set  
Hoop cage ----- 1 set  
Forming section ----- 1 set  
Welding section ----- 1 set  
Cooling box & emulsion recycling system ---- 1 set  
Sizing section ----- 1 set  
Cut off machine ----- 1 set  
Run out table ----- 1 set  
Tooling ( Rolls ) 139.8 / 100 x 100, 100 x 50 - 3 sets  
End facing machine / Pockt / Evacon cooler / Air compressor

#### 1. Uncoiler

Type : Single drum style

Coil outer diameter : Max.  $\Phi$ 1800 mm



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Coil inner diameter : MNax.  $\Phi$ 508 mm  
Coil width : Max. 440 mm  
Coil thickness : 1.4 ~ 4.5 mm  
Coil weight : Max. 8,089 kg/DRUM  
Max. uncoiling speed : Max. 40 m/min

Component ;  
Expanded clamping : Single acting Hydraulic cylinder  
Tensioning Brake : Hyd. cylinder, released Drum type brake

### 2. Hoop cage

Strip width : Max. 440 mm  
Pinching speed : Max. 40 m/min

#### Specification :

Pinch roll equipment  
- Pinch roll diameter :  $\Phi$ 230 mm  
- Width of roll : 500 mm  
- Press down : Upper roll single press down by air controlled link lever  
- Motor : AC 7.5kW x 4p x 1/10  
- Brake : AC magnetic disc brake

### 3. FORMING SECTION

Forming section is composed of ; BD1+BDS1+BD2+BDS2+BD3+BDS3+BD4+SC1+  
SC2+FP1+FPS1+FP2+FPS2+FP3+SG

- a) Guide roll ----- 1 set
- b) Side guide roll ----- 2 sets
- c) Leveler ----- 1 set
- d) Forming stand ----- 4 sets
- e) Forming side cluster ----- 5 sets
- f) Fin pass stand ----- 3 sets
- g) Fin pass side cluster ----- 2 sets
- h) Seam guide----- 1 set
- i) Driving gear box ----- 7 sets
- j) D.C motor for forming ----- 1 set

#### a) Guide roll

Upper roll diameter and width :  $\Phi$ 265 X W480 mm

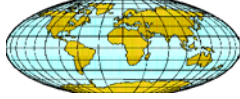
- b) Side guide roll - Roll diameter and height :  $\Phi$ 115 X H125 mm  
Q'ty : 2 sets

#### c) Leveler

No. of rolls : Five (5) rolls - leveler  
Roll diameter :  $\Phi$ 100 mm  
Width of roll : 480 mm  
Roll material : SKD-11(JIS)

#### d) Forming stand

Breakdown section roll : BD1,2,3,4  
Driven roll shaft diameter :  $\Phi$ 80 mm  
Normal roll root diameter :  $\Phi$ 160 mm



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Max. speed of lower roll : Max. 66 rpm

e) Forming cluster

Side roll stand : BDS1, 2, 3 SC1, SC2

Roll shaft diameter :  $\Phi 55$  mm

Roll root diameter :  $\Phi 120$  mm

f) Fin pass stand

Finpas roll stand : FP 1, 2, 3

Roll shaft diameter :  $\Phi 80$  mm

Roll root diameter :  $\Phi 160$  mm

g) Fin pass side cluster

Same as forming side cluster : FPS 1, 2

h) Seam guide

Roll root diameter :  $\Phi 160$  mm

Angle of seam moving : 90 deg

i) Driving gear box

Type : Helical gear type

Gear ratio - Worm gearing : 1/30

- Helical gearing

Forming stand #1 : 1/1.52

Forming stand #2 : 1/2.00

Forming stand #3 : 1/2.35

Forming stand #4 : 1/2.54

Fin pass stand #1~ #4 : 1/1

j) D.C. Motor for forming

Output : D.C. 45 kW (Torque & power constant)

No. of motor : 1 set for forming

Output revolution : Max. 2,000 rpm

Basic lower speed : Min. 650 rpm

#### 4. WELDING SECTION

Welding section is composed of ; SQ+BD+IR

a) Squeeze roll stand ----- 1 set

b) H.F Welder ----- 1 set

c) Bead scarfing unit ----- 2 sets

d) Ironing stand ----- 1 set

e) Scrap winder ----- 1 set

f) C/T Box die ----- 1 set

a) SQUEEZE ROLL

Roll shaft diameter(side roll) :  $\Phi 55$  mm

Roll root diameter :  $\Phi 110$  mm

b) H.F Welder

H.F. output power : 300 kW

Standard supply voltage : AC 380Volt, 3Phase, 60cps

Permissible net oscillation :  $\pm 10\%$

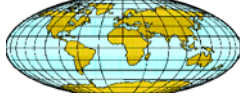
Standby consumption : 10 kW

Standby consumption : Siemens or richardson

Oscillator tube efficiency : 78%

Oscillator nominal frequency :  $350 \pm 10\%$  kHz

Total efficiency : 68% (DIN 48 600)



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Output control : By thyristor phase control range 10 - 100% stepless  
Output stabilization : By thyristor phase control built-in  
Voltage regulator; :  $\pm 1\%$  at net variation  $\pm 10\%$   
Rectifier system : Solid state silicon diode stacks 3ph full wave rectification  
DC wave total flattening :  
Ripple filter : "L" in LV and "C" in HV  
Residual ripple : Less than 1%  
Cooling method : Water to water by stainless steel heat exchanger type

c) Bead scarfing unit

No. of cutting tool unit : 2 unit  
Cutter up/down method : Air cylinder  $\Phi 80 \times 35$ st  
Tip adjusting range : 50 mm

d) Scrap winder

Bobbin diameter : Max. 250 mm  
Expanding method : Air cylinder  $\Phi 63 \times 35$ st  
Driving power : 0.4 kW  
Rpm of bobbin : Max. 60 rpm  
Geared motor ratio : 1/30  
Tensioning device : To  
Power source : AC, 220V, 3Ph, 60Hz

e) Ironing stand

f) CT box die

5. COOLING BOX AND EMULSION RECYCLING SYSTEM

Cooling box length : 3,000 mm  
Emulsion recycle system : 300 Lt/min  
Cooling equip(evapcon) : Water and fan cooling

6. SIZING SECTION

This section is composed of ; SS1+S1+SS2+S2+SS3+S3+SS4+S4+  
MR+TH1+TH2+PO

- a) Sizing stand ----- 4 sets
- b) Sizing side cluster ----- 4 sets
- c) Turks head ----- 2 sets
- d) Pull out stand ----- 1 set
- e) Measuring roll ----- 1 set
- f) Driving gear box ----- 4 sets
- g) D.C. motor for sizing---- 1 set

a) Sizing stand

Roll shaft diameter :  $\Phi 80$  mm  
Roll root diameter :  $\Phi 160$  mm

b) Sizing side cluster

Same as forming side cluster

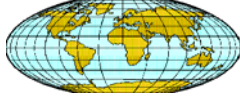
c) Turks head

Roll shaft diameter :  $\Phi 35$  mm  
Turning range of roll holder :  $360^\circ$  deg

d) Pull out stand

e) Measuring roll

Roll root diameter :  $\Phi 127.324$  mm



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Pulse per revolution : 5000 pulse

Hysterisis : 0.08 mm

Linear length of revolution : 400 mm

Pushing type : Air cylinder  $\Phi$ 40x30st

Touching pressure : 3.5 bar

Touching force : 44 kg

f) Driving gear box

Type : Helical gear type

Gear ratio - Worm gearing : 1/30

- Helical gearing

Sizing stand #1 - #4 : 1/1

g) D.C. Motor for forming ]

Output : D.C. 45 kW(Torque & power constant)

No. of motor 1 set for sizing

Output revolution : Max. 2,000 rpm

Basic lower speed : Min. 650 rpm

7. Flying cutter

Type : Flying friction saw type

Cutter travelling length : Approx. 4,000 mm

Travelling device - Type : AC Servo motor

Cut-off device - Saw :  $\Phi$ 700 X 4.5t Friction saw

- Saw motor power : A.C. 55kW X 2Pole

- Tolerance of cutting length :  $\pm$ 1.0 mm

8. Runout table

Type : roll conveyor

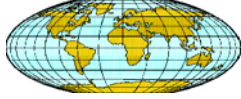
Feeding speed : 50 m/min

Motor power : 2.2 kW

Dump : kick by the air cylinder

Table length :8,500mm

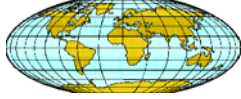
SCROLL TO NEXT PAGE FOR PICTURES.....



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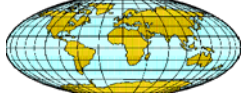




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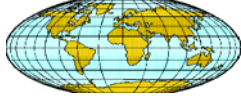




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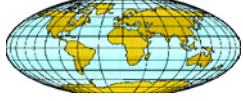




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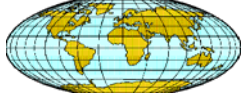




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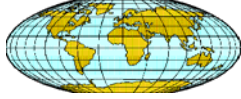




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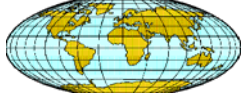




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