

SHANTHI INTERNATIONAL

19/20, Center Point, Indira Gandhi Road, Jamnagar 361008 (Gujarat) India.
Ph. +91-288-2555867/2556671/72 Fax. +91-288-2554254/2751388 Email: servoday@sify.com
Website: www.servoday.com

BY EMAIL/FAX

TO:	THE PURCHASE MANAGER	FROM:	KIRIT MASURIA (DIRECTOR)
COMPANY:		DATE:	October 31, 2006.
FAX/ NUMBER:		TOTAL NO. OF PAGES INCLUDING COVER:	24 (TWENTY FOUR)
PHONE/EMAIL NUMBER:		SENDER'S REFERENCE NUMBER:	SI/1751.
RE:	SLITTING & CUT TO LENGTH LINE.	YOUR REFERENCE NUMBER:	

DEAR SIR,

PLEASE FIND FOLLOWING USED MACHINERY AS AVAILABLE WITH US, IF YOU ARE INTERESTED TO VISIT ANY OF THE LINE, PLEASE CONFIRM YOUR INTEREST BY RETURN MAIL.

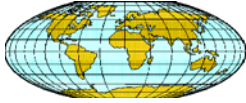
OPTION – I

Cut-To-Length Shear Line 0.3 ~ 3.2mm t x 1350mm W x 20 Ton x 40 MPM



Under Power Now and Installed - Built by Korean Maker in 2004

PRICE: US\$380,000 EX-SITE LOADED INTO CONTAINER.



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1. Mother Coil : HR/CR/Stainless Steel

Coil Thickness : 0.3 ~ 3.2mm

Coil Width : 1330mm

Coil Weight : 12 Ton

2. Piler : 1 Pilers

Sheet Length : 4 Meter L

Length Tolerance : +/- 1mm

3. Line Speed : 50 MPM

4. Electricity : 380 Voltage

5. Line Direction : Left to Right
Total Around 36 Meter L

7. Equipment List & Specification

1) Uncoiler : DC 18.5 KW, Yaskawa Japan, 220V

2) Coil Opener

3) Pinch Roll : DC 22KW

4) Fine Leveller : 5 +6 Rolls x 85mm Dia
DC 15 KW

5) Crop Shear

6) Loop Table

7) Side Guide

8) Measure Roll

9) Up Cut : AC 110KW Servo Motor

10) Inspection Table

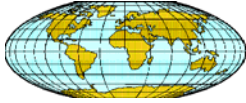
11) Piler

OPTION – II

Used Carbon Steel SETSU JAPAN Used Shear Line 6mm x 1350mm x 25 Ton x 60 mpm

- Built by Japan, SETSU in 1984
- Electrical Panel New in 1997
- Under Operation

PRICE: US\$249,000 EX-SITE LOADED INTO CONTAINER.



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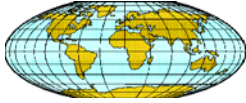


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* Equipment List

Used Up-Cut Shear Line for HR Coil
1.2 ~ 6mm t x 1350mm x 25 Ton x 60 mpm

- 1) Uncoiler : 25 Ton : Double Cone
- Coil Car
- 2) Rough Leveller :
- (6 +7 Rolls) x 120mm Dia
- 1550mm W
- DC 80KW Toyo denki, Japan, 1984, 220V, 2750rpm
- 3) 1st Loop
- 4) Side Trimmer :
- DC 55KW, Korea, Chungsong 1st Class,
1991, 220V, 1150 rpm
- 5) Scrap Winder
- 6) 2nd Loop
- 7) Side Guide & Measuring Roll



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- 8) Up Cut Shear :
- Width 1550mm
- DC 37KW, Reliance Japan, 1984, 220V, 1150rp
- 9) Finish Leveller :
- (7+8 Rolls) x 100mm Dia.
- 1700mm Width
- DC Motor
- 10) Piler : 6 Meter Length
- 11) Line Direction : From Left to Right

OPTION – III

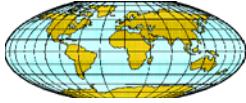
Used HR/CR/Stainless Steel Rotary Shear Line 0.3 ~ 3.2mm t x 1350mm W x 20 Ton x 40 MPM

- Under Operation Now and Installed.
- Built by Japan Sumitomo in 1976.

US\$499,000.- Subject to Re-Confirm



1. Mother Coil : HR/CR/Stainless Steel



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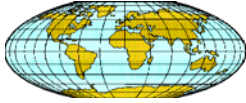
- Coil Thickness : 0.3 ~ 3.2mm
Coil Width : 1350mm
Coil Weight : Max 20 Ton
2. Piler : 1 Pilers
Sheet Length : 5 Meter L
3. Line Speed : 40 MPM
5. Electricity : 220 Voltage
* But Transformer is available.
Transformer changing 380 Voltage to 220 Volt
* DDS, Reliance
6. Line Direction : Left to Right -Total Around 36 Meter L
7. Equipment List & Specification
- 1) Uncoiler : DC 18.5 KW, Yaskawa Japan, 220V
2) Coil Opener
3) Pinch Roll : DC 22KW
4) Fine Leveller : 10 + 11 Rolls x 58mm Dia DC 75 KW
6) #1 Loop Table
7) Side Trimmer DC 18.5 KW
Scrap Winder
8) #2 Loop
9) Side Guide
10) Measure Roll
11) Rough Leveller : DC 55KW, Sumitomo Japan, 220 V
12) Rotary Shear : AC 110KW Servo Motor
13) Inspection Table
14) No.1 Piler

OPTION – IV

**Used Carbon Steel Slitting Line 1.2 ~ 6mm t x 1320mm W x 20 Ton x 80 MPM
Pull Cut Type Built in 1987 by Dae-Hyun Tech, Korea**

Now under Operation, Installed

PRICE: US\$299,000 EX-SITE LOADED INTO CONTAINER.



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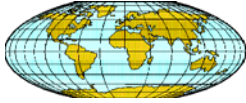
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1. MATERIAL : COLD ROLLED STEEL COIL
2. THICKNESS : 1.6 mm ~ 6.0 t mm
3. WIDTH : 1320 w mm
4. WEIGHT : 22 ton
5. COIL O.D : 1800 ϕ mm
6. COIL I.D : 508mm (610, 762 mm)
7. CUTTING : PULL CUTTING TYPE
8. LINE SPEED : 50 & 100 m/min (2-step)
9. THREADING SPEED : MAX. 20 m/min
10. CONTROL SYSTEM: DC CONTROL SYSTEM
11. LINE THREADING DIRECTION: FORM RIGHT TO LEFT(VIEW OF THE OPERATION SIDE)
12. PASS LINE HIGHT: APPROX. FL +800 MM
13. STANDQRD OF THREADING: LINE CENTER

LIST OF EQUIPMENT

1. Coil loading car
2. Double cone uncoiler
3. Coil peeler roll & opener
4. Pinch roll
5. Side guide roll
6. 5 roll straightener



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7. End shear
8. Slitter
9. #1 Loop table
10. Scrap winder
11. #2 Loop table
12. Tension pad
13. Separator
14. Recoiler
15. Coil car
16. Hydraulic power pack
17. Hydraulic piping
18. Main operators control desk
19. Auxiliary pushbutton station
20. Tooling

DETAIL SPECIFICATION OF COMPONETS:

1. Coil loading car

Type : 4- wheel driven type
Frame : Steel plate, welded
Lifting : By Hydraulic cylinder
Lifting weight: 22 ton
Traveling: By hydraulic motor
Traveling rail: 22 kg/m

2. Double cone uncoiler

Type: Double cone type
Capacity: 20 ton
Drum I.D: 508,610, 762 mm
Drum expanding: Hydraulic cylinder
Centering: Hydraulic cylinder
Brake: Block brake by air cylinder

3. Coil peeler roll & opener

Type: roll & edge guide type
Peeler roll: 250 mm x 400 mm L
(Urethane coating)

Peeler roll lifting & pusher: By hydraulic cylinder
Opener lifting & removing: By hydraulic cylinder

4. Pinch roll

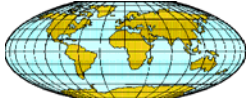
Type: 2-roll type
Roller; 1500 mm x 1400 mm L
Roll adjusting: Screw by manual
Drive: By leveler

5. Side guide roll

Type: Vertical roller
Roller: 1500 mm X 100 mm L
Roll adjust: Screw by manual

6. 5 roll straightened

Type: 2-3 roll type
Roller: 150 mm x 1400 mm L
Clutch: Jaw clutch by air cylinder



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Drive Motor : DC 15kw (500~1500rpm)

7. End shear

Type: crank type
Capacity: 6 Tmm x 1400 mmL
Motor: AC 5.5kw

8. Slitter

Type : Motor driven roll clutch type
Number of slitter: 14 cut of 1.6 T mm
4 cut of 6.0 Tmm
Stand : Horizontal type
Shaft : 220 mm x 1400 mmL
Knife size: 220 mm (I.D) x 350 mm (O.D) x 25 Tmm (SKD11)
Stand adjustment: Screw by manual
Driven motor: DC 55kw

9. #1 Loop table

Wide: 1400 mmW
Length: 6000 mmL

10. Scrap winder

Type: Drum type
Scrap wide: 30 mm
Drum size: 500 mm x 400 mmL

11. #2 Loop table

Wide: 1400 mmW
Length: 8000 mmL

12. Tension pad

13. Separator

Type: Over hang disc type
Knife: 120 mm (I.D) x 230 mm (O.D) x 5 Tmm

14. Recoiler

Type: Manual type
Capacity: 22 ton
Drum : 480 mm ~ 520 mm (O.D)
Drive motor: DC 110 kw

15. Coil car

Type: 4- wheel driven type
Frame: Steel plate, welded
Lifting: By Hydraulic cylinder
Lifting weight: 20 ton
Traveling: By hydraulic motor
Traveling rail: 22 kg/m

16. Hydraulic power pack

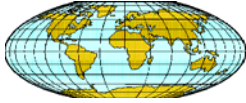
17. Hydraulic piping

18. Main operators control desk

19. Auxiliary pushbutton station

20. Slitting knife :

365 mm(O.D)- 40 EA
350 mm(O.D)- 40 EA
340 mm(O.D)- 40 EA
339 mm(O.D)- 27 EA
336 mm(O.D)- 57 EA
Rubber ring, Separator knife,
Separator spacer, Etc



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OPTION – V

Used Cut-To-Length Line (Shearing Line) Up-Cut Type 0.4 - 2.3mmT x 1250mmW x 12TON x 40m/min

Guarantee of Operation at Buyer's Factory and Warantee 1 Year

NEW Electrical Control Panel in 2006
New Motor in 2006
New Servo in 2006

Un-Coiler : Wean, USA
Up-Cut Shear : Honda, Japan Refurbished

U\$470,000 Subject to re-Confirm

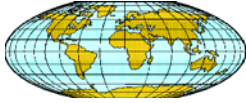
1. GENERAL SPECIFICATION

MATERIAL COLD ROLLED MILD STEEL COILS GI COILS SURFACE
TREATED COILS COLOR COATED COILS STAINLESS COILS(SUS304)



TENSILE STRENGTH 41Kg/mm2(MAX)

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65Kg/mm²(MAX)-SUS 1.0mm미만

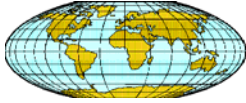
COIL THICKNESS	0.4mm - 2.3mm
COIL WIDTH	300 - 1250mm
COIL WEIGHT	12,000Kg(MAX)
COIL INSIDE DIA.	Φ508mm, Φ610mm
COIL OUTSIDE DIA.	Φ1,500mm(Max.)
CUTTING LENGTH	600mm ~ 3,500mm
NUMBER OF CUT	30 CPM (MAX)
LINE SPEED	40 m/min (MAX)
CONTROL SYSTEM	DIGITAL AC SERVO SYSTEM
HYDRAULIC PRESSURE	NORMAL WORKING PRESSURE 100Kg/cm ²



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PNEUMATIC PRESSURE	NORMAL WORKING PRESSURE 5Kg/cm ²
MAIN ELECTRIC SOURCE	AC 440V × 60Hz 3ph
OPERATIONAL ELECTRIC SOURCE	AC 220V × 60Hz
PASS LINE HEIGHT	FL + 1,000mm



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LINE TRAVELING DIRECTION FROM 'RIGHT' TO 'LEFT' VIEWING AT THE
OPERATION SIDE

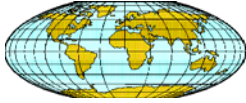
LENGTH TOLERANCE $\pm 0.5\text{mm}$ OR LESS FOR LENGTH LESS THAN
1,000mm

2. LINE COMPOSITION

- 1 COIL CAR-----1SET
- 2 UNCOILER -----1SET
- 3 SNUBBER ROLL-----1SET
- 4 OPENER-----1SET



- 5 LEVELLER WITH PINCH ROLL-----1SET
- 6 LOOP TABLE-----1SET
- 7 SIDE GUIDE-----1SET
- 8 FEEDER UNIT-----1SET
- 9 UP CUT SHEAR-----1SET
- 10 RUN OUT CONVEYOR-----1SET



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- 11 PILER-----1SET
- 12 PILER ROLL CONVEYOR-----1SET
- 13 HYDRAULIC EQUIPMENT-----1SET
- 14 PENUMATIC EQUIPMENT-----1SET
- 15 ELECTRICAL (AC/DC) EQUIPMENT-----1SET

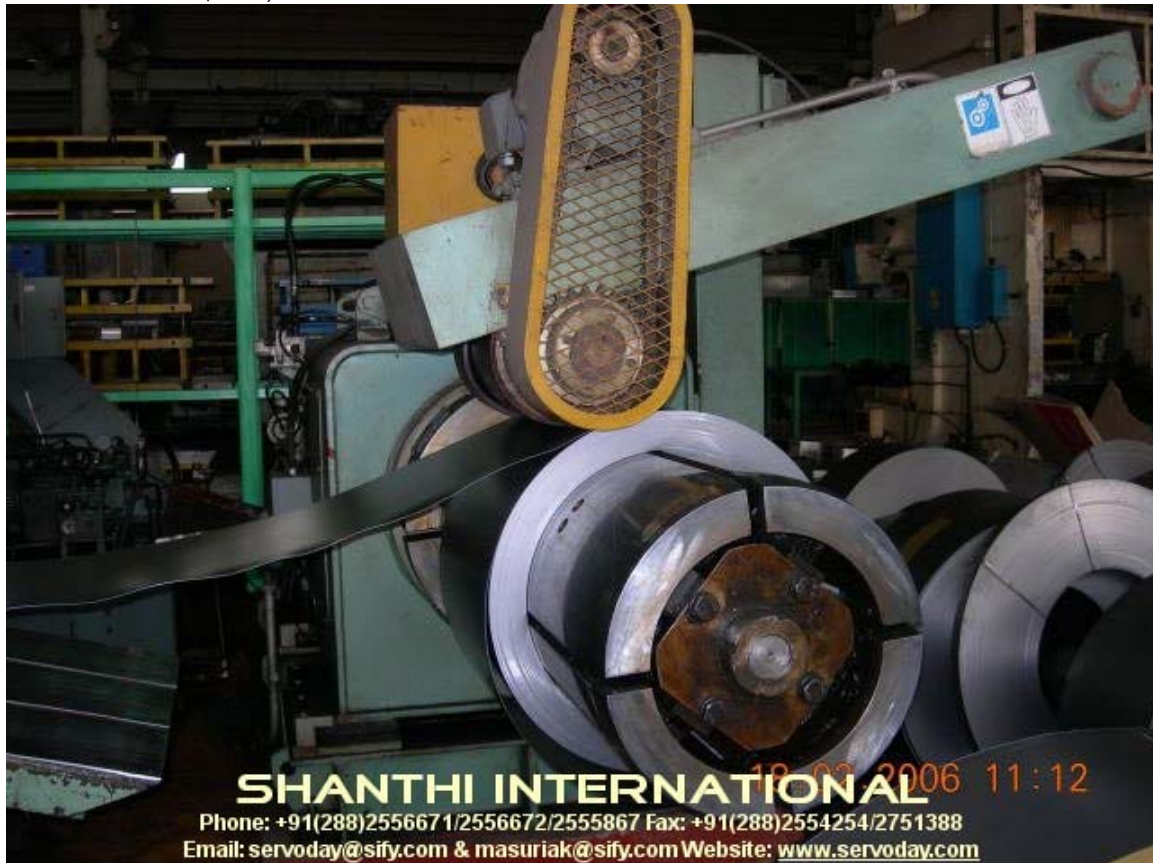
MORE DETAILS AVAILABLE ON REQUEST.

OPTION – VI

Used Cut- To -Length Line (Up-Cut Shear) 0.3 ~ 3mm t x 1250mm W x 10 Ton x 20 Cuts/ Minute

Shut Down, Dismantled
Built in 1991 by Daehyun Tech, Korea

Price : U\$289,000

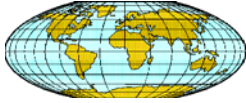


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1. Feeding Material :

- 1) Carbon Steel & SUS : 0.3 ~ 3.2mm Thickness
- 2) Aluminum : 0.5 ~ 5mm Thickness



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2. Carbon Steel : CR, GI, EG, PO
SSPC –SHPC –SAPH (41KG/Cm² 32KG/Cm²)

0.3 -3.2mm t x 1,250mm Width x 10.000kg Coil
Ø800-Ø1.500mm O.D x Ø508mm I.D

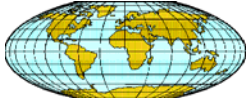
UP CUT SHEAR : 1,200 CUT/HOUR
Length of Sheet : 300-2,200mm
Speed : 1,200 CUTS/HOUR = 50 Meter/Minute
Length Tolerance : ± 0.2mm



Diagonal Tolerance: ± 0.5mm
Electricity : AC 380V, 60hz, 3Ø, AC 220V, 60hz, 3Ø
PL + 1,000mm
Line Direction : Right –Left
Control Type : DDS – F Type

3. Equipment List

- 1) COIL CAR
- 2) UNCOILER WITH SNUB ROLL
- 3) DEFLECTOR ROLL WITH OPENER
- 4) LEVELLER WITH W-PINCH ROLL
- 5) LOOP TABLE
- 6) SIDE GUIDE



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- 7) FEEDER ROLL UNIT WITH MEASURE ROLL
- 8) UP CUT SHEAR
- 9) RUN OUT CONVEYOR
- 10) NO 1 PILER
- 11) ELECTRICAL EQUIPMENT
- 12) HYDRAULIC & PNEUMATIC EQUIPMENT

3. Spec

- 1) COIL CAR
TYPE

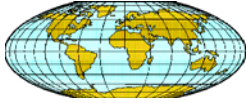
V-SHAPE OF FOUR WHEEL, TWO POST

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CAPACITY
UP AND DOWN
TRAVELLING
SURFACE OF V-SKID
COIL SIDE

10.000KG
BY HYDRAULIC CYLINDER
BY HYDRAULIC MOTOR
RUBBER PLATE
1 COIL SKID



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LEVELLER WORK ROLL	Ø 60 X 1,400mmL (5 X 6 RILL)
LEVELLER BACK UP ROLL	Ø 120 X 60L (35MIN)
WORK ROLL UP AND DOWN	BY GEARED NOTOR AC 1.5KW
BACK UP ROLL UP AND DOWN	SCREW BY MANUAL
ROLL DRIVE	UNIVERSAL JOINT
CAMWALTZ GEAR BOX	
DRIVE MOTOR	DC 37KW
INDICATOR	DIAL GAUGE

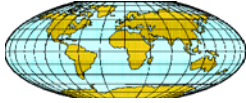
5) LOOP TABLE TYPE SINGLE SWING TYPE



UP AND DOWN SURFACE OF TABLE	BY HYDRAULIC CYLINDER STEEL PLATE BY cr COATED
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6) SIDE GUIDE TYPE ROLL ADJUSTMENT	VERTICAL 4ROLL TYPE SCREW BY HANDLE
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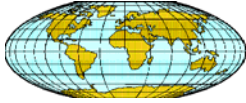
7) PEEDER ROLL UNIT PINCH ROLL SIZE	Ø150 X 1,400mmL 2PCS
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MEASURE ROLL SIZE	(SURFACE cr COATED) Ø 90 X 250mmL 2PCS
PEEDER ROLL SIZE	(HARDENED & GROUND) Ø180mm X 1,400mmL (HARDENED & GROUND)
PINCH ROLL	
MEASURE ROLL	UP AND DOWN ; BY PNEUMATIC CYLINDER
PEEDER ROLL	
MEASURE ROLL	PG
PEEDER ROLL DRIVE	AC 11kw SERVO MOTOR
8) UP CUT SHEAR	
TYPE	UP CUT TYPE BY CRANK
RAKE	DOUBLE RAKE
RAKE ANGLE	1.5
CLUTCH BRAKE	ATR TYPE
OPEN ??	50mm
DRIVE	AC 22kw
9) RUN OUT CONVEYOR	
TYPE	BELT TYPE
SPEED	60m/min
DRIVE	AC 5.5KW G/M
SPEED CONTROL	INVERTOR
10)PILER	
TYPE	AUTO DROP TYPE
SHEET LENGHT	300 -2.2??mm
UP AND DOWN	BY GEARED MOTOR AC 3.7KW
cAPACITY	5.000KG
RIDE ???	BY PNEUMATIC CYLINDER
STOPPER	BY PNEUMATIC CYLINDER Ø63 X 50ST
SIDE GUIDE ADJUSTMENT	SCREW BY GEARED MOTOR
END STOPPER ADJUSTMENT	SCREW BY GEARED MOTOR



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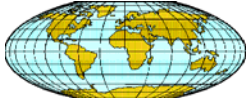
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OPTION – VII

Used BRONX Cut- To -Length Line (Up-Cut Shear) 0.7 ~ 4.5mm t x 2000mm W x 25 Ton

Price : (GBP) £375,000 Dismantling / loading / packing / FOB / C & F., can be arranged at extra cost if required.





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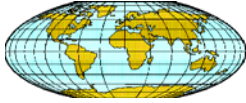
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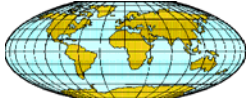


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Bronx cut to length line (cap. 2000 x 0.70 / 4.5 mm m.s.)

Manufacturer:	Bronx Eng Co Ltd
Original year of manufacture:	1972
Various mechanical upgrades:	1990 to 1995
New electrics:	1998 (new main electrical panel)
New thyristor drive:	1998 (Mentor d.c. thyristor drive - for 17 roll leveller)
Technical data:	
Cut to length sheets from coil:	CRS, galv, alloyed; m.s., stainless steel
Material thickness:	0.70 - 4.5 mm m.s.
Max material width:	2000 mm
Max coil weight:	25 tons
Cut lengths:	1000 / 6000 mm
Pass line height:	1137 mm above finished floor level
Equipment:	
Coil car:	Power operated 25 ton coil cap ¹
Uncoiler:	Twin cone type (both cone heads driven) Suitable for coil bores 508 / 610 / -760+ dia Back tension by twin Alanco air brake discs on each cone shaft Lateral travel of cone heads by hydraulic cylinders
Snubber roll:	Power driven and fitted to peeler unit frame
Peeler unit:	With heavy duty breaker roll and hydraulic coil peeler
Entry flattener / pinch rolls:	5-roll flattener with motor drive to entry pinch rolls *Note: Pinch rolls only driven Vertical adjustment of pinch rolls by air cylinders
Feed conveyor to leveller:	Short steel roller conveyor from exit side of flattener to entry side of precision leveller
6 high Bronx 17 roll precision leveller:	
No of work rolls:	17 (8 over 9)
Work roll dia:	76 mm
Intermediate roll dia:	50 mm
No of flights (backup rolls):	7 (top / bottom)
Adjustment of bottom back up rolls:	Motorised



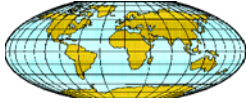
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Adjustment of head tilt:	Motorised (+/- 15°)
Entry pinch rolls:	Heavy duty polyurethane covered rolls (hydraulic raise / lower)
Drive motor:	166 kW d.c. 1440 rpm 411 A
Encoder unit:	For length measurement (fitted to exit side of leveller)
*Operation mode for line control:	Stop / start system
Line shear:	Bigwood upcut mechanical shear c/w Wichita clutch / brake, plus spare shear blades
Power driven run out conveyor:	Twin heavy duty bands running over steel fabricated roller table
Sheet piler / stacker:	Tilting type sheet piler with adjustable stop, c/w adjacent stacker with steel rollers and ch-plate - treads between rollers (max sheet length 6000 mm)
Electrics (main panel):	Supplied new in 1998, c/w Mentor thyristor drive system for d.c. supply.
Control Desks:	<ol style="list-style-type: none">1. Asea main line control, c/w Bronx visual roll positioning indicator - console for the precision leveller.2. Uncoiler push button / switch control console.3. Sheet piler push button control.
Hydraulics (line control):	Rexroth-hydraulic power / pump unit.
Pneumatics:	On-line factory supply
*Line direction:	Operation running from right to left
*Line speed:	Max 30 metres / min
*Tolerance on cut lengths:	Short cut lengths 1000 / 3000mm (+2 mm) Long cut lengths up to 6000mm (+4 mm)
Overall space requirements:	Approx: 28 metres long x 12 metres wide

*Note: the line has been very well maintained and is in excellent working order.

*Can be inspected in production on site by prior arrangement.



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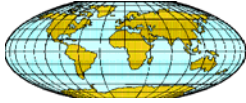
OPTION – VIII

Used PROIN Cut- To -Length Line - 0.5 ~ 3.0mm t x 1500mm W x 15 Ton

Price : EURO 650,000 Dismantling / loading / packing / FOB / C & F., can be arranged at extra cost if required.

- Manufacturing year: 1972
- Width (max.): 1500 mm
- Thickness: 0.5 - 3.00 mm
- Weight: 15 Tn
- Speed: 90 m/min





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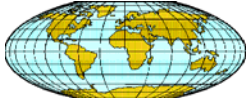
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(GENERAL TERMS AND CONDITION OF SALE AVAILABLE ON REQUEST)