

PRECISION BLANKING LINE SYSTEM SPECIFICATIONS**GENERAL DATA****Tolerances**

Length Accuracy

+- .005" (.127 mm)

@ Maximum Speed & Gage *

Squareness (D1-D2)/2

.015" (.38 mm)

Diagonal (D1-D2)

.030" (.76 mm)

Feed Stroke Length

120" (3048 mm)

Production Speed-

See Enclosed Speed Chart

Line Direction

LEFT TO RIGHT**MATERIAL DATA**

Type

CRS-HRS-HR P&O-GALV-GALVANEAL

Maximum Tensile Strength @ Maximum Thickness

80,000 PSI (56.25 kg/mm2) **

Maximum Thickness

0.312" (7.92 mm) **

Minimum Thickness

0.040" (1.02 mm) **

COIL SPECIFICATIONS

Maximum Entry Weight

80,000 lbs (36,287 kg)

Maximum Entry Width (Machine Clearance)

75" (1905 mm)

Maximum Entry Coil Outside Diameter

84" (2134 mm)

Maximum Payoff Reel Mandrel Diameter

25" (635 mm)

Minimum Payoff Reel Mandrel Diameter

19" (483 mm)

BLANK/SHEET SPECIFICATIONS

Maximum Stack Length

240" (6096 mm)

Maximum Primary Stack Weight

20,000 lb (9,071 kg)

Refer to specification page
for detailed capacities

Maximum Stack Height

24" (610 mm) Including Skid

MOTOR DATA

Primary Hydraulic Power

150 HP (112 KW) AC /

66-66-33 GPM (250-250-125 LPM)

Secondary Hydraulic Power

200 HP (149 KW) AC /

60-60 GPM (227-227 LPM)

Primary LV Hydraulic Power

100 HP (75 KW) AC /

59 GPM (223 LPM)

Secondary LV Hydraulic Power

150 HP (112 KW) AC /

80 GPM (303 LPM)

ELECTRICAL

575 Volt 3 Phase

AIR

80 PSI (5.5 Bar)

TEMPERATURE

Maximum Ambient Temperature

100°F (38°C)

Minimum Ambient Temperature

35°F (2°C)

* Refer to Grip Feed feature page for additional information

** Refer to Special Page for alternative material specifications

Equipment with Qty (1)

1 BLCA-BLANK LINE AUTO-LOGIC PLC MAIN CONTROL-PLC-HG
1 BLCF Elevated Operator Control Platform

1 PUVV-150H66-66-33 VARI-VOL 350 POWER UNIT
1 PUVV-200H66-66 VARI-VOL 300 POWER UNIT
1 PUCH-150 Air Blower Type Cooler-Hydraulic
1 PUCH-125 Air Blower Type Cooler-Hydraulic
1 PUAH Heavy Duty Hydraulic Accumulator-2-1/2
1 PUAH Heavy Duty Hydraulic Accumulator-5
1 PUMD-325A Lo-Hi-Temp Lo-Level Main Disconnect
1 PUMD-550A Lo-Hi-Temp Lo-Level Main Disconnect
1 PUBA Auto-Logic Hyd-Elec Blank Line Piping/Wiring
2 PUVV-100H Motor & Transformer Voltage Conversion
0 PUCF CTL Line Installation Component Package

1 CLSL-80 JIT SPACE SAVER 84 OD COIL STAGE & LOAD SYSTEM
1 CLES-80 Integrated Electronic Scale

1 RM24-72-80 19-25 EXP X 84 OD REEL-SA
1 RMMD Heavy Gage Clutch Motor Drive
1 RMTB-3080 Four Wheel Hyd Drive Traversing Base
1 RMWC-24-30 Hi-Torque Water Cooled Brake
1 RMSS-24-6C 19-25 Exp Standard Shoes-SA
1 RMSS 25" to 30-1/2" Steel Shoe Spacer Set
1 RMOA-24-30 8-5/8 Dia x 18 Wide Overarm
1 RMOP Speed Coordinated 14-10Ga Powered OA Roll
1 RMAT-1330 Material Alignment Auto Centering System-32
1 RMBC Auto Adjust Automatic Brake Control
1 RMGM Increments 1" Scale 1/2 Graduated Mandrel
1 RMCG Clockspring Contain Coil Guard

Equipment with Qty (1)

1 PBTH-32-96-36 EXT HEAVY GAGE PEELER BREAKER
1 PBFS Pass Line Ht as Required Free Standing Support-32
1 RLPR ROLLER LEVELER Threading Pinch Rolls-HG-72

1 SH18-250-72 BLANKS DIRECT DOWN SHEAR - CROP 1R

1 SM06-72 R60-65 6 DIA X 11 ROLL PRECISION STRAIGHTENER
1 SM06 Precision Straightener Platform with Steps
1 SMSA Push-Button Dial Readout Power Roll Adjust
1 SMPA Hydra-Drive Smooth Auto Logic Power-PLC
1 SMPS-120 Urethane Cover Protective Surface
1 SMDC-15HP Top & Bottom Nozzle Dust Collector System

1 THSR-STRETCHER TRAVERSING RAMPS/THREAD SYSTEM-120
1 THHS-120 Feed Ramp Hi-Speed Hold Down

1 LSM-PATENTED NO MARK CLAMPING STRETCHER LEVELER-250
1 LSPR Thin Material Threading Pinch Rolls/Side Guides
1 LSLA-24' Clamp Center Length Addition-250
1 LSCT Carbide Surface ToolSteel Clamp Tooling-250

1 PUVV-100H59 LV VARI-VOL 200 POWER UNIT
1 PUVV-150H85 LV VARI-VOL 250 POWER UNIT
2 PUCH-125 Air Blower Type Cooler-Hydraulic
1 PUMD-200A Lo-Hi-Temp Lo-Level Main Disconnect
1 PUMD-325A Lo-Hi-Temp Lo-Level Main Disconnect
2 PUVV-100H Motor & Transformer Voltage Conversion

1 FMHG-3 PRECISION LENGTH DUAL MOTOR GRIP FEED-HG-AL
1 FMCC Automatic Material Clamp Cylinder-HG
1 FMNW Gage Attachment 2"Minimum Narrow Width-HG -> 3"
1 FMSR-120 Full Width Roller Support Ramp
1 FMPS-120 Urethane Cover Protective Surface

Equipment with Qty (1)

1 SLSA Material Supports & Space Slitter Install Area

1 SH24-250-72 BLANKS DIRECT DOWN SHEAR-HG VAR/R
1 SHPA-24 Programmable Automatic Shear Angle Adjust
1 SHPC-24 Programmable Automatic Blade Gap Adjust

1 SSDS-144 3 SIDE BLANK SUPPORT DROP STACKER/DIVERT/HG
1 SSSP SG Stacker Head/Tail Scrap Puller
1 SSWD Push Button Powered Width Drive
1 SSBS Push Button Powered Back Stop
4 SSLA-168 Drop Stacker-HG 24" Length Addition / Divert
1 SSPM Long Blanks / Clearance Pivot Mount System
1 SSSC Heavy Material / Dual Support Cylinders

1 SSTS-288-20 AUTOMATIC LOWERING STACK TABLE-RT
1 SSES-20 Integrated Electronic Scale-Table
1 SSRT-144-20 END ROLL DISCHARGE ROLLOUT-TABLE-5.5
2 SSRF-144-20 END ROLL DISCHARGE ROLLOUT-FLOOR-5.5
1 SSTV Table Rollout Soft Start Variable Speed Drive
2 SSFV Floor Rollout Soft Start Variable Speed Drive
1 SSIF-1020 Stack Storage Floor Multi Rollout Interface
4 SSLA-24 End Roll Discharge Length Addition
1 SSPL End Discharge Roll Type Pallet Loader-DS

RED BUD INDUSTRIES' SPECIAL EQUIPMENT SPECIFICATIONS

NOTES:

Reel, Peeler, Crop Shear and Straightener will require a 24" deep pit

Line rated for 100,000 Yield @ .250" thick material

Line rated for 64,000 Yield @ .312" thick material

Maximum Straightener speed is 170 FPM

STACK TABLE / SKID LOADER DESIGN

Provide slots in Roller Conveyor Side Plates to mount Skid Loader
on Table centerline

LINE DESIGN

Allows Customer to run in Start/Stop mode up to 3/8" thick,
60" wide @ 50,000 Yield

Includes Thread System modifications to support material in
Start/Stop mode

Includes Measuring System/Controls and Gaging prior to and after
Feed System

Accuracy to range from +/- 1/16" to +/- 3/16" dependant on speed
and material variables

LEVELER SPACE DESIGN

Provide space for adding Leveler at a later date

Includes Crossover Table and Guarding

SPARE PARTS

Set of Gripper Pads for Heavy Gage Feed

Set of Shear Blades for Heavy Gage Shear