

Specifications

Slitter Line

2.3 t × 1,300 w × 20(15) ton

I. General Specifications

(1) Input Conditions

- | | | | |
|---|---------------------|---|-----------------------------------|
| ① | Materials | : | CR, HR, Surface Treated Coil, SUS |
| ② | Thickness | : | 0.4 ~ 2.3 t
(SUS 2.0t MAX) |
| ③ | Width | : | 300 ~ 1,300 mm (1,290 mm) |
| ④ | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Rubber Sleeve) |
| ⑤ | Coil Outer Diameter | : | φ 900 ~ 2,000 mm (MAX) |
| ⑥ | Coil Weight | : | 20,000 kg (MAX) |

(2) Slitting Conditions

- | | | | |
|---|-----------------------|---|------------------|
| ① | Slitting Method | : | Drive & Pull Cut |
| ② | Line Speed | : | 150 m/min (MAX) |
| ③ | Cutter Inner Diameter | : | φ 180 mm |
| ④ | Cutter Outer Diameter | : | φ 260 ~ 300 mm |

(3) Output Conditions

- | | | | |
|---|---------------------|---|--------------------------------|
| ① | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Attachment) |
| ② | Coil Outer Diameter | : | φ 650 ~ 1,800 mm (MAX) |
| ③ | Coil Weight | : | 15,000 kg (MAX) |

(4) Line Direction & Line Length

- | | | | |
|---|----------------------------|---|---|
| ① | Line Direction | : | 「Right」 → 「Left」
From Operator's point of view |
| ② | Length × Width | : | Approx. 21 m × 13 m |
| ③ | Installation Area Required | : | Approx. 273 m ² |
| ④ | Pass Line Height | : | FL +900 mm |

(5) Electric Power

- ① Power : AC220V (60Hz)
- ② Control : Type

(6) Line History

NO	Year	Contents
1	1991	Installed by ChoKyo Kohan
2	2020 ?	Dismantled Slitter Line

II. Machine Specifications

1. Coil Skid

- Type V Surface Rubber Type
- Coil Weight 20,000 kg (MAX) x 2pc)
- Coil Outer Diameter ϕ 900 ~ 2,000 mm

2. Entry Coil Car

- Type Guide Post Type
- Coil Weight 20,000 kg
- Coil Receiving Cradle Roll ϕ 200 x 1,000 mm
(Band Grooved)
- Movement AC 1.5KW , Geared Motor
Stroke 3,750mm
- Lifting Hydraulic Cylinder ϕ 250 x 1,000 mm

3. Uncoiler

- Type Hydraulic Expand Mandrel Type
(with Drum Support)
- Drum Diameter ϕ 407 ~ 520 mm
- Drum Expand Hydraulic Cylinder ϕ 220 x 125 mm
- Drum Support Hydraulic Cylinder ϕ 100 x 650 mm
- Brake Air Disk Brake
Tension Air Disk Brake (2pcs)
- Motor AC 2.2KW Geared Motor
- Clutch Air Clutch
- Sleeve ϕ 610 x 400 mm (2pcs) Rubber Sleeve

4 .	Snubber Roll	
	Type	Roll Pressure Type
	Roll Dimensions	ϕ 200 \times 400 L Urethane Rubber Lining
	Roll Up/Down	Air Cylinder ϕ 80 x 400 mm
	Motor	AC 1.5KW Geared Motor
5 .	Coil Opener	
	Swing	Hydraulic Cylinder ϕ 80 x 700 mm
	In/Out	Hydraulic Cylinder ϕ 63 x 290 mm
6 .	Pinch Roll	
	Type	Upper Roll Hydraulic Cylinder Type
	Roll	ϕ 400 x 1,400 L Urethane Rubber Lining
	Motor	VS 22KW
	Up/Down	Hydraulic Cylinder ϕ 100 x 120 mm (2pcs)
	Tip Roll	ϕ 150 x 1,400 L Urethane Rubber Lining Hydraulic Cylinder ϕ 50 x 100 mm (2pcs)
7 .	Entry Shear	
	Type	Hydraulic Down-Cut Type
	Cut	2.3 t x 1,300 mm
	Shear Blade	25t x 75 mm x 1,350 mm (SKD-11)
	Up/Down	Hudraulic Cylinder ϕ 140 x 175 mm (2pcs)
	Cart	1,800 L x 1,300 W x 2,000kg 0.4KW Geared Motor
8 .	No.1 Loop Table	
	Type	Titing Type, Surface Rubber
	Up/Down	Hydraulic Cylinder ϕ 100 x 600 mm
9 .	Side Guide	
	Type	Vertical Roll Type
	Roll	ϕ 80 \times 140mm
	Width	(200) 300 ~ 1,350 mm
	Motor	AC0.2KW Geared Motor
	Hold Roll	ϕ 72 x 1,400 L
	Up/Down	Air Cylinder ϕ 50 x 100 mm (2pcs)

1 0 .	Slitter Stand	
	Type	2-Slitter Stand Type
	Cutter	5t x ϕ 180 x ϕ 260 ~ 300 mm
	Arbor Shaft	ϕ 180 mm
	Open/Close	AC 0.75KW Geared Motor
	Up/Down	AC 0.4KW Geared Motor
	Motor	DC 30KW
	Movement	0.75KW Geared Motor
	Fixed	Hydraulic Cylinder ϕ 80 x 50 mm (4pcs)
	Felt Pad	Air Cylinder ϕ 63 x 200 mm (2pcs)
1 1 .	Turn Table	
	Type	Turn Table Type
	Motor	AC1.5KW Geared Motor
1 2 .	Scrap Winder	
	Type	Vertical Winding Type (WS,DS)
	Winding Width	3 ~ 25 mm
	Drum Diameter	ϕ 450 mm
	Maximum	ϕ 800 mm (MAX)
	Winding Weight	250 kg
	Motor	VS 3.7KW
1 3 .	No.2 Loop Table	
	Type	Titing Type, Surface Rubber
	Up/Down	Hydraulic Cylinder ϕ 100 x 600 mm
1 4 .	Separator	
	Type	Air Shaft Pinch Type
	Separator	5t x ϕ 220 x ϕ 130 mm
	Ring	ϕ 190 x ϕ 130 mm
	Drive	Chain, Powder Clutch (Tension Roll)
	Air Shaft	ϕ 130 x 1,654 L
	Up/Down	Air Cylinder ϕ 80 x 110 mm

1 5 .	Tension Pad	
	Type	Hydraulic Cylinder Pressure Type
	Pad	200W x 1,600L
	Cylinder	Hydraulic Cylinder ϕ 50 x 175mm (4pcs)
1 6 .	Tension Roll	
	Type	Straight Pinc Type
	Roll	ϕ 300 x 1,650 L Urethane Rubber Lining
	Brake	Water Cooling Air Brake
	Motor	AC1.5KW Geared Motor
	Clutch	Cam Clutch
	Pressure	Hydraulic Cylinder ϕ 100 x 120 mm (2pcs)
1 7 .	Exit Shear	
	Type	Hydraulic Down-cut Type
	Cut	2.3 t x 1,650 mm
	Shear Blade	25t x 75 mm x 1,650 mm
	Up/Down	Hydraulic Cylinder ϕ 140 x 175 mm (2pcs)
1 8 .	Deflector Roll	
	Roll	ϕ 520 x 1,650 L Urethane Rubber Lining
	Up/Down	Hydraulic Cylinder ϕ 100 x 120 mm
	Guide Table	Hydraulic Cylinder ϕ 100 x 490 mm
1 9 .	Recoiler	
	Type	Mandrel, Hydraulic Expansion
	Coil Weight	15,000 kg (MAX)
	Drum Length	1,600 mm
	Drum Diameter	ϕ 470 ~ ϕ 508
	Drum Expansion	Hydraulic Cylinder ϕ 225 x 125st
	Brake	Air Disk Brake
	Motor	DC 75KW
	Pusher	Hydraulic Cylinder ϕ 125 x 1,850st

- 2 0 . Recoiler Separator
- | | |
|---------------|------------------------------|
| Type | Air Shaft Type |
| Separator | 5t × φ 220 (OD) × φ 130 (ID) |
| Disk | φ 190 (OD) × φ 130 (ID) |
| Air Shaft | φ 130 × 1,650st |
| Shaft Up/Down | Air Cylinder φ 200 × 500st |
- 2 1 . Exit Coil Car
- | | |
|-------------|----------------------------------|
| Type | Guide Post Type |
| Coil Weight | 15,000 kg (MAX) |
| Surface | V Saddle , Rubber |
| Up/Down | Hydraulic Cylinder φ 224 × 900st |
| Motor | AC 1.5KW |
- 2 2 . Hydraulic Equipment
- | | |
|-----------------|-----------------------------|
| Type | Oil Unit Type |
| Pump Capacities | 70 kg/cm ² (MAX) |
| Tank Capacities | Approx. 8000L |
- 2 3 . Cooling Unit
- | | |
|------------|-------------------------|
| Type | Water Cooling Type |
| Capacities | 23,300kcal/hr |
| Pomp | 1.1KW 117ℓ/min × 24mAq |
| Pomp | 0.75 KW 56ℓ/min × 25mAq |
| Tank | Approx. 100ℓ |
- 2 4 . Pneumatic Equipment (Not included)
- 2 5 . Electric Equipment (Control Panels, Operation Panels)

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(1) Input Conditions

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| ② | Thickness | : | 0.4 ~ 2.3 t
(SUS 2.0t MAX) |
| ③ | Width | : | 300 ~ 1,300 mm (1,290 mm) |
| ④ | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Rubber Sleeve) |
| ⑤ | Coil Outer Diameter | : | φ 900 ~ 2,000 mm (MAX) |
| ⑥ | Coil Weight | : | 20,000 kg (MAX) |

(2) Slitting Conditions

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| ① | Slitting Method | : | Drive & Pull Cut |
| ② | Line Speed | : | 150 m/min (MAX) |
| ③ | Cutter Inner Diameter | : | φ 180 mm |
| ④ | Cutter Outer Diameter | : | φ 260 ~ 300 mm |

(3) Output Conditions

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|---|---------------------|---|--------------------------------|
| ① | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Attachment) |
| ② | Coil Outer Diameter | : | φ 650 ~ 1,800 mm (MAX) |
| ③ | Coil Weight | : | 15,000 kg (MAX) |

(4) Line Direction & Line Length

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|---|----------------------------|---|---|
| ① | Line Direction | : | 「Right」 → 「Left」
From Operator's point of view |
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| ③ | Installation Area Required | : | Approx. 273 m ² |
| ④ | Pass Line Height | : | FL +900 mm |

(5) Electric Power

- ① Power : AC220V (60Hz)
- ② Control : Type

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2. Entry Coil Car

- Type Guide Post Type
- Coil Weight 20,000 kg
- Coil Receiving Cradle Roll ϕ 200 x 1,000 mm
(Band Grooved)
- Movement AC 1.5KW , Geared Motor
Stroke 3,750mm
- Lifting Hydraulic Cylinder ϕ 250 x 1,000 mm

3. Uncoiler

- Type Hydraulic Expand Mandrel Type
(with Drum Support)
- Drum Diameter ϕ 407 ~ 520 mm
- Drum Expand Hydraulic Cylinder ϕ 220 x 125 mm
- Drum Support Hydraulic Cylinder ϕ 100 x 650 mm
- Brake Air Disk Brake
Tension Air Disk Brake (2pcs)
- Motor AC 2.2KW Geared Motor
- Clutch Air Clutch
- Sleeve ϕ 610 x 400 mm (2pcs) Rubber Sleeve

4 .	Snubber Roll	
	Type	Roll Pressure Type
	Roll Dimensions	ϕ 200 \times 400 L Urethane Rubber Lining
	Roll Up/Down	Air Cylinder ϕ 80 x 400 mm
	Motor	AC 1.5KW Geared Motor
5 .	Coil Opener	
	Swing	Hydraulic Cylinder ϕ 80 x 700 mm
	In/Out	Hydraulic Cylinder ϕ 63 x 290 mm
6 .	Pinch Roll	
	Type	Upper Roll Hydraulic Cylinder Type
	Roll	ϕ 400 x 1,400 L Urethane Rubber Lining
	Motor	VS 22KW
	Up/Down	Hydraulic Cylinder ϕ 100 x 120 mm (2pcs)
	Tip Roll	ϕ 150 x 1,400 L Urethane Rubber Lining Hydraulic Cylinder ϕ 50 x 100 mm (2pcs)
7 .	Entry Shear	
	Type	Hydraulic Down-Cut Type
	Cut	2.3 t x 1,300 mm
	Shear Blade	25t x 75 mm x 1,350 mm (SKD-11)
	Up/Down	Hudraulic Cylinder ϕ 140 x 175 mm (2pcs)
	Cart	1,800 L x 1,300 W x 2,000kg 0.4KW Geared Motor
8 .	No.1 Loop Table	
	Type	Titing Type, Suface Rubber
	Up/Down	Hydraulic Cylinder ϕ 100 x 600 mm
9 .	Side Guide	
	Type	Vertical Roll Type
	Roll	ϕ 80 \times 140mm
	Width	(200) 300 ~ 1,350 mm
	Motor	AC0.2KW Geared Motor
	Hold Roll	ϕ 72 x 1,400 L
	Up/Down	Air Cylinder ϕ 50 x 100 mm (2pcs)

1 0 .	Slitter Stand	
	Type	2-Slitter Stand Type
	Cutter	5t x ϕ 180 x ϕ 260 ~ 300 mm
	Arbor Shaft	ϕ 180 mm
	Open/Close	AC 0.75KW Geared Motor
	Up/Down	AC 0.4KW Geared Motor
	Motor	DC 30KW
	Movement	0.75KW Geared Motor
	Fixed	Hydraulic Cylinder ϕ 80 x 50 mm (4pcs)
	Felt Pad	Air Cylinder ϕ 63 x 200 mm (2pcs)
1 1 .	Turn Table	
	Type	Turn Table Type
	Motor	AC1.5KW Geared Motor
1 2 .	Scrap Winder	
	Type	Vertical Winding Type (WS,DS)
	Winding Width	3 ~ 25 mm
	Drum Diameter	ϕ 450 mm
	Maximum	ϕ 800 mm (MAX)
	Winding Weight	250 kg
	Motor	VS 3.7KW
1 3 .	No.2 Loop Table	
	Type	Titing Type, Surface Rubber
	Up/Down	Hydraulic Cylinder ϕ 100 x 600 mm
1 4 .	Separator	
	Type	Air Shaft Pinch Type
	Separator	5t x ϕ 220 x ϕ 130 mm
	Ring	ϕ 190 x ϕ 130 mm
	Drive	Chain, Powder Clutch (Tension Roll)
	Air Shaft	ϕ 130 x 1,654 L
	Up/Down	Air Cylinder ϕ 80 x 110 mm

1 5 .	Tension Pad	
	Type	Hydraulic Cylinder Pressure Type
	Pad	200W x 1,600L
	Cylinder	Hydraulic Cylinder ϕ 50 x 175mm (4pcs)
1 6 .	Tension Roll	
	Type	Straight Pinc Type
	Roll	ϕ 300 x 1,650 L Urethane Rubber Lining
	Brake	Water Cooling Air Brake
	Motor	AC1.5KW Geared Motor
	Clutch	Cam Clutch
	Pressure	Hydraulic Cylinder ϕ 100 x 120 mm (2pcs)
1 7 .	Exit Shear	
	Type	Hydraulic Down-cut Type
	Cut	2.3 t x 1,650 mm
	Shear Blade	25t x 75 mm x 1,650 mm
	Up/Down	Hydraulic Cylinder ϕ 140 x 175 mm (2pcs)
1 8 .	Deflector Roll	
	Roll	ϕ 520 x 1,650 L Urethane Rubber Lining
	Up/Down	Hydraulic Cylinder ϕ 100 x 120 mm
	Guide Table	Hydraulic Cylinder ϕ 100 x 490 mm
1 9 .	Recoiler	
	Type	Mandrel, Hydraulic Expansion
	Coil Weight	15,000 kg (MAX)
	Drum Length	1,600 mm
	Drum Diameter	ϕ 470 ~ ϕ 508
	Drum Expansion	Hydraulic Cylinder ϕ 225 x 125st
	Brake	Air Disk Brake
	Motor	DC 75KW
	Pusher	Hydraulic Cylinder ϕ 125 x 1,850st

- 2 0 . Recoiler Separator
- | | |
|---------------|--|
| Type | Air Shaft Type |
| Separator | 5t × ϕ 220 (OD) × ϕ 130 (ID) |
| Disk | ϕ 190 (OD) × ϕ 130 (ID) |
| Air Shaft | ϕ 130 × 1,650st |
| Shaft Up/Down | Air Cylinder ϕ 200 × 500st |
- 2 1 . Exit Coil Car
- | | |
|-------------|---------------------------------------|
| Type | Guide Post Type |
| Coil Weight | 15,000 kg (MAX) |
| Surface | V Saddle , Rubber |
| Up/Down | Hydraulic Cylinder ϕ 224 × 900st |
| Motor | AC 1.5KW |
- 2 2 . Hydraulic Equipment
- | | |
|-----------------|-----------------------------|
| Type | Oil Unit Type |
| Pump Capacities | 70 kg/cm ² (MAX) |
| Tank Capacities | Approx. 8000L |
- 2 3 . Cooling Unit
- | | |
|------------|--------------------------------|
| Type | Water Cooling Type |
| Capacities | 23,300kcal/hr |
| Pomp | 1.1KW 117 ℓ /min × 24mAq |
| Pomp | 0.75 KW 56 ℓ /min × 25mAq |
| Tank | Approx. 100 ℓ |
- 2 4 . Pneumatic Equipment (Not included)
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Slitter Line

2.3 t × 1,300 w × 20(15) ton

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| ② | Thickness | : | 0.4 ~ 2.3 t
(SUS 2.0t MAX) |
| ③ | Width | : | 300 ~ 1,300 mm (1,290 mm) |
| ④ | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Rubber Sleeve) |
| ⑤ | Coil Outer Diameter | : | φ 900 ~ 2,000 mm (MAX) |
| ⑥ | Coil Weight | : | 20,000 kg (MAX) |

(2) Slitting Conditions

- | | | | |
|---|-----------------------|---|------------------|
| ① | Slitting Method | : | Drive & Pull Cut |
| ② | Line Speed | : | 150 m/min (MAX) |
| ③ | Cutter Inner Diameter | : | φ 180 mm |
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(3) Output Conditions

- | | | | |
|---|---------------------|---|--------------------------------|
| ① | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Attachment) |
| ② | Coil Outer Diameter | : | φ 650 ~ 1,800 mm (MAX) |
| ③ | Coil Weight | : | 15,000 kg (MAX) |

(4) Line Direction & Line Length

- | | | | |
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(3) Output Conditions

- | | | | |
|---|---------------------|---|--------------------------------|
| ① | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Attachment) |
| ② | Coil Outer Diameter | : | φ 650 ~ 1,800 mm (MAX) |
| ③ | Coil Weight | : | 15,000 kg (MAX) |

(4) Line Direction & Line Length

- | | | | |
|---|----------------------------|---|---|
| ① | Line Direction | : | 「Right」 → 「Left」
From Operator's point of view |
| ② | Length × Width | : | Approx. 21 m × 13 m |
| ③ | Installation Area Required | : | Approx. 273 m ² |
| ④ | Pass Line Height | : | FL +900 mm |

(5) Electric Power

- ① Power : AC220V (60Hz)
- ② Control : Type

(6) Line History

NO	Year	Contents
1	1991	Installed by ChoKyo Kohan
2	2020 ?	Dismantled Slitter Line

II. Machine Specifications

1. Coil Skid

- Type V Surface Rubber Type
- Coil Weight 20,000 kg (MAX) x 2pc)
- Coil Outer Diameter ϕ 900 ~ 2,000 mm

2. Entry Coil Car

- Type Guide Post Type
- Coil Weight 20,000 kg
- Coil Receiving Cradle Roll ϕ 200 x 1,000 mm
(Band Grooved)
- Movement AC 1.5KW , Geared Motor
Stroke 3,750mm
- Lifting Hydraulic Cylinder ϕ 250 x 1,000 mm

3. Uncoiler

- Type Hydraulic Expand Mandrel Type
(with Drum Support)
- Drum Diameter ϕ 407 ~ 520 mm
- Drum Expand Hydraulic Cylinder ϕ 220 x 125 mm
- Drum Support Hydraulic Cylinder ϕ 100 x 650 mm
- Brake Air Disk Brake
Tension Air Disk Brake (2pcs)
- Motor AC 2.2KW Geared Motor
- Clutch Air Clutch
- Sleeve ϕ 610 x 400 mm (2pcs) Rubber Sleeve

4 .	Snubber Roll	
	Type	Roll Pressure Type
	Roll Dimensions	ϕ 200 \times 400 L Urethane Rubber Lining
	Roll Up/Down	Air Cylinder ϕ 80 x 400 mm
	Motor	AC 1.5KW Geared Motor
5 .	Coil Opener	
	Swing	Hydraulic Cylinder ϕ 80 x 700 mm
	In/Out	Hydraulic Cylinder ϕ 63 x 290 mm
6 .	Pinch Roll	
	Type	Upper Roll Hydraulic Cylinder Type
	Roll	ϕ 400 x 1,400 L Urethane Rubber Lining
	Motor	VS 22KW
	Up/Down	Hydraulic Cylinder ϕ 100 x 120 mm (2pcs)
	Tip Roll	ϕ 150 x 1,400 L Urethane Rubber Lining Hydraulic Cylinder ϕ 50 x 100 mm (2pcs)
7 .	Entry Shear	
	Type	Hydraulic Down-Cut Type
	Cut	2.3 t x 1,300 mm
	Shear Blade	25t x 75 mm x 1,350 mm (SKD-11)
	Up/Down	Hudraulic Cylinder ϕ 140 x 175 mm (2pcs)
	Cart	1,800 L x 1,300 W x 2,000kg 0.4KW Geared Motor
8 .	No.1 Loop Table	
	Type	Titing Type, Surface Rubber
	Up/Down	Hydraulic Cylinder ϕ 100 x 600 mm
9 .	Side Guide	
	Type	Vertical Roll Type
	Roll	ϕ 80 \times 140mm
	Width	(200) 300 ~ 1,350 mm
	Motor	AC0.2KW Geared Motor
	Hold Roll	ϕ 72 x 1,400 L
	Up/Down	Air Cylinder ϕ 50 x 100 mm (2pcs)

1 0 .	Slitter Stand	
	Type	2-Slitter Stand Type
	Cutter	5t x ϕ 180 x ϕ 260 ~ 300 mm
	Arbor Shaft	ϕ 180 mm
	Open/Close	AC 0.75KW Geared Motor
	Up/Down	AC 0.4KW Geared Motor
	Motor	DC 30KW
	Movement	0.75KW Geared Motor
	Fixed	Hydraulic Cylinder ϕ 80 x 50 mm (4pcs)
	Felt Pad	Air Cylinder ϕ 63 x 200 mm (2pcs)
1 1 .	Turn Table	
	Type	Turn Table Type
	Motor	AC1.5KW Geared Motor
1 2 .	Scrap Winder	
	Type	Vertical Winding Type (WS,DS)
	Winding Width	3 ~ 25 mm
	Drum Diameter	ϕ 450 mm
	Maximum	ϕ 800 mm (MAX)
	Winding Weight	250 kg
	Motor	VS 3.7KW
1 3 .	No.2 Loop Table	
	Type	Titing Type, Surface Rubber
	Up/Down	Hydraulic Cylinder ϕ 100 x 600 mm
1 4 .	Separator	
	Type	Air Shaft Pinch Type
	Separator	5t x ϕ 220 x ϕ 130 mm
	Ring	ϕ 190 x ϕ 130 mm
	Drive	Chain, Powder Clutch (Tension Roll)
	Air Shaft	ϕ 130 x 1,654 L
	Up/Down	Air Cylinder ϕ 80 x 110 mm

1 5 .	Tension Pad	
	Type	Hydraulic Cylinder Pressure Type
	Pad	200W x 1,600L
	Cylinder	Hydraulic Cylinder ϕ 50 x 175mm (4pcs)
1 6 .	Tension Roll	
	Type	Straight Pinc Type
	Roll	ϕ 300 x 1,650 L Urethane Rubber Lining
	Brake	Water Cooling Air Brake
	Motor	AC1.5KW Geared Motor
	Clutch	Cam Clutch
	Pressure	Hydraulic Cylinder ϕ 100 x 120 mm (2pcs)
1 7 .	Exit Shear	
	Type	Hydraulic Down-cut Type
	Cut	2.3 t x 1,650 mm
	Shear Blade	25t x 75 mm x 1,650 mm
	Up/Down	Hydraulic Cylinder ϕ 140 x 175 mm (2pcs)
1 8 .	Deflector Roll	
	Roll	ϕ 520 x 1,650 L Urethane Rubber Lining
	Up/Down	Hydraulic Cylinder ϕ 100 x 120 mm
	Guide Table	Hydraulic Cylinder ϕ 100 x 490 mm
1 9 .	Recoiler	
	Type	Mandrel, Hydraulic Expansion
	Coil Weight	15,000 kg (MAX)
	Drum Length	1,600 mm
	Drum Diameter	ϕ 470 ~ ϕ 508
	Drum Expansion	Hydraulic Cylinder ϕ 225 x 125st
	Brake	Air Disk Brake
	Motor	DC 75KW
	Pusher	Hydraulic Cylinder ϕ 125 x 1,850st

- 2 0 . Recoiler Separator
- | | |
|---------------|--|
| Type | Air Shaft Type |
| Separator | 5t × ϕ 220 (OD) × ϕ 130 (ID) |
| Disk | ϕ 190 (OD) × ϕ 130 (ID) |
| Air Shaft | ϕ 130 × 1,650st |
| Shaft Up/Down | Air Cylinder ϕ 200 × 500st |
- 2 1 . Exit Coil Car
- | | |
|-------------|---------------------------------------|
| Type | Guide Post Type |
| Coil Weight | 15,000 kg (MAX) |
| Surface | V Saddle , Rubber |
| Up/Down | Hydraulic Cylinder ϕ 224 × 900st |
| Motor | AC 1.5KW |
- 2 2 . Hydraulic Equipment
- | | |
|-----------------|-----------------------------|
| Type | Oil Unit Type |
| Pump Capacities | 70 kg/cm ² (MAX) |
| Tank Capacities | Approx. 8000L |
- 2 3 . Cooling Unit
- | | |
|------------|--------------------------------|
| Type | Water Cooling Type |
| Capacities | 23,300kcal/hr |
| Pomp | 1.1KW 117 ℓ /min × 24mAq |
| Pomp | 0.75 KW 56 ℓ /min × 25mAq |
| Tank | Approx. 100 ℓ |
- 2 4 . Pneumatic Equipment (Not included)
- 2 5 . Electric Equipment (Control Panels, Operation Panels)

Specifications

Slitter Line

2.3 t × 1,300 w × 20(15) ton

I. General Specifications

(1) Input Conditions

- | | | | |
|---|---------------------|---|-----------------------------------|
| ① | Materials | : | CR, HR, Surface Treated Coil, SUS |
| ② | Thickness | : | 0.4 ~ 2.3 t
(SUS 2.0t MAX) |
| ③ | Width | : | 300 ~ 1,300 mm (1,290 mm) |
| ④ | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Rubber Sleeve) |
| ⑤ | Coil Outer Diameter | : | φ 900 ~ 2,000 mm (MAX) |
| ⑥ | Coil Weight | : | 20,000 kg (MAX) |

(2) Slitting Conditions

- | | | | |
|---|-----------------------|---|------------------|
| ① | Slitting Method | : | Drive & Pull Cut |
| ② | Line Speed | : | 150 m/min (MAX) |
| ③ | Cutter Inner Diameter | : | φ 180 mm |
| ④ | Cutter Outer Diameter | : | φ 260 ~ 300 mm |

(3) Output Conditions

- | | | | |
|---|---------------------|---|--------------------------------|
| ① | Coil Inner Diameter | : | φ 508 mm, φ 610mm (Attachment) |
| ② | Coil Outer Diameter | : | φ 650 ~ 1,800 mm (MAX) |
| ③ | Coil Weight | : | 15,000 kg (MAX) |

(4) Line Direction & Line Length

- | | | | |
|---|----------------------------|---|---|
| ① | Line Direction | : | 「Right」 → 「Left」
From Operator's point of view |
| ② | Length × Width | : | Approx. 21 m × 13 m |
| ③ | Installation Area Required | : | Approx. 273 m ² |
| ④ | Pass Line Height | : | FL +900 mm |

(5) Electric Power

- ① Power : AC220V (60Hz)
- ② Control : Type

(6) Line History

NO	Year	Contents
1	1991	Installed by ChoKyo Kohan
2	2020 ?	Dismantled Slitter Line

II. Machine Specifications

1. Coil Skid

- Type V Surface Rubber Type
- Coil Weight 20,000 kg (MAX) x 2pc)
- Coil Outer Diameter ϕ 900 ~ 2,000 mm

2. Entry Coil Car

- Type Guide Post Type
- Coil Weight 20,000 kg
- Coil Receiving Cradle Roll ϕ 200 x 1,000 mm
(Band Grooved)
- Movement AC 1.5KW , Geared Motor
Stroke 3,750mm
- Lifting Hydraulic Cylinder ϕ 250 x 1,000 mm

3. Uncoiler

- Type Hydraulic Expand Mandrel Type
(with Drum Support)
- Drum Diameter ϕ 407 ~ 520 mm
- Drum Expand Hydraulic Cylinder ϕ 220 x 125 mm
- Drum Support Hydraulic Cylinder ϕ 100 x 650 mm
- Brake Air Disk Brake
Tension Air Disk Brake (2pcs)
- Motor AC 2.2KW Geared Motor
- Clutch Air Clutch
- Sleeve ϕ 610 x 400 mm (2pcs) Rubber Sleeve

4 .	Snubber Roll	
	Type	Roll Pressure Type
	Roll Dimensions	ϕ 200 \times 400 L Urethane Rubber Lining
	Roll Up/Down	Air Cylinder ϕ 80 x 400 mm
	Motor	AC 1.5KW Geared Motor
5 .	Coil Opener	
	Swing	Hydraulic Cylinder ϕ 80 x 700 mm
	In/Out	Hydraulic Cylinder ϕ 63 x 290 mm
6 .	Pinch Roll	
	Type	Upper Roll Hydraulic Cylinder Type
	Roll	ϕ 400 x 1,400 L Urethane Rubber Lining
	Motor	VS 22KW
	Up/Down	Hydraulic Cylinder ϕ 100 x 120 mm (2pcs)
	Tip Roll	ϕ 150 x 1,400 L Urethane Rubber Lining Hydraulic Cylinder ϕ 50 x 100 mm (2pcs)
7 .	Entry Shear	
	Type	Hydraulic Down-Cut Type
	Cut	2.3 t x 1,300 mm
	Shear Blade	25t x 75 mm x 1,350 mm (SKD-11)
	Up/Down	Hudraulic Cylinder ϕ 140 x 175 mm (2pcs)
	Cart	1,800 L x 1,300 W x 2,000kg 0.4KW Geared Motor
8 .	No.1 Loop Table	
	Type	Titing Type, Suface Rubber
	Up/Down	Hydraulic Cylinder ϕ 100 x 600 mm
9 .	Side Guide	
	Type	Vertical Roll Type
	Roll	ϕ 80 \times 140mm
	Width	(200) 300 ~ 1,350 mm
	Motor	AC0.2KW Geared Motor
	Hold Roll	ϕ 72 x 1,400 L
	Up/Down	Air Cylinder ϕ 50 x 100 mm (2pcs)

1 0 .	Slitter Stand	
	Type	2-Slitter Stand Type
	Cutter	5t x ϕ 180 x ϕ 260 ~ 300 mm
	Arbor Shaft	ϕ 180 mm
	Open/Close	AC 0.75KW Geared Motor
	Up/Down	AC 0.4KW Geared Motor
	Motor	DC 30KW
	Movement	0.75KW Geared Motor
	Fixed	Hydraulic Cylinder ϕ 80 x 50 mm (4pcs)
	Felt Pad	Air Cylinder ϕ 63 x 200 mm (2pcs)
1 1 .	Turn Table	
	Type	Turn Table Type
	Motor	AC1.5KW Geared Motor
1 2 .	Scrap Winder	
	Type	Vertical Winding Type (WS,DS)
	Winding Width	3 ~ 25 mm
	Drum Diameter	ϕ 450 mm
	Maximum	ϕ 800 mm (MAX)
	Winding Weight	250 kg
	Motor	VS 3.7KW
1 3 .	No.2 Loop Table	
	Type	Titing Type, Surface Rubber
	Up/Down	Hydraulic Cylinder ϕ 100 x 600 mm
1 4 .	Separator	
	Type	Air Shaft Pinch Type
	Separator	5t x ϕ 220 x ϕ 130 mm
	Ring	ϕ 190 x ϕ 130 mm
	Drive	Chain, Powder Clutch (Tension Roll)
	Air Shaft	ϕ 130 x 1,654 L
	Up/Down	Air Cylinder ϕ 80 x 110 mm

1 5 .	Tension Pad	
	Type	Hydraulic Cylinder Pressure Type
	Pad	200W x 1,600L
	Cylinder	Hydraulic Cylinder ϕ 50 x 175mm (4pcs)
1 6 .	Tension Roll	
	Type	Straight Pinc Type
	Roll	ϕ 300 x 1,650 L Urethane Rubber Lining
	Brake	Water Cooling Air Brake
	Motor	AC1.5KW Geared Motor
	Clutch	Cam Clutch
	Pressure	Hydraulic Cylinder ϕ 100 x 120 mm (2pcs)
1 7 .	Exit Shear	
	Type	Hydraulic Down-cut Type
	Cut	2.3 t x 1,650 mm
	Shear Blade	25t x 75 mm x 1,650 mm
	Up/Down	Hydraulic Cylinder ϕ 140 x 175 mm (2pcs)
1 8 .	Deflector Roll	
	Roll	ϕ 520 x 1,650 L Urethane Rubber Lining
	Up/Down	Hydraulic Cylinder ϕ 100 x 120 mm
	Guide Table	Hydraulic Cylinder ϕ 100 x 490 mm
1 9 .	Recoiler	
	Type	Mandrel, Hydraulic Expansion
	Coil Weight	15,000 kg (MAX)
	Drum Length	1,600 mm
	Drum Diameter	ϕ 470 ~ ϕ 508
	Drum Expansion	Hydraulic Cylinder ϕ 225 x 125st
	Brake	Air Disk Brake
	Motor	DC 75KW
	Pusher	Hydraulic Cylinder ϕ 125 x 1,850st

- 2 0 . Recoiler Separator
- | | |
|---------------|--|
| Type | Air Shaft Type |
| Separator | 5t × ϕ 220 (OD) × ϕ 130 (ID) |
| Disk | ϕ 190 (OD) × ϕ 130 (ID) |
| Air Shaft | ϕ 130 × 1,650st |
| Shaft Up/Down | Air Cylinder ϕ 200 × 500st |
- 2 1 . Exit Coil Car
- | | |
|-------------|---------------------------------------|
| Type | Guide Post Type |
| Coil Weight | 15,000 kg (MAX) |
| Surface | V Saddle , Rubber |
| Up/Down | Hydraulic Cylinder ϕ 224 × 900st |
| Motor | AC 1.5KW |
- 2 2 . Hydraulic Equipment
- | | |
|-----------------|-----------------------------|
| Type | Oil Unit Type |
| Pump Capacities | 70 kg/cm ² (MAX) |
| Tank Capacities | Approx. 8000L |
- 2 3 . Cooling Unit
- | | |
|------------|--------------------------------|
| Type | Water Cooling Type |
| Capacities | 23,300kcal/hr |
| Pomp | 1.1KW 117 ℓ /min × 24mAq |
| Pomp | 0.75 KW 56 ℓ /min × 25mAq |
| Tank | Approx. 100 ℓ |
- 2 4 . Pneumatic Equipment (Not included)
- 2 5 . Electric Equipment (Control Panels, Operation Panels)

Slitter Parts List for 2.3t x 1300w x 20(15)ton Slitter Line

(スリッター消耗品一覧表)

2021年7月30日

I . Slitter Knives (スリッターナイフ)							
NO	Name (Material etc) 品名 (材質等)	O.D. (外形) (mm)	I.D. (内径) (mm)	Thickness (厚み) (mm)	Q'TY (数量) (枚)	Value (評価単価) (¥)	Total Value (評価額) (¥)
1	Slitter Knives (SHK)	φ 284.0	φ 180.0	10.00 t	49 枚	9,000	441,000
2	Slitter Knives (SHK)	φ 284.0	φ 180.0	10.00 t	50 枚	9,000	450,000
Total					99 枚		¥891,000
<備考> 購入時外径 (NEW) : φ 300mm、使用限界外径 (LIMIT) : φ 260mm							

II . Slitter Spacer (スリッタースペーサー)							
NO	Name (Material etc) 品名 (材質等)	O.D. (外形) (mm)	I.D. (内径) (mm)	Thickness (厚み) (mm)	Q'TY (数量) (枚)	Value (評価単価) (¥)	Total Value (評価額) (¥)
1	Slitter Spacer (Steel)	φ 220.0	φ 180.0	50.00 t	54 枚	10,000	540,000
2	Slitter Spacer (Steel)	φ 220.0	φ 180.0	40.00 t	37 枚	8,500	314,500
3	Slitter Spacer (Steel)	φ 220.0	φ 180.0	30.00 t	18 枚	7,000	126,000
4	Slitter Spacer (Steel)	φ 220.0	φ 180.0	20.00 t	11 枚	6,000	66,000
5	Slitter Spacer (Steel)	φ 220.0	φ 180.0	10.00 t	29 枚	5,000	145,000
6	Slitter Spacer (Steel)	φ 220.0	φ 180.0	9.00 t	28 枚	4,700	131,600
7	Slitter Spacer (Steel)	φ 220.0	φ 180.0	8.00 t	24 枚	4,400	105,600
8	Slitter Spacer (Steel)	φ 220.0	φ 180.0	7.00 t	28 枚	4,100	114,800
9	Slitter Spacer (Steel)	φ 220.0	φ 180.0	6.00 t	13 枚	3,800	49,400
10	Slitter Spacer (Steel)	φ 220.0	φ 180.0	5.00 t	34 枚	3,500	119,000
11	Slitter Spacer (Steel)	φ 220.0	φ 180.0	4.00 t	33 枚	3,200	105,600
12	Slitter Spacer (Steel)	φ 220.0	φ 180.0	3.00 t	29 枚	2,900	84,100
13	Slitter Spacer (Steel)	φ 220.0	φ 180.0	2.00 t	28 枚	2,600	72,800
14	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.00 t	23 枚	2,300	52,900
15	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.90 t	32 枚	2,500	80,000
16	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.80 t	28 枚	2,500	70,000
17	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.70 t	27 枚	2,500	67,500
18	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.60 t	32 枚	2,500	80,000
19	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.50 t	20 枚	2,500	50,000
20	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.40 t	28 枚	2,500	70,000
21	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.30 t	30 枚	2,500	75,000
22	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.20 t	28 枚	2,500	70,000
23	Slitter Spacer (Steel)	φ 220.0	φ 180.0	1.10 t	19 枚	2,500	47,500
Total					633 枚		¥1,782,800

Slitter Parts List for 2.3t x 1300w x 20(15)ton Slitter Line

III. Separator Disk (セパレーターディスク)							
NO	Name (Material etc) 品名 (材質等)	O.D. (外形) (mm)	I.D. (内径) (mm)	Thickness (厚み) (mm)	Q'TY (数量) (枚)	Value (評価単価) (¥)	Total Value (評価額) (¥)
1	Separator Disk & Spacer	φ 220.0	φ 130.0	25.00 t	50 枚	10,000	500,000
Total					50 枚		¥500,000

IV. Separator Spacer (セパレーター Spacer)							
NO	Name (Material etc) 品名 (材質等)	O.D. (外形) (mm)	I.D. (内径) (mm)	Thickness (厚み) (mm)	Q'TY (数量) (枚)	Value (評価単価) (¥)	Total Value (評価額) (¥)
1	Separator Spacer (Urethane&Steel)	φ 190.0	φ 130.0	35.00 t	20 枚	5,000	100,000
2	Separator Spacer (Urethane&Steel)	φ 190.0	φ 130.0	25.00 t	29 枚	4,000	116,000
3	Separator Spacer (Urethane)	φ 190.0	φ 130.0	50.00 t	7 枚	1,000	7,000
Total					56 枚		¥223,000

V. Others				
NO	Name (品名)	Q'TY (数量)	Value (評価単価) (¥)	Total Value (評価額) (¥)
1	Floating Sheet	4 枚	70,000	280,000
Total		4 枚		¥280,000

I ~ V. Grand Total	¥3,676,800
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