



HIGH VOLUME LASER BLANKING LINE - BWD LINE 1 SPECIFICATIONS

Line	Gauge Range (Inches)		Coil Width (Inches)		Coil Weight Max (lbs)	Coil Size ID and OD (Inches)		Pallet Weight Max (lbs)	Pallet Height Max (Inches)	Blank Width and length (inches)		Blank Weight Max (lbs)	Materials						
			Min	Max		20.0	24.0			15.75	165.0		HR	CR	CO	SS	EX	ALM	AHS
BWD 1	0.024	0.12	15.75	84.5	77,000	20.0	24.0	22,000 Lbs	26.0	15.75	165.0	110	X	X	X	X	X	X	X
	0.024	0.12				32.5	78.0												

Line	Gauge Range (MM)		Coil Width (MM)		Coil Weight Max (kg)	Coil Size ID and OD (MM)		Pallet Weight Max (mT)	Pallet Height Max (mm)	Blank Width and length (MM)		Blank Weight Max (kg)	Materials							
			Min	Max		508.0	609.6			400	2150		HR	CR	CO	SS	EX	ALM	AHS	
BWD 1	0.6	3.0	400	2140	35,000	508.0	609.6	10	710.0	400	2150	50	X	X	X	X	X	X	X	X
	0.6	3.0				825.5	1981.2													

COIL SPECIFICATIONS		MIN	MAX	Unit
MAXIMUM COIL WEIGHT			35,000	kg
			77,000	lbs
STRIP WIDTH		400	2150	mm
		16	84	inch
COIL OD		774	1981	mm
		35	78	inch

MATERIAL SPECIFICATIONS		MIN	MAX	Unit
MILD STEEL				
STRIP THICKNESS		0.60	3.0	mm
		0.02	0.12	inch
Tensile strength Rm		270	600	N/mm ²
Yield strength Re		150	480	N/mm ²

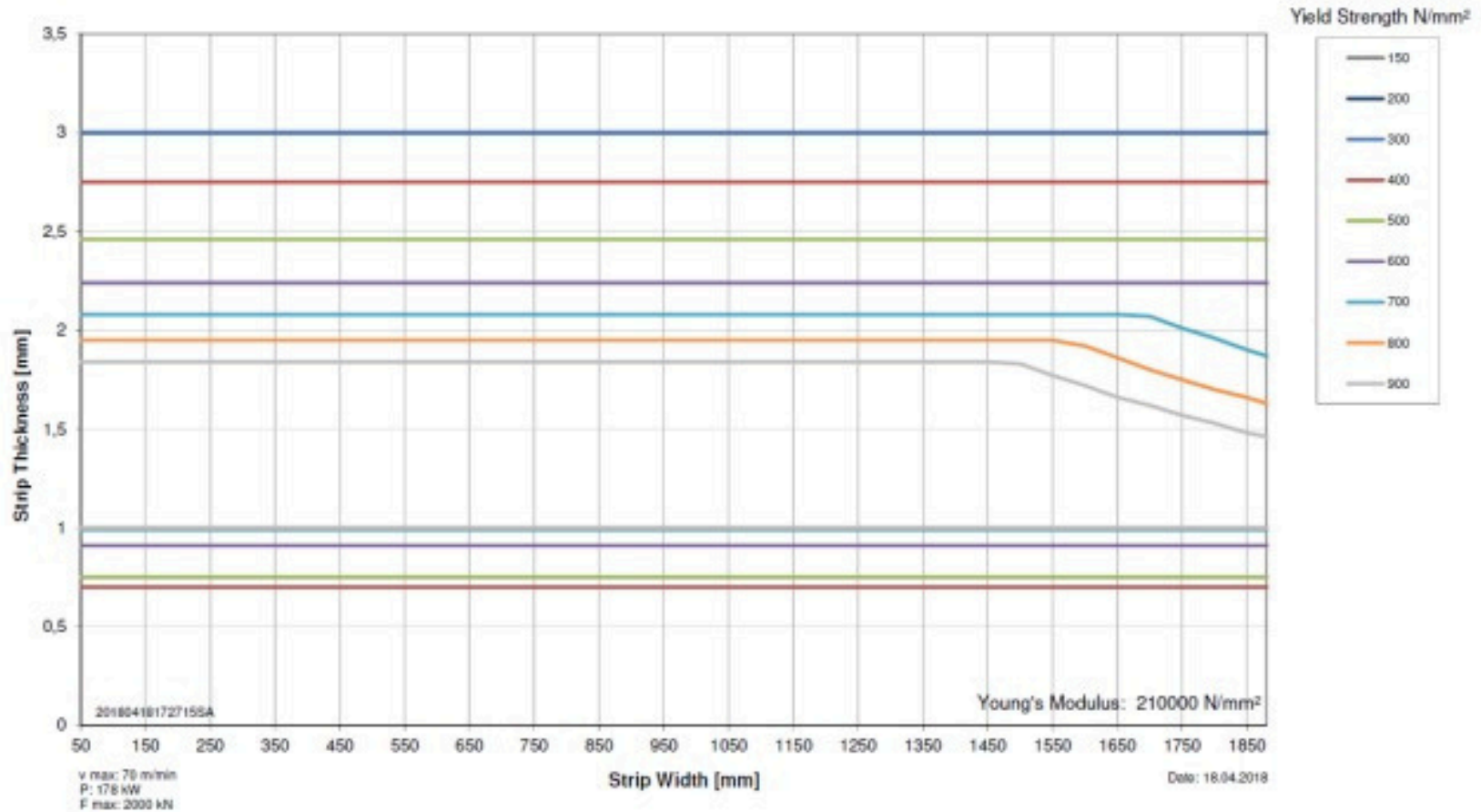
HIGH STRENGTH STEEL		MIN	MAX	Unit
STRIP THICKNESS		0.60	3.0	mm
		0.02	0.12	inch
Tensile strength Rm			1000	N/mm ²
Yield strength Re			1200	N/mm ²

ALUMINUM		MIN	MAX	Unit
STRIP THICKNESS		0.7	3.0	mm
		0.03	0.12	inch
Tensile strength Rm			140 - 450	N/mm ²
Yield strength Re			85 - 280	N/mm ²

BLANK SPECIFICATIONS		MIN	MAX	Unit
Length with handover robots		600	4200	mm
		24	165	inch
Length without handover robots		400	4200	mm
		16	165	inch
Width		400	2150	mm
		16	85	inch
Blank weight, max.			50	kg
			110	lbs.
			10	t
Stack weight, incl. pallet, max./cart			11	tn. Sh.
			710	mm
Stack height			28	inch

SCRAP SPECIFICATIONS		MIN	MAX	Unit
Min. length passing gap & slide bars (laser 1 finished cut)		250		mm
		10		inch
Min. length passing gap & slide bars (laser 2 finished cut)		125		mm
		5		inch
Max. length falling into debris gap under laser			130	mm
			5	inch
Max. scrap diagonal for falling into the debris gap under the laser			175	mm
			7	inch
Max. scrap diagonal for falling onto the scap conveyor belt (in case of a 5-blade slitter device)			800	mm
			31	inch

LEVELLING CAPABILITY CHART AC-SBAC-17-50-212-1880-900-70



The straightening diagram shows the possible processing spectrum of the straightener at defined grades of penetration. The minimal possible elongation is >5%. At complex materials deviate the real material characteristics to the assumed calculation model. Material properties could be influenced by previous processes for example, cutting, bending or heat treatment. The straightening performance and result need to be checked by practical experience.