

Cold pilger rolling mill

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Description	Manufacturer		SMS (MDM)		
	Year of manufacture / assembly / modification		1977	1978	
	Standard version		Cold pilger mill 3 x 115 VMR		
Indicator	Number of billets		3		
	Feeder system (cont/discont.)		Continuous		
	Strokes per minute (max / actual)		90 / 85		
	Feed rate (mm per stroke)		15.8 / 14.1		
	Filter		Paper band filter		
	shell length; min / max (mm)		14000 / 8000		
	shell diameter, outer/inner (mm)		115 / 89		
	Output diameter, outer/inner (mm)		58 / 53.2		
	Max. shell eccentricity (%)		± 2		
Main motor	Max. power / speed (kW / rpm)		950 / 800		
	Version (AC or DC)		DC		
Rolling tools	Calibrating roller manufacturer		Kind+Co / Century		
	Calibrating roller (diameter x width)		610 x 220		
	Calibrating roller material (material No.)		TQ1 / 1.2344		
	Chrome plated? (y/n) if "y", thickness (mm)		N		
	Calibrating roller hardness (HRC)		> 52		
	Service life of calibrating roller				
	(rel. to km of pilger pipe)	Material Cu	Approx. 350 - 2000		

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Mandrels	Manufacturer		NN		
	Material		1.2363		
	Chrome plated? (y/n) If "y", thickness (mm)		Y	0.003	
	Hardness (HRc)		54 - 56		
Productivity	Operating staff (staff per shift)		1		
	Use of the system (hours per week 1992)		144		
	Time to change the calibrating roller (h)		3.5		
	Time to change the mandrels		1.5		
	shell weight		500		
	Degree of deformation (%)		100		
	Machine availability (%)		76		
	Machine performance				
	Material	Reduction	Theor.	Actual	
		Input – output			
		Dia. x wall thickness (mm x m)	(t per h)	(t per h)	
	SF - Cu	115 x 13 - 58 x 2.4	9.0	6.9	



