Piercing Mill

Piercing Mill, incl. walking-beam furnace		Page 1/2
Description	Manufacturer	INNSE
	Year of manufacture / assembly / modification	1976 / 1976
	Standard version	
Indicator	Max. billet; dia. x length (mm)	120 x 5700
	Min. billet; dia. x length (mm)	80 x 3000
	Billet length; min / max (mm)	7000 / 14000
	Feeder system (cont. / discont.)	Continuous
	Roller application angle (°)	5 - 9 °
	Roller speed (min/max, rpm)	87 - 175
Additional Features	Transverse transport unit	
	Re-sawing unit	
	Inert gas tunnel in the feeder unit	
Main motor	Max. power / speed (kW / rpm)	2 x 700 / 1000
	Version (AC or DC)	DC
Tools	Dimensions of pressure rollers (diameter x width)	116 - 145 x 450
	Dimensions of pressure rollers (dia. x W)	650 x 500
	Roller material (material No.)	1.2343
	Core material of the pressure rollers	1.2343
	Hardness of the outer alloy	1.9080
	Mandrel diameter (mm)	86
	Mandrel material	1.2581
	Service life (rel. to km of bloom) — Rollers	24,2
	Mandrel	3,6
	Pressure roller	36,3

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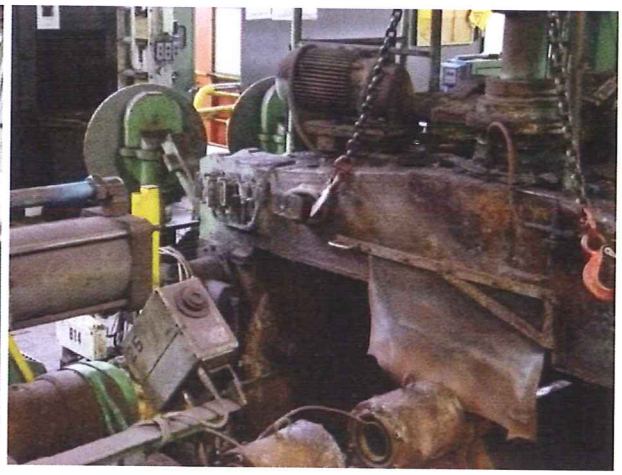
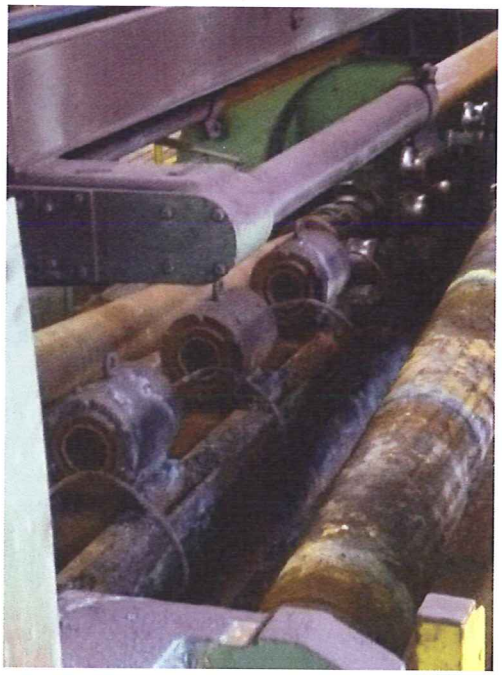
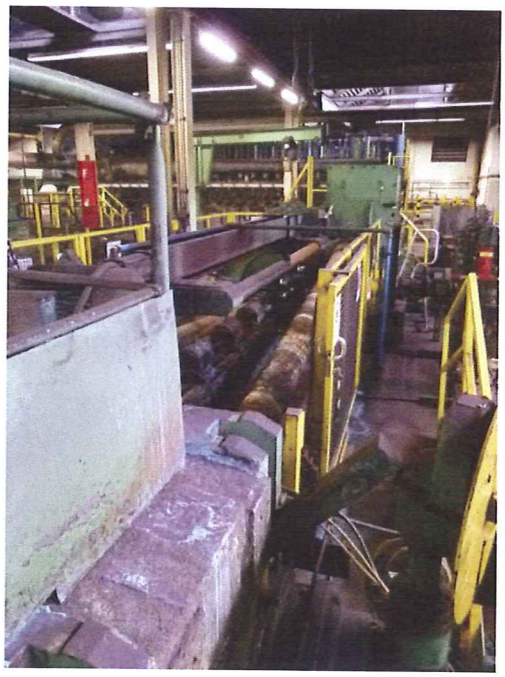
Productivity	22 .) Operating staff (staff per shift)	1
	23 .) Use of the system (hours per week 1992)	120
	24 .) Time needed to change the tools (min)	150
	25 .) Time needed to change the mandrels (min)	2
	26 .) Time needed to change pressure rollers (min)	30
	27 .) Incoming billets Dia. x l (mm)	115 x 5400
	Weight (kg)	508
	Temp (°C)	930
	28 .) Outgoing billets Dia. x width x length (mm)	115 x 13 x 12500
	29 .) Roller speed (rpm)	70 - 90
	30 .) Max. performance (pieces per h)	28
	31 .) Roller application angle (°)	7
	32 .) Degree of deformation (%)	98
	33 .) Machine availability (%)	82

34 .) Machine performance

Material	Reduction Input – output Dia. of raw material / outer dia. x wall	Speed (rpm)	Theor. (t per h)
SF - Cu	115 / 115 x 13	70-90	11.7