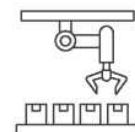




MWM ELEKTRO



PROCESS LINES

LP-6T PRODUCTION LINE



STEEL COIL TRANSPORT PRODUCTION LINE – LP-6T

Purpose

The LP-6T line is the final section of a larger process line used for cutting, coiling and packaging steel coils. It is designed for handling, weighing and packing of previously prepared steel coils. It is made up of 8 types of equipment that, when configured and used with a master control and power supply system, form a complete line.

Design/characteristics

The LP-6T line consists of a set of equipment as well as a master control and power supply system. The line is equipped with a safety system containing laser curtains and sensors, as well as properly designed fencing.

Transport capabilities of the LP-6T line

Transported steel coil characteristics

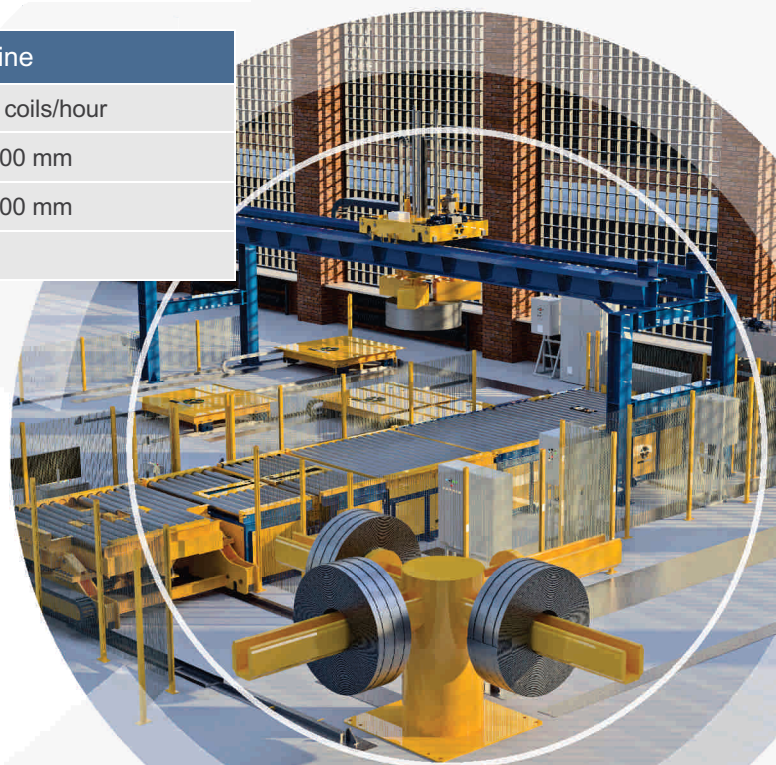
Type of material	Steel
Inner coil diameter	from 508 to 610 mm
Outer coil diameter	from 800 to 2100 mm
Coil height	from 18 to 2500 mm
Coil weight	up to 6000 kg

Technical characteristics of the production line

Production line capacity	max. 60 coils/hour
Maximum stack height of coils	up to 1000 mm
Maximum stack height of coils with pallet	up to 1300 mm
Maximum stack weight of coils with pallet	6000 kg

Main configurable elements of the LP-6T line

- Tippler SW-6Tx2,1
- Rotary roller table SRO-6TX2,1
- Roller table with scale SRW-6TX2,1
- Roller table SR-6Tx2,1
- Centring roller table SRC-6TX2,1
- Receiving platform PO-6TX2,1
- Magnetic conveyor TM-6TX2,1
- Hydraulic power unit HU-500
- Master control and power supply system





TIPPLER SW-6Tx2,1

It is designed for material handling of elements / products from the point of entry of the element on the table to the point of exit of the element from the table and their lifting. During transport, the coils are repositioned within the tippler – coil axis is moved from a horizontal position to a vertical position.



ROTARY ROLLER TABLE SRO-6TX2,1

It is designed for handling of elements / products from the point of entry of the element on the table to the point of exit of the element from the table, as well as their rotation and centring. It is prepared for manual binding of coils with tape or working with an automated binding machine.



ROLLER TABLE WITH SCALE SRW-6TX2,1

It is designed for material handling of elements / products from the point of entry of the element on the table to the point of exit of the element from the table with simultaneous weighing.



ROLLER TABLE SR-6TX2,1

It is designed for material handling of elements / products from the point of entry of the element on the table to the point of exit of the element from the table.



CENTRING ROLLER TABLE SRC-6TX2,1

It is designed for material handling of elements / products from the point of entry of the element on the table to the point of exit of the element from the table with simultaneous centring of its position relative to the receiving element (magnetic conveyor). The steel coil is removed from the table in the upwards direction. Two different diameters of rollers of the centring mechanism are used, depending on the inner diameter of the coil to be transported (rollers are interchangeable).



RECEIVING PLATFORM PO-6TX2,1

It is designed for storage of process line products (steel coils) and taking out of the work zone the unit placing the products on the platform to allow unloading by external equipment (forklifts, overhead cranes). The LP-6T line is equipped with 4 platforms.



MAGNETIC CONVEYOR TM-6TX2,1

It is designed for material handling of elements / products using a gripper unit equipped with electromagnets. Allows a steel coil to be picked up from the centring roller table and placed on the selected receiving platform. Conveyor drive in the vertical axis is provided by a hydraulic cylinder, and in the horizontal axis – by a motor-driven wheeled chassis.



HYDRAULIC POWER UNIT HU-500

It is designed to supply the hydraulic receivers of the magnetic conveyor, tippler, rotary roller table and centring roller table. Provided with double pump sets which are used depending on the control method and speed of the LP-6T line. It is equipped with an efficient heating and cooling system for the working medium.

Basic technical specifications:

- Maximum operating pressure – 175 bar
- Maximum capacity of single pump set – 186 dm³/min
- Main pump drive motor power – 55 kW
- Supply voltage – 400 VAC
- Oil tank capacity – 1200 dm³



MASTER CONTROL AND POWER SUPPLY SYSTEM FOR THE LP-6T LINE

The LP-6T line is powered from the R-04 auxiliary switchgear.

The line's master control system is installed in the MST cabinet as well as on the PG and PS 60 control panels. The system offers several modes of line operation:

- service control mode: allows manual control of individual line components from a dedicated cabinet (built in the vicinity of the unit), is mainly designed for line maintenance and operation.
- semi-automatic control mode: for controlling the technological process using manual binding of steel coils.
- automatic control mode: for controlling the technological process using an automatic coil binder.

The main line operating station is located on the PG control panel (along with the video monitoring system), while it is also possible to control the operation of the receiving platforms from the PS 60 panel.





ABOUT US

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