



DIVIDING SHEARS



SHEARS PURPOSE



The Machine to be installed in existing plant has been calculated and designed to carry out the operations of dividing the rolled stock in multiple of commercial length, before sending them in cooling bed.

The rolled stock, coming from the rolling train and quenched in line passing into thermo processing water box, arrives to the Shear at 550° C.

The Machine cuts the rolled stock in lengths accepted in cooling bed.

The Machine starts and stops at each cut.

SHEARS DATA

THE MACHINE IS DESIGNED AND MANUFACTURES ACCORDING TO THE FOLLOWING DATA:

TYPE		DCS-75	DCS-F50	DCS-115
Machine		Start Stop Dividing Shear	Start Stop Dividing Shear	Start Stop Cropping Shear
Cutting mode		Crack only	Crank + Rotary	Crank only
Cutting force	kN	1060	588	1250
Curring section	mm ²	2900 max (ø60mm)	2000 max. (ø50mm)	8650 max. (ø105mm)
Cutting temperature	°C	550 min	500 min	950 min
Cutting sizes	mm	Ø 32 to 60 (quenched rebar)	8 up to 40 (ø50mm @ 800°C)	Up to ø 105
Steel grade		230 REG, 500B, 550 REG	230 REG, 500B, 550 REG	230 REG, 500B, 550 REG
Cutting radus	mm	280	500 rotary 240 crank	280
Bar linear cutting speed	m/s	1.2 (ø 60mm) 5.5 (ø 32mm)	1.5 (ø 50mm) 15 (ø 8mm)	0.6-2.5
Cutting accuracy	mm	± 30	± 30	± 30
Service factor		≈ 2.2	≈ 2.2	≈ 2.2
Internal gear ratio		1:3,4	1:3,5	1:5,3
Number of knives		1 pair	1 pair	1 pair
Type of knife		Shaped	Flat shaped	Shaped
Motor type		A.C./D.C.	A.C./D.C.	A.C/D.C



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