

# Coil and Flat Sheet Processing

## Processing Parameters

### Line #1

#### Slitting

##### Forstner

Machine	<u>Forstner KA6</u>
PVC Applicator	Yes
Line speed	110 FPM

Accuracy tolerance	.02"
Edge trim required	.375" (.1875" each side)
Minimum slit width	2.5"

	<u>Min.</u>	<u>Max.</u>
Incoming coil weight	n/a	9,500 lbs
Incoming coil width	n/a	50"
Incoming coil OD	n/a	51"
Incoming coil ID	16"	20"
Outgoing coil OD	n/a	51"
Outgoing coil ID	20"	20"

#### Coil Thickness

	<u>Min.</u>	<u>Max.</u>
Steel	0.015	0.066
Copper	0.02	0.036
Aluminum	0.02	0.105
Zinc	.5 mm	1.0 mm

#### Cut to Length

Machine Auto	<u>Forstner</u>
stacker PVC	No
Applicator	Yes
Liner Speed	115 FPM
Accuracy of Length	+/-0.032

#### Coil Thickness

	<u>Min.</u>	<u>Max.</u>
Steel	0.014	0.066
Copper	0.02	0.06
Aluminum	0.02	0.105
Zinc	.5 mm	1.0 mm

### Line #2

#### Slitting

##### Schlebach

Machine	<u>Schlebach Slasher</u>
PVC Applicator	Yes
Line speed	72 FPM

Accuracy tolerance	.02"
Edge trim required	no
Minimum slit width	2.0"

	<u>Min.</u>	<u>Max.</u>
Incoming coil weight	n/a	3,500
Incoming coil width	n/a	49"
Incoming coil OD	n/a	45"
Incoming coil ID	16"	20"
Outgoing coil OD	n/a	45"
Outgoing coil ID	20"	20"

#### Coil Thickness

	<u>Min.</u>	<u>Max.</u>
Steel	0.015	0.058
Copper	0.02	0.036
Aluminum	0.02	0.08
Zinc	.5 mm	1.0 mm

#### Cut to Length

Machine Auto	<u>Schlebach</u>
stacker PVC	No
Applicator	Yes
Liner Speed	72 FPM
Accuracy of Length	+/-0.086

#### Coil Thickness

	<u>Min.</u>	<u>Max.</u>
Steel	0.014	0.058
Copper	0.02	0.06
Aluminum	0.02	0.08
Zinc	.5 mm	1.0 mm