



CONTRACT SPECIFICATION

MATERIAL SPECIFICATION

- Input Material
- : Cold rolled low carbon steel.
 - UTS : 28 to 50 kg / mm² (Full hard material)
 - Strip Thickness : 0.12 mm (min) / 1.0 mm (max)
 - Strip Width : 650 mm (min) / 1500 mm (max)

INCOMING COIL DATA

- Weight : 15,000 kgs. (max) / 3,000 kg (min)
- Inside Diameter : 508 mm
- Outside Diameter : 1920 mm max. / 1000 mm min.
- Flatness : Within 30 l units & No Edge Waviness

OUTGOING COIL DATA

- Material : Pre painted Metal coated strip
- Weight : 15,000 kg (max.) / 3,000 kg (min)
- Inside Diameter : 508 mm
- Outside Diameter : 1,500 mm Max. / 1,000 mm Min.
- Coating : Polyester, PU, & Epoxy
- Coating Range - 5 to 25 µ per side Max.

LINE SPECIFICATION

- Line Type : Single Pass 3 coat 3 Bake Continuous Color Coating Line with Convection Oven.
- Strip flow Direction : Right to Left (As seen from operator side at entry/exit section)

Line Speed

- Entry Section : 120 mpm (max) / 20 mpm (min)
- Process Section : 100 mpm (max) / 20 mpm (min)
- Exit Section : 120 mpm (max) / 20 mpm (min)
- Threading Speed : 20 mpm
- Line Acceleration : 10 mpm/sec

Strip Tension

- Entry Section : 0.5 kg/mm²
- Entry Accumulator : 1.0 kg/mm²
- Process Section : 3.0 kg/mm²
- Exit Accumulator : 1.0 kg/mm²
- Exit Section : 2.5 kg/mm²

Accumulator Capacity

- : 120 Sec @ 100mpm.

TYPICAL COATING REFERENCE (ON POFESTER PAINT)

- Prime Coating (each side) : 4-25µm @ 35-40% solids
- Finish Coating (top side) : 15-25µm @ 45-48% solids
- Back Coat (bottom side) : 5-25µm @ 35-40% solids
- Oven Dwell : Prime Oven - 20 Sec.^{SS}
- : Finish Oven - 23 Sec.^{SS}
- : 0.40 mm X 1200mm @ 100 mpm
- Reference Strip Size : 19.65 Ton / Hr of Ref Strip @ 100 mpm.
- Production Capacity : 10,000 - 130,000 Tons/Year**
- Annual Output :

LINE GA PRELIMINARY RIGHT TO LEFT

REV	DATE	DESCRIPTION	BY	CHKD

ITEM No.	DESCRIPTION	QTY	MATL	RM. SIZE	RM. CODE	RM. WT

<p>MMC Technologies Pvt Ltd</p> <p>LINE GA PRELIMINARY COIL COATING LINE</p>		<p>DRN : 600</p> <p>CHD : N/A</p> <p>APP'D : N/A</p>
<p>DATE : MMC-61-00-000</p> <p>SCALE: 1:200</p>	<p>PREP. :</p> <p>SCALE: 1:200</p>	<p>DRN : 600</p> <p>CHD : N/A</p> <p>APP'D : N/A</p>