Liquidation of Complete State of the Art 1600mm Stainless Steel Cold Rolling Facility

- (2) 20Hi Sendzimir Rolling Mills
- (2) Bright Anneal Lines
- (2) Cut-To-Length Lines
- (2) 2Hi Reversing Skin Pass Mills
- (2) Hot/Cold Annealing Pickling Lines
- (3) Slitting Lines
- 4Hi Reversing Cold Rolling Mill
- CNC Roll Grinders
- Plant Support and More

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1600MM SMS DEMAG ZR21BB-64
SENDZIMIR COLD ROLLING MILL

- Strip width: 850mm - 1600mm
- Strip thickness: 0.6mm - 10mm
- Coil dimensions: 610mm - 1950mm
- Max. coil weight: 23 ton
- Max. rolling speed: 500m/min
- Max. strip tension: 400kN
- Max. rolling force: 16,000kN
- Work roll diameter: 82mm - 105mm
- First IMR rolls: 128mm - 140mm
- Lateral Adjustment: Push - Pull, Hydraulic
- Back-up roll/2st IMR: 228mm - 235mm
- Backing Bearings: 180/406/171mm
- Tension Reel: 3x 1700kW DC Each
- Mill stand motor: 3 x 2000kW DC motors

Revamps and Upgrades
- 2002 Modernization oil wiper system
- 2006 Revamp of all main drives
- 2009 Modernization of all control systems for AFC, AGC
- 2010 Modernization First IMR roll system
- 2011 Modernization power converters main drives
- 2012 Electrical Modernization Pay-off reel

1300MM SMS DEMAG ZR22-52
SENDZIMIR COLD ROLLING MILL

- Strip width: 750mm - 1300mm
- Strip thickness: 0.25mm - 4mm
- Coil dimensions: 610mm - 2000mm
- Max. coil weight: 23 ton
- Max. rolling speed: 450m/min
- Max. strip tension: 400kN
- Max. rolling force: 8000kN
- Work roll diameter: 47mm - 62mm
- First IMR rolls: 97mm - 104mm
- Lateral Adjustment: Push - Pull, Hydraulic
- Back-up roll/2st IMR: 168mm - 175mm
- Backing Bearings: 130/300/172mm
- Tension Reel: 2 x 1025kW DC motors each
- Mill stand motor: 2x 1203kW DC motors

Revamps and Upgrades
- 2001 Modernization First IMR roll system
- 2004 Modernization oil wiper system
- 2005/2006 Revamp of all main drives
- 2008 New mill stand gear box
- 2010 Modernization of AFC, AGC control & PLC systems
- 2011 Modernization power converters main drives
1600MM SCHLOEMANN 2HI REVERSING SKIN PASS COLD ROLLING MILL

Strip width: 500mm - 1600mm  
Strip thickness: 0.6mm - 6.0mm  
Coil diameter: 610mm - 2160mm  
Max. Coil weight: 26 ton  
Max. Rolling speed: 200/400m/min  
Max. Strip tension: 300/150kN  
Max. Rolling force: 12,000kN  
Hydraulic Screw down  
Work roll diameter: 730mm - 780mm  
Barrel length of work roll: 1620mm  
Tension Reels: AC induction motor (2008) 1150kW each  

Revamps and Upgrades
- Complete electrical & mechanical modernization of electrical equipment for rolling mill, new winder gear boxes, winders, mill gear box & work rolls protection

1300MM KRUPP 2HI REVERSING SKIN PASS COLD ROLLING MILL

Strip width: 500mm - 1320mm  
Strip thickness: 0.2mm - 4.0mm  
Coil dimensions: 610mm - 2160mm  
Max. coil weight: 26 ton  
Max. rolling speed: 190/370m/min  
Max. strip tension: 200/100kN  
Max. rolling force: 12,000kN  
Hydraulic Screw down: 150mm  
Work roll diameter: 720mm - 780mm  
Barrel length of work roll: 1440mm  
Tension Reel: 2x 346kW DC motor each  
Mill stand motor: 880kW DC motor each

Revamps and Upgrades
- 2006/2007 Revamp of all main drives
- 2010 Modernization of rolling force & thickness control

1320MM SMS SCHLOEMANN 4HI REVERSING COLD ROLLING MILL

Strip width: 800mm - 1320mm  
Strip thickness: 0.4mm - 4mm  
Coil dimensions: 610mm - 2160mm  
Max. coil weight: 26 ton  
Max. rolling speed: 240/400m/min  
Max. strip tension: 240/140kN  
Max. rolling force: 16,000kN  
Work roll diameter: 320mm - 350mm  
Barrel length of work roll: 1650mm  
Back-up roll diameter: 1180mm - 1260mm  
Barrel length of back up roll: 1380mm  
Tension Reels: 2x 550kW DC motors each  
Mill stand motor: 1000kW DC motors

Revamps and Upgrades
- 2005/2006 Revamp of all main drives
- 2009 Installation of a new twin drive gear box for mill drive
- 2010 Modernization of rolling force & thickness control
- Modernization of main drive and paper winder drive converter
- Modernization of drive control
1300MM GENERAL ELECTRIC BRIGHT ANNEALING LINE

Performance: 11.1T/H N
Max Line Speed: 40M/Min
Monthly Throughput: 6970 ton
Austenetic 1.9%, Ferritic 98.1%
Width: 500 - 1300mm
Thickness: 0.30 - 3.00mm
Entry: (2) Uncoilers, (2) Flatteners, (2) Crop Shears
Welder: Miebach
Degreasing: Pre-Purge, Degreasing, Rinse After Degreasing
Temperature: 60 oC
Strip Dryer: 60 - 120 oC Steam
Furnace / Cooling Type: Electric
Furnace Length: 10.2M
Energy Consumption: 210 Kwh/T
Temperature: Max 1150 oC
Protective Gas: H275%, N225%
Jet Cooler: 20
HNO3 - Electrolytic: Concentration: 12%
Parsytec Surface Detector System
Exit: (2) Recoilers

1300MM DREVER BRIGHT ANNEALING LINE

Performance: 13.2 T/H N
Max Line Speed: 70M/Min
Monthly Throughput: 9080 ton
Austenitic 26.9 %; Ferritic 73.1 %
Width: 800 - 1320mm
Thickness: 0.15 - 1.00mm
Entry: (2) Uncoiler, (2) Flatteners, (2) Crop Shears
Welder: MiebachSeam Welder
Degreasing: Pre-Purge, Degreasing, Rinse After Degreasing
Temperature: 60 Oc
Strip Dryer: 60 - 120 Oc Steam
Furnace / Cooling Type: Electric
Length: 20.8M
Energy Consumption: 220 Kwh/T
Temperature: Max 1150C
Protective Gas: H275 %, N225 %
Jet Cooler: 4
HNO3 - Electrolytic: Concentration: 12%
Exit: (1) Looper, (1) recoiler
Parsytec Surface Detector System

1600MM SUNDWIG HOT/COLD ANNEALING PICKLING LINE

Performance: hot 41.7 t/h N; cold t/h N
Max line speed: 50m/min
Monthly throughput: hot 1300 ton / cold 6300 ton
Coll size: max 26 ton
Austenitic 37 %; Ferritic 63 %
Width: 1000 - 1600mm
Thickness: 0.70 - 8.00mm
Entry: (2) Uncoilers, (2) Flattenner, (2) crop shears
Vertical accumulator
Thermtec Furnace, 3 zones
Length: 41.1m
Gas consumption 430kwh/t
Temperature: max 1250 oc
Gas: natural gas
Cooling section: air / water
Shot blaster: 2 cabinets, 4 wheels each
Brush 2
Na2SO4 - electrolytic:
Pickling bath 1+2
Mixed acid: HNO3 / HF
Temperature: 60 oc
Final rinse: (2) brushes
Exit: (1) recoiler, (1) paper winder

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1300MM SUNDWIG PICKLING LINE

Performance: Hot 26.5t/h N
Max Line speed: 30m/min
Monthly throughput: Hot 16,100 ton
Coil size: max 25 ton
Ferritic 100 %
Width: 900 - 1300mm
Thickness: 1.5 - 5.5mm
Entry: (1) uncoiler, (1) flattener, (1) crop shear
Welder: Dystechnik
Shot blaster: cabin 1 & 2 (4) wheels each
Brushing Unit 1: brushes 2
Pickling bath 1 + 2
Acid: H2SO4, Temperature: 90oC
Length: 2 x 15.5m
Brushing unit 2: brushes 2
Pickling bath 3
Mixed acid: HNO3 / HF, Temperature: 40C
Length: 13m
Brushing Unit 3: brushes 2
Final rinse: 2 brushes
Exit: (1) recoiler

1600MM SUNDWIG/ACME MURRAWAY COIL GRINDING LINE

Total length: 46m
Strip width: 550 -1560mm
Strip thickness: 0.3 - 8mm
Coil ID/OD: 610mm - 1850mm
Coil weight max.: 26 ton
Speed range: 10 - 40 m/min
Strip tension max.: 400 KN = 40 ton
Belt polishing/Grinding cabinets: (4) ACME Murraway
Side: Top cut
Grinding speed:
- I and II: 10-15 m/sec
- III and IV: 15-22.5 m/sec
Angle: from 20 to 7 positive negative
Coolant: Mineral oil (from KWW scaffolding)
Turn speed: 1000 l/min per cabin
Grinding method: with cooling oil, positive or negative angle
Sanding belts: Silicon carbide and aluminum oxide
Grain size: 36 to 240, abrasive mat
Motor drives: (2) 160kW DC motors = 320kW

1600MM X 6MM X 29 TON SUNDWIG STAINLESS STEEL SLITTING LINE

Coil Car, "C" Type
Mandrel Type Uncoiler: 508 - 610mm, 110 Kw
Peeler & Straightener
Entry Strip Width Range: 350 - 1600mm
Finished Strip Width: 50 - 1560mm
Max. Coil Weight Uncoiler: 29 ton / Coiler 29 ton
Material Thickness: 0.8 - 6mm
Max. Speed [M/Min]: 180mm
Trimming Width 200 - 1560mm
Strip Tensile Force [Kn]:1.4 - 67
Slitting Head, Shaft Dia: 200mm
(2) Slitting Heads - Liftout
Tension Stand/Device
Recoiler 135kw, Overarm Separator
Paper Winder
Coil Car, "C" Type, Vertical Coil Control Holedown
2-Arm Turnstile
Emg Edge Control
Paper Wrapping
Tooling
Line Direction: Right To Left
Coil Car, “C” Type
Mandrel type uncoiler: 508 - 610mm, 105kW
Peeler & Straightener
Entry Strip Width Range: 150 - 1400mm
Finished Strip Width: 30 - 1350mm
Max. Coil weight Uncoiler: 26 ton / Recoiler: 26 ton
Min. Material Thickness: 0.3-2.5 mm
Max. Speed [M/Min]: 200
Looping Pit
Cutting Knives Dia.: 320 - 260mm
Slitting Heads, Injector, Turntable 2
Slitter Shaft Diameter (mm): 200mm
Paper Wrapping
Tension Unit, 3 Roll Bridle Type, (3) Individual Motor Drives
Recoiler 105 Kw/440 Volt/278 Rpm, Overare Separator
Paper Winder
Coil Car, “C” Type, Vertical Coil Control Holdown
2 Arm Turnstile, At Right Angle
EMG Edge Control
Tooling
Direction: Right To Left
**600MM X 2MM X 13 TON UNGERER STAINLESS STEEL CUT TO LENGTH LINE**

Mandrel Type Uncoiler: 508 - 610mm  
Entry Strip Width Range: 100 - 690mm  
Finished Sheet Length: 500 - 4000mm  
Max. Coil weight Uncoiler: 13 ton  
Material Thickness: 0.3 - 2mm  
Max. Speed (M/Min): 60  
23 Roll Ungerer Leveler, Model Rm900/2/23  
Looping Pit  
Flying Shear Model S-60-900/3  
Paper Wrapping  
Run Out  
Direction: Right To Left

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**ANDRITZ LYNSON V 330 CNC ROLL GRINDER (NEW 2005)**

Length: 3000mm  
Diameter: 30mm - 300mm  
Weight: 1000 Kg max.  
Rotation speed rolls: 0 - 300 rpm  
Rotation speed grinding wheel: 0-4500 rpm  
Support / table speed: 0-15000 mm/min.  
Dimensions grinding wheel: 7  
50 mm x 80 mm (40 mm/CBN) x (305 mm)  
Accessories: Steady rests, air shoes, oil station for roll conservation, automatic balance system for the grinding wheel

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**ANDRITZ LYNSON V 645 CNC ROLL GRINDER (NEW 2006)**

Length: 4500mm  
Diameter: 100mm - 645mm  
Weight: 3000 Kg max.  
Rotation speed rolls: 10 - 300 rpm  
Rotation speed grinding wheel: 50m/s  
Support / table speed: 0-10000 mm/min.  
Dimensions grinding wheel: 750 mm x (305 center) x 80 - 100 mm  
Accessories: "Focke" chuck for the grinding wheel, steady rests, air shoe's

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**DEHN AUTOMAT/SCHMALTZ CNC ROLL GRINDER**

Length: 7000mm  
Diameter: 78mm - 105mm  
Weight: 200 Kg max.  
Rotation speed rolls: 0 - 300 rpm  
Rotation speed grinding wheel: 35m/s  
Support / table speed: 5000 mm/min.  
Dimensions grinding wheel: 750 mm x (305 center) 100 mm  
Accessories: Bosch control Typ3osa PNC-R

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**NAXOS UNION W1400 ROLL GRINDER**

Length: 4000mm  
Diameter: 1400mm  
Weight: 20000 Kg max.  
Rotation speed rolls: 0 - 44 upm  
Rotation speed grinding 0 - 1000rpm  
Support / table speed: 0 - 3000mm  
Dimensions grinding wheel: 600 mm x (305 center) x 80 mm  
Accessories: steady rests, mechanical component for crown and taper grinding, different gearwheels
(3) NAXOS UNION W500 ROLL GRINDERS

Length: 4000mm
Diameter: 500mm
Weight: 2000 Kg max.
Rotation speed rolls: 11 - 66 rpm
Rotation speed grinding 100 - 1000rpm
Support / table speed: 20mm - 4000mm
Dimensions grinding wheel: 600 mm x (203 center) 40 - 60 mm
Accessories: steady rests, mechanical component for crown and taper grinding, different gearwheels

NAXOS UNION W400 ROLL GRINDER

Length: 1500 - 4000 mm
Diameter: 400 mm
Weight: 1000 Kg max.
Rotation speed rolls: 13 - 78 rpm
Rotation speed grinding wheel: 12 - 28 m/s
Support / table speed: 50 - 3000 mm/min.
Dimensions grinding wheel: 600 mm x (center 203 mm) x 50 mm
Accessories: Steady rests, mechanical component for crown and taper grinding, different gear wheels

SCHMALTZ WR4/2000 ROLL GRINDER

Length: 2000 mm
Diameter: 400 mm
Weight: 800 Kg max.
Rotation speed rolls: 18 - 180 upm
Rotation speed grinding wheel: 800 - 1600 rpm
Support / table speed: 30 - 3000 mm/min.
Dimensions grinding wheel: 750 mm x (305 mm center) x 65mm
Accessories: steady rests, mechanical component for crown and taper grinding

ANDRITZ LYNSON V 330 CNC ROLL GRINDER (NEW 2005) & ANDRITZ LYNSON V 645 CNC ROLL GRINDER (NEW 2006), See Page 7

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