

# Slitting Line Capabilities



Approved by: General Manager  
 Authorized by: Q.A. Manager  
 Date: 3/5/2021

**400 Glover Road, Stoney Creek Ontario L8E 5X1**

<b>Material type processed</b>	Cold Rolled, Galvanized/Galvanneal, HR/PO, Hot Rolled Pickled Dry, Cold Rolled Full Hard, Hot Rolled Pickled Dry Lube		
	Special note: Cannot process Hot Rolled Plain Dry (no processing of unpickled coils) For Hot Rolled Pickled Dry Lube please inquire. Must specify Grade and Yield Strength for all material type processed		
<b>Multi Slitting</b>	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	<b>Gauge Trace</b>	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
<b>Edge Trimming</b>	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	<b>Entry Mandrel</b>	<b>Expanding - Overwind Only</b>
<b>Shape Improvement (Korfex)</b>	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	<b>Exit Mandrel</b>	<b>Latch - Overwind Only</b>

Machine Limitations			
Thickness	.050" - .375"	Charged ID	20", 24"
Charged Width	12" min. / 74" max.	Finished ID	20", 24"
Finished Slit Width <.299"	2" min. / 72" max.	Charged OD	36" min. - 80" max.
Finished Slit Width >.300"	4" min. / 72" max.	Finished OD	80" max.
Charged Weight	80,000 lbs. Max	<i>Finished Sizes Must Equal 12" Minimum for Scrap Choppers</i>	

Max # of Cuts						
Thickness	Number of Mults based on Material Yield Strength					
	<40 ksi	40.1 - 50 ksi	50.1 - 60 ksi	60.1 - 70 ksi	70.1 - 80 ksi	80.1 - 90 ksi
.050" - .064"	30	30	25	21	19	17
.065" - .074"	30	27	22	19	16	14
.075" - .084"	30	20	17	14	14	12
.085" - .094"	26	20	17	14	14	12
.095" - .104"	23	18	15	13	12	10
.105" - .114"	20	16	13	11	10	9
.115" - .124"	20	16	13	11	10	9
.125" - .134"	19	15	12	10	9	8
.135" - .144"	16	13	10	9	8	7
.145" - .154"	16	13	10	9	8	7 *71"
.155" - .164"	15	12	10	8	7	7 *66"
.165" - .174"	13	10	9	7	7	6 *62"
.175" - .184"	13	10	9	7	7	6 *58"
.185" - .194"	13	10	8	7	7	6 *55"
.195" - .204"	11	9	7	6	6 *66"	5 *52"
.205" - .214"	11	9	7	6	6 *63"	5 *50"
.215" - .224"	11	9	7	6	6 *60"	5 *48"
.225" - .234"	10	8	6	5	5 *58"	4 *45"
.235" - .244"	10	8	6	5	5 *55"	4 *43"
.245" - .254"	10	8	6	5 *69"	5 *53"	4 *42"
.255" - .264"	8	6	6	5 *66"	4 *51"	3 *40"
.265" - .274"	8	6	6	5 *64"	3 *49"	3 *38"
.275" - .284"	8	6	5	4 *62"	3 *47"	3 *37"
.285" - .294"	8	6	5	4 *59"	3 *45"	3 *36"
.295" - .304"	8	6	5	4 *57"	3 *44"	3 *34"
.305" - .314"	8	6	5	4 *55"	3 *42"	3 *33"
.315" - .324"	6	6	4	4 *54"	2 *41"	2 *32"
.325" - .334"	6	4	4	3 *52"	2 *40"	2 *31"
.335" - .344"	6	4	4	3 *50"	2 *38"	2 *30"
.345" - .354"	6	4	4	3 *49"	2 *37"	2 *29"
.355" - .364"	6	4	4	3 *48"	2 *36"	2 *29"
.365" - .374"	6	4	4	3 *46"	2 *35"	2 *28"
.375"	6	4	4	3 *45"	2 *34"	2 *27"

If >90 ksi please inquire  
 \* Maximum incoming width

# Slitting Line Capabilities

Edge Trim Capability per Side			
Thickness	Minimum	Maximum	Material can also be processed with off-cuts.
.050" - .124"	.1875"	2.5"	
.125" - .249"	.250"	2.5"	
.250" - .375"	.500"	2.5"	
Please include finished slit width tolerances when calculating edge trim allowance, this will ensure the minimum requirements are met.			

Slit Width Capability	
Thickness	Tolerance
.050" - .150"	plus .010 / minus.000"
.151" - .375"	plus .020 / minus.000"
Capability based on slit width equal to or less then 12". Please inquire for others.	

Repair Capability
Entry and exit crop shears.
Defect Removal
Off-gauge Removal
Rewinding narrow mults - 12" min. (Inquire if under 12")

Incoming Telescope
Up to 6" per side can be slit, over 6" please inquire.

Camber Measurement
Not Available

Packaging Line Specifications				
Max. Slit Weight	Min./Max Width	Coil I.D.	Coil O.D.	Max. Package Height
13,875 lbs. at a 48" max O.D. Please inquire for others.	2" to 26"	20 and 24"	30 to 80"	37" Includes material, spacers, and skid height

I.D. Band Size	O.D. Band Size	Plastic Wrap Available
0.750" x 0.020"	1.250" x 0.029"	

**Note:** For any slitting, sidetrimming or packaging requirements that do not conform to the above specifications, please inquire.

**Effective Date: March 5, 2021**