

Cut-to-Length Lines

Steel and aluminium cut-to-length lines — coil range, accuracy and leveller.

Steel cut-to-length line (1600 mm class)

Item	Value
Supported coil sheet	0.28 – 4.0 mm
Coil width	500 – 1500 mm
Coil inner ID	Φ508.62 mm
Max coil weight	12 t
Cutting length	500 – 3000 mm
Length accuracy	+/-0.5 mm within 2000 mm; diagonal within +/-0.5 mm
Working speed	2000 mm per minute
Machine height	1150 mm
Working direction	left to right

Aluminium cut-to-length line (2600 mm class)

Item	Value
Coil material / thickness	Aluminium coil, max 1.5 mm
Coil width	2600 mm
Cut length	4000 mm
Decoiler	5 t hydraulic with loading car; coil OD max 1600 mm, ID 470 – 530 mm
Max working speed	20 m/min
Leveller	15 rolls, 4-high (7 over 8), one feed shaft
Leveller rolls	Φ100 mm, face 2600 mm, 40Cr, HF hardened, hard chrome plated
Backup rolls	4 rows top and bottom, Φ90 mm, 45# steel, HF hardened
Motors	5.5 kW decoiler; 7.5 kW servo on leveller; 5.5 kW shear
Shearing	1.5 mm thickness × 2600 mm width
Run-out table / hydraulics	6 m / two hydraulic power units
Power supply	400 V, 50 Hz, 3-phase

What the leveller is for

Cut-to-length accuracy is decided at the leveller, not the shear. A coil that arrives with retained set or edge damage leaves the line flat only if the leveller has the roll diameter and backup support to flatten it — which is why the two lines above differ so much in leveller specification rather than in cut length.

Machine pages and further reading

- Pipe cutting machines — category — steelpipemachines.com/category/pipe-cutting-machine
- 1600 mm 6 mm cut-to-length line — steelpipemachines.com/posts/1600mm-6mm-cut-to-length-for-sale