

# Steel Coil Slitting Line

SL-1250 and SL-1600 — strip range, tolerances and what decides slit-strip quality.

## Two models, compared

| Parameter           | SL-1250                                         | SL-1600                                  |
|---------------------|-------------------------------------------------|------------------------------------------|
| Strip material      | Cold-rolled, galvanized sheet                   | Galvanized, cold-rolled, hot-rolled coil |
| Strip thickness     | 0.3 – 3.2 mm                                    | 0.35 – 4.0 mm                            |
| Coil width          | 600 – 1250 mm                                   | up to 1600 mm                            |
| Coil inner diameter | 508 mm                                          | 508 / 610 / 750 mm                       |
| Coil outer diameter | max 1600 mm                                     | max 1600 mm                              |
| Coil weight         | max 12 t                                        | max 15 t                                 |
| Coil camber         | —                                               | max 2 mm/m                               |
| Slit strip width    | from 20 mm                                      | —                                        |
| Width tolerance     | +/-0.05 mm                                      | +/-0.05 mm                               |
| Line speed          | up to 25 m/min                                  | threading 10 m/min; 10 – 20 m/min        |
| Line footprint      | —                                               | 20 m × 8 m (L × W)                       |
| Supply              | AC 380 V +/-10%, 50 Hz +/-5%,<br>3-phase 5-wire | —                                        |
| Air supply          | 0.4 – 0.6 MPa                                   | —                                        |

A slitting line takes one wide coil and cuts it lengthwise into narrower coils. The coil is uncoiled, the strip is slit by a set of circular knives, then the individual strips are recoiled under tension. Slitting normally comes before tube making, when the strip width a line needs is not a standard mill width.

## What decides slit-strip quality

- **Width tolerance** — both models hold +/-0.05 mm; this is what the forming section sees.
- **Coil camber** — a cambered coil slits into cambered strips. The SL-1600 states a maximum of 2 mm/m on incoming coil.
- **Knife condition and recoil tension** — they set burr height and coil tightness. Burrs are what mark the forming rolls.

## Machine pages and further reading

- Steel coil slitting line — full specification — [steelpipemachines.com/posts/steel-coil-slitting-line](https://steelpipemachines.com/posts/steel-coil-slitting-line)
- Slitting line category — [steelpipemachines.com/category/slitting-line](https://steelpipemachines.com/category/slitting-line)