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مكتبة خرشة مبرة ليبيا - طرابلس - رقم الهاتف: 01, 091733319 - رقم الهاتف: 02, 0913103162 - رقم الهاتف: 03, 0923103162

Address: Al-Masira Al-Kubra Street / Opposite Al-Jumhouria Bank - Tripoli (Libya)

التنوان: شارع المسيرة الشوري / مقابل مصرف الجمهورية - طرابلس (ليبيا)

For Our Clients in Libya

Technical Specification & Quotation For Rebar Rolling Mill Production Line.





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العنوان: شارع المسيرة الكبرى / مقابل مصرف الجمهورية - طرابلس (ليبيا)

Design principle

The basic designing principle of the proposed rolling process and equipment is to implement the applicability and practicability, reliability and economy principle. Also a good investment return has been considered sufficiently. So the solution can achieve high product standards, meanwhile low investment.

All the technical parameters of the proposed solution are in conformity and the relevant professional provisions of the People's Republic of China and ISO.

Design features

- Long life & superior quality, ISO9001-2000 certified, robust infrastructure & precisely well tested.
- High durability & reliability, hydraulic & clamping adjustments & low maintenance requirements.
- Design high quality standards, customized solutions available & built with latest hi-tech equipment.
- Axial, horizontal & vertical adjustments, easy and convenient to install successfully.
- Safe & simple to operate then machine successfully, sturdy, elegant, compact, heavy duty, user friendly designed.
- Design as all type of metals can be molded into tubes, sheets and wires.

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1. Summarize

Subject: 50000tpy production capacity of deformed bar.

FOB Price: **Tianjin USD 1,676,000.00 Excluding the sea shipping**

2. Technical specification

Raw Materials: scrap

Finished product: $\Phi 8 \sim 25$ mm deformed bar.


Comprehensive production capacity: 6-8T/ Per hour.

Technological process shall be as follows:

Scrap-- melting in furnace-- continuous casting--rough rolling mill-- Hydraulic head cutting ---end cutting--continuous rolling ---cooling system-- Dividing shear---collection device--inspection & acceptance--labeling-- Weigh-- Storage.

Production features: Production line shall be short process layout with compact arrangement and smooth operation, which lower the investment of production cost.

3. Equipment Composition

No.	Equipment Description	Unit	QTY	Remarks
I	$\Phi 350 \times 1$ roughing mill	Row	1	
1	ZD Reducer	Set	1	
				
2	Three-axle gear box	set	1	



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3	Three roller mill housing	Stand	1	
				
4	Roller	Piece	3	
				
5	Cardan shaft	Piece	3	



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6	Special bearing for rolling mill	Set	12	



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7	Bearing box	Piece	6	
8	Motor	Set	1	
9	Flying shear	Set	1	
10	Rolling mill, gearing box, motor base and couplings	Set	1	



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II	φ250 One drive with two mills	Row	4	
1	Mill housing	Stand	8	
2	Gearing box	set	8	
3	Compound reducer	set	4	
4	Motor	Set	4	



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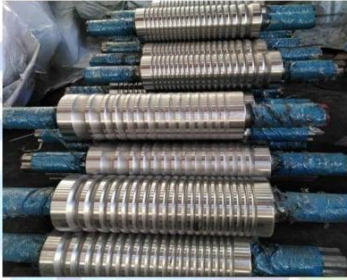

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5	Roller	piece	8	
				
6	Cardan shaft	Piece	8	
 <p>شركة Miza Company for Import & Export</p>				
7	Special bearing for rolling mill	set	64	



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8	Bearing box	Piece	16	
				
9	Rolling mill, gearing box, motor base and couplings	Set	4	
				
III	Walking cooling bed (40*6)	Set	1	



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IV	Roller table			
1	Delivering roller table	Set	1	
2	Roller table in front of billet machine	Set	2	
3	Lifting platform	Set	1	
4	Cantilever roller table	Row	3	
5	Output roller table of cooling bed	Set	1	
6	Roller table with fixed dimension	set	1	



V	Accessory equipment			
1	Electric controlling system for rolling mill 1) Distribution cabinet & start-up cabinet Subsidiary start-up cabinet	set	1	



2	Water system	Set	1	
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3	Dilute oil lubrication station	Set	1	
				
4	Air compressor system	Set	1	
				
5	Water treatment device	Set	1	
				
6	Hydraulic head cutting shear & end cutting shear	Set	2	



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7	Multiple flying shear	Set	1	
				
8	Pinch roll	set	2	
				
9	Cold shearing device	Set	1	
				
VI	Smelting equipment			



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1	<ul style="list-style-type: none"> ● Two tones Induction furnace (Three motors with three furnaces) ● Equipment cabinet & switch box ● Furnace body ● Furnace sheer and loop ● Reactor ● Capacitor (1.6-1600-0.5) ● Bracket & foundation of capacitor ● Reducer, bracket, flange and furnace ● Water separator (stainless steel pipes are installed properly) ● Cable & wire ● Copper bar (well connected to capacitor & copper bar) ● Underwater cable, including copper wire and various type of reinforced pipes. 	set	3	
2	<p>Continuous casting machine (70x70, R4000)</p> <ul style="list-style-type: none"> ● Main part: R4000-70, single flow ● Arc frame (R4000) ● Blank drawing machine, hydraulic station, type 20. ● Roller table (12m) ● Dummy bar (R4000-70) ● Tundish (800×750×650) ● single level transducer with distribution box. ● Manual controlling cabinet to monitor the Tundish. 	set	1	



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VII Scrap Shredder 350

No.	Item	Qty	Unit	Remarks
1	Heavy duty & seamless chain apron feeder	1	Set	15kw
2	Two roll pre-crushing forced feeder	2	Set	11kw
3	Heavy duty machine 350	1	Set	Plate thickness: 50mm
4	Vibration feeder	2	Set	2X7.5kw vibration motor
5	Material output belt conveyor. 800mm width (2ps) , 600mm width (1pcs)	3	Pcs	
6	Start cabinet 500	1	Set	Special motor 350
7	Magnetic separator	1	Set	
8	Magnetic pulley	1	Set	
9	Motor 350KW	1	Set	
10	Operation platform	1	Set	



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11	Centrifugal dust separator	1	Set	
12	Pulsed pocket dust collector	1	Set	Fan 18.5kw
13	Circulation water tank	1	Set	
14	Hydraulic station	1	Set	11kw
15	Rotor disk (60mm thickness)			Including scuff Sleeve
16	Hammer	40	Kg	One Set
17	Sieve			120mm thickness
18	Main bearing ϕ 210	1	Pcs	Forging 42crmo
19	Couplings	1	Pcs	Type 250
VIII	Dust collector body			
1	Air reservoir			Including relevant pipeline
2	Discharge hopper			
3	Filter-bag			
4	Skeleton			
5	Impulse valve			
6	Opening access			
7	Air intake			
8	Air drain			
9	Pulse port			
10	Draught fan			
11	Electrical control system			
12	Umbrella dust collecting cover			
13	Sparkler			
14	Terrace			

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Each stand shall be complete with:

Rolling mill body assembling, including a set of preliminary rolls

1. Roll material: nodular pearlitic cast iron
2. Roll body hardness : C3-C6 : 50-55HS/C7-C12 : 55-65HS/C13-C18:70-75HS
3. Large Base of Rolling Mill: Including Roll Change Transverse Moving Device and Frame Locking Device. The Locking Device of Rolling Mill is opened by spring locking hydraulic pressure.
4. Small base of rolling mill: supporting roll system and sliding on large base
5. Universal axle: retractable
6. Joint Bracket: Hydraulic type. Hold the sleeve at the end of the roll when changing the roll of the rolling mill.
7. Guide beam: steel plate welded structure, supporting and fixing guide
8. Piping of rolling mill: rolling mill hydraulic piping and lubricating piping are made of stainless steel and equipped with quick change joint, which is convenient for roll change.
9. The main motor of rolling mill is equipped with base and welded by steel plate.



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10. Hydraulic Cylinders for Stand Traversing Device, Stand Extraction Device and Coupling Holder

Inter Stand Loopers

Loop is used to achieve tension-free rolling to achieve better product quality.

Loop setting height: 250mm

Loop stability zone: ± 50 mm

Loop height adjustment range: 0-400mm

Loop length: about 2150 mm

Number of fixed rollers:2

Fixed roll spacing: 1300mm

Diameter of screw down roll and jacket roll: 188mm

The looper shall be complete with: Pneumatic Cylinders, Electro-Pneumatic Equipment,

Mill Stand By-Pass Roller Tables

Function: When flinging the stand , the rolling piece is conveyed, and the base is shared with the rolling mill.

Roll spacing: 1000mm

Roller: Hollow roll, wall thickness 20mm

Bearing: SKF/FAG Products

Inter-Stand Guides & Channels

Location: between all mechanical equipment of roughing and finishing mill

Function: Supporting and guiding the rolled piece into the mill

Structure: The guide is installed on the guide beam of the rolling mill stand, and the guide groove is welded steel plate structure.

Water Treatment system (TMT) Line

Cooler Form: Bomeni Model (Venturi Tube Form)

Temperature of water-cooled pre-rolled parts: 900-950 C

Minimum tempering temperature of water-cooled rolled piece: 550 C

Cooling water temperature: 35 C

Dividing shear (including motors)

Usage: Shearing the rolled piece by double length

Location: Before the Cold Bed

Type: crank rotary combination(Crank Eccentricity: 220mm Rotary Radius: 500mm)

Motor: DC motor drive

Maximum shear force: 450 KN

Rolling speed: 2.0~16 m/s

Rolling temperature: ≥ 500 °C

Dividing shear run-out roller table

Position: After the Dividing shear.

Function: Conveying the rolled piece from the exit of flying shear to the direction of cold bed roller, speed variable frequency speed regulation



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Type: Variable Frequency Motor Drive Separately

Frequency conversion range: 5 ~ 80HZ, with fan cooling, regular refueling and lubrication.

Step Cooling Bed Body

Function: Through the interactive action of dynamic and static racks, the rolled piece is conveyed slowly. During the conveying time, the shape of the rolled piece is kept stable, and the rolled piece is cooled to the temperature required by the process.

Performance description: Stepping cooling bed consists of the following main parts: cold bed transmission device, moving beam, static beam, moving beam bracket, static beam pillar, moving rack and static rack. The cold bed transmission device includes: motor, reducer, long shaft and eccentric wheel.

Cooling type: air cooling

Cooling rod size: $\phi 8-\phi 40$

The entry temperature of the rolled piece into the cold bed is 550-650°C

Maximum Cooling Temperature: max300°C

Dynamic and static pitch: 80mm

One step rack movement stroke: 80mm

Spacing between static and dynamic racks: 200mm

Rack material: 16Mn

Lubrication: Centralized Dry Oil Lubrication

Alignment rollers

Performance Description: The alignment roller of the cold bed is installed at the end of the output side of the cold bed. By aligning the roller, the rolled materials on the cold bed are aligned at one end to prepare for the next bed and finishing.

Roller body size: $\Phi 140 \times 650$ mm

Number of roll grooves: 8

Tooth pitch: 80mm (same as rack tooth shape)

Roller speed: 0.4 m/s

Roll spacing: 1200 / 1000 mm

Power: 1.1 KW

Concentrate on dry oil lubrication, harden the surface of alignment rolls, increase wear resistance and improve the service life of rolls.

Transfer Trolley

Performance description:

The transport trolley conveys the rolled material collected in the transfer chain to the output roller of the cold bed, which has the functions of lifting and transverse movement. The transverse movement function is accomplished by chain dragging. The chain is fixed on the car, which drives the car to move forward and backward on the chain bracket.

Chain spacing of steel shifter: 1600 mm

Transfer step: 20~70 mm

Vehicle speed: 0.5 m/s (variable frequency adjustable)

Chain pitch: 38.1 mm



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Lubrication: Centralized Dry Oil Lubrication.

Cold Shear with Fixed Length

Usage: Fixed-length shearing of finished products after cold bed in bar workshop

Structural form: fixed upper tangent

Maximum shear force: 500t

Shear blade opening: 140mm

Cutting edge width: 1200mm

Cutting edge inclination: 1.2°

Shear times: 18 times per minute

Shear steel section: $\phi 8$ - $\phi 40$ mm

Shear temperature: $\leq 300^{\circ}\text{C}$

Chain Transfer

Function: Transport the cut bar to the transport chain

Location: After shearing and conveying rollers

Type: Individual transmission

Specification of Rolled Parts: $\phi 8$ - $\phi 40$ mm

Roller speed: 1.5 m/s

7. Technical Service Contents

The main design services include:

1. Responsible for the complete design of the system, and responsible for the integrity and reliability of the system.
2. Responsible for system schematic design, product manufacturing design, product supply of contract equipment, and responsible for the production progress and quality of contract equipment.
3. Power supply and distribution design related to transmission control.
4. Selection (or supply) of on-line measuring instruments related to electric drive/automation.
5. Application software design and programming.
6. The corresponding interface for cooperation and coordination with other system suppliers.

Environmental Conditions

The design of the proposed equipment is based on the following environmental installation and operation conditions:

Elevation above sea level $\leq 1000\text{m}$

Electric room ambient temperature: $-5 \sim 40^{\circ}\text{C}$

Maximum humidity in electrical room: $< 95\%$

8. Automation Control System

Principles of Equipment Selection

It can fully meet the requirements of the system for realizing various process control functions.



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The server station is located in the main control room, which is used for system debugging, fault diagnosis, system management and maintenance, temperature monitoring of main drive motor and other fault alarm signals, so as to facilitate maintenance personnel to detect the operation status of equipment. The portable programmer is equipped with Ethernet interface and related programming debugging and monitoring software, which can be operated in the main control room. The system is programmed, debugged and maintained at any place such as station. The system is equipped with WINCC 7.0 industrial configuration software. It can realize the on-line monitoring of the whole rolling line, the setting of process parameters, the storage and analysis of various historical data, and form various historical trend recording curves, which provide the basis for the analysis of equipment faults and quality production accidents, and carry out necessary operation control, parameter setting correction and dynamic display of rolling mills and other equipment. Charts and charts, with fault alarm, display, storage and printing functions. According to the requirement, the method of combining model theory calculation with system self-learning statistical correction can be used to form rolling process parameters tables of various specifications, which can be easily modified manually

Main Drive System

System characteristics:

1. SIEMENS 6RA80 DC full digital single quadrant control system is adopted. The control unit adopts Siemens original control device 6RA80. The rectifier unit has high quality thyristor made in China, and the excitation is reversible.
2. The motor uses a speed-measuring code disc, and the system is double closed-loop control of speed and current. The DC circuit between cabinets is connected by copper bars. All copper bars are processed by 823.
3. The rectifier cabinet should be equipped with over-voltage protection, pulse amplifier circuit, necessary instrument indication, etc. The power unit can directly accept the trigger pulse signal from the original digital device of Siemens.
4. The power unit has trigger pulse indication to show the working status of each power element, and has the function of component and integrated fast fuse signal indication and alarm, which is convenient for maintenance personnel to check and maintain equipment.
5. Schneider products are used for low voltage electrical appliances in cabinets except for special requirements.
6. Data communication between 6RA80, CBP communication board and PLC is realized through PROFIBUS_DP network. The transmission system is equipped with motor temperature and bearing temperature inspection function. It can directly receive PT100 and other temperature measurement signals and transmit them to PLC and HMI operation stations through PROFIBUS-DP network for recording and alarming.



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In the modern hot rolling line, the automation degree is high, the rolling rhythm is fast, and the product quality is also high. In the computer control system, there is a key program, which plays a scheduling role in the operation of all functional control programs, which is the tracking program. The tracking program is to simulate the state of the hot metal detector and the pressure load relay (HMD, LR) of the flat roll stand on the rolling line, and then indicate the actual position and running state of the billet on the rolling line, so as to achieve the purpose of scheduling.

In actual rolling, the ON/OFF state of HMD and LR mainly depends on the arrival and departure time of the rolled piece (except for a few HMD errors). But for simulating rolling, the ON/OFF state of HMD and LR will also be produced when the non-rolling piece moves on the rolling line. This is the function of the computer in simulating rolling through the hardware interface according to the time sequence. Firstly, according to the actual rolling process and the specific rolling plan, the state sequence of each HMD and LR on the rolling line is calculated according to the model. interface to control the actual HMD and LR secondary detectors in time sequence. Then the input interface is adopted into the state of each detector, and the tracking program can be like real rolling. The scheduling function is produced at the same time.



If you do not use hardware, such as in the laboratory stage or when the field process interface is not complete, you can only use pure software mode to work. That is to use computational roll-call in distributed system database instead of detector roll-call. At this time, the detector signal will not be directly used in the computer input interface, but will be used in the rolling roll-call and the signal after the operation or operation.

The analog state and time sequence of each detector are determined in advance according to the die rolling scheme. After the determination of the rolling plan, the specific time series data (also the plan data at the time of rolling) are generated in advance according to the process model and the time sequence of each state change in the detector to form the data of rolling plan in combination with words and stored in the computer for easy operation.



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If the formulation of the above method is only for reference, it can be flexibly combined according to actual needs. In the actual operation of the die rolling program, the above combination words are decomposed, the ON/OFF state is sent out according to the detector number specified in the field and in time sequence, and then the corresponding secondary detector is controlled by the output of the computer interface. This is the basic principle and realization method of realizing the simulated rolling.

Simulations of speed and speed of die rolling program setting are carried out. Slow mode is used to discover faults in programs and equipment. Fast mode is used to simulate actual rolling rhythm. The advance of slow mode timing is to be confirmed by the operator, otherwise it will stop at this detector. This is for important detectors.

The generation of die rolling scheme data is a key problem in the concrete realization of simulated rolling. For the rolling mill that has been produced, if the new computer system and the simulated rolling function are equipped, the ON/OFF state of the detectors can be acquired through the actual rolling sequence, and the data of the die rolling scheme can be combined after finishing, which is a very simple and practical method. However, for the newly established production line, the function of die rolling can only be completed by off-line generation in advance.

Data generation theory of die rolling scheme is the calculation theory of various models and parameters in rolling process. Specific calculation is divided into two series, the first is the ON state timing calculation of each detector, and the second is the OFF state timing calculation of each detector. When two series of time series are calculated and merged into one time coordinate, the complete simulated rolling scheme data are formed. In rolling simulation of multi-block steel, the same scheme data can be obtained by repeated calls and staggered coordinate origins.

Simulated operation of analog regulation and control function

In the computer control function of hot strip mill, most of the logic control function is called action program. They can simulate normal operation under the scheduling of tracking program. The above-mentioned method has met the requirements of simulated rolling for general manufacturers. The testable control functions of simulated rolling include model setting calculation of process mill, APC program of rolling line tracking, all roller control, sequence control of reversible rolling mill and related equipment, and main speed control.

In order to improve the efficiency of die rolling and enlarge the scope of action, various necessary signals such as pressure, temperature and tension are provided by the die rolling program, and the signal changes during actual rolling can be simulated online, so that the analog control program can run correctly during die rolling.

10. Design and Manufacturing Standards

Standards for the design, manufacture, quality control and inspection of equipment, spare parts and materials shall be in line with international standards. Adopt international standards or national



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and industrial standards equivalent to international standards. In the same kind of standards, high-grade standards should be implemented to ensure that the physical quality of equipment and materials reaches the same level of equipment and materials in the same kind of production line in China.

9.1 Domestic Standards of China

GB /China National Standard

YB /Metallurgical Industry Standard

JB /Machinery Industry Standard

Design

1. The Seller shall carry out the basic and detailed design of equipment, spare parts and materials in accordance with the standards stipulated in the Contract, and shall be responsible for the integrity and correctness of the design.
2. The Seller shall be responsible for the correctness of the drawings, technical information, technical standards and valid documents relating to the Contract Works.
3. The buyer has the right to review and propose amendments and supplementary opinions to the design made by the seller. The seller shall cooperate actively and take full account of the buyer's opinions and requirements. The buyer's review does not relieve the seller of the responsibility for the design.

Equipment Manufacturing

1. The seller is responsible for the technology, quality, complete sets and progress of the manufacturing equipment. The buyer has the right to audit the design, manufacturing process, inspection and other contents and methods of the equipment, and to participate in the manufacturing process and pre-factory testing and inspection of the equipment.
2. Sellers should formulate construction plans and quality control systems for equipment manufacturing, and strictly manage progress and quality. Sellers should formulate construction plans and quality control systems for equipment manufacturing, and strictly manage progress and quality.
3. The Seller shall formulate manufacturing processes: mainly including technology (drawings), process preparation, smelting, casting, forging, welding, heat treatment, physical and chemical inspection, machining, parts process inspection, assembly, packaging and transportation, etc.

Quality Control and Inspection in Manufacturing Process

Manufacturing equipment, spare parts of metal materials (including ferrous metal materials, non-ferrous metal materials), non-metallic materials, welding materials, lubricating materials and so on should have factory certificates, and the seller should conduct quality spot checks. Seller shall not use seriously rusted or defective materials in the manufacturing process of equipment. All welding processes, such as welding process, welding preparation, welding, welding correction,



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post-weld heat treatment, post-weld surface treatment, weld quality inspection and weld repair, must comply with relevant standards.

To inspect the composition and internal defects of castings, sandblasting and grinding the surface, and the surface roughness meets the standard requirements. Inspection and implementation of steel castings industry standard JB/ZQ5000IV.

The forging ratio, physical and chemical properties and heat treatment of the forgings should meet the JB/ZQ5000 standard.

Mechanical processing accuracy should meet the requirements of design drawings and related standards.

The quality inspection of each process in the manufacturing process must be documented.

The surface treatment and anti-corrosive coating of the equipment should be machined, polished, pickled and rusted to obtain a clean and smooth surface. General non-processing surface painting, processing surface coating protection.

Inspection of equipment before leaving factory

Before leaving the factory, complete completion data should be prepared, including completion drawings and product quality certification documents. The certification documents include material certification and inspection, test report, component assembly and assembly inspection and test record, weld quality inspection record and non-destructive inspection report, casting and forging inspection report and heat treatment report of other components. The original documents should be complete and accurate in handling records of major quality defects.

The Seller's Quality Inspection Department completes the self-inspection of the equipment and the equipment is assembled. The Buyer sends relevant personnel to the Seller to participate in the commissioning inspection of the equipment.

Assemble the rolling mill and other equipment, test the assembly clearance, whether the components are flexible or not, etc.

The buyer has the right to refuse the acceptance of the visa, otherwise the seller is responsible for the delay in delivery.

For the inspection of the equipment subcontracted by the seller, the seller organizes the time-line inspection from the buyer to the subcontractor's site. For some reason, if the buyer fails to participate in the inspection, the seller's representative shall be responsible



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11. Picture show





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Short stress mill

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Vertical looper





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Increasing gear box



Pinch roll





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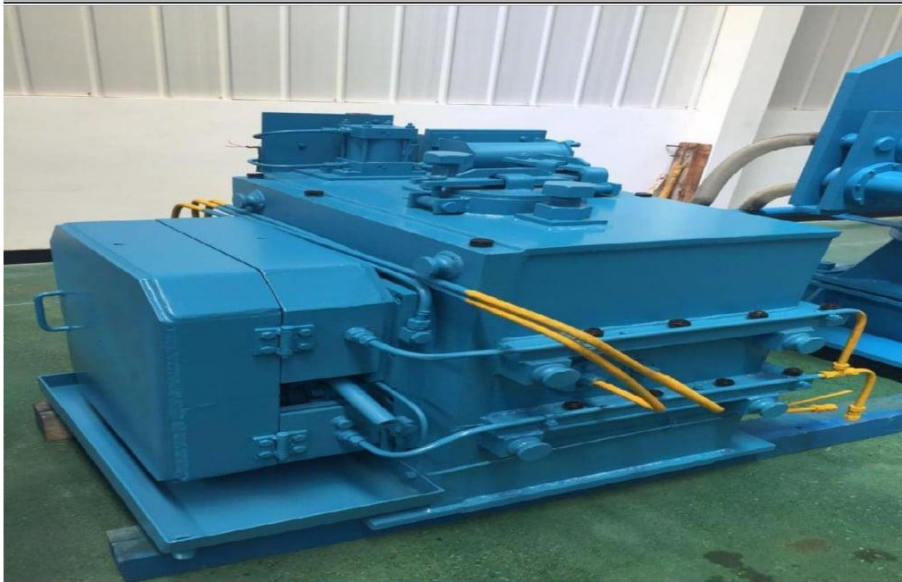
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Flying shear



Pinch roll





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Cooling bed



Factory view



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Rough mill





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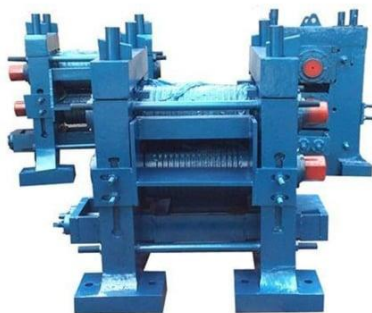
Head cutting shear



Power cabinet



Material Input roller table





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<p>90m spiral bevel gear</p> 	<p>135m Bevel gear of bevel box</p> 
<p>90m, 135m front panel of roll box</p> 	<p>90m Rear side panel of roll tank</p> 
<p>90m,135m eccentric locking collar</p> 	<p>Roll shaft</p> 
<p>Taper sleeve</p>	<p>10 - inch roll box, adjust lead screw and nut</p>



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135 m slip ring



90m Sealing ring of roll tank



Protective cap



135m cone Box



Spare Parts





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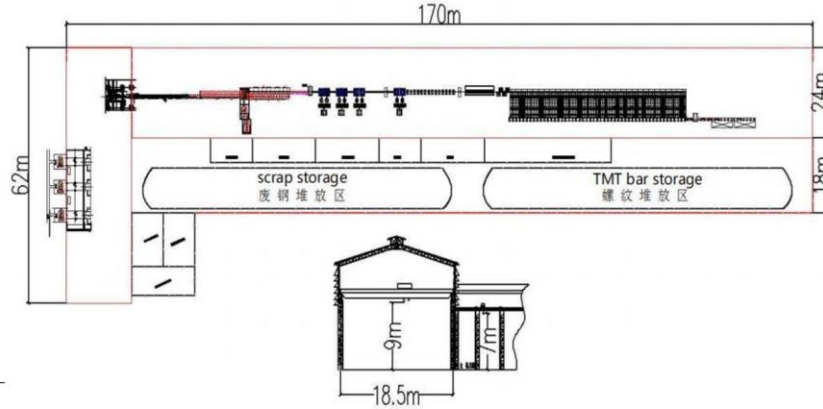
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12. Layout



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13. Oversea Project Cases

Thailand (Double high speed bar rolling line, with annual capacity 1.2 million tons, output speed 40m / s)

Myanmar (Annual output of 400,000 tons, output speed 70m / s high-speed wire production line)

Ethiopia (Annual capacity 400,000 tons, output speed 70m / s ,high-speed wire production line)

Indonesia (Annual capacity 400,000 tons, output speed 70m / s ,high-speed wire production line)

Vietnam (Annual output of 400,000 tons, output speed 70m / s high-speed wire production line)

Vietnam (Annual output of 500,000 tons, output speed 90m / s high-speed wire production line)

Vietnam (Annual capacity 400,000 tons, output speed 70m / s ,high-speed wire production line)

Iran (Annual output of 700,000 tons, output speed 100m / s high-speed wire production line) India (

Annual output of 200,000 tons, output speed 70m / s high-speed wire production line)

Our factory has manufactured rolling mills for more than 60 lines in China, at the same time, under the impetus of "one belt and road", our rolling equipment has been exported to Vietnam, Philippines, Burma, Indonesia, India, Iran, Ethiopia and other countries, and has accumulated a lot of experience for overseas manufacturing, installation and commissioning. This time, we trust your company and we expect to serve your company, so as to enhance our friendship. In accordance with the international standards and requirements for the manufacturing process of



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stainless steel wire rod rolling mill, engineers and technicians are sent to form a working group with your company's designers and civil construction unit to jointly agree on the construction schedule, and will provide the equipment installation drawings, assembly drawings, and water, electricity, wind and air lubrication requirements of the equipment, so as to ensure the rapid progress of this project and construction progress. All in all, we will do our best to create high quality projects for you!



شركة ميزة للإستيراد والتصدير

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