

**Matandy Steel and Metal Products**  
**Red Bud Slitting Line**  
**Slitting Equipment Specifications and Processing Capabilities**

4/29/04

**Input Material Data**

Material Type Cold Rolled and Coated Products (**NO HOT ROLLED**)  
 Maximum Tensile Strength 50,000 PSI  
 Maximum Yield Strength 40,000 PSI  
 Minimum Thickness 0.015"  
 Maximum Thickness 0.135"

**Coil Specifications:**

Maximum Entry/Exit Weight 60,000 LBS.  
 Maximum Entry Width 74.5"  
 Maximum Exit Width 72.0"  
 Maximum Entry O.D. 72"  
 Maximum Exit O.D. 75"  
 Minimum Entry I.D. 20"  
 Maximum Entry I.D. 24"  
 Exit End I.D. 20" or 24"

**Slitting Arbor Cut Capacity**

<b>Gauge</b>	<b>Max # Cuts *</b>	<b>Limiting Factor**</b>
.015"-.025"	25	Tooling
.026"-.035"	25	Tooling
.036"-.045"	25	Tooling
.046"-.055"	25	Tooling
.056"-.065"	25	Arbor Deflection
.066"-.075"	22	Arbor Deflection
.076"-.085"	20	Arbor Deflection
.086"-.095"	18	Arbor Deflection
.096"-.105"	16	Arbor Deflection
.106"-.115"	14	Arbor Deflection
.116"-.125"	13	Horsepower
.126"-.135"	12	Horsepower

Minimum Mult Slit Width \*\*\* 1.000" (Slit Width Tolerance +/- .005")  
 Minimum Scrap Trim (total) .5" (.250"/side)

Notes: \* Maximum Number of Cuts Must Include Trim, Higher Line Speeds May Reduce Max. Number  
 \*\* Max # of Cuts and Limiting Factor May Be Affected By Master Coil Width (< 72") and Setup Configuration (Centerline or Offset).  
 \*\*\* Actual Minimum Width May Be Less Than 1.000" And As Narrow As 0.810", Consult With Operations Management For Specific Requests.

**Additional Features:**

Maximum Line Speed is 1350 F.P.M. with 14.0" Diameter Slitter Knives.  
 Non-Contact Thickness Gauge - Monitors and Records Material Thickness Through Out Entire Run  
 Herr-Voss, 5 High 19 Roll Precision Leveler-Enhances Final Mult Shape And Reduces Burr  
 5 Strategically Placed Cameras and Centrally Located Display Unit to Assist in Monitoring Process