

## SUCCESS STORY

Performance and  
optimized yield for  
color coated products



METALS

# COIL COATING LINE NO. 2

VOESTALPINE AG AUSTRIA

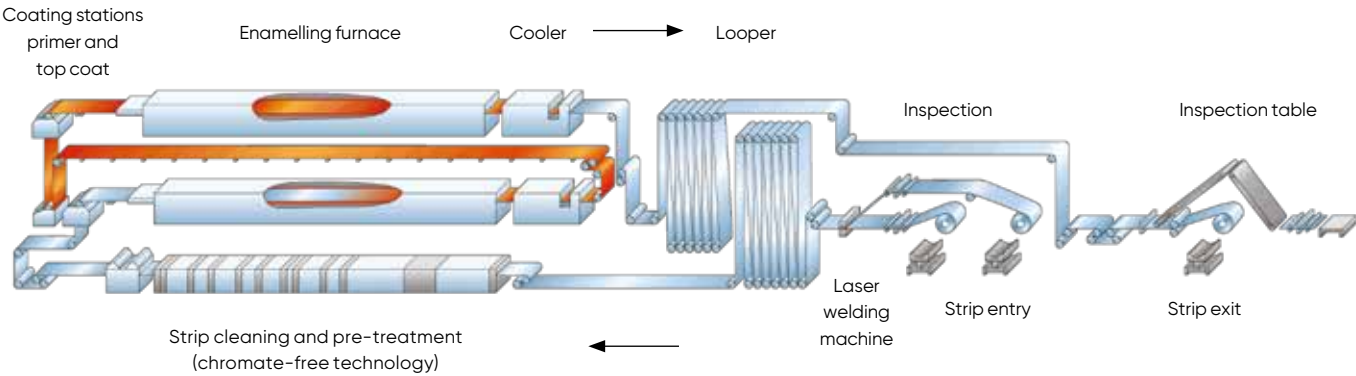
**ANDRITZ**

ENGINEERED SUCCESS



# Coil coating line for highest quality

ANDRITZ Metals supplied a coil coating line for the production of organically coated steel sheets with a strip thickness of 0.4-2.0 mm and a strip width of 700-1,850 mm. The capacity is around 200,000 tons per annum.



### ENTRY SECTION

This section consists of two pay-off reel groups each equipped with a leveller and a crop shear. The head and tail ends of the coils are welded together through a laser welding process in order to create a continuous strip.

### EXIT SECTION

The exit section consists of one coiling reel group as well as a bypass to a separate crop shear in order to cut larger sample quantities.

### STRIP CLEANING AND PRE-TREATMENT

After passing the entry accumulator the strip continues through a horizontal, alkaline strip cleaning to achieve optimal surface conditions for painting. This is done in the fol-

lowing zones:

- Alkaline spray cleaning 1
- Brushing machine
- Alkaline spray cleaning 2
- Cascade rinsing with demineralized (also sometimes soft or de-salted) water
- Chromium-free pre-treatment Dryer

### COATER

The top and bottom coating applies at three stations:

- Prime coater (basecoat on top and bottom)
- Finish coater A (topcoat on top)
- Finish coater B (topcoat on top and bottom)

### ENAMELLING FURNACE

The strip passes through a horizontal furnace in order to condition the

coat. Basically, the holding time is approximately 20 to 25 seconds, in which the hot air is blown directly on the strip. Finally, the outgoing strip has a temperature of about 240° C.

### COOLER

Directly after being enamelled the strip is cooled down from 240° C to approximately 40° C. The cooling takes place in a horizontal stainless steel tank by quenching the strip with demineralized water.

### LOOPER

The vertical entry and exit accumulators compensate any downtime to avoid stops and provide a continuous strip travel in the process section.



Enamelling furnace



Waterquench



Vertical entry looper

### PLANT FACTS

Capacity	200,000 t/year
Strip thickness	0.4–2.0 mm
Strip width	700–1,850 mm
Entry section speed	max. 210 m/min
Process section speed	max. 120 m/min
Exit section speed	max. 210 m/min
Project start	2002
Start of operation	2003





## ENGINEERED SUCCESS FOR FLAT PRODUCT PROCESSING

ANDRITZ Metals is – via the Schuler Group – one of the world's leading suppliers of technologies, plants and digital solutions in sheet metal forming. The product portfolio also includes automation and software solutions, dies, process know-how and service. In the metals processing segment, the business area provides innovative and market-leading solutions for production and processing of flat products, for welding systems, as well as furnaces and services for the metals industry.

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