

Sendzimir 20-High mills: ZR 24

INNOVATION BY DESIGN

Design, Fabrication, Installation, Maintenance

The ZR 24 Sendzimir Cold Rolling Mill is used for rolling a variety of materials, such as low carbon steel, medium and high carbon steel, stainless steels, nickel and nickel alloys, copper alloys and the brasses, nickel silver, phosphor bronze, cobalt bearing alloys, super alloys, and other materials.

This mill section is particularly suited for rolling strip in gauges of approximately 0.0004" (0.01 mm) and up. One of these mills is also used exclusively for rolling 1.25% carbon steel for razor blades. Total reductions of up to 80% are taken without intermediate anneals, with the reduction per pass being between 20 and 30 percent.

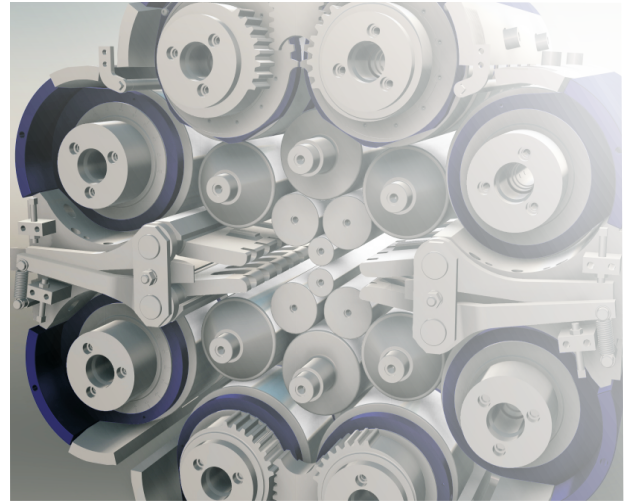
This mill section is supplied either with winders in a solid block configuration or a collapsible mandrel configuration on both entry and exit sides. Of course, almost all mills incorporate the ancillary equipment to load, payoff and unload coils from the mill.

Most ZR 24 mills are sized for 14" strip width. Some recent mills have been sized for 15" and 16" as well. The ZR 24 section has rolled as heavy a starting gauge as 0.150" (3.8 mm) but it is better suited to finish gauge rolling and will finish such strip to a relatively very thin gauge down below the "dark rolling" gauges.

Typical new mills roll up to 350 mpm. The ZR 24 mill housing is based on the Zero Crown housing and incorporates many of the features of the larger mills on a scaled down basis such as; As-U-Roll Crown Control, Hydraulic Lateral Adjust, High Efficiency Sprays, Pressure Boards and Side guides and a sophisticated wiping system.

The ZR 24 is the smallest of the modern mill designs and has by and large superseded the older ZR 32 and 34 mill sections. It uses the modern roll configuration of the mill housing to minimize bearing loads and maximize roll utilization range of all rolls. The ZR 24 Section is an excellent entry level mill suitable for thin gauge rolling. Cost of operation is economical

Compared to the larger housing of a ZR 33 mill, the entry gauge is limited as is the max RSF. However, specified correctly and operated within its size range, no other mill exceeds its capabilities!



<u>ZR 24 Mill Section</u>	<u>Inches</u>	<u>MM</u>
Nominal Work Roll Diameter	0.844	21.5
Backing Bearing Diameter	4.724	120
Minimum Strip Thickness	0.0008	0.02
Work Roll Face: Narrowest Mill	11.5	290
Work Roll Face: Widest Mill	22.5	570
Max Width of Strip: Narrowest Mill	8.5	215
Max Width of Strip: Widest Mill	19.5	500

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