The intermediate shear is intended for head end cropping or continuous chopping of Electrical Conductor (EC), Electrical, and Mechanical Alloy grade non-ferrous rods produced on continuous cast rolling mills.

The shear is sized according to process section being rolled, material grades, and temperature range requirements. The flexible design enables the shear to be matched with the specific current technical requirements and also considers future ambitions.

A cantilevered table located after the electric rotary shear indexes up during “crop cut” signals, allowing automatic deposits of crop sections in a scrap bin. During normal operation the table from the shear guides the front end of the bar to the finishing mill.

Once the bar is successfully threaded into the finishing mill, the table is lowered and a down looper is used to automatically control the tension between roughing mill and finishing mill.

**FIELD OF APPLICATION**
Non-ferrous long rolling mills

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**INTERMEDIATE SHEAR**

FOR PROCESS CONSISTENCY AND RELIABILITY

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**MAIN BENEFITS**

- One-piece modular design offers fast “plug and play” installation
- The combination of robust mechanical equipment with electro-pneumatic controls provides reliable production, low maintenance, and high quality finished product
- During initial thread up, the shear provides a chamfered shape to the leading edge of the bar, resulting in increased yield due to more consistent and reliable thread up
- This design protects the finishing mill equipment and reduces time to clear cobbles by preventing additional material from entering the mill - chopping the remaining upstream material into customized lengths until the cobble can be cleared
- The Primetals Technologies intermediate shear improves operator safety as it minimizes the need for manual intervention and the use of manual hydraulic cutters or other devices during thread up or when cobbles occur in the finishing mill

primetals.com
PRODUCT FEATURES

Rotary multi-blade design
Heavy-duty welded steel construction
Hardened steel knife blades for long life
Independently driven to match rolling speed
ISO quality gearing design to match shear torques
Integrated lubrication system
Full safety guarding

SERVICES

• Integration engineering – customized solutions
• Erection advising – planning and supervision of installation to minimize disturbance of operations
• Commissioning – expertise provided for start-up and training on system operation
• Maintenance – system designed for long life
• Spare parts – customized program minimizes inventory and controls cash flow

TECHNICAL DATA

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
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</thead>
<tbody>
<tr>
<td>Production rates</td>
<td>2 - 54+ t/hr</td>
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<tr>
<td>Typical crop length</td>
<td>500 mm</td>
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<tr>
<td>Finished product sizes</td>
<td>8.0 - 25.0 mm</td>
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<tr>
<td>Grades</td>
<td>Cu and Al EC &amp; Alloys</td>
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</tbody>
</table>

OTHER RELATED PRODUCTS

• Entry shear and table
• Rolling mill stands
• Hydraulic roll mounting
• Rolling mill lubrication systems
• Coil forming equipment
• Coil handling solutions
• Dual reel coiler and automatic unloader