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London, March 8, 2018

## New reversing cold mill from Primetals Technologies produces first coil at Tyasa

- **Complete package for reversing cold mill with a single point of responsibility**
- **Flexible production of diverse range of end products, particularly suitable for small batches**
- **Tight flatness and thickness tolerances, good surface quality**
- **Compact design, for minimized off-gauge and maximized yield**
- **Project completed on schedule within 21 months**

In January, the reversing cold rolling mill supplied by Primetals Technologies to TA 2000, S.A. de C.V.(Tyasa), a Mexican steel producer, has been brought into operation and the first coil was rolled in Tyasa's production plant in Ixtaczoquitlan. The cold rolling mill is another element in Tyasa's strategy of extending its portfolio to include flat products. The mill is designed for an annual production of 200,000 metric tons of low-carbon and high-strength steel grades. The reversing cold rolling mill is designed as a single stand four-high mill, will handle a wide range of end products, and is particularly suitable for small batches. The process equipment and technology packages not only maintain tight flatness and thickness tolerances but also ensure a good quality surface. The compact design minimizes the out-of-tolerance strip thickness. The project was completed on schedule within 21 months.

Primetals Technologies supplied the complete process equipment, electrics and automation from a single source, and was also responsible for supervising the installation and start-up of the plant. The cold rolling mill is designed for an annual production of 200,000 metric tons of low-carbon and high-strength steel grades. It has a maximum roll separating force of 18,000 kilonewton, and allows to produce strips with an entry thickness ranging from 0.7 to 2.0 mm down to exit thicknesses between 0.3 and 1.0 mm. The strip width ranges from 900 to 1,650 mm. The maximum coil weight is 32 metric tons.

The scope of supply from Primetals Technologies included the roll force cylinders – with integrated high resolution position transducers, low friction seal and guiding rod assembly – which form the key element in achieving precise thickness control. The cylinders and other core components were manufactured in

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the company's own workshops, and thoroughly tested before delivery. The production of perfectly flats strips is ensured by advanced work roll bending, multizone cooling of the work rolls and continuous flatness measurements, combined with special technology packages, such as automatic flatness control. For strip blow-off, a special air-nozzle arrangement is used. The design ensures efficient blow-off at all rolling speeds thus contributing to a high surface quality of the rolled strip. The surface quality is further improved by using a Coil Eccentricity Compensator (CECO) model. CECO stabilizes the strip tension and ensures a consistent strip thickness by compensating for any eccentricities in the coil which may have been caused by the clamped head ends of the strips.



4-high reversing cold mill at TA 2000, S.A. de C.V.(Tyasa), Mexico

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