

Production calculation sheet (Cold Rolling)

Based on Aisha pro-mix dated on 20070713

*1 = 5.7 (at 6pass)

0.85

Cold Rolling

No.	Entry thickness	Product thickness	Width (mm)	Production (Tons/year)		Coil Weight (Tons)	Pass No.	Operation Time (min)			Theoretical Prod. Tons/Hour	Achievement Ratio	Actual Prod. Tons/Hour	Required time	
								*1	*2	Total					
1	2.00	0.25	914	10,000	4.55%	18.00	5	5.4	26.53	31.93	33.8	0.85	28.7	347.8	
2	2.00	0.30	914	18,000	8.18%	18.00	5	5.4	23.43	28.83	37.5	0.85	31.8	565.2	
3	2.00	0.30	1,219	7,000	3.18%	18.00	5	5.4	19.96	25.36	42.6	0.85	36.2	193.3	
4	2.30	0.35	914	18,000	8.18%	20.00	5	5.4	22.79	28.19	42.6	0.85	36.2	497.4	
5	2.30	0.35	1,219	7,000	3.18%	20.00	5	5.4	20.26	25.66	46.8	0.85	39.7	176.1	
6	2.30	0.40	914	10,000	4.55%	20.00	5	5.4	21.12	26.52	45.2	0.85	38.5	260.0	
7	2.30	0.40	1,219	18,000	8.18%	20.00	5	5.4	18.22	23.62	50.8	0.85	43.2	416.8	
8	2.30	0.45	914	5,000	2.27%	20.00	5	5.4	19.22	24.62	48.7	0.85	41.4	120.7	
9	2.30	0.45	1,219	17,000	7.73%	20.00	5	5.4	16.76	22.16	54.1	0.85	46.0	369.4	
10	2.30	0.50	914	5,000	2.27%	20.00	3	4.8	15.73	20.53	58.4	0.85	49.7	100.7	
11	2.30	0.50	1,219	17,000	7.73%	20.00	5	5.4	15.44	20.84	57.6	0.85	49.0	347.3	
12	2.30	0.55	914	15,000	6.82%	20.00	3	4.8	14.33	19.13	62.7	0.85	53.3	281.3	
13	2.30	0.55	1,219	12,000	5.45%	20.00	5	5.4	14.44	19.84	60.5	0.85	51.4	233.4	
14	2.30	0.60	1,219	5,000	2.27%	20.00	4	5.1	13.17	18.27	65.7	0.85	55.8	89.6	
15	2.30	0.65	1,219	5,000	2.27%	20.00	4	5.1	12.34	17.44	68.8	0.85	58.5	85.5	
16	2.70	0.70	1,219	5,000	2.27%	20.00	5	5.4	12.81	18.21	65.9	0.85	56.0	89.3	
17	2.70	0.75	1,219	5,000	2.27%	20.00	5	5.4	12.32	17.72	67.7	0.85	57.6	86.9	
18	2.70	0.80	1,219	5,000	2.27%	20.00	4	5.1	11.57	16.67	72.0	0.85	61.2	81.7	
19	2.70	1.00	1,219	5,000	2.27%	20.00	4	5.1	9.31	14.41	83.3	0.85	70.8	70.6	
20	2.70	1.10	1,219	5,000	2.27%	22.00	3	4.8	8.98	13.78	95.8	0.85	81.5	61.4	
21	2.70	1.20	1,219	20,000	9.09%	22.00	3	4.8	7.85	12.65	104.3	0.85	88.7	225.5	
22	2.70	1.50	1,219	6,000	2.73%	22.00	2	4.5	5.62	10.12	130.4	0.85	110.9	54.1	
Total				220,000	100.00%										4,754.1

*1 : Threading and coil handling time

*2 : Rolling time

bcg

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