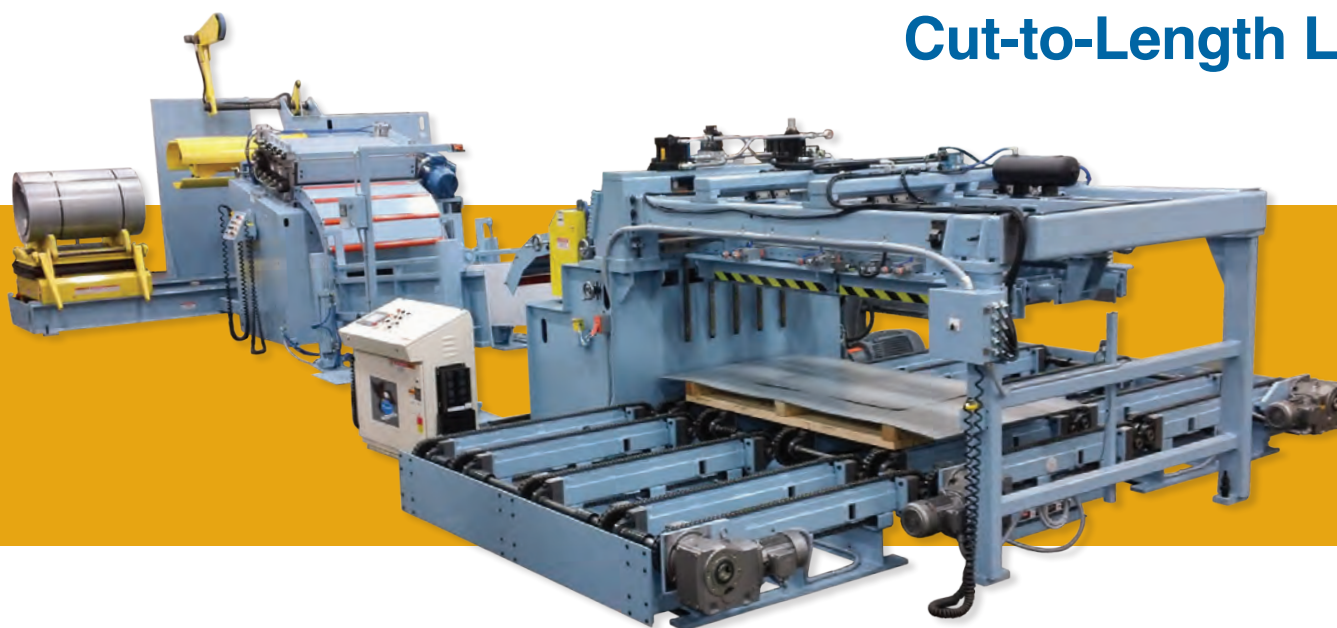




COE Press Equipment Cut-to-Length Lines



For processing of coil from 12"-78" wide, .020"-.500" material thickness, and 6,000#-60,000# coil weights in a variety of materials including CR Steel, HR Steel, Galvanized, Stainless, Pre-painted, and Aluminum.

At COE, we make it happen.

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Why In-House Cut-to-Length?

If you are looking for a competitive advantage, investment in a Cut-to-Length line from COE can bring capability in-house for better operational control, improved quality, and reduced processing costs for quick ROI. With a COE CTL, you benefit from proven designs manufactured with attention to detail by our family of skilled professionals, and backed by the COE Assurance 24/7/365 service advantage.

From light to heavy gauge applications, COE can develop the right CTL solution to fit your unique metal processing needs.



Benefits

- **Outside cost savings**
 - Eliminate \$20 - \$50/ton processing fees
- **Transportation savings**
 - Eliminate \$1.50-\$2.0/mile trucking fees
- **Inventory reduction**
 - Reduce WIP and carrying costs
- **Streamlined process**
 - JIT can be applied to blanking process
- **Improved quality**
 - Easily detect and contain material defects
- **Floorspace savings**
 - Floorspace can be used for value added operations
- **Scrap reduction**
 - Ability to cut-to-size optimizes material usage

Cost Savings

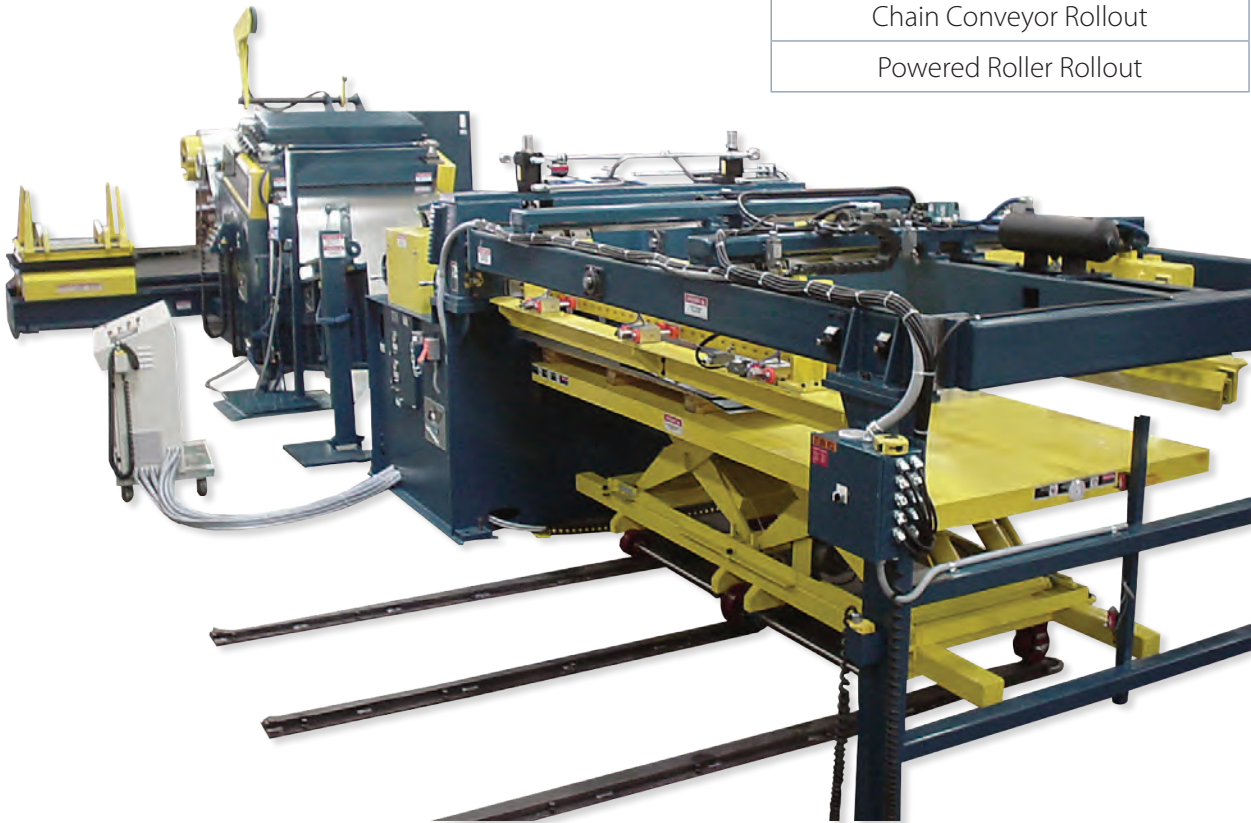
Tons	Toll Rate/Ton	Monthly	Annually
500	\$20	\$10,000	\$120,000
	\$30	\$15,000	\$180,000
	\$40	\$20,000	\$240,000
	\$50	\$25,000	\$300,000
1000	\$20	\$20,000	\$240,000
	\$30	\$30,000	\$360,000
	\$40	\$40,000	\$480,000
	\$50	\$50,000	\$600,000
2000	\$20	\$40,000	\$480,000
	\$30	\$60,000	\$720,000
	\$40	\$80,000	\$960,000
	\$50	\$100,000	\$1,200,000

Factors that Impact Toll Rate: Material Types, Material Thickness, Flatness Requirements, Stress Relieving, Special Packaging, CTL Efficiency, and Transportation.

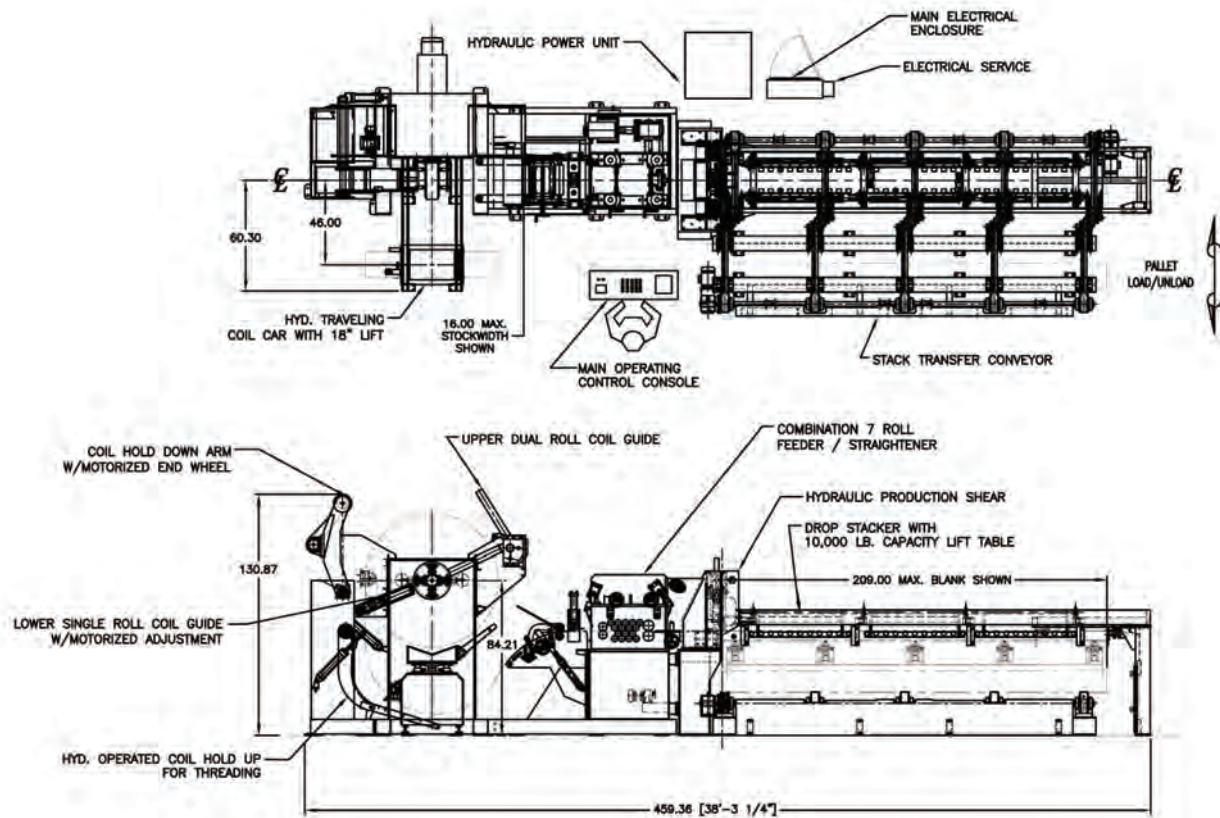


CTL System Considerations

Duty Requirements	Control Systems	Shear Type
Light	ServoMaster Standard	Economy
Medium	Level Two PLC Upgrade	Hydraulic
Heavy	Level Three PLC Upgrade	Mechanical
Typical Coil Line Factors	Machine Set-up	Stacker Type
Width	Threading Systems	Drop
Weight	Manual Set-up	Air Drop
Speed	Motorized Set-up	Finger Drop
Materials	Motorized & Encoded Set-up	Combination Finger/Magnetic
		Stacker Configurations
		Single Station
		Dual Station
		Powered Table Rollout
		Chain Conveyor Rollout
		Powered Roller Rollout

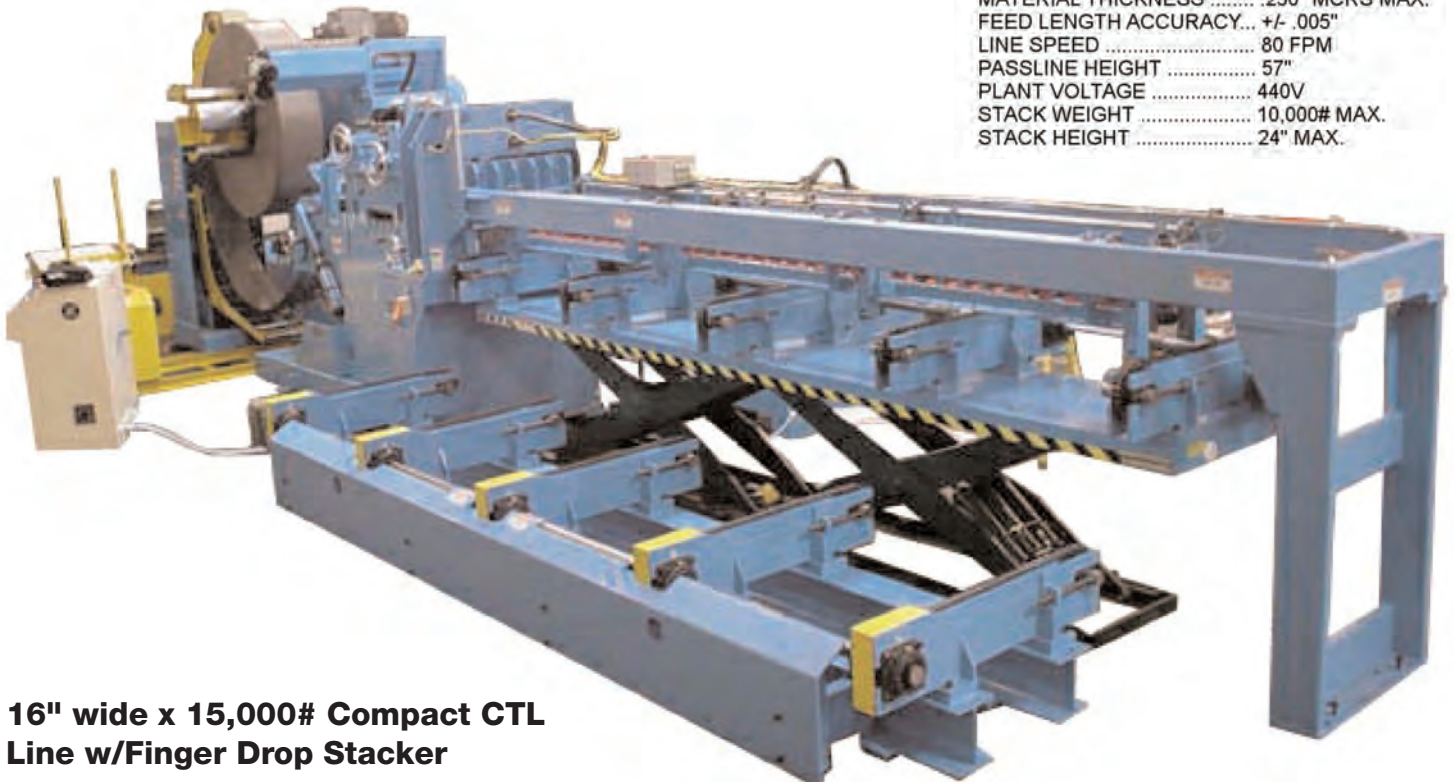


Cut-to-Length Line – Automotive Stamper



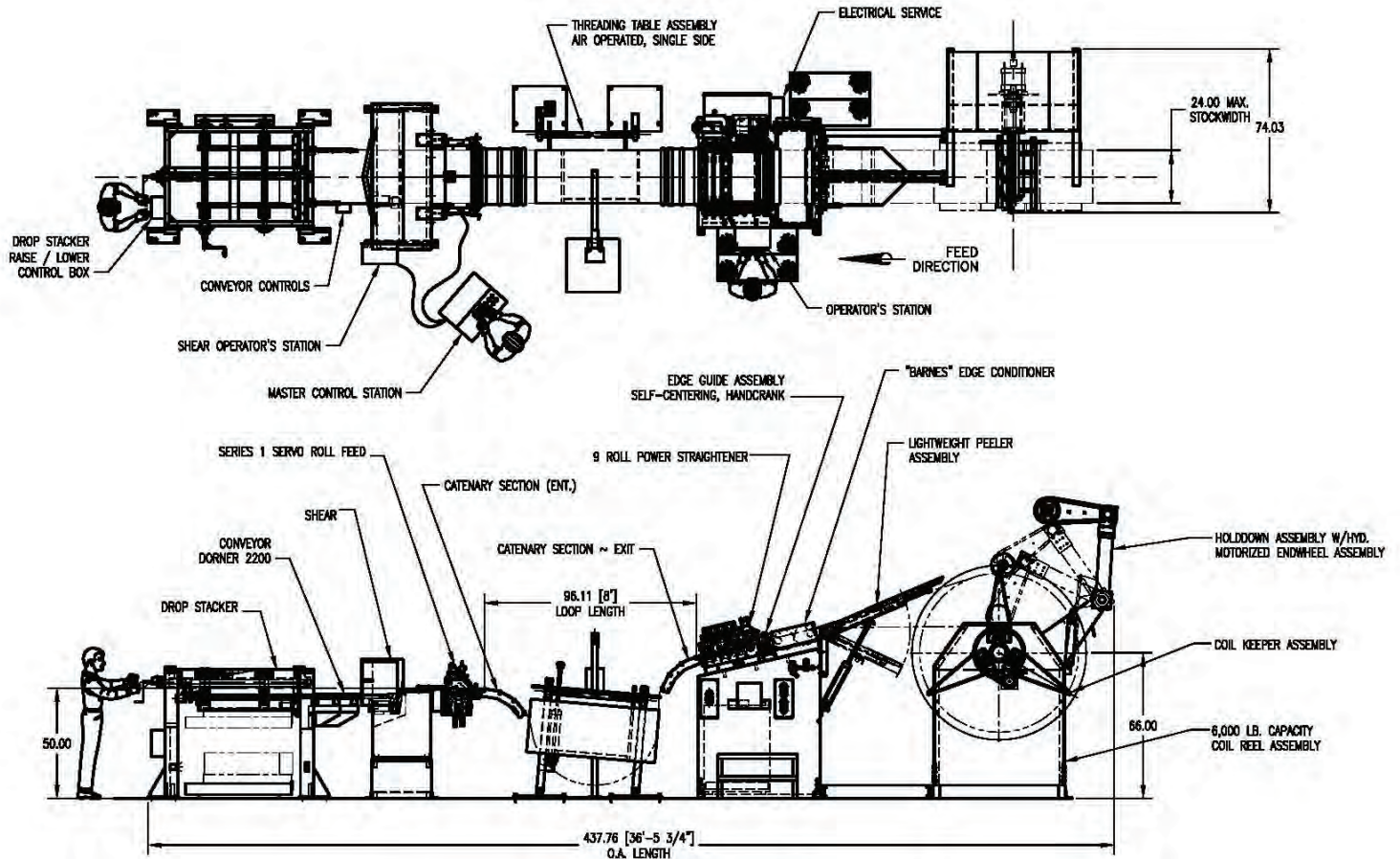
SPECIFICATIONS

COIL WEIGHT	15,000# Max
COIL WIDTH	12" TO 16" MAX.
COIL I.D.	20" NOMINAL
COIL O.D.	72" MAX.
MATERIAL BEING RUN.....	MCRS, HSLA
MATERIAL THICKNESS250" MCRS MAX.
FEED LENGTH ACCURACY....	+/- .005"
LINE SPEED	80 FPM
PASSLINE HEIGHT	57"
PLANT VOLTAGE	440V
STACK WEIGHT	10,000# MAX.
STACK HEIGHT	24" MAX.



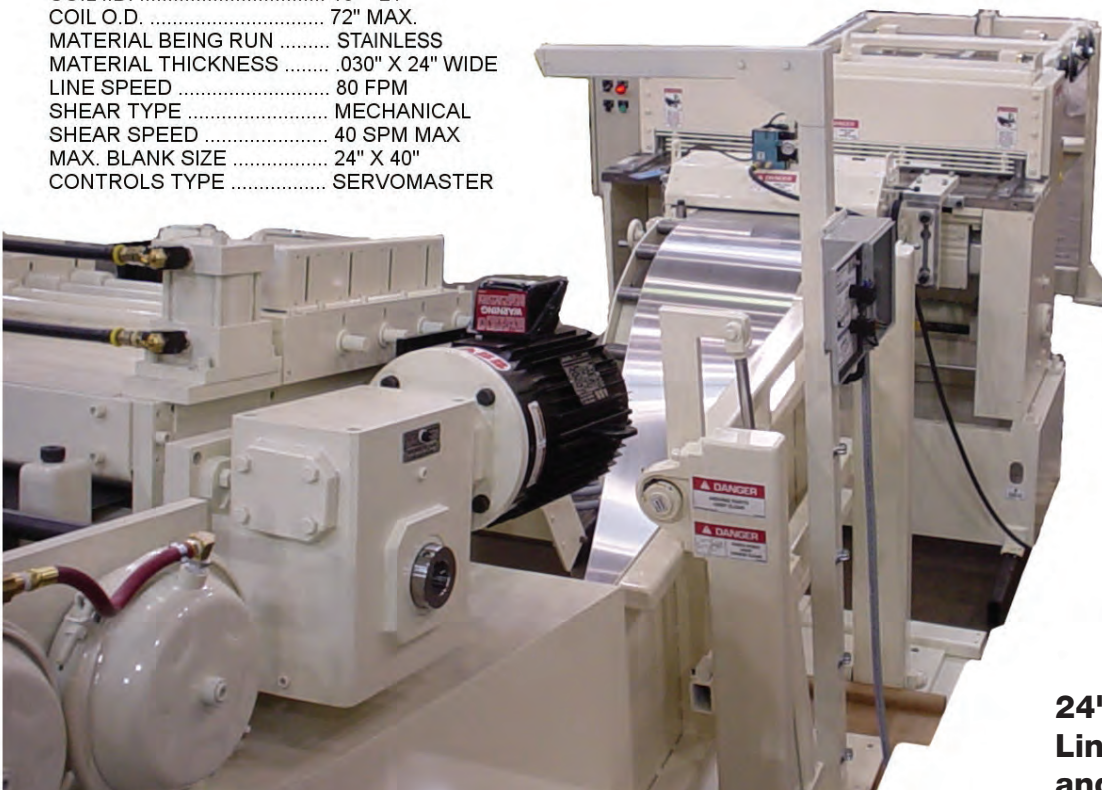
16" wide x 15,000# Compact CTL Line w/Finger Drop Stacker

Cut-to-Length Line – Washroom Equipment OEM



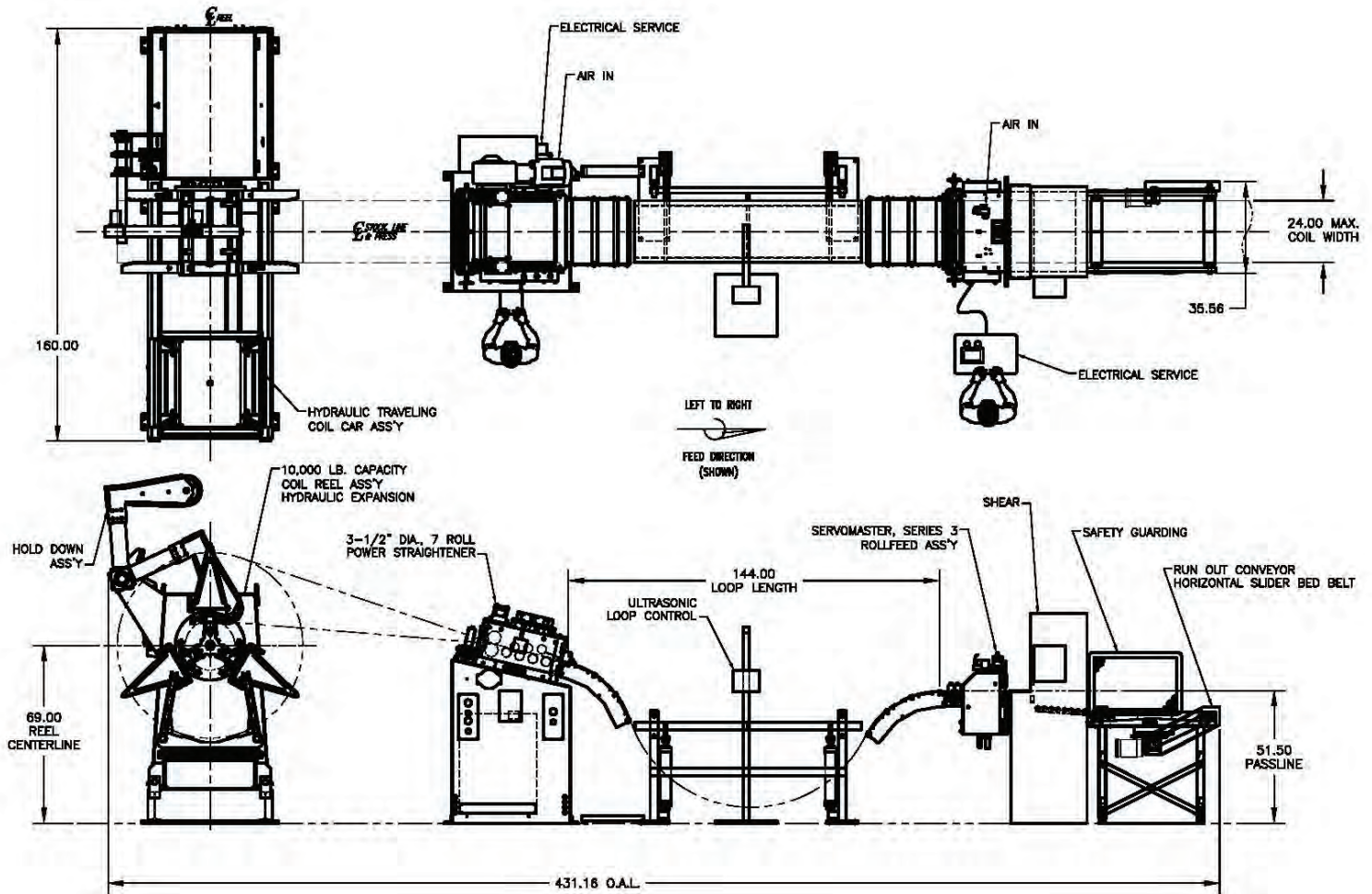
SPECIFICATIONS

COIL WEIGHT	6,000# Max
COIL WIDTH	24" MAX.
COIL I.D.	16" - 21"
COIL O.D.	72" MAX.
MATERIAL BEING RUN	STAINLESS
MATERIAL THICKNESS030" X 24" WIDE
LINE SPEED	80 FPM
SHEAR TYPE	MECHANICAL
SHEAR SPEED	40 SPM MAX
MAX. BLANK SIZE	24" X 40"
CONTROLS TYPE	SERVOMASTER



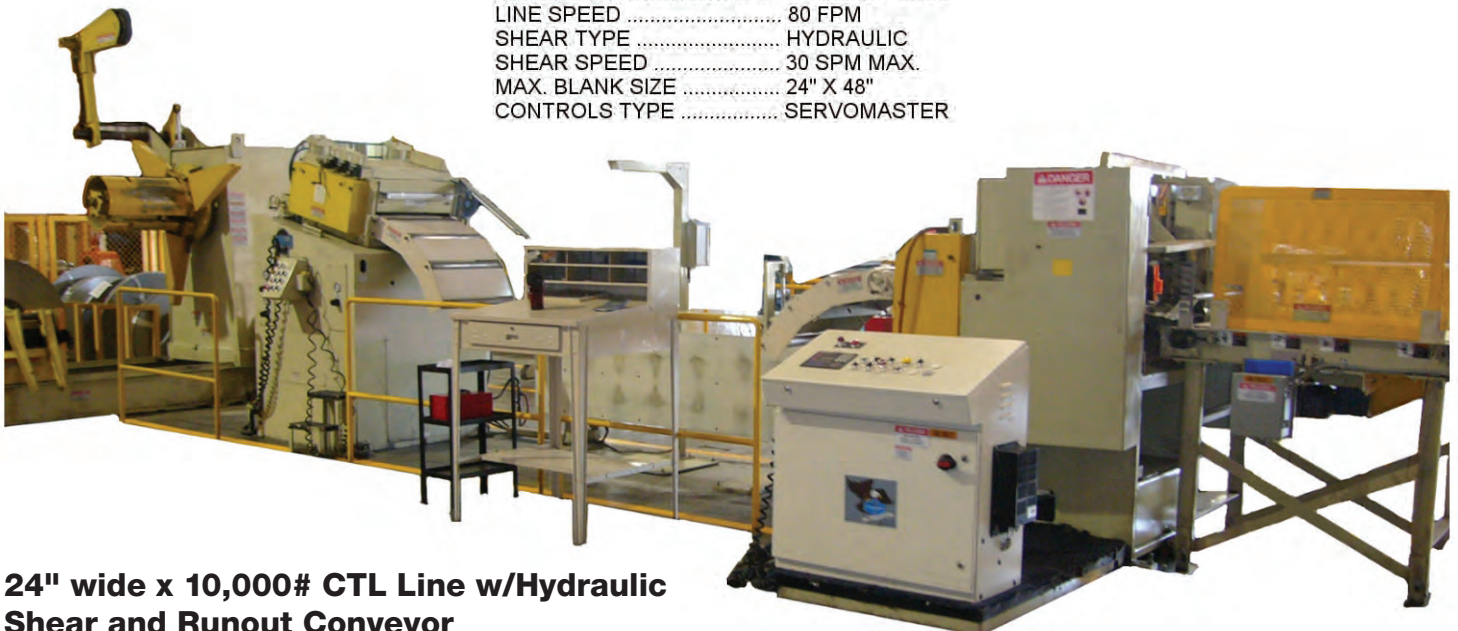
**24" wide x 6,000# CTL
Line w/Edge Conditioner
and Drop Stacker**

Cut-to-Length Line – Steel Service Center



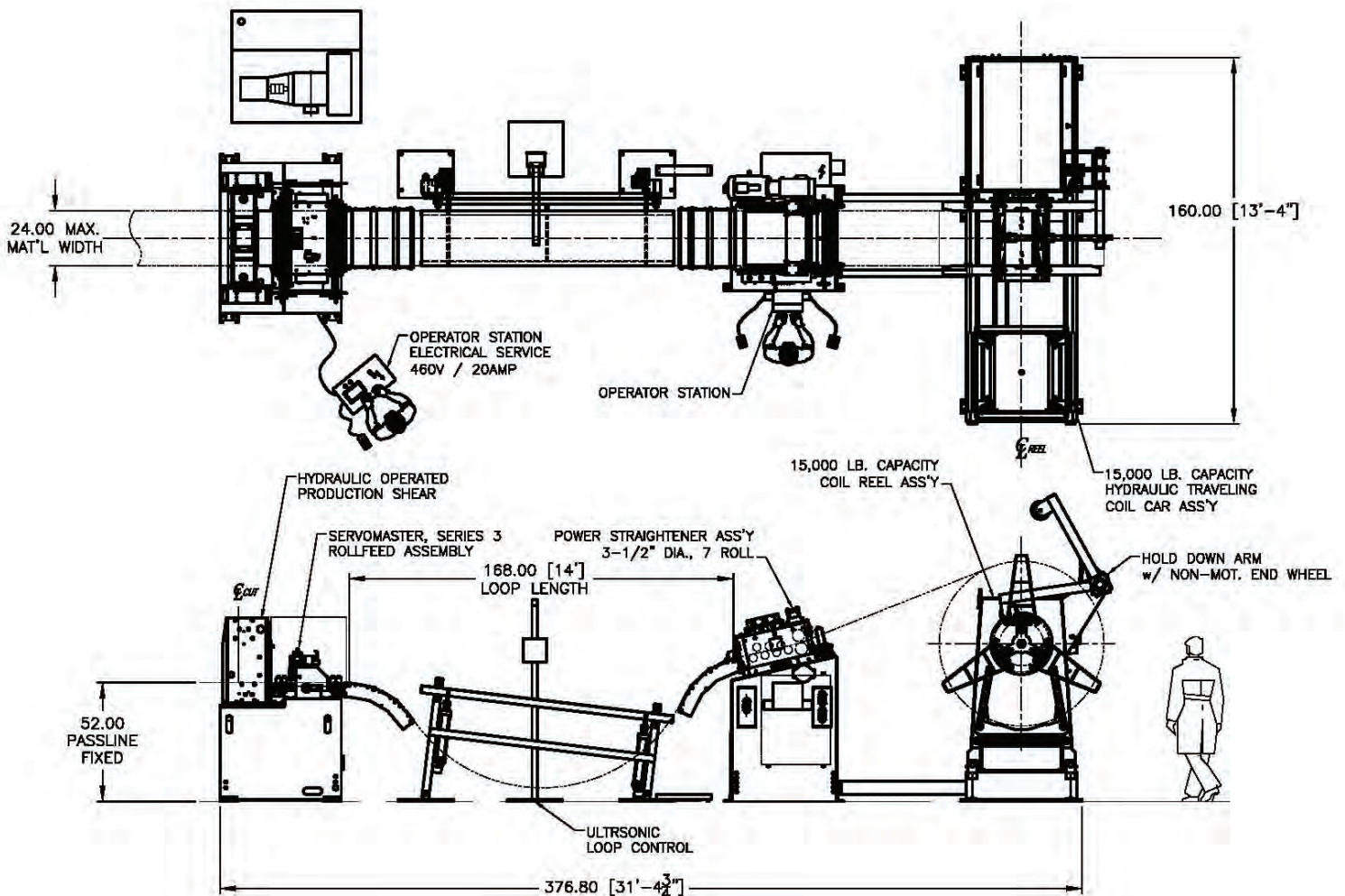
SPECIFICATIONS

COIL WEIGHT	10,000# Max
COIL WIDTH	24" MAX.
COIL I.D.	20" - 24"
COIL O.D.	72" MAX.
MATERIAL BEING RUN	MCRS
MATERIAL THICKNESS120" X 24" WIDE
LINE SPEED	80 FPM
SHEAR TYPE	HYDRAULIC
SHEAR SPEED	30 SPM MAX.
MAX. BLANK SIZE	24" X 48"
CONTROLS TYPE	SERVOMASTER



24" wide x 10,000# CTL Line w/Hydraulic Shear and Runout Conveyor

Cut-to-Length Line – Steel Service Center

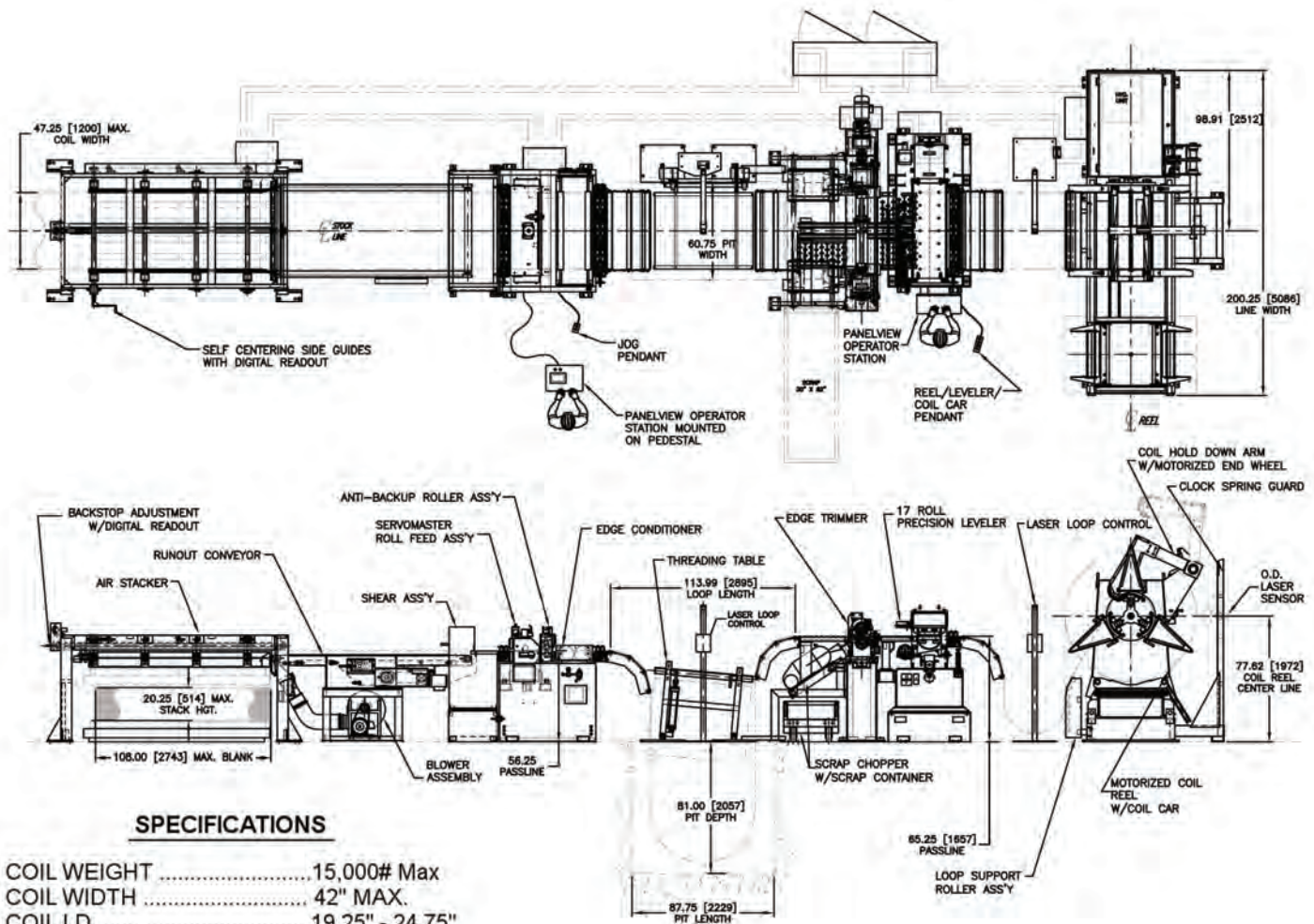


SPECIFICATIONS

COIL WEIGHT	15,000# Max
COIL WIDTH	24" MAX.
COIL I.D.	20" - 24"
COIL O.D.	72" MAX.
MATERIAL BEING RUN	MCRS
MATERIAL THICKNESS135" X 24" WIDE
LINE SPEED	100 FPM
SHEAR TYPE	HYDRAULIC
SHEAR SPEED	35 SPM
MAX. BLANK SIZE	24" X 36"
CONTROLS TYPE	SERVOMASTER

**24" wide x 15,000# CTL Line
w/Hydraulic Production Shear**

Cut-to-Length Line – Aluminum Service Center



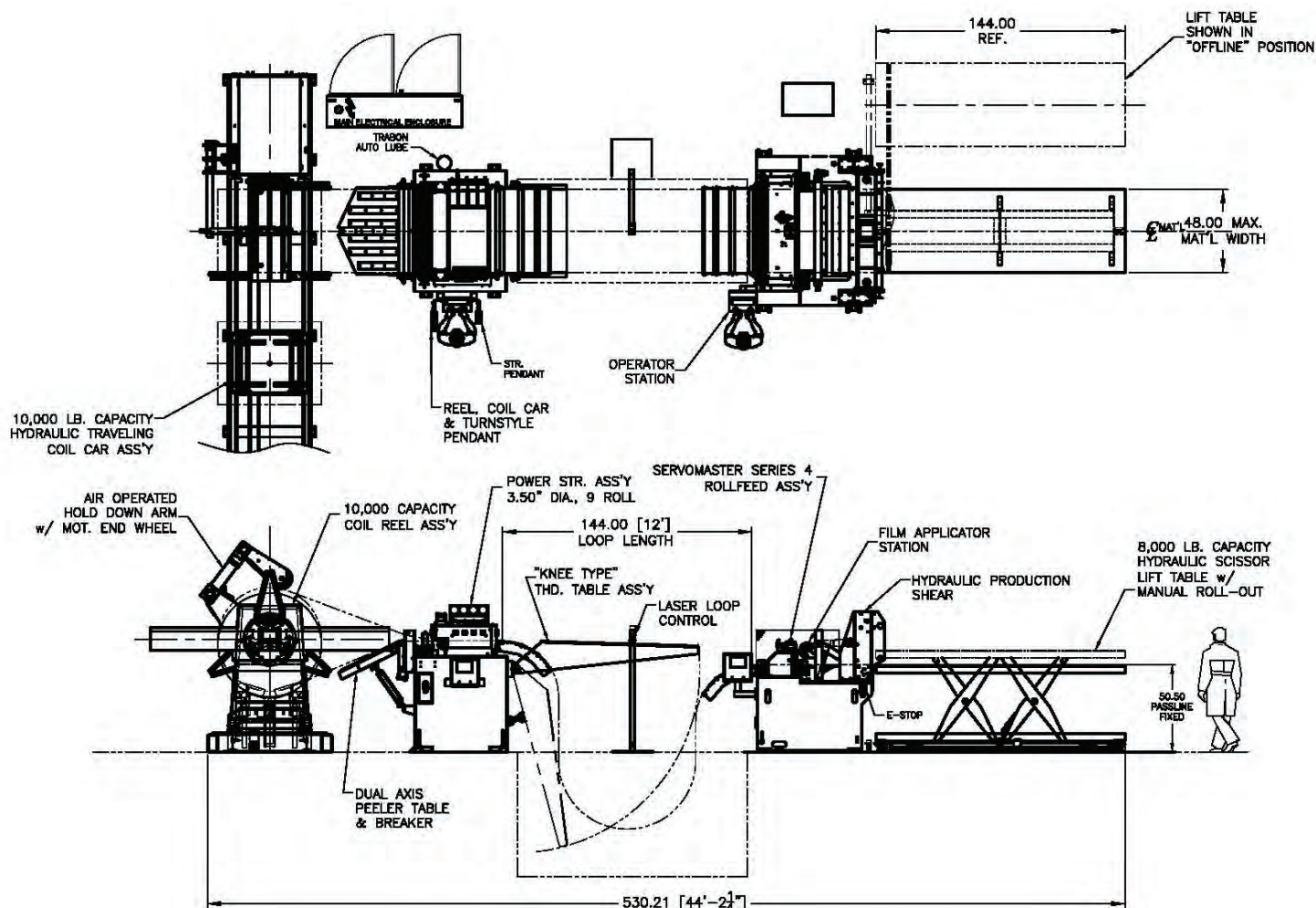
SPECIFICATIONS

COIL WEIGHT	15,000# Max
COIL WIDTH	42" MAX.
COIL I.D.	19.25" - 24.75"
COIL O.D.	72" MAX.
MATERIAL BEING RUN	ALUMINUM
MATERIAL THICKNESS012" - .032" @ 42" WIDE
FEED LENGTH ACCURACY...	+/- .003"
LINE SPEED	150 FPM
SHEAR SPEED	40 SPM MAX.
PASSLINE HEIGHT	50"
MAX. BLANK SIZE	42" X 96"
STACK WEIGHT	10,000# MAX.
AIR REQUIREMENTS	45 SCFM APPROX.
LINE VOLTAGE	480 V, 3PH., 60 Hz, 200A



42" x 15,000# Aluminum CTL Line w/Leveler and Air Drop Stacker

Cut-to-Length Line – Walk-in Cooler OEM

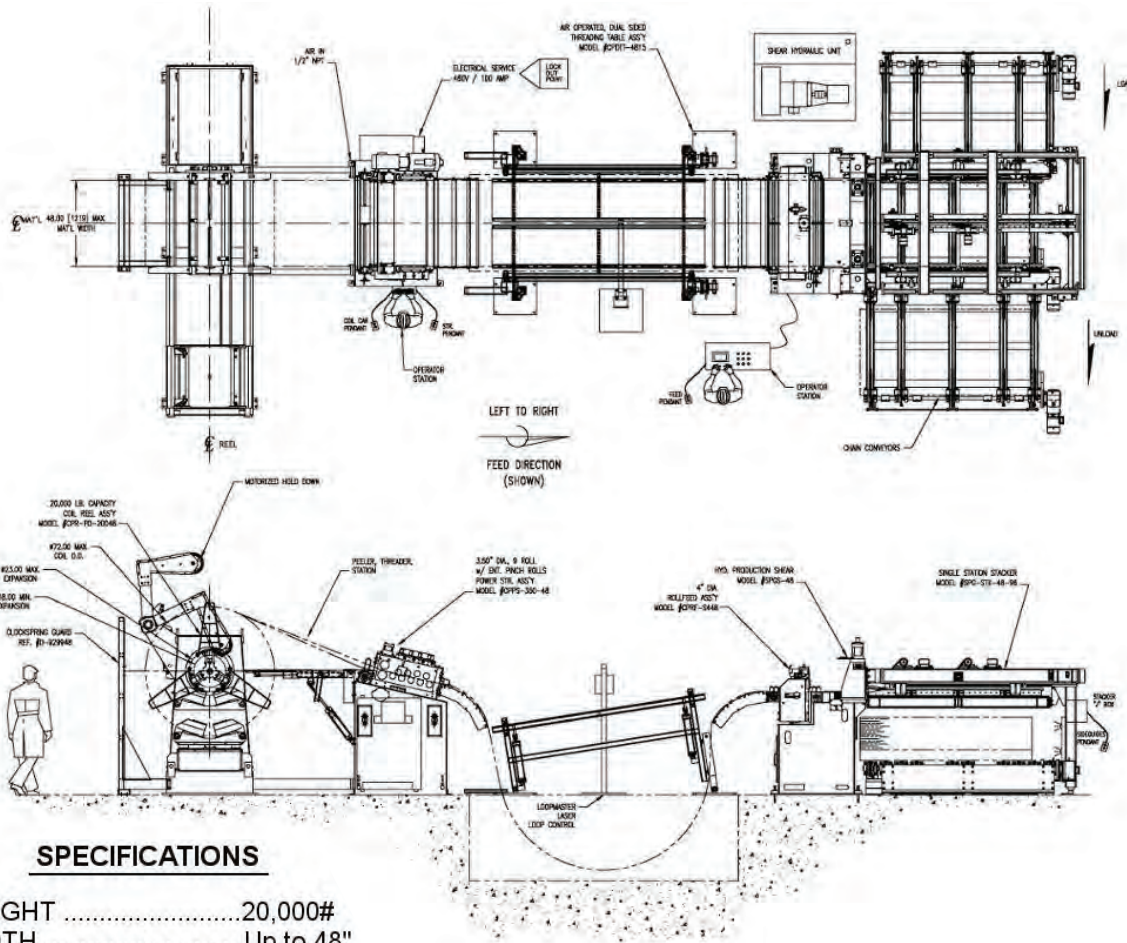


SPECIFICATIONS

COIL WEIGHT	10,000# MAX.
COIL WIDTH	48" MAX.
COIL I.D.	18" STD.
COIL O.D.	60" MAX.
MATERIAL BEING RUN	ALUMINUM
MATERIAL BEING RUN	STAINLESS
MATERIAL THICKNESS105" X 48" WIDE
LINE SPEED	120 FPM
SHEAR TYPE	HYDRAULIC
SHEAR SPEED	30 SPM
MAX. BLANK SIZE	48" X 144"
MAX. STACK WEIGHT	8,000# MAX.
CONTROLS TYPE	ALLEN-BRADLEY

**48" wide x 10,000# CTL Line
w/Hydraulic Shear and Scissor Lift**

Cut-to-Length Line – Contract Manufacturer



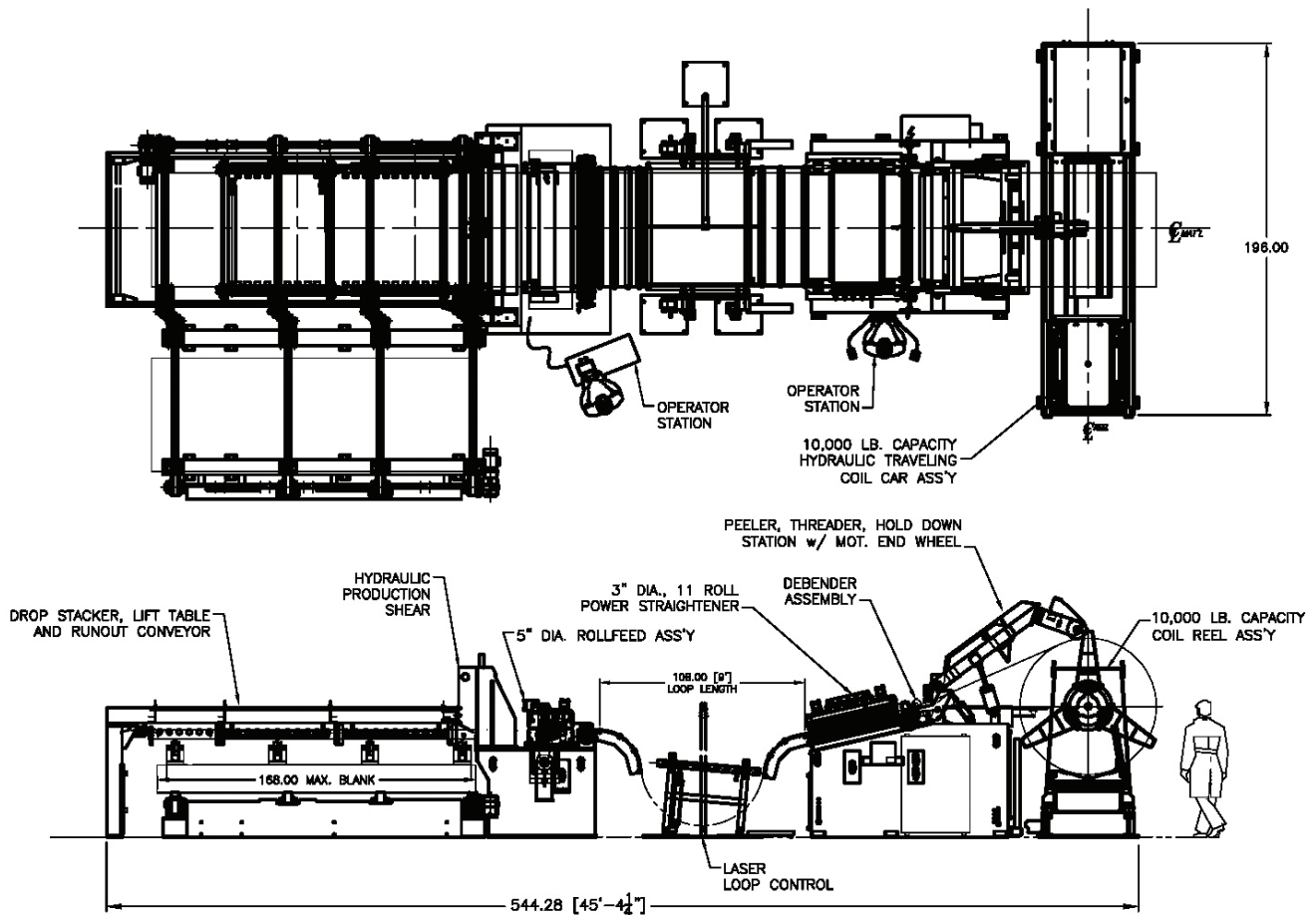
SPECIFICATIONS

COIL WEIGHT	20,000#
COIL WIDTH	Up to 48"
COIL I.D.	18" to 23"
COIL O.D.	72" MAX.
MATERIAL BEING RUN	MCRS & SS
MATERIAL THICKNESS018" - .074" @ 48" Wide
FEED LENGTH ACCURACY...	+/- .003"
SHEAR SPEED	Up to 30 SPM
BLADE GAP	Adj. via hand crank
STACKER TYPE	Single Station, Finger Drop w/Chain Conveyors
MAX. BLANK SIZE	48"W x 96"L
MIN. BLANK SIZE	13"W x 13"L



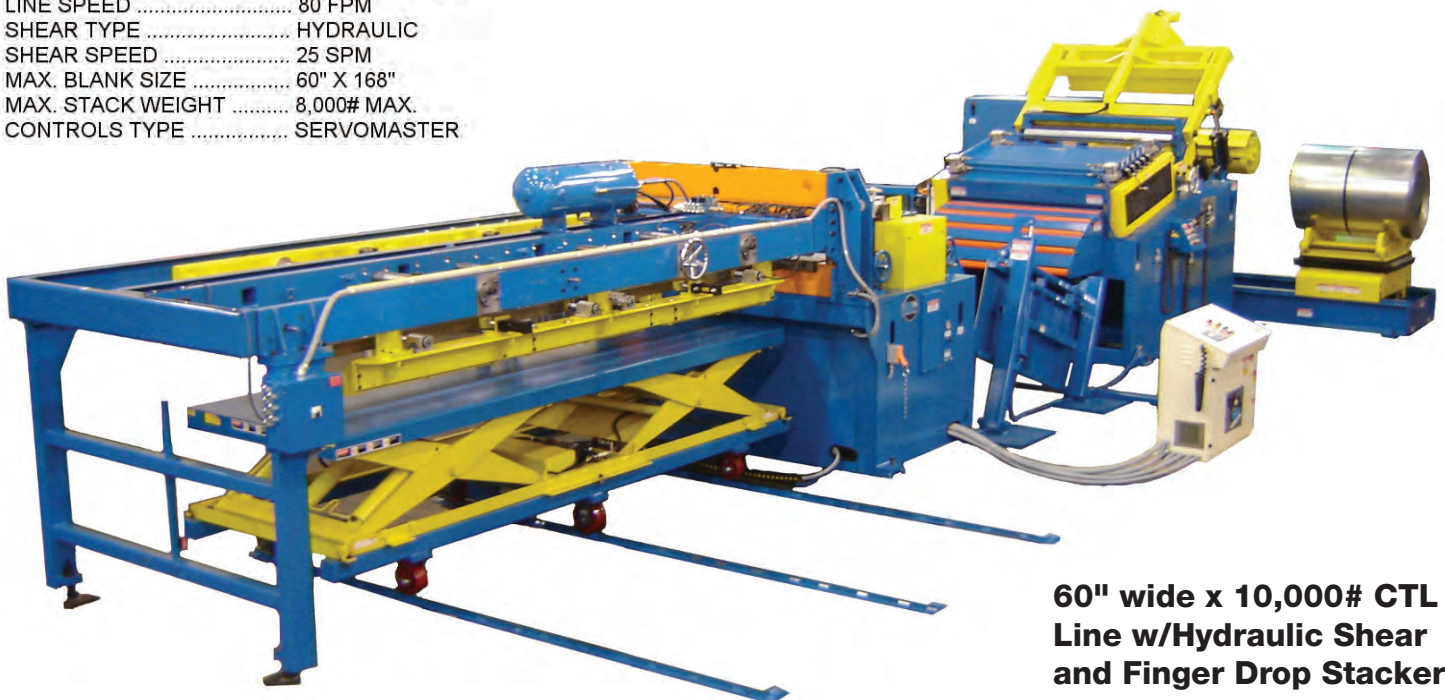
48" wide x 20,000# CTL Line w/Hydraulic Shear and Finger Drop Stacker

Cut-to-Length Line – Air Handling Unit OEM



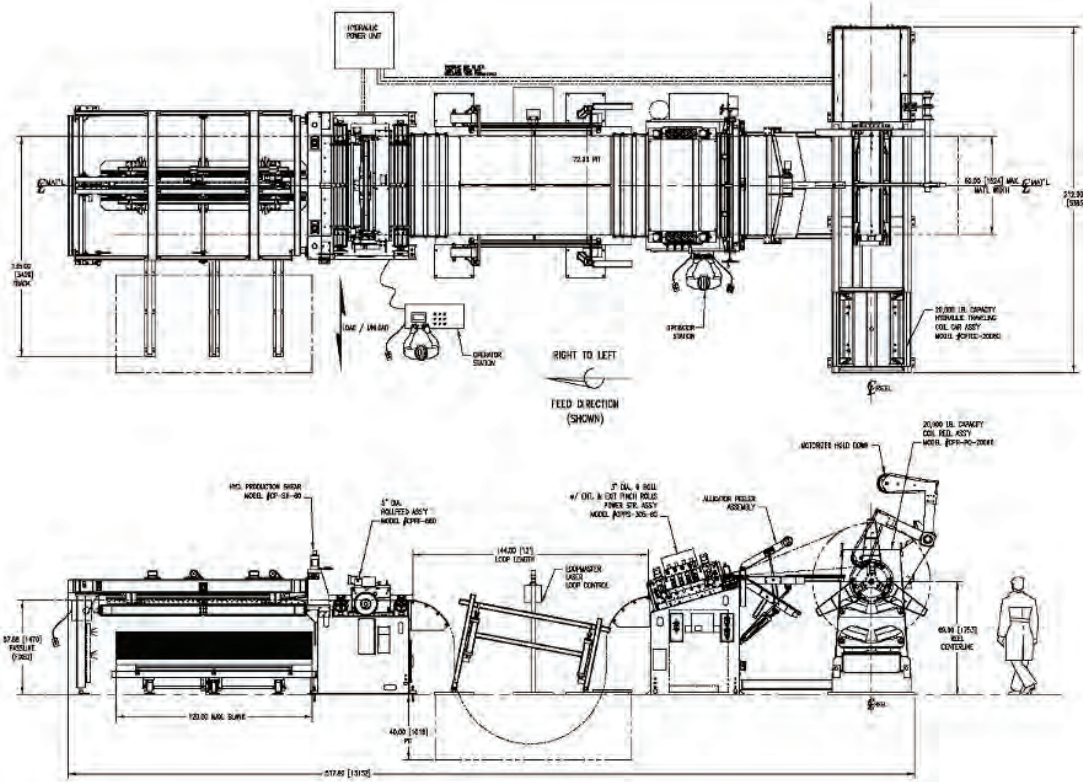
SPECIFICATIONS

COIL WEIGHT	10,000# MAX.
COIL WIDTH	60" MAX.
COIL I.D.	20" - 24"
COIL O.D.	72" MAX.
MATERIAL BEING RUN	MCRS & STAINLESS
MATERIAL THICKNESS080" X 60" WIDE
LINE SPEED	80 FPM
SHEAR TYPE	HYDRAULIC
SHEAR SPEED	25 SPM
MAX. BLANK SIZE	60" X 168"
MAX. STACK WEIGHT	8,000# MAX.
CONTROLS TYPE	SERVOMASTER



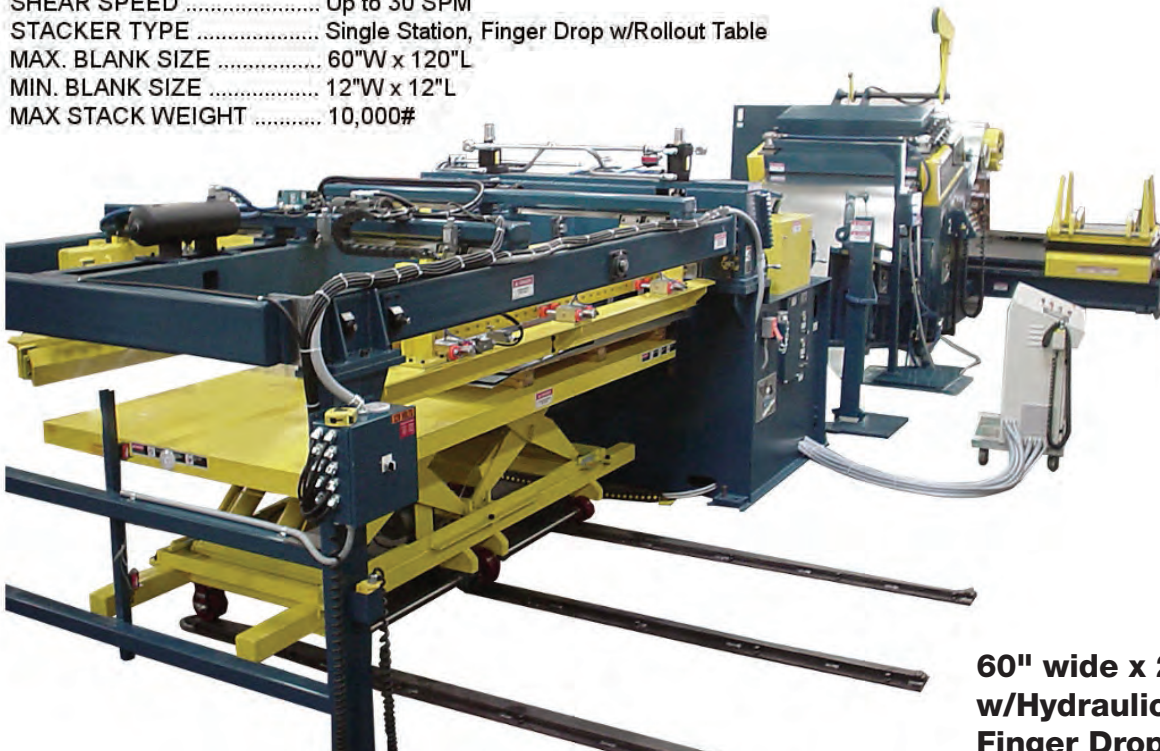
**60" wide x 10,000# CTL
Line w/Hydraulic Shear
and Finger Drop Stacker**

Cut-to-Length Line – Glass Front Cooler OEM



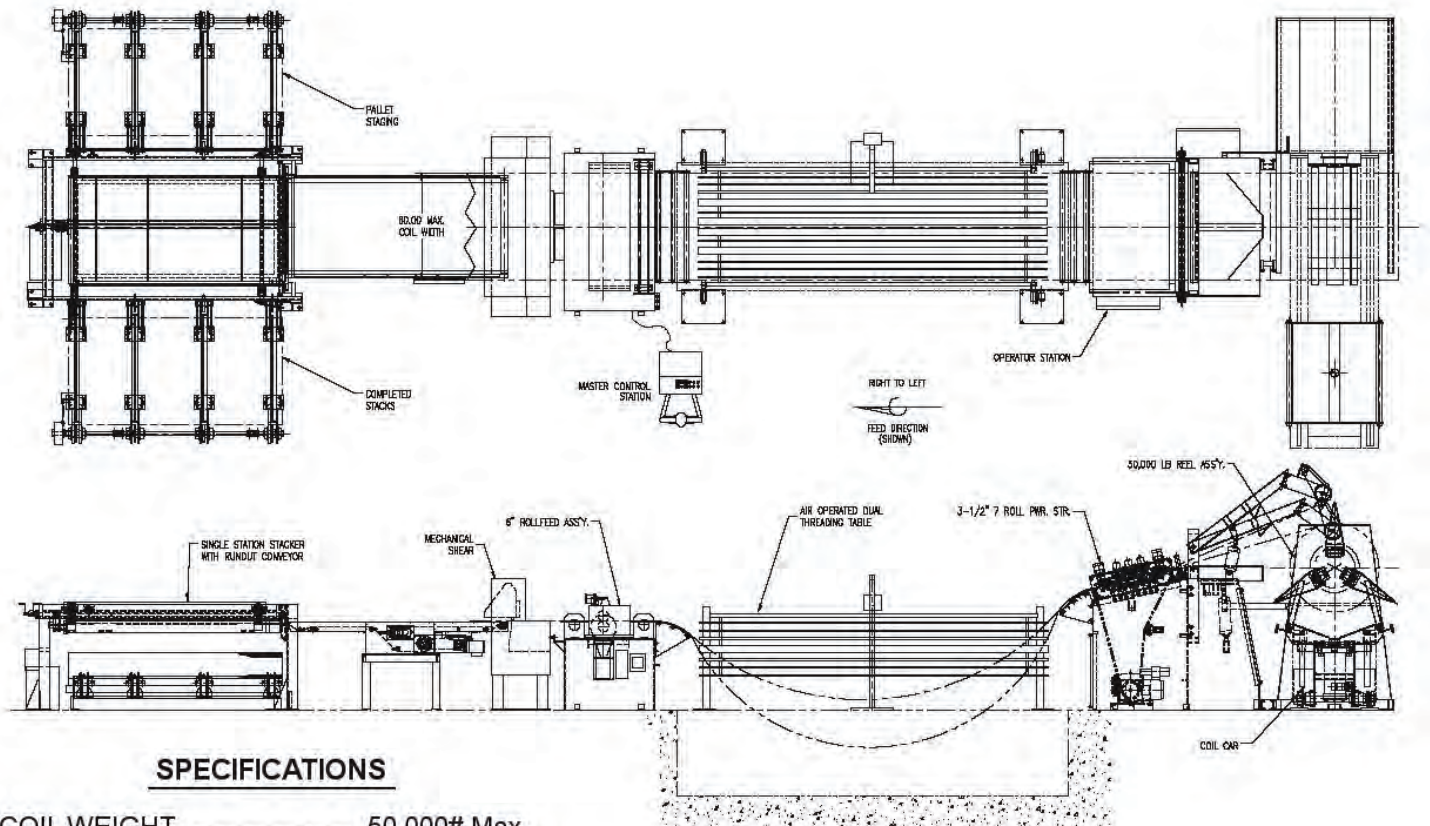
SPECIFICATIONS

COIL WEIGHT	20,000#
COIL WIDTH	Up to 60"
COIL I.D.	20" - 24"
COIL O.D.	72" MAX.
MATERIAL BEING RUN	MCRS & SS & Prepainted
MATERIAL THICKNESS020"-.080" @ 60" Wide
FEED LENGTH ACCURACY...	+/- .003"
SHEAR SPEED	Up to 30 SPM
STACKER TYPE	Single Station, Finger Drop w/Rollout Table
MAX. BLANK SIZE	60"W x 120"L
MIN. BLANK SIZE	12"W x 12"L
MAX STACK WEIGHT	10,000#



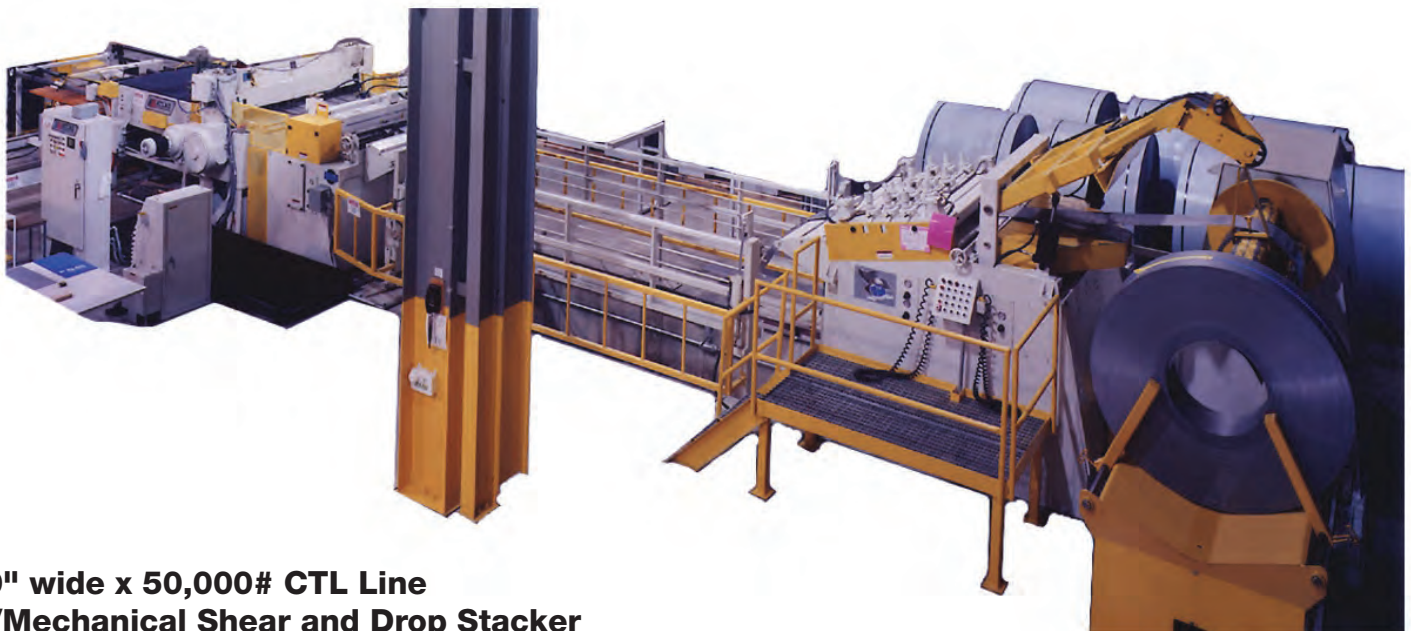
**60" wide x 20,000# CTL Line
w/Hydraulic Shear and
Finger Drop Stacker**

Cut-to-Length Line – Automotive Stamper



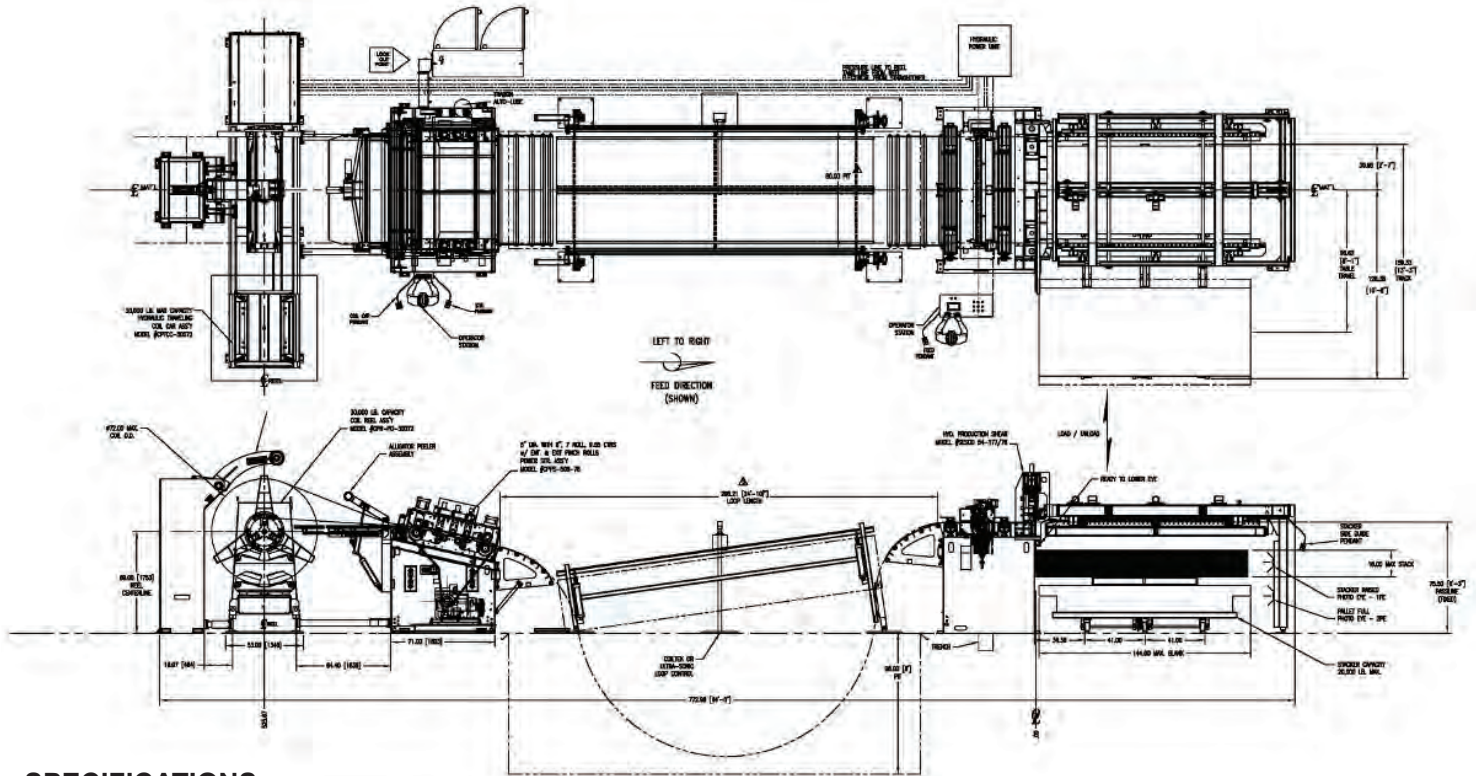
SPECIFICATIONS

COIL WEIGHT	50,000# Max
COIL WIDTH	60" MAX.
COIL I.D.	19.25" - 24.75"
COIL O.D.	72" MAX.
MATERIAL BEING RUN	MCRS
MATERIAL THICKNESS100" X 60" WIDE
FEED LENGTH ACCURACY...	+/- .003"
LINE SPEED	100 FPM
SHEAR TYPE	MECHANICAL
SHEAR SPEED	40 SPM MAX.
MAX. BLANK SIZE	60" X 96"



**60" wide x 50,000# CTL Line
w/Mechanical Shear and Drop Stacker**

Cut-to-Length Line – Contract Manufacturer



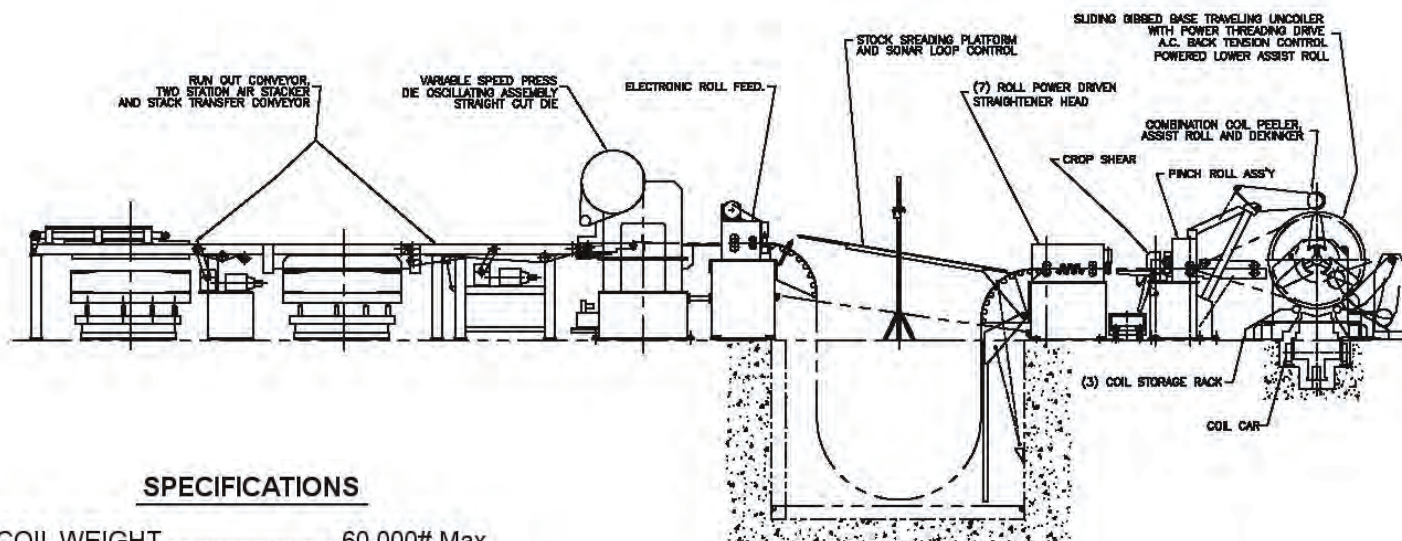
SPECIFICATIONS

COIL WEIGHT	30,000#
COIL WIDTH	Up to 72"
COIL I.D.	20" – 24"
COIL O.D.	72" Max.
MATERIAL BEING RUN	MCRS & Galvanized
MATERIAL THICKNESS250" @ 60" wide
FEED LENGTH ACCURACY	+/- .005"
SHEAR SPEED	Up to 30 SPM
STACKER TYPE	Finger Drop w/Rollout Table
MAX. BLANK SIZE	72" W x 144" L
MIN. BLANK SIZE	12" W x 12" L
MAX. STACK WEIGHT	20,000#



**72" wide x 30,000# CTL Line
w/Hydraulic Shear and Finger Drop Stacker**

Cut-to-Length Line – Automotive Stamper



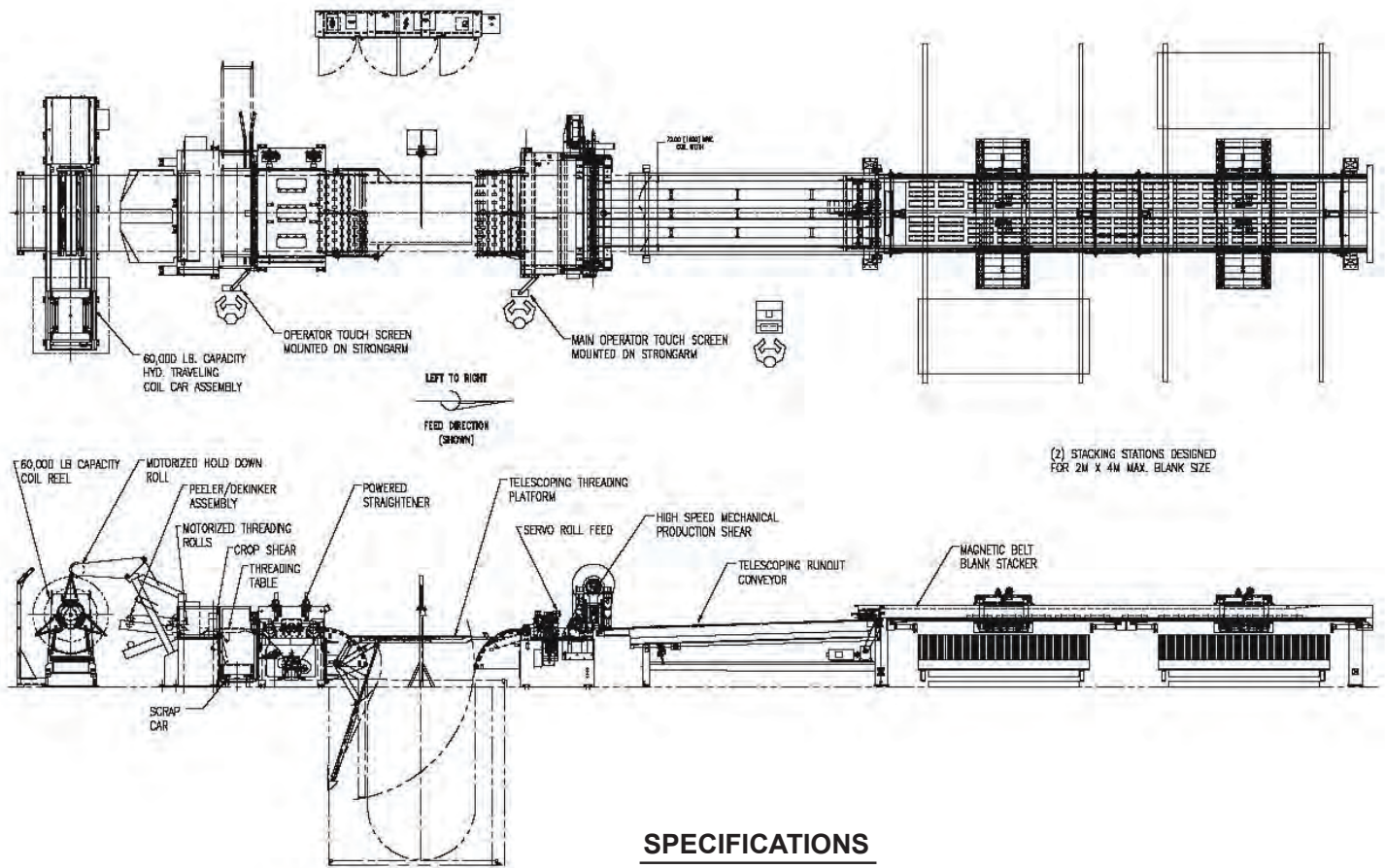
SPECIFICATIONS

COIL WEIGHT	60,000# Max
COIL WIDTH	8" TO 72"
COIL I.D.	24"
COIL O.D.	36" TO 72" MAX.
MATERIAL BEING RUN	MILD STEEL, CLASS "A"
MATERIAL THICKNESS125" @ 72" WIDTH
MATERIAL THICKNESS200" @ 48" WIDTH
FEED LENGTH RANGE	6" TO 96"
FEED LENGTH ACCURACY...	+/- .010"
ACCURACY ACROSS DIAG...	+/- .060"
SHEAR OSCILLATION	+/- 30 deg.
STACK WEIGHT	10,000# MAX.
STACK HEIGHT	15" TO 18" OVER PALLET
PLANT VOLTAGE	460V., 3PH., 60 Hz



**72" wide x 60,000# CTL Line
w/Oscillating Shear Press and
2 Station Air Drop Stacker**

Cut-to-Length Line – Steel Service Center



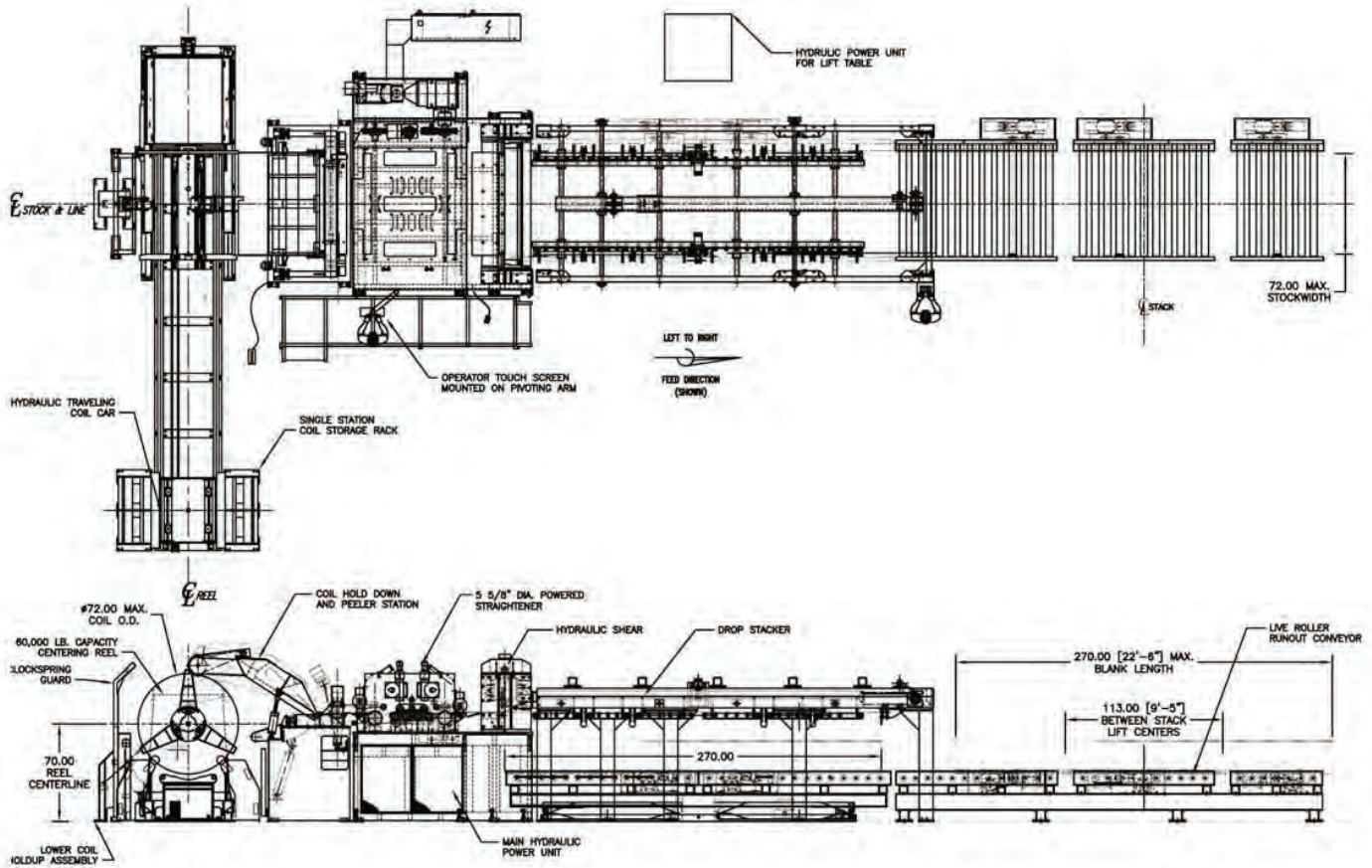
SPECIFICATIONS

COIL WEIGHT	60,000# Max.
COIL WIDTH	10" to 72"
COIL I.D.....	20" to 24"
COIL O.D.....	72" Max.
MATERIAL BEING RUN.....	Mild Steel
MATERIAL THICKNESS	Up to 0.13"
FEED LENGTH ACCURACY	$\pm .003$ "
LINE SPEED	300 FPM
FEED DIRECTION	Left to Right



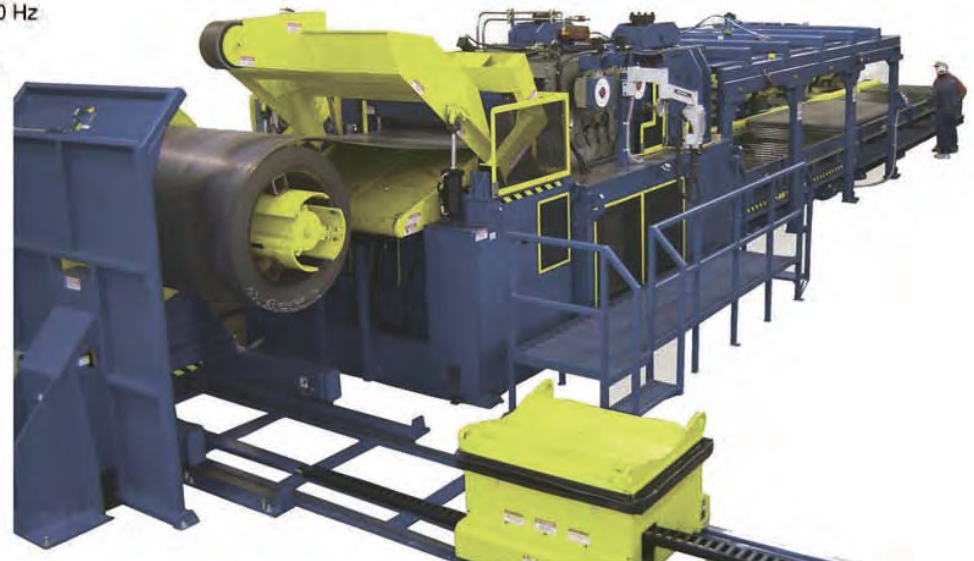
**72" wide x 60,000# CTL Line
w/Magnetic Stacker**

Cut-to-Length Line – Storage Tank OEM



SPECIFICATIONS

COIL WEIGHT	60,000# Max
COIL WIDTH	36" TO 72"
COIL I.D.	19.25" TO 24.75"
COIL O.D.	30" TO 72" MAX.
MATERIAL BEING RUN	MCRS & SS
MATERIAL THICKNESS060" - .375" MCRS
MATERIAL THICKNESS060" - .187" SS
FEED LENGTH RANGE	96" TO 270"
LINE SPEED	60 FPM
PASSLINE HEIGHT	78"
MAX. BLANK SIZE	72" X 270"
MIN. BLANK SIZE	36" X 96"
LINE VOLTAGE	460V, 3PH., 60 Hz
STACK HEIGHT	12" TO 25"
STACK WEIGHT	60,000# MAX.



**72" wide x 60,000# CTL Line
w/Finger Drop Stacker**



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