

10H-CTL

Bar Edging • Straightening • Cut to Length



The 10H Cut to Length bar edging and straightening system is constructed with reliability in mind. This unit has been designed to include the human engineering factor, since simplicity of operation was one of the criteria in the development of the 10H-CTL. Engineered to cover the wide gamut of service center requirements, the 10H-CTL can produce edge-finished bars and trips from sheared plate. When you can produce what you need, when you need it, you can eliminate the need to stock hundreds of different sizes.

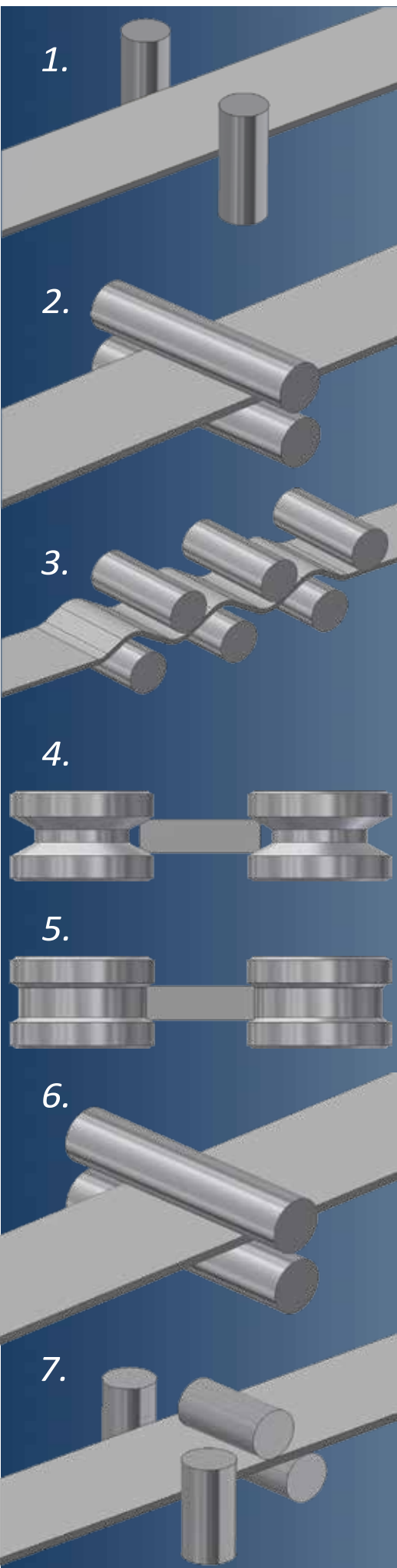
The 10H-CTL is run by time proven hydraulic systems, which not only provides the driving force, but also furnishes pressure to the edging rolls. Using hydraulics eliminates the need for cumbersome drive shafts, couplings and universal joints, allowing Gauer Metal to maintain the compact size of their machines.

10H-Cut to Length Specifications:

- Capacity: Width Range: 1" to 8"
- Thickness Range: 1/8" to 1/2"
- Material: All ferrous and non-ferrous metals with a yield strength of 50,000 PSI or less
- Speed: Up to 200 ft/min (variable speed)
- Electrical: 230/460 Volts, 3 phase, 60 Hertz, 78 total horsepower
- Length Accuracy: Within 1/16"
- Edge Capability: Universal Mill Edge, Square Edge, Modified Square, or other special forms, subject to approval.
- Dimensions: 7'0" long x 7'1" wide x 5'10" high
- Weight: Approximately 13,500 lbs



Every Gauer built machine has been designed and manufactured to include the highest quality components commercially available. All parts are manufactured under stringent specifications and conversely rated to provide long life even under adverse conditions.



10H–Cut to Length Operation:

1. **Entrance Guide Rolls:** After basic adjustments, stock is fed either from coil or by hand to the Entrance Guide Rolls. The guide rolls maintain constant stock alignment with the edging rolls. Hand cranks efficiently adjust roll positioning, eliminating tedious nut and bolt adjustments.

2. **Primary Pinch Rolls:** The Pinch Rolls are power driven and synchronized to assure proper line speed through the edging and cutting stages. Their primary function is to provide easy entrance to the straightening stage, along with partial flattening of burrs. This section is open and closed hydraulically, with hand wheels for thickness adjustment, when running sheared stock. The Pinch Roll pressure can be varied through the hydraulic system; once pressure is selected, it will stay constant to accommodate variations in thickness along the material.

3. **Straightener Rolls:** Six rolls comprise the straightening section; three on the bottom that are hydraulically driven to maintain smooth material flow, and the three on top. The primary function of this stage is to insure that the material is completely flat prior to entering the edging stage, eliminating problems that may arise from bowed stock. The entire section opens hydraulically for roll positioning, which again is done with the use of efficient hand wheels. Additionally, the rolls are equipped with digital read out position indicators, providing readings, which can be recorded and used again to simplify the set up of similar jobs.

4. **Initial Edge Finishing:** Phase one of basic edge configuration is initiated here, using two opposing, hydraulically powered edging rolls which maintain even pressure throughout the stage.

5. **Final Edge Finishing:** In the same manner as the Initial Edge Finishing, two opposing, hydraulically powered rolls perform the final edging to your stock. Pressure adjustments can be easily made with a knob and shown on a read out gauge. The entire edging process occurs without pressure changes despite possible variations in bar width.

6. **Final Pinch Rolls:** Similar to the Primary Pinch Rolls except providing a much higher hydraulic pressure, the Final Pinch Roll stage flattens any build-up resulting from the edging stages.

7. **Camber and Twist Control:** Two hand crank adjustable rolls control camber, while two horizontally positioned rolls control twist without disturbing any other adjustments.

8. **Shearing:** Heavy duty, hydraulically operated blades are utilized in the shearing stage. The blades are reversible to provide four cutting edged, and easily removed to re-sharpen. Electronic controls in the control panel ensure shear accuracy within 1/16".




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