

High-Speed Cut-to-Length Lines

SREE

For high volume and frequent product changeover

What it is for

Servo high-speed cut-to-length lines for transformer core laminations. Continuous strip feeding with synchronised shearing keeps the line moving during punching, which lifts output on long production runs and shortens changeover between core types.

Headline specifications

Peak feeding speed	up to 240 m/min (300 / 400 class)
Typical rated speed	210 m/min
Recommended working speed	120 - 180 m/min
Strip thickness	0.18 - 0.35 mm
Shearing burr	under 0.02 mm
Length tolerance	+/-0.2 mm / 3 m

Why customers choose this line

- Peak speed is a machine rating, not a shift figure: real output = rated speed, minus stops for each punch and V-notch, minus coil and job changeover, times shift utilisation.
- Our engineers calculate sheets-per-minute and cores-per-shift from your own lamination drawing before quoting; that calculated figure goes into the technical agreement and the FAT.
- Automatic stacking to up to 40 core-limb stacks removes the manual take-off bottleneck.
- Designed for mixed production: recipe-driven changeover instead of mechanical resetting.

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Full specification, configuration and acceptance

Full technical parameters

Machine models	SRHJ200-G / 300-G / 400-G / 600-G class
Peak speed source	SRHJ300-24 and SRHJ400-24B technical files: feeding 0 - 240 m/m
Common configuration	210 m/min rated, working speed 120 - 180 m/min
Shearing	five-synchronous shearing, servo driven
Feeding	push-pull servo feeding for ultra-thin gauge
Decoiler	2 or 4 head, hydraulic mandrel clamping
Stacking	automatic collation, up to 40 stacks
Power supply	380 V / 50 Hz three-phase (others on request)

Standard and optional configuration

- Control: Siemens or Rockwell; servo axes for feeding, notching and shear synchronisation.
- Punching: V-notch and hole punch modules per lamination pattern; frame prepared for later upgrade.
- Options: scrap collection and baling, line enclosure, drawing-driven program generation, MES interface.

Acceptance and service

- Speed and output verified against the agreed lamination pattern, not against peak rating alone.
- Continuous-run test at FAT; length, angle and burr measured on production laminations.
- Commissioning, operator training and remote support included.

Figures are reference values from delivered builds and technical files. Actual performance depends on material grade and flatness, lamination geometry, punching pattern and plant conditions. Binding specifications, scope of supply and acceptance criteria are fixed in the project technical agreement.