

Standard Cut-to-Length Lines

SREE

200 / 300 / 400 / 600 / 800 / 1000 width class

What it is for

Silicon steel cut-to-length lines for distribution and power transformer cores. One line shears, V-notches and punches laminations to finished length, then collates them into stacks ready for core assembly. Width class is chosen from the widest lamination in your core drawings.

Headline specifications

Strip thickness	0.18 - 0.35 mm
Strip width	up to 1020 mm (1000 class)
Lamination length	600 - 5000 mm (1000 class)
Length tolerance	+/-0.2 mm / 3 m
Angle tolerance	+/-0.02 deg
Shearing burr	under 0.02 mm

Why customers choose this line

- Five-synchronous shearing keeps length and angle tolerance stable across the whole stack, which is what decides core loss and noise.
- Push-pull feeding handles 0.18 mm ultra-thin CRGO without wrinkling or edge damage.
- Modular V-notch and punch stations: build the frame for the higher configuration now, fit heads as your product mix grows.
- Roller take-off and magnetic collation remove crane moves between cutting and stacking.

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Full specification, configuration and acceptance

Full technical parameters

Machine models	SRHJ200 / 300 / 400 / 600 / 800 / 1000
Reference build (1000 class)	2 shears, 2 V-notch, 2 hole punch, 4 corner punch
Max line speed	210 m/min (1000 class reference build)
Decoiler	2-head, coil OD 1200 mm, 5 t per head
Stack height	up to 600 mm
Installed capacity	approx. 80 kW (1000 class)
Footprint	approx. 32.3 x 8 m (1000 class)
Line weight	approx. 45 t (1000 class)
Power supply	380 V / 50 Hz three-phase (others on request)

Standard and optional configuration

- Control: Siemens or Rockwell PLC and servo drives; cost-optimised domestic package available.
- Punching: V-notch units, bolt or tie-rod hole punches, corner punches, sized to your lamination drawing.
- Take-off: 4 / 10 / 20-station collation, front-rear or left-right, automatic stacking interface.
- Options: PLS machine terminal that reads lamination drawings and generates cutting programs, scrap collection, enclosure, remote diagnostics.

Acceptance and service

- FAT at our works with your own material where supplied: length, angle, burr and continuous-run tests.
- SAT after installation, plus operator and maintenance training on site.
- Spare and wear part list issued with the machine; remote diagnostics and program updates.

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.