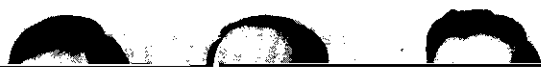
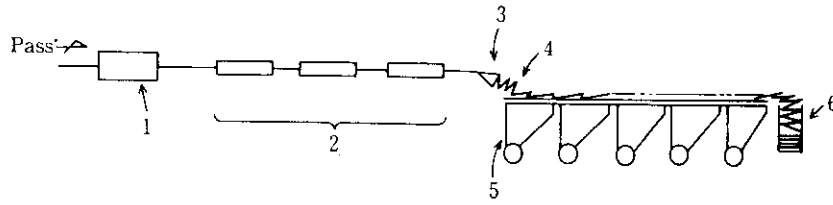




New Type Stelmor Equipment of Wire Rod and Bar Mill*

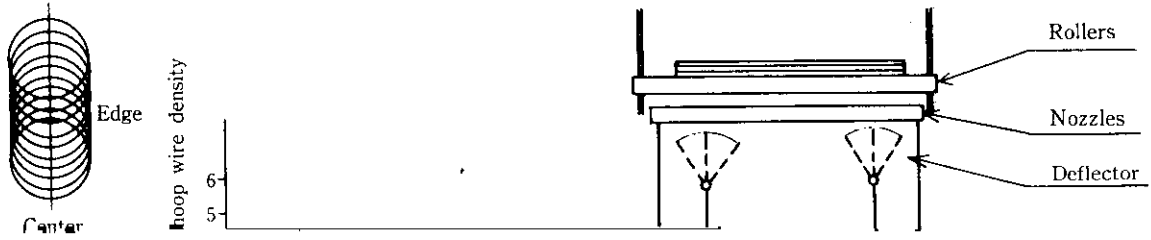
Synopsis:

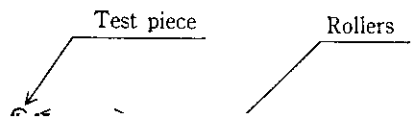




- | | |
|------------------------|---------------------------------|
| 1. Finishing mill | 4. Hoop wire |
| 2. Water cooling zones | 5. Blowers (forced air cooling) |
| 3. Laying head | 6. Reforming tub |

Fig. 1 Equipment of Stelmor line





Furthermore, cooling characteristics were examined using bundled test pieces to simulate ring edge piling of hoop wire in the actual Stelmor conveyer (Fig. 5). Ring

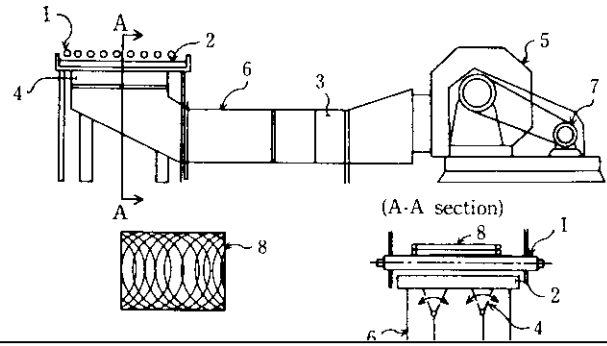
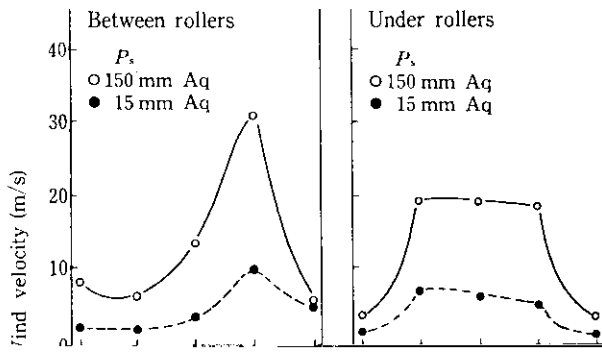
1

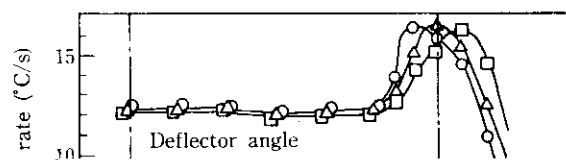
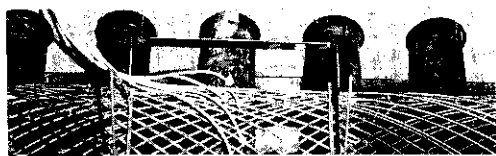
11.

The results of the preliminary tests are as follows:

nozzles under the rollers

(1) Figure 9 compares calculated and actual results. Based on the data on the diameter of the rollers.





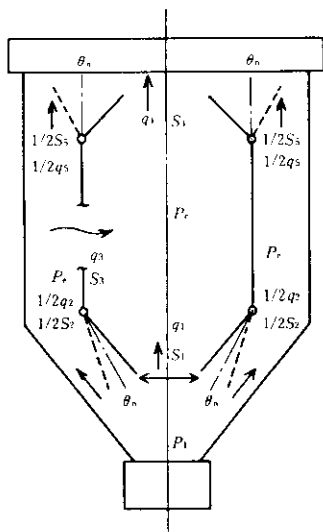


Fig. 18 Model of damper and deflector

$$P_e = P_1$$

$$q_1 = C_1 S_1 \sqrt{\frac{2g(P_1 - P_e)}{\gamma}}$$

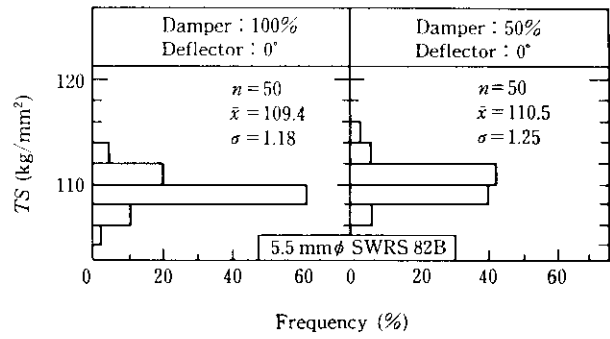


Fig. 19 Tensile strength with simulator

From the results described above, the characteristics of the dampers and deflectors are clear, and, therefore, by their control, it becomes possible not only to obtain material of uniform quality but also to control the manufacture of wire rods to meet prescribed quality specifications.

5 Actual Stelmor Equipment Design

In the design of the new Stelmor equipment, nozzle

Table 3 Specifications of the new Stelmor line

Type	Roller conveyer × 8 zones
Blower	250 mmAq × 1 100 m ³ /min × 11
Control	AC-VVVF
Maker	SHI-Morgan

