

Hot-Dip Galvanizing Production line



[Specification of CGL1250 Hot-dip Galvanizing Production Line](#)

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1. Moving car for steel coil

Rail moving car is used for material on or off loading, driven by motor reducer speed, lifting up and down is finished by hydraulic system. Moving position inspector and controller of the car is available when it is running.

2. Unwinder

After unloaded by car, raw coils are sent to expansion drum to tension to be tight, and feeding material when the drum is rotating.

3. Pinching transmitter

To pinch steel strip while on or off loading, bottom rollers are driven by motor reducer of speed, with pneumatically pressed down structure of upper rollers.

4. Shear

For easy control and operation, and to reduce coil changing time, every uncoiler has its own shear, and every shear adopts double decker, pressed down hydraulically.

Specially, shear operation has interlocked with whole line control. Shear also contains scrap guiding table and scrap car.

5. Welting machine

Connect the head and end of steel strips to ensure continuous production.

6. Deflective setting

To deflect the direction of strip.

7. Accumulating unit

To accumulate strips, the volume should ensure 2-2.5 min of line running, especially,

maintain continuous production when changing coil.

8. Cleaning unit

The pre-treatment units make up of roller brusher, pump, spray nozzle, containing three processing sections: 3 steps for alkali cleaning, 3 times of roller brushing and 3 times of water cleaning.

9. Air blowing unit

To blow water film to be dried by hot air, the step is after water cleaning and water cooling.

10. Tension measuring roller

To measure tension inside the annealing furnace, make up of 3 deflective rollers, among these three, one roller can show tension results with pressure inspection.

11. Annealing furnace

To dismiss rolling stress, improve mechanical performance inside annealing furnace and raise heat of strip to certain temperature; clean surface of strip; micro- oxide film on strip surface is deoxidized to pure ferric layer by hydrogen in the furnace, preparing an adhesive surface for coating; also to control strip temperature precisely while entering into zinc pot through fast or slow cooling; keep or improve strip shape.

12. Galvanizing pot

To melt zinc ingot, and to realize zinc coating of strip.

13. Air blade

To adjust zinc thickness of strip surface through air blowing.

14. Cooling tower

To cool steel strip from zinc pot naturally or forcedly, ensuring zinc layer of newly coated strip has already been solidified when reach the first deflective roller.

15. Cooling and drying

To cool the strip by circulation water, and then press it.

16. Tension leveler

To haul the strip to be tight and straight.

17. Skin pass mill

To press spangle to be flat, improve smoothness of the surface, avoid and eliminate any bending or slip line during pinching and hauling. Improve plate form and straightness.

18. Chromizing chamber

To passivate the strip surface after zinc coating.

19. Hot air dry

Dry water film on strip surface after passivation.

20. Oil coater

To protect strip surface by oil coating.

21. Protection unit

To supply nitrogen and hydrogen for annealing furnace. There are three pumps, two for using and one for reserving.

22. Winder

Wind up the final strip to coil, convenient for storing and transportation.