



SPECIFICATION OF 55 Gallons STEEL DRUM PRODUCTION LINE with CAPACITY: 400 DRUM/HOUR

General Specification

Designed production capacity of the line : Maximum 400 pcs/hour
(practical production output is subject to conditions which shall be taken into consideration)

Grade of Automation : Semi-Automatic

Seaming Type : Spiralon Seaming

Material : JIS G 3141 Cold Milled Steel Sheet or Equivalent

Product Standard : JISZ 1601 Tight Head Drum & JISZ 1600 Open Head Drum

Application thickness of material) : 1.0 – 1.2 mm (for 0.8 mm application, minor modification may be required)

| Equipment Item | Specification | No. of Unit | Manufacturer | Modified & Overhauled Year |
|---|--|-------------|---------------|----------------------------|
| 1. BODY SEAMING LINE | | | | |
| De-stacker/Sheet Feeder - Lifter Table Maximum Load - Lifter Table Maximum Height - Lifter Up/Down Speed - Drive for Lifter - Drive for Pinch Roller - Drive for Sheet Feed | 5,000.00 Kg 406.44 mm 762 mm/min. 1.5 HP 1 HP 3/4 HP | 1 lot | Newcor U.S.A. | 2001 |
| Sheet Edge Grinder - The number of Grinding Head - Grinder Setting Degree - Grinder Adjustment - Sheet Adjusting Method - Dust Collector - Drive for Conveyor - Drive for Grinder - Drive for Dust Collector | 4 heads 15 degree Manual handle type Air Cylinder type 2 Units 1 HP 1.5 HP x 4 units 1.5 KW x 2 units | 1 Unit | Newcor U.S.A. | 2001 |
| Right Angle Feeder - Sheet Feeder System - Guide Adjustment Method | Air Cylinder Manual handle type | 1 Unit | Newcor U.S.A. | 2001 |
| Exit Conveyor - Body transfer system - Drive | V-belt type 0.2 KW | 1 Unit | Newcor U.S.A. | 2001 |

| Equipment Item | Specification | No. of Unit | Manufacturer | Modified & Overhauled Year |
|---|--|-------------|------------------------------------|----------------------------|
| Seam Welder - Maximum welding length - Minimum welding length - Welding Diameter - Forming Roll Adjustment - Body Transfer Method - Rated Capacity - Maximum welding current - Drive for Forming Roll - Drive for Forming Roll Adjust - Drive for Conveyor - Drive for Electrode - Drive for Roller - Welding current control | 1,066.80 mm 381.00 mm Dia. 568 ± 1 mm by Motor Drive Chain conveyor & pusher 250 KVA 500 A 3 HP 1/6 HP 1.5 HP 2 HP 1.5 HP Thyristor type | 1 Unit | Newcor U.S.A. | 2001 |
| 2. BODY FORMING LINE | | | | |
| Gravity Conveyor - Kick out method | By air cylinder | 1 Unit | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| Double End Flanger - Drive for Hydraulic pump | 15 KW | 1 Unit | Atlanta Grotnes Machine Co. U.S.A. | 2001 |
| Double Bead Expander - Drive for Hydraulic pump | 22 KW | 1 Unit | Atlanta Grotnes Machine Co. U.S.A. | 2001 |
| Leak Tester - Testing air pressure | 0.3 Kgf/cm2 | 1 Unit | Atlanta Grotnes Machine Co. U.S.A. | 2001 |
| Indexing Conveyor - Drive | 3.7 KW | 1 Unit | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| 3. ASSEMBLING LINE | | | | |
| Body Positioner - Drive | 0.2 KW | 1 Lot | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| End Plate Pre- fitter - Drive - Drive for top plate positioning | 0.4 KW x 2 units 0.2 KW | 1 Lot | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| Double Seamer - Drive - Drive for adjusting head - Drive for hydraulic pump | 22 KW x 2units 0.6 KW 5.5 KW | 1 Unit | Atlanta Grotnes Machine Co. U.S.A. | 2001 |

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|--|--|-------------|----------------------------------|----------------------------|
| Leak Tester - Test air pressure | 0.3 Kgf/cm2 | 1 Unit | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| Equipment Item | Specification | No. of Unit | Manufacturer | Modified & Overhauled Year |
| Indexing Conveyor - Drive | 3.7 KW | 1 Unit | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| 4. END PLATE PRESS DIE | | | | |
| Blanking | | 1 Set | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| Straining | | 1 Set | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| Flange Setting | | 1 Set | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| Bottom Plate Marking | | 1 Set | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| Punching | | 1 Set | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| Scrap Cutter Share | | 1 Set | Maeda Manufacturing Co.Ltd JAPAN | 2001 |
| 5. POWER PRESS | | | | |
| 200 Ton Press Model DA-200 - Maximum Torque - Stroke - SPM - Die Height - Main Motor - Adjust Motor - Air Pressure - Air Requirement - Other Equipment - Power Source | 200 Ton 300 mm 24 spm 500 mm 22 KW 1.5 KW 5 Kgf/cm2 100 Liter/min. With Die Cushion 200 V, 3 Phase, 4 wiring 50 or 60 Hz | 2 Sets | Shinohara Press JAPAN | 2001 |

| Equipment Item | Specification | No. of Unit | Manufacturer | Modified & Overhauled Year |
|---|---|--------------------|------------------------------|---------------------------------------|
| 150 Ton Press Model CD-150L - Maximum Torque - Stroke - SPM - Die Height - Main Motor - Adjust Motor - Air Pressure - Air Requirement - Other Equipment - Power Source | 150 Ton 200 mm 40 spm 450 mm 15 KW x 4 Pole 1.5 KW x 4 Pole 5 Kgf/cm2 100 Liter/min. Double Crank Type with 2 power take point 200 V, 3 Phase, 4 wiring 50 or 60 Hz | 1 Set | AIDA JAPAN | 2001 |
| 100 Ton Press Model PC-10 - Maximum Torque - Stroke - SPM - Die Height - Main Motor - Adjust Motor - Air Pressure - Air Requirement - Other Equipment - Power Source | 100 Ton 110 mm 70 spm 285 mm 7.5 KW - 5 Kgf/cm2 60 Liter/min. - 200 V, 3 Phase, 4 wiring 50 or 60 Hz | 1 Set | AIDA JAPAN | 2001 |
| 70 Ton Press Model PGA-70AC - Maximum Torque - Stroke - SPM - Die Height - Main Motor - Adjust Motor - Air Pressure - Air Requirement - Other Equipment - Power Source | 70 Ton 1650 mm 40 spm 270 mm 3.7 KW - 5 Kgf/cm2 50 Liter/min. - 200 V, 3 Phase, 4 wiring 50 or 60 Hz | 1 Set | Shinohara Press JAPAN | 2001 |