





Tension / Bridle Rolls

#### Wringer / Squeegee Rolls

## **JV/V** Rolls<sup>®</sup>



#### JVM Industries-



1988 (Erkrath)

#### , JVM Industries GmbH

'JVM Rolls'

	(	)
JVM Rolls		'가



CNC-가. 가





가

#### JVM Rolls

- ⊃ Rubber coated rolls
- ⊃ Urethane coated rolls
- ⊃ Polyurethane coated rolls
- ⊃ Non-woven covered rolls
- ⇒ Felt covered rolls







Copper

⊃ Aluminium

⊃ Automotive ⊃ Paper

Srass

⊃ Plastics

⊃ Glass

⊃ Textile

JVM Rolls	
	(). (Conventional rolls)



- Rolls 가 (conventional rolls)::
- ⊃ Steel rolls
- ⇒ Bronze coated steel rolls
- ⊃ Alloyed steel rolls
- ⊃ Hardened steel rolls
- ⊃ Other rolls

#### JVM Rolls



(Treat),

#### JVM Rolls<sup>®</sup>



JVM

, (Cuts)

, JVM Rolls , 40% (void volume) 가

JVM Rolls

가 **JVM Rolls** 

(Porosity) (Uniformly)

#### , JVM Rolls

( Carry-over)	, (Friction )
( Carry - over)	)

#### **Technical Benefits:**

- ⇒ Extremely resistant and elastic surface( :極强耐具性)
- ⇒ Roll surface cannot be (無 destroyed by distortion
- ⊃ High nip pressure reserves, therefore no danger of burning or destroying the roll covering by strip buckles or
- twisting ( ⇒ Roll surface does not become glazed, like rubber, polyurethane or similar coated rolls (
- Constant, extremely high friction values to achieve high tension and more precise steering control (
- No aquaplaning/hydroplaning or air planing (無

#### **Economic Benefits:**

- ⊃ Higher line productivity (高 ⇒ Extreme reduction in maintenance costs ( Visible quality improvements( ⇒ Higher strip speeds (高) Considerably longer roll life ( ⇒ Less downtime of line (7) ⇒ Much lower maintenance expenditure ( ⊃ Low set-up costs ( ⇒ Less scrap (
- ⊃ Substantial overall cost savings

#### **Environmental Benefits:**

- $\supset$  Carry-over in wringing/ ( squeezing applications will be greatly reduced. Consequently, the replacement intervals of the cleaning and rinsing ( solutions (liquids), such as demineralised water, acids and alkalis are substantially higher
- ⊃ Up to 50% lower oil consumption due to more uniform oiling or more effective de-oiling ) Much lower costs for disposal
- of liquids( 50% Cleaner line (

#### **Technical Data of JVM Rolls®**

Roll outside Ø:	40–1500 mm
ace (covering) length:	max. 8000 mm
lardness range:	30–100° Shore A
Nip (roll) pressure:	max. 90 kg/cm
Range of application:	pH 0–14
Operating temperature:	max. 150 °C
itrip speed:	max. 2000 m/min
Roll revolution:	max. 2500 r. p. m.



#### Working Method of JVM Rolls With Special Fibre Covering (

- 1. The porous roll surface ( absorbs the solution (fluid) enabling relief, in spite of pressure, while still keeping the tight contact with the strip.
- compressed to near zero at the nip centre, creating a seal which is restored with each revolution of the roll( 3. The porous roll surface
- decreases. This sponge-like function removes residual moisture from the strip.

#### Comparison



# deformation)

**Rubber Coated Roll** 

and tearing)



2. The void volume of the roll is reopens when the compression

#### **Operation Mode of Rolls Under Pressure**

가 . JVM Rolls

#### (Plastic

(Nip)

(Cutting





'JVM (self-healing effect) (cuts and tears) , JVM Rolls (Regeneration)

## JVM Rolls<sup>®</sup> – Higher Quality Standards For Many Industries

#### **Coil Coating Lines**

- Wringer/Squeegee rolls in rinse stations of pre-treatment and cleaning sections
- Wringer/Squeegee rolls in final rinse stations after coating/ painting/lacguering
- Deflector rolls
- Tension/Bridle rolls

#### **Cleaning Lines**

- Wringer/Squeegee rolls in rinse stations
- De-oiler rolls before cleaning section

#### **Strip and Blank Washers**

- Wringer/Squeegee rolls
- De-oiler rolls
- Oiler rolls
- Entry feed rolls

#### Hot Dip Galvanising Lines

- Wringer/Squeegee rolls in rinse stations of pre-treatment and cleaning sections
- Wringer/Squeegee rolls after water guench
- Wringer/Squeegee rolls after wet temper mill
- Wringer/Squeegee rolls in rinse stations of aftertreatment section
- Oiler rolls
- Deflector rolls
- Tension/Bridle rolls

#### **Electro-Galvanising Lines**

- Wringer/Squeegee rolls in rinse stations after degreasing/ cleaning sections
- Wringer/Squeegee rolls in brushing machines
- Wringer/Squeegee rolls in rinse stations after pickling/ after galvanising/after phospating

Snubber roll

Uncoiler

- Oiler rolls
- Deflector rolls
- Tension/Bridle rolls





Ironing roll/ Snubber roll

Recoiler

Oiler rolls Applicator/Coater rolls De-oiler rolls

Temper mill

#### Slitting and Cut-to-Length Lines

- Brake (Tension) rolls
- Oiler rolls
- Feed rolls
- Pinch (Driving) rolls

#### **Punching/Stamping and Embossing Lines**

- Feed rolls
- Pinch (Driving) rolls
- De-oiler rolls
- Oiler rolls

#### **Tin Plating Lines**

- Wringer/Squeegee rolls in rinse stations of pre-treatment and cleaning sections
- Wringer/Squeegee rolls in final rinse stations after tin plating
- Oiler rolls
- Deflector rolls
- Tension/Bridle rolls

## JVM Rolls<sup>®</sup> –



0 0

Э

Э

resistant)

⊃ "Self - healing effect"

(cuts) (extremely high

#### Wringer/Squeegee rolls

Э	wringing/squeezing	
⊃ so	95% lutions)	(carry - over ( - )
٢	100	( )
Э		

⊃ No aquaplaning/hydroplaning 

Oiler Rolls			
Applying a definable, ( streak-free oil film ,	)	Э	
Easy control of the oil film by adjusting the contact pressure of the rolls (	)	C	(extremely resistant)
⊃ Up to 50% lower oil	X	C	
consumption (50%	)	C	/
Non-marking roll surface ( )		Э	/





Э

**De-oiler Rolls** С

Э

- (th
- ⊃ No aquaplaning effect ( ,
- ⊃ Non-marking r

e residual oil film) ()	0
g/hydroplaning	0
)	$\supset$
oll surface )	Э

### (cuts) (extremely resistant)

### JVM Rolls®









. . .



Comparison of Fr Data of the Fricti

Steel strip
Dry
Wet
Oily
Stainless steel strip
Dry
Wet
Oily
Aluminium strip
Dry
Wet
Oily
Copper strip
Dry
Wet
Oily
Durana atula

Brass strip
Dry
Wet
Oily

ents of frictio guide of 180° (see schematic drawing)

#### ...

С

#### Advantages of JVM Rolls: (

Э - 50%

```
40
                       (oiled strips))
    (
Э
```

Э (glazed)"

С

⊃ No aquaplaning/hydroplaning or air planing (

Э (Very long life)

#### (Productivity)

가) – higher strip speeds ( considerably higher strip tensions ( 가)

- no scratching of strip surfaces as a result of strip slipping
- ⊃ Tighter wound coils(
- <sup>1</sup> C Better strip control
- ⊃ More precise coil winding
- More consistent movement of strips and better strip control during follow-up treatment in continuous annealing furnace





riction Factors, ion Values in μ			
JVM	Rubber		
Roll	Coated Roll		
Ron	couled non		
0.52	0.36		
0.44			
0.36	0.01		
0.29			
0.27			
0.25			
0.29	0.36		
0.31	-,-		
0.32	0.01		
0.34			
0.31			
0.34			
0.34			
0.37	-,-		
0.30			
n measured with a strip			





# JVM Squeegee/Wringer Rolls<sup>®</sup> and Entry Feed Rolls in Blank and Strip Washers in the Automotive Industry



#### **Clean Blank Surfaces Provide Superior Product** Quality(

(the draw dies)

JVM (blank and strip washers) (Oil film)

(the deep - draw dies)

(Nip)

## The Process (

**JVM Rolls** 

In Operation (

JVM squeegee/wringer rolls entry feed rolls

SCHULER, Schleifenbaum & Steinmetz, MÜLLER WEINGARTEN, 10

The Result ( )

- $\bigcirc$  Residual oil film of 0.5–4 g/m<sup>2</sup> dependent on:(
  - operating speed (
- cleaning fluid (
- viscosity of the fluid (
- number of JVM squeegee/ wringer roll pairs



**Benefits of JVM Squeegee/** Wringer Rolls: ( )

- С (oil, emulsion or watery solution (liquid))
- Cleaning effect dirt particles are absorbed by the roll



#### **Benefits of JVM Squeegee/** Wringer and Entry Feed Rolls: ( 5 40

- $\supset$  No aquaplaning/( hydroplaning effect
- ⊃ Non-marking roll surface
- ⇒ Cleaning effect dirt particles are absorbed by the roll
- No scratching of the blank or strip surface(
- ⊃ Roll surface is resilient and extremely resistant against cuts from blank or strip edges
- $\supset$  "Self-healing effect" of the roll covering in case of cuts caused by blank or strip edges ( (cuts) ⊃ Long life

# JVM Rolls<sup>®</sup> – Also Highly Effective for Manufacturing, Treating and Further Processing of Tubes, Pipes and Profiles

Tubes, pipes and profiles made of aluminium, copper, brass, stainless steel or steel are often covered with lubricants such as oil, emulsion or grease during the various manufacturing processes.

Conventional rubber or polyurethane coated rolls are often not as suitable for driving or braking tubes, pipes and profiles or for applying or wringing/ squeezing solutions (liquids), because they have a low coefficient of friction and they cut easily.

Steel rolls are also often used in order to work with higher contact pressure. However, these rolls cause scratches and marks on the work piece surface, which leads to scrap.







(High tension)

- Pinch (Driving) rolls
- Brake (Tension) rolls
- Entry feed rolls
- Feed rolls
- Applicator/Coater rolls



- De-oiler rolls
- Wringer/Squeegee rolls
- Cleaning Rolls
- Speedometer rolls/ Measuring wheels

- ⊃ Extremely high, durable friction value, for example up to 40 times higher in comparison with rubber or polyurethane coated rolls on oiled tubes, pipes or profiles.
- 40 ⇒ Non-marking roll surface
- ⊃ No scratching of the tube, pipe or profile surfaces
- C Very good and uniform oiling/ lubrication effect (greasing)

- Very effective and even squeezing of oil or emulsion
- ⇒ Excellent wringing/squeezing performance of watery solutions (liquids)
- ⇒ Roll surface is resilient and extremely resistant against cuts from tube and pipe head ends or profile edges
- ⇒ Long life



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Presented by:

