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Nueva Montana Rolls

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I enclose the report on the number of rolls required in Spain to cover three years operation based on the Scunthorpe Rod Mill requirements.

At present they buy an average of 150 rolls per year for an output of about 170,000 tons. Spain should therefore be about 288 rolls for a total three years output of 294,000 tons. The G.K.N. figure is 1132 tons per roll and the Nueva Montana is 1022 ton per roll.

I am preparing a schedule for Taudevin to prepare a quotation for gang tools for the finishing mill rolls. Scunthorpe Morgoil spares figure is not a reliable one due to the bad run they had caused by the awful water they use, so I will contact G.K.N. as soon as possible.

I have an application for the three films importation on the way.

Sincerely

W. M.
NUÉVA MONTANA

STATEMENT OF ROLLS REQUIRED IN

THE FIRST THREE YEARS OF OPERATION

It is assumed that the mill will commence operation on a single shift basis and that after a period of say ten weeks will introduce a second shift making twelve production shifts per week.

The single shift period will therefore occupy 60 shifts and the remainder of the year will occupy 480 shifts making a total of 540 shifts. The average production per shift over the year should be around 160 tons, yielding 86,000 tons for the first year's operation. This is assuming that the percentage of 5 mm. and 5.5 mm. is around 50% of the total production.

The second year's production will be made on a double shift basis namely twelve shifts per week and the 600 shifts should yield 100,000 tons of rods.

On the same shift basis the third year production can be expected to be in the neighbourhood of 108,000 tons.

Taking the ratio of production to roll usage in established mill over a long time, the estimate of rolls required in the first year is:

- Roughing Mill Rolls: 26
- Intermediate Mill Rolls: 12
- Repeating Stands Rolls: 10
- Finishing Train Rolls: 36
- Total: 84

**Second Year**

- Roughing Mill Rolls: 28
- Intermediate Mill Rolls: 14
- Repeater Stands: 12
- Finishing Mill: 40
- Total: 94

**Third Year**

- Roughing Mill Rolls: 34
- Intermediate Mill Rolls: 16
- Repeater Stands: 14
- Finishing Mill Rolls: 46
- Total: 110

Thus to cover for three years at double shift working Nueva Montana would require to replace 288 rolls.
Note: The numbers of finishing rolls mentioned cover the large sizes of rod which finish in stand 15.

Finalising this matter it will be necessary for Nueva Montana to buy three complete furnishings of rolls initially and to buy 288 rolls to replace discarded rolls during the period of 3 years.

W. Murray

WM/BW